

# Rotating tools

MILLING  
DRILLING  
BORING  
ROTATING TOOL ADAPTORS







# Let us introduce our new catalogues

The catalogue consists of three volumes: Turning tools, Rotating tools and Solid round tools. In total, over 30,000 standard products are presented.

**Turning tools** – General Turning, Parting and Grooving, Thread Turning, Multifunctional tools, Tool holding and Turning tool adaptors

**Rotating tools** – Milling, Drilling, Boring and Rotating tool adaptors

**Solid Round Tools** – Milling, Drilling, Tapping and Reaming









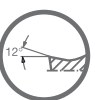





Use the product overviews in the beginning of each chapter to find your area of interest, and a reference will take you to the actual product page. References at the bottom of each product page will guide you to related products and information, such as holders, inserts and cutting data.

Our total offer of approximately 50,000 standard products can be found at [www.sandvik.coromant.com](http://www.sandvik.coromant.com). If your requirements are particularly demanding, we have a wide range of products that can be tailored upon your request.

Please visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com) to be sure of getting the latest measurements and tolerances, get detailed cutting data, and order all available products and spare parts.



## Explanation of reference symbols:

 Inserts	 Milling cutters	 Drill bodies	 Boring tools	 Adaptors
 Accessories	 Cutting data	 Grade description	 Geometry description	 Parameter explanation
 Tailor Made	 Code key	 Coolant information	 Information	

	First choice
	Good choice
	Not available

Our first choice recommendation is a good starting point for most operations, from which you can choose a grade with other attributes if needed.

I Milling

J Drilling

K Boring

L Rotating tool adaptors

M Accessories

N General information

# Milling

## Face milling tools 13

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## Thread milling tools 1135

CoroMill® 328	1148
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## Chamfer milling tools 1135

CoroMill® 327	1150
CoroMill® 495	1151-1153

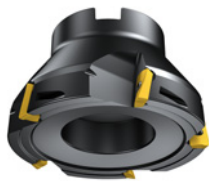
For complete assortment, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# How to choose your milling tool

## Cutter pitch

**L**



**Coarse pitch**

Reduced number of inserts, low cutting forces. Small machines. Best productivity when stability and power is limited. Long overhang.

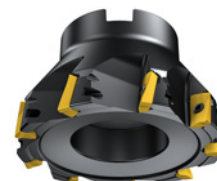
**M**



**Close pitch**

General purpose milling and mixed production. Always first choice.

**H**

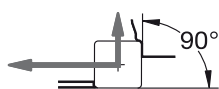


**Extra close pitch**

Maximum number of inserts for best productivity under stable conditions. Short chipping or heat resistant materials.

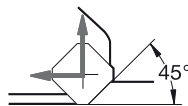
## Entering angle

**90° entering angle**



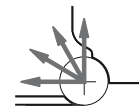
- Thin-walled components
- Weak fixtured components
- Where 90° form is required

**45° entering angle**



- General purpose first choice
- Reduces vibration on long overhang
- Chip thinning effect allows increased productivity

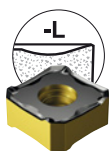
**Round insert cutters**



- Strongest cutting edge with multiple indexes
- General purpose cutter
- Increased chip thinning effect for heat resistant alloys

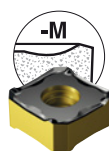
## Insert geometries

**Light**



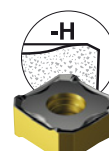
Extra positive, light machining, low cutting forces and for low feed rates.

**Medium**



For general use in most materials.

**Heavy**



Reinforced cutting edge, heavy machining, highest edge security and for high feed rates.

## Explanation of application symbols



Face milling



Thin walls



Edging



Profiling



Helical interpolation



Long overhang



Plunge milling



Slotting



Ramping



Parting



Chamfering



Grooving



Threading




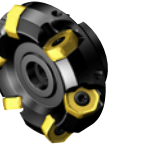

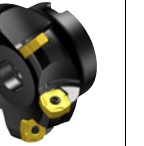













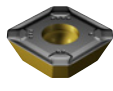


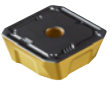
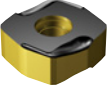















Intermittent milling



Shoulder milling

## Face milling tools

	CoroMill® 345	CoroMill® 245	CoroMill® 425	CoroMill® 745	CoroMill® 360	CoroMill® 365
						
Page	15	110	114	117	121	123
Material						
Main operation						
KAPR	45°	45°	25°	42°	60°	65°
DC mm	40 - 250	32 - 250	100 - 500	63 - 250	160 - 400	50 - 250
DCX mm	54.1 - 264.1	44.5 - 268.8	107.0 - 507.0	78.2 - 264.4	175.0 - 420.8	50.0 - 166.7
APMX mm	6	6 - 10	0.90	5.20	13 - 18	6.0
Insert						
Insert sizes	13	12 & 18	17	21	19 & 28	15
Couplings	Coromant Capto® Cylindrical shank Arbor	Arbor Cylindrical shank	Arbor Cap coupling	Coromant Capto® Arbor	Arbor	Coromant Capto® Arbor
Internal coolant						
Options	Shim protection tipseat	Shim protection tipseat	Adjustable cassettes for wiper inserts		Exchangeable cassette design	Internal coolant on selected models
Other operations				 		

# CoroMill® 345

Face mill for high productivity

## Application

- Face milling
- Roughing to finishing

## ISO application area:



## Benefits and features

- Low cost per component thanks to eight cutting edges
- High output – with internal coolant high productivity is possible also in demanding materials
- Secure machining thanks to shim-protected tip seats and tough cutter body
- Optimized machine utilization and productivity with four different pitches
- Wide application area – use the same concept for different application

[www.sandvik.coromant.com/coromill345](http://www.sandvik.coromant.com/coromill345)

## Couplings

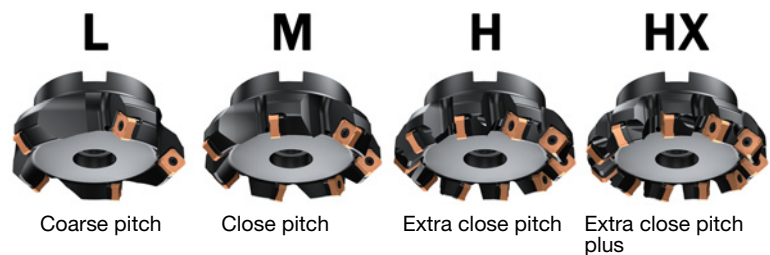
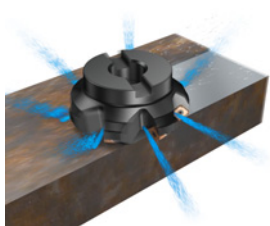
- Coromant Capto®
- Arbor
- Cylindrical shank

## Inserts

- Eight cutting edges
- Wiper inserts for excellent surface finish at high feed per tooth

## Internal coolant

Coolant supply to each insert pocket gives good chip evacuation and performance in demanding materials.



15



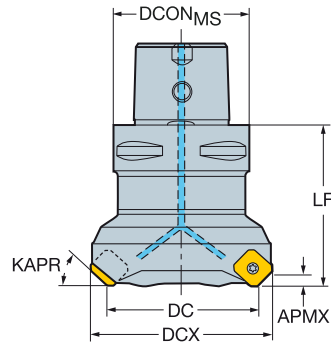
18



# CoroMill® 345 face milling cutter

Coromant Capto® - Internal coolant supply

KAPR 45°



							Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	LF	NM	KG	RPM	CICT	MIID	
40.0	13	C4	6.00	3	4	345-040C4-13M	40.0	54.1	60.0	3.0	0.89	19600	4	345R-1305
50.0	13	C5	6.00	3	4	345-050C5-13M	50.0	64.1	60.0	3.0	1.39	17500	4	345R-1305
	13	C6	6.00	3	4	345-050C6-13M	63.0	64.1	60.0	3.0	1.80	17500	4	345R-1305
	13	C5	6.00	3	5	345-050C5-13H	50.0	64.1	60.0	3.0	1.48	17500	5	345R-1305
	13	C6	6.00	3	5	345-050C6-13H	63.0	64.1	60.0	3.0	1.79	17500	5	345R-1305
63.0	13	C5	6.00	3	5	345-063C5-13M	50.0	77.1	60.0	3.0	1.53	15500	5	345R-1305
	13	C6	6.00	3	5	345-063C6-13M	63.0	77.1	60.0	3.0	1.91	15500	5	345R-1305
	13	C5	6.00	3	6	345-063C5-13H	50.0	77.1	60.0	3.0	1.62	15500	6	345R-1305
	13	C6	6.00	3	6	345-063C6-13H	63.0	77.1	60.0	3.0	1.97	15500	6	345R-1305
80.0	13	C6	6.00	3	6	345-080C6-13M	63.0	94.1	70.0	3.0	2.46	13700	6	345R-1305
	13	C8	6.00	3	6	345-080C8-13M	80.0	94.1	70.0	3.0	3.32	13700	6	345R-1305
	13	C6	6.00	3	8	345-080C6-13H	63.0	94.1	70.0	3.0	2.54	13700	8	345R-1305
100.0	13	C8	6.00	3	7	345-100C8-13M	80.0	114.1	80.0	3.0	4.01	12200	7	345R-1305

## Spare parts

Insert screw	Shim	Shim screw
416.1-834	5322 474-01	5512 090-11

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I8



L2



N23



N9



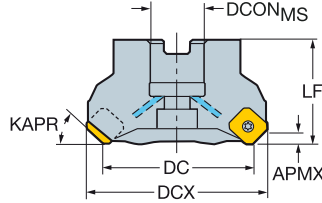
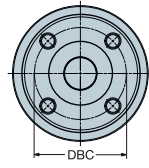
N15

# CoroMill® 345 face milling cutter

Arbor - Internal coolant supply

STDNO  
KAPR

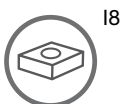
ISO6462  
45°



						Dimensions, mm											
DC	CZC <sub>MS</sub>	APMX <sub>FW</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ISO	DBC	DCX	LF	NM	KG	RPMX	CICT	MIID			
40.0	13	22	6.00	1	3	345-040Q22-13L	22.0	A	54.1	45.0	3.0	0.68	19600	3	345R-1305		
	13	22	6.00	1	4	345-040Q22-13M	22.0	A	54.1	45.0	3.0	0.67	19600	4	345R-1305		
50.0	13	22	6.00	1	3	345-050Q22-13L	22.0	A	64.1	45.0	3.0	0.82	17500	3	345R-1305		
	13	22	6.00	1	4	345-050Q22-13M	22.0	A	64.1	45.0	3.0	0.78	17500	4	345R-1305		
	13	22	6.00	1	5	345-050Q22-13H	22.0	A	64.1	45.0	3.0	0.82	17500	5	345R-1305		
63.0	13	22	6.00	1	4	345-063Q22-13L	22.0	A	77.1	45.0	3.0	0.98	15500	4	345R-1305		
	13	22	6.00	1	5	345-063Q22-13M	22.0	A	77.1	45.0	3.0	0.94	15500	5	345R-1305		
	13	22	6.00	1	6	345-063Q22-13H	22.0	A	77.1	45.0	3.0	0.60	15500	6	345R-1305		
	13	22	6.00	1	7	345-063Q22-13HX	22.0	A	77.1	45.0	3.0	1.03	15500	7	345R-1305		
80.0	13	27	6.00	1	4	345-080Q27-13L	27.0	A	94.1	50.0	3.0	1.65	13700	4	345R-1305		
	13	27	6.00	1	6	345-080Q27-13M	27.0	A	94.1	50.0	3.0	1.72	13700	6	345R-1305		
	13	27	6.00	1	8	345-080Q27-13H	27.0	A	94.1	50.0	3.0	1.72	13700	8	345R-1305		
	13	27	6.00	1	9	345-080Q27-13HX	27.0	A	94.1	50.0	3.0	1.76	13700	9	345R-1305		
100.0	13	32	6.00	1	5	345-100Q32-13L	32.0	A	114.1	50.0	3.0	2.30	12200	5	345R-1305		
	13	32	6.00	1	7	345-100Q32-13M	32.0	A	114.1	50.0	3.0	2.29	12200	7	345R-1305		
	13	32	6.00	1	10	345-100Q32-13H	32.0	A	114.1	50.0	3.0	2.31	12200	10	345R-1305		
	13	32	6.00	1	11	345-100Q32-13HX	32.0	A	114.1	50.0	3.0	2.38	12200	11	345R-1305		
125.0	13	40	6.00	1	6	345-125Q40-13L	40.0	B	139.1	63.0	3.0	3.64	10900	6	345R-1305		
	13	40	6.00	1	8	345-125Q40-13M	40.0	B	139.1	63.0	3.0	3.48	10900	8	345R-1305		
	13	40	6.00	1	12	345-125Q40-13H	40.0	B	139.1	63.0	3.0	3.63	10900	12	345R-1305		
	13	40	6.00	1	14	345-125Q40-13HX	40.0	B	139.1	63.0	3.0	3.64	10900	14	345R-1305		
160.0	13	40S	6.00	0	7	345-160Q40-13L	40.0	C	66.7	174.1	63.0	3.0	4.59	9600	7	345R-1305	
	13	40S	6.00	0	10	345-160Q40-13M	40.0	C	66.7	174.1	63.0	3.0	4.50	9600	10	345R-1305	
	13	40S	6.00	0	12	345-160Q40-13H	40.0	C	66.7	174.1	63.0	3.0	4.72	9600	12	345R-1305	
	13	40S	6.00	0	16	345-160Q40-13HX	40.0	C	66.7	174.1	63.0	3.0	4.58	9600	16	345R-1305	
200.0	13	60	6.00	0	12	345-200Q60-13M	60.0	C	101.6	214.1	63.0	3.0	10.60	8600	12	345R-1305	
	13	60	6.00	0	16	345-200Q60-13H	60.0	C	101.6	214.1	63.0	3.0	6.64	8600	16	345R-1305	
250.0	13	60	6.00	0	14	345-250Q60-13M	60.0	C	101.6	264.1	63.0	3.0	10.36	7700	14	345R-1305	
	13	60	6.00	0	18	345-250Q60-13H	60.0	C	101.6	264.1	63.0	3.0	10.79	7700	18	345R-1305	

Spare parts				
DC	Shower screw	Insert screw	Shim	Shim screw
40.00-63.00	5512-073-01	416.1-834	5322 474-01	5512 090-11
80.00	5512-073-02	416.1-834	5322 474-01	5512 090-11
100.00	5512-073-05	416.1-834	5322 474-01	5512 090-11
125.00-160.00	5512-098-03	416.1-834	5322 474-01	5512 090-11
250.00		416.1-834	5322 474-01	5512 090-11

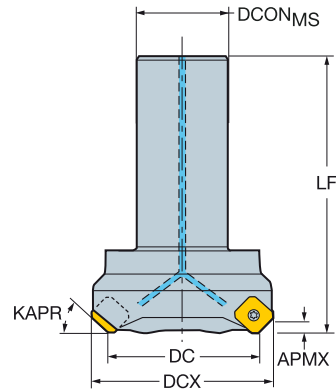
For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 345 face milling cutter

Cylindrical shank - Internal coolant supply

KAPR 45°



							Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCX	LF	NM	KG	RPMX	CICT	MIID		
40.0	13	32	6.00	1	4	345-040A32-13M	32.0	54.1	120.0	3.0	1.26	19600	4	345R-1305
50.0	13	32	6.00	1	3	345-050A32-13L	32.0	64.1	120.0	3.0	1.41	17500	3	345R-1305
	13	32	6.00	1	4	345-050A32-13M	32.0	54.1	120.0	3.0	1.41	17500	4	345R-1305

## Spare parts

Insert screw	Shim	Shim screw
416.1-834	5322 474-01	5512 090-11

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I8



L2



N23



N9

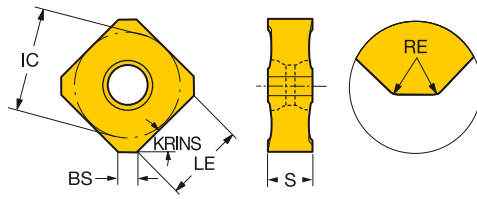
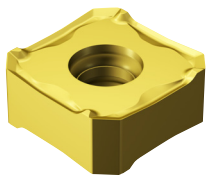


N15



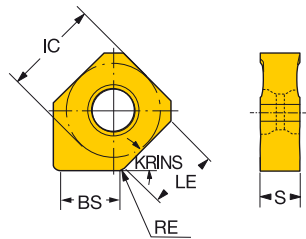
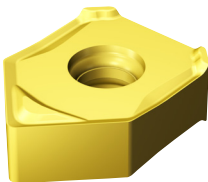
# CoroMill® 345 insert for milling

KRINS 45°



		RE	Ordering code	P				M		K				N		S		H		Dimensions, mm											
				1130	4220	4330	4340	530	1040	2040	530	1020	3040	3220	3330	H13A	K20W	1130	530	H13A	S30T	S40T	H13A	1010	1130	530	IC	LE	S	BS	
Light	KL	0.80	345R-1305E-KL							★	☆	☆	☆	☆												13.0	8.8	5.60	2.0		
		0.80	345R-1305M-KL		☆						★	☆	☆	☆	☆												13.0	8.8	5.60	2.0	
	0.80	345R-13T5E-ML		☆					★	☆									★	☆							13.0	8.8	5.95	2.0	
	ML	0.80	345R-1305E-PL		☆		★	☆															★	☆			13.0	8.8	5.60	2.0	
		0.80	345R-1305M-PL		☆	☆	★	☆																★	☆			13.0	8.8	5.60	2.0
Medium	KM	0.80	345R-1305E-KM					☆			☆	☆		★										★	☆		13.0	8.8	5.60	2.0	
		0.80	345R-1305M-KM								☆	☆	☆	★											★	☆		13.0	8.8	5.60	2.0
	0.80	345R-13T5E-MM		☆					★	☆									★	☆					☆	☆	13.0	8.8	5.95	2.0	
	0.80	345R-13T5M-MM		☆					★	☆									★	☆					☆	☆	13.0	8.8	5.95	2.0	
	0.80	345L-1305M-PM		☆		★	☆																		☆	☆	13.0	8.8	5.60	2.0	
	PM	0.80	345R-1305M-PM		☆	☆	★	☆																	☆	☆	13.0	8.8	5.60	2.0	
		0.80	345R-1305M-KH		☆	☆	★	☆																		☆	☆	13.0	8.8	5.60	2.0
Heavy	KH	0.80	345R-1305M-KH		☆	☆	★	☆																		☆	☆	13.0	8.8	5.60	2.0
		0.80	345R-1305M-PH		☆	☆	★	☆						★												☆	☆	13.0	8.8	5.60	2.0
	PH																														

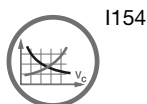
KRINS 45°



**Wiper** TECHNOLOGY

		RE	Ordering code	P				M		K				N		S		H		Dimensions, mm												
				1130	4330	530	1040	2040	530	1020	3220	3330	H13A	K20W	1130	530	H13A	H13A	S30T	S40T	1010	1130	530	IC	LE	S	BS	BSR				
Light	KW8	1.00	345N-1305E-KW8								☆	☆	☆	☆	☆												13.0	8.8	5.60	8.0	500.0	
		1.00	345N-13T5E-MW8		☆			☆	☆											☆	☆							13.0	8.8	5.95	8.0	500.0
	PW5	1.00	345N-1305E-PW5		☆	☆								☆														13.0	8.8	5.60	5.0	500.0
		1.00	345N-1305E-PW8		☆	☆	☆							☆	☆													13.0	8.8	5.60	8.0	500.0

T5 Wiper insert should be used with T5 standard insert



# CoroMill® 245

Light-cutting face mill for heavy roughing to mirror finishing

## Application

- Face milling
- Roughing to finishing

## ISO application area



## Benefits and features

- Easy to use and high productivity
- Light cutting with low power consumption
- Close tolerance combined with the wiper insert for superior surface finish
- 45° face milling cutter
- Demanding roughing to mirror finishing
- Smooth and light-cutting action for low cutting forces
- Available in exchangeable cassette system, a concept for rough to semi-finishing of steel



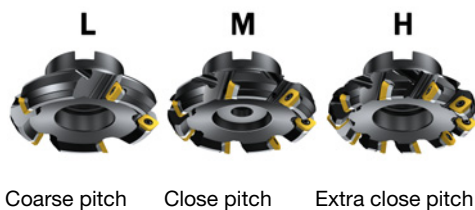
[www.sandvik.coromant.com/coromill245](http://www.sandvik.coromant.com/coromill245)

## Couplings

- Arbor
- Cylindrical Shank

## Inserts

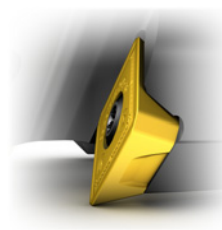
- Four cutting edges
- Wide range of grades and geometries including ceramic and CBN grades
- Wiper inserts for high feed finishing



Coarse pitch

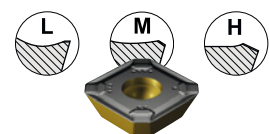
Close pitch

Extra close pitch

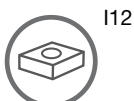


## Light cutting action

Single-sided positive inserts positioned to give a smooth cutting action and very low cutting forces.



I10



I12



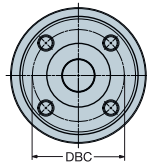
N6

# CoroMill® 245 face milling cutter

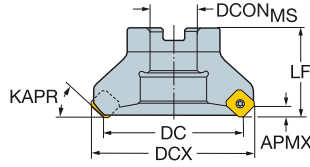
Arbor



STDNO  
KAPR



ISO6462  
45°



						Dimensions, mm											
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	Ordering code			DCON <sub>MS</sub>	ISO	DBC	DCX	LF	NM	KG	RPMX	CICT	MIID		
50.0	12	22	6.00	3	R245-050Q22-12L	22.0	A	62.5	40.0	3.0	0.65	16250	3	R245-12T3..			
	12	22	6.00	4	R245-050Q22-12M	22.0	A	62.5	40.0	3.0	0.67	16250	4	R245-12T3..			
	12	22	6.00	5	R245-050Q22-12H	22.0	A	62.5	40.0	3.0	0.62	16250	5	R245-12T3..			
63.0	12	22	6.00	4	R245-063Q22-12L	22.0	A	75.5	40.0	3.0	0.89	14400	4	R245-12T3..			
	12	22	6.00	5	R245-063Q22-12M	22.0	A	75.5	40.0	3.0	0.84	14400	5	R245-12T3..			
	12	22	6.00	6	R245-063Q22-12H	22.0	A	75.5	40.0	3.0	0.87	14400	6	R245-12T3..			
80.0	12	27	6.00	4	R245-080Q27-12L	27.0	B	92.5	50.0	3.0	1.50	12700	4	R245-12T3..			
	12	27	6.00	6	R245-080Q27-12M	27.0	B	92.5	50.0	3.0	1.45	12700	6	R245-12T3..			
	12	27	6.00	8	R245-080Q27-12H	27.0	B	92.5	50.0	3.0	1.40	12700	8	R245-12T3..			
	18	32	10.00	4	R245-080Q32-18M	32.0	B	98.8	50.0	5.0	1.72	6100	4	R245-18T6..			
100.0	18	32	10.00	5	R245-080Q32-18H	32.0	B	98.8	50.0	5.0	1.60	6100	5	R245-18T6..			
	12	32	6.00	5	R245-100Q32-12L	32.0	B	112.5	50.0	3.0	1.77	11300	5	R245-12T3..			
	12	32	6.00	7	R245-100Q32-12M	32.0	B	112.5	50.0	3.0	1.81	11300	7	R245-12T3..			
	12	32	6.00	10	R245-100Q32-12H	32.0	B	112.5	50.0	3.0	1.74	11300	10	R245-12T3..			
125.0	18	32	10.00	4	R245-100Q32-18M	32.0	B	118.8	50.0	5.0	2.08	5400	4	R245-18T6..			
	18	32	10.00	6	R245-100Q32-18H	32.0	B	118.8	50.0	5.0	1.92	5400	6	R245-18T6..			
	12	40	6.00	6	R245-125Q40-12L	40.0	B	137.5	63.0	3.0	3.20	10100	6	R245-12T3..			
	12	40	6.00	8	R245-125Q40-12M	40.0	B	137.5	63.0	3.0	3.12	10100	8	R245-12T3..			
	12	40	6.00	12	R245-125Q40-12H	40.0	B	137.5	63.0	3.0	3.10	10100	12	R245-12T3..			
160.0	18	40	10.00	5	R245-125Q40-18M	40.0	B	138.8	63.0	5.0	3.74	4900	5	R245-18T6..			
	18	40	10.00	7	R245-125Q40-18H	40.0	B	138.8	63.0	5.0	3.64	4900	7	R245-18T6..			
	12	40S	6.00	7	R245-160Q40-12L	40.0	C	66.7	172.5	63.0	3.0	4.63	8900	7	R245-12T3..		
	12	40S	6.00	10	R245-160Q40-12M	40.0	C	66.7	172.5	63.0	3.0	4.50	8900	10	R245-12T3..		
	12	40S	6.00	16	R245-160Q40-12H	40.0	C	66.7	172.5	63.0	3.0	4.49	8900	16	R245-12T3..		
200.0	18	40S	10.00	6	R245-160Q40-18M	40.0	C	66.7	178.8	63.0	5.0	5.11	4300	6	R245-18T6..		
	18	40S	10.00	9	R245-160Q40-18H	40.0	C	66.7	178.8	63.0	5.0	4.99	4300	9	R245-18T6..		
	12	60	6.00	8	R245-200Q60-12L	60.0	C	101.6	212.5	63.0	3.0	6.43	7950	8	R245-12T3..		
	12	60	6.00	12	R245-200Q60-12M	60.0	C	101.6	212.5	63.0	3.0	10.64	7950	12	R245-12T3..		
250.0	18	60	10.00	8	R245-200Q60-18M	60.0	C	101.6	218.8	63.0	5.0	6.24	3800	8	R245-18T6..		
	18	60	10.00	12	R245-200Q60-18H	60.0	C	101.6	218.8	63.0	5.0	6.43	3800	12	R245-18T6..		
	12	60	6.00	10	R245-250Q60-12L	60.0	C	101.6	262.5	63.0	3.0	9.12	7100	10	R245-12T3..		
	12	60	6.00	14	R245-250Q60-12M	60.0	C	101.6	262.5	63.0	3.0	8.93	7100	14	R245-12T3..		
	12	60	6.00	24	R245-250Q60-12H	60.0	C	101.6	262.5	63.0	3.0	8.74	7100	24	R245-12T3..		
	18	60	10.00	10	R245-250Q60-18M	60.0	C	101.6	268.8	63.0	5.0	17.22	3400	10	R245-18T6..		
18	60	10.00	14	R245-250Q60-18H	60.0	C	101.6	268.8	63.0	5.0	16.00	3400	14	R245-18T6..			

Spare parts				
DC	Insert screw	Shim	Shim screw	
50.00-250.00	12	5513 020-01	5322 472-01	5512 090-09
80.00-100.00	18	5513 020-55		
125.00-250.00	18	5513 020-26	5322 472-03	5512 090-10

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

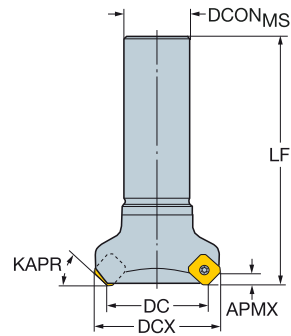




# CoroMill® 245 face milling cutter

Cylindrical shank

KAPR 45°



						Dimensions, mm								
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>		Ordering code	DCON <sub>MS</sub>	DCX	LB	LF	NM	KG	RPMX	CICT	MIID	
32.0	12	32	6.00	3	R245-032A32-12M	32.0	44.5	39.0	117.0	3.0	0.97	18250	3	R245-12T3..
40.0	12	32	6.00	3	R245-040A32-12L	32.0	52.5	39.0	120.0	3.0	1.06	18250	3	R245-12T3..
50.0	12	32	6.00	3	R245-050A32-12L	32.0	62.5	39.0	120.0	3.0	1.28	16250	3	R245-12T3..
	12	32	6.00	4	R245-050A32-12M	32.0	62.5	39.0	120.0	3.0	1.33	16250	4	R245-12T3..
63.0	12	32	6.00	4	R245-063A32-12L	32.0	75.5	39.0	120.0	3.0	1.48	14400	4	R245-12T3..
	12	32	6.00	5	R245-063A32-12M	32.0	75.5	39.0	120.0	3.0	1.49	14400	5	R245-12T3..
80.0	12	32	6.00	4	R245-080A32-12L	32.0	92.5	39.0	120.0	3.0	1.80	12700	4	R245-12T3..
	12	32	6.00	6	R245-080A32-12M	32.0	92.5	39.0	120.0	3.0	1.74	12700	6	R245-12T3..

Spare parts				
DC		Insert screw	Shim	Shim screw
32.00	12	5513 020-01		
40.00-80.00	12	5513 020-01	5322 472-01	5512 090-09

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I12



L2



N23



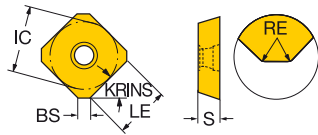
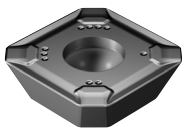
N6



N9

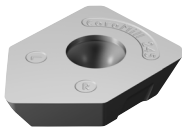
# CoroMill® 245 insert for milling

KRINS 45°

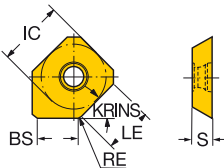


	RE	Ordering code	P M K N S H													Dimensions, mm														
			1130	4220	4330	4340	530	1040	2040	3040	3220	3330	H13A	K15W	K20W	1130	H10	H10	H13A	H13A	S30T	S40T	1010	1130	530	IC	LE	S	BS	
Light	AL	12 1.50	R245-12 T3 E-AL														*										13.4	10.0	3.97	2.3
	KL	12 1.50	R245-12 T3 E-KL							*	*	*	*	*				*		*							13.4	10.0	3.97	2.1
		1.50	R245-12 T3 M-KL						*	*	*	*	*	*						*	*						13.4	10.0	3.97	2.0
	ML	12 1.50	R245-12 T3 E-ML	*					*							*								*			13.4	10.0	3.97	2.1
	PL	12 1.50	R245-12 T3 E-PL	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	13.4	10.0	3.97
1.50		R245-12 T3 M-PL	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	13.4	10.0	3.97	2.1
Medium	KM	12 1.50	R245-12 T3 M-KM						*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	13.4	10.0	3.97	2.0
		18 1.00	R245-18 T6 M-KM						*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	18.0	13.9	6.10	1.5
	MM	12 1.50	R245-12 T3 K-MM						*										*	*							13.4	10.0	3.97	2.1
		18 1.00	R245-18 T6 M-MM						*											*	*						18.0	13.9	6.10	1.5
	PM	12 1.50	R245-12 T3 M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	13.4	10.0	3.97
18 1.00		R245-18 T6 M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	18.0	13.9	6.10	1.5
Heavy	KH	12 1.50	R245-12 T3 M-KH						*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	13.4	10.0	3.97	2.0
		12 1.60	R245-12 T3 M-PH	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	13.4	9.8	3.97	1.5

KRINS 45°



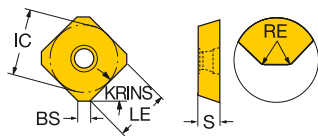
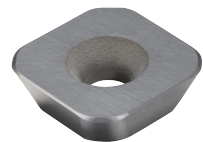
**Wiper** TECHNOLOGY



	RE	Ordering code	P M K N S H													Dimensions, mm															
			1130	530	1020	3220	CB50	H13A	K15W	H10	1130	530	H13A	H13A	1130	1010	1130	530	CB50	IC	LE	S	BS	BSR							
Light	W	12 2.50	R245-12 T3 E-W	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	13.4	3.5	3.97	6.4	400.0
	18 1.00	R245-18 T6 E-W	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	18.0	13.9	6.10	10.8	500.0

## Advanced cutting materials

KRINS 45°



	RE	Ordering code	K N H				Dimensions, mm											
			6190	CB50	CD10	6190	CB50	IC	LE	S	BS							
Light	12 1.50	R245-12 T3 E	*	*	*	*	*	*	*	*	*	*	*	*	13.4	3.5	3.97	1.4
	2.50	R245-12 T3 E1	*	*	*	*	*	*	*	*	*	*	*	*	13.4	10.0	3.97	0.4



110



1154



1175



N23



N10



N2

# CoroMill® 425

Easily adjustable finish face milling

## Application

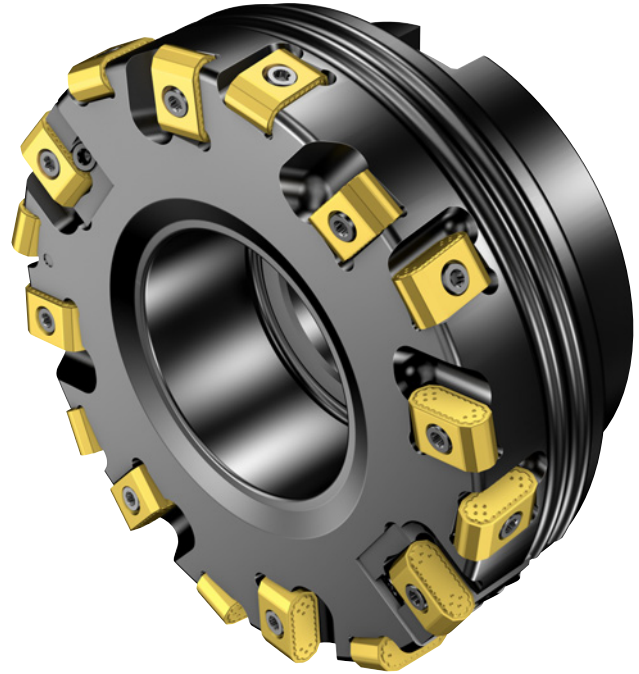
- Finish face milling in cast iron
- Main components: Engine blocks and cylinder heads
- Other components: Axle housings, brake carriers, crank cases

## ISO application area:

**K**

## Benefits and features

- Easy to use
- Eight cutting edges
- Accurate and reliable adjustment system



[www.sandvik.coromant.com/coromill425](http://www.sandvik.coromant.com/coromill425)

## Couplings

- Arbor
- Cap mounting

## Inserts

- Eight cutting edges

## Adjustable wiper inserts

CoroMill® 425 is designed to allow for easily adjustable wiper inserts. You can adjust the wiper insert up and down without loosening the cartridge clamping screw.

Thanks to the design, the adjustment system is very stable and accurate.



I14

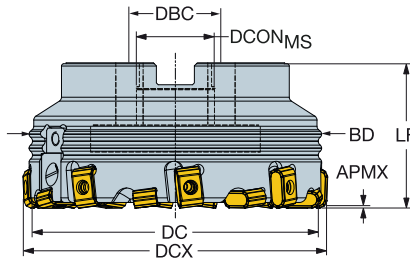


I15

# CoroMill® 425 face milling cutter

Arbor

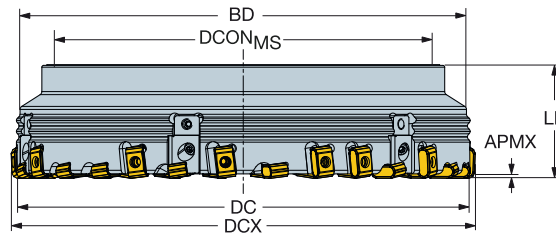
STDNO ISO6462  
KAPR 25°



							Dimensions, mm										
DC	CZC <sub>MS</sub>	APMX	ZADJ	Ordering code	DCON <sub>MS</sub>	ISO	DBC	DCX	BD	LF	NM	KG	RPMX	CICT	MIID		
100.0	17	32	0.9	2	12	425-100Q32-17H	32.0	A	107.0	101.9	63.0	3.0	2.23	4770	12	425N-1707	
125.0	17	40	0.9	2	16	425-125Q40-17H	40.0	B	132.0	126.6	63.0	3.0	3.45	3820	16	425N-1707	
160.0	17	40S	0.9	3	18	425-160Q40-17H	40.0	C	66.7	167.0	161.3	63.0	3.0	5.10	2980	18	425N-1707
200.0	17	60	0.9	3	24	425-200Q60-17H	60.0	C	101.6	207.0	201.1	63.0	3.0	7.69	2390	24	425N-1707
250.0	17	60	0.9	6	30	425-250Q60-17H	60.0	C	101.6	257.0	251.1	63.0	3.0	12.99	1910	30	425N-1707

## Cap coupling

KAPR 25°



							Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX	ZADJ	Ordering code	DCON <sub>MS</sub>	DCX	BD	LF	NM	KG	RPMX	CICT	MIID			
250.0	17	250	0.9	6	30	425-250P-17H	203.7	257.0	251.1	63.0	3.0	9.62	1910	30	425N-1707	
17	250	0.9	6	30	L425-250P-17H	203.7	257.0	251.1	63.0	3.0	9.62	1910	30	425N-1707		
315.0	17	315	0.9	6	36	425-315P-17H	268.7	322.0	316.1	63.0	3.0	13.60	1520	36	425N-1707	
17	315	0.9	6	36	L425-315P-17H	268.7	322.0	316.1	63.0	3.0	13.60	1520	36	425N-1707		
355.0	17	355	0.9	6	48	425-355P-17H	308.7	362.0	356.1	63.0	3.0	16.45	1340	48	425N-1707	
17	355	0.9	6	48	L425-355P-17H	308.7	362.0	356.1	63.0	3.0	16.45	1340	48	425N-1707		
400.0	17	400	0.9	9	54	425-400P-17H	353.7	407.0	401.1	63.0	3.0	20.09	1190	54	425N-1707	
17	400	0.9	9	54	L425-400P-17H	353.7	407.0	401.1	63.0	3.0	20.09	1190	54	425N-1707		
500.0	17	500	0.9	9	54	425-500P-17M	453.7	507.0	501.1	63.0	3.0	30.92	950	54	425N-1707	
17	500	0.9	9	54	L425-500P-17M	453.7	507.0	501.1	63.0	3.0	42.00	950	54	425N-1707		

## Spare parts

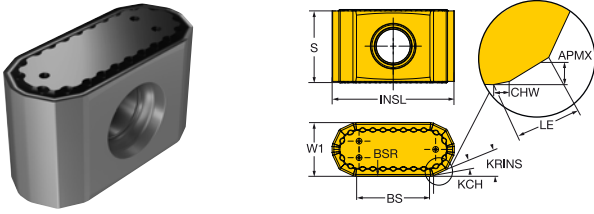
Clamping screw	Wedge	Screw	Screw	Insert screw	Cassette
3212 012-260	5332 010-09	5516 035-09	5513 014-75	5513 020-13	R425-CA-17-2

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 425 insert for milling

KRINS 25°



						K		Dimensions, mm						
Light	KLW	KCH	CHW	Ordering code	1010	1020	3220	3330	K20W	W1	LE	S	BS	BSR
					17	14°	0.4	425N-1707E-KLW12	★	☆	☆	☆	☆	7.5



I14



I154



I175



N23



N10



# CoroMill® 745

Multi-edge face milling and high feed milling concepts

## Application

- Face milling
- Roughing to semi-finishing
- High feed milling

## ISO application area:



## Benefits and features

- Multi-edge concept suitable for large batch productions, flexible transfer lines and when maximum tool utilization is important
- CoroMill 745 with 42° entering angle is used in ISO P, K, M and S applications where APMX is 5.2 mm
- CoroMill 745 high feed cutter with 25° entering angle is used as a productivity booster in ISO P and ISO K applications where APMX is 2.8 mm
- Great problem-solving abilities when machining vibration-sensitive components and in weak set-ups with the unique differential MD pitch



CoroMill® 745 face milling cutter See page I17

CoroMill® 745 high feed face milling cutter See page I43

[www.sandvik.coromant.com/coromill745](http://www.sandvik.coromant.com/coromill745)

## Couplings

- Coromant Capto®
- Arbor

## Inserts

- 14 cutting edges
- The secure tip seat and the large, robust insert with strong, light-cutting geometries are designed for reliable and predictable machining.

## Ground-breaking technology

Available with 42° entering angle for larger cutting depths and as a high feed version with 25° entering angle for an even higher metal removal rate. Same inserts are used in both cutters.



## Differential MD pitch

The unique differential MD pitch is first choice in roughing operations where light cutting action is required, e.g. in vibration-sensitive and weak set-ups. It is a perfect problem-solver when vibration is a limitation in the production. The length and weight of the cutter body has been reduced in order to boost the performance in low-productive applications. The cutter has a logarithmic differential pitch design, and the insert position is radially compensated to produce an even chip load on every insert.



I17



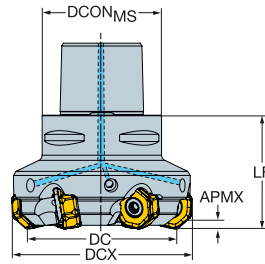
I19

# CoroMill® 745 face milling cutter

Coromant Capto® - Internal coolant supply

KAPR

42°



						Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	LF	NM	KG	RPMX	CICT	MIID		
63.0	21	C5	5.20	3	5	745-063C5-21M	50.0	78.2	60.0	12.0	1.30	5894	5	745R-2109	
	21	C6	5.20	3	5	745-063C6-21M	63.0	78.2	60.0	12.0	1.84	5894	5	745R-2109	
	21	C5	5.20	3	7	745-063C5-21H	50.0	78.2	60.0	12.0	1.34	5894	7	745R-2109	
	21	C6	5.20	3	7	745-063C6-21H	63.0	78.2	60.0	12.0	1.66	5894	7	745R-2109	
80.0	21	C6	5.20	3	6	745-080C6-21M	63.0	95.2	60.0	12.0	2.21	5324	6	745R-2109	
	21	C8	5.20	3	6	745-080C8-21M	80.0	95.2	65.0	12.0	3.12	5324	6	745R-2109	
	21	C6	5.20	3	9	745-080C6-21H	63.0	95.2	60.0	12.0	2.09	5324	9	745R-2109	
	21	C8	5.20	3	9	745-080C8-21H	80.0	95.2	65.0	12.0	3.23	5324	9	745R-2109	
100.0	21	C8	5.20	3	7	745-100C8-21M	80.0	115.2	65.0	12.0	3.66	4765	7	745R-2109	
	21	C8	5.20	3	11	745-100C8-21H	80.0	115.2	65.0	12.0	3.62	4765	11	745R-2109	

## Spare parts

Insert screw  
5513 020-80

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I19



L2



N23



N9



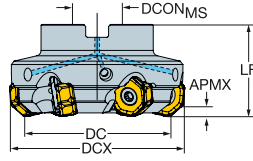
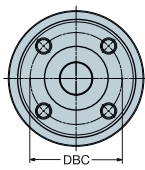
N15

# CoroMill® 745 face milling cutter

Arbor - Internal coolant supply

STDNO  
KAPR

ISO6462  
42°



						Dimensions, mm											
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code		DCON <sub>MS</sub>	ISO	DBC	DCX	LF	NM	KG	RPMX	CICT	MIID		
63.0	21	22	5.20	3	5	745-063Q22-21M	22.0	A	78.2	50.0	12.0	0.80	5894	5	745R-2109		
	21	22	5.20	3	5	745-063Q22-21MD	22.0	A	78.2	46.0	12.0	0.83	5894	5	745R-2109		
	21	22	5.20	3	7	745-063Q22-21H	22.0	A	78.2	50.0	12.0	0.98	5894	7	745R-2109		
80.0	21	27	5.20	3	6	745-080Q27-21M	27.0	A	95.2	50.0	12.0	1.48	5324	6	745R-2109		
	21	27	5.20	3	6	745-080Q27-21MD	27.0	A	95.2	48.0	12.0	1.38	5324	6	745R-2109		
	21	27	5.20	3	9	745-080Q27-21H	27.0	A	95.2	50.0	12.0	1.37	5324	9	745R-2109		
100.0	21	32	5.20	3	7	745-100Q32-21M	32.0	A	115.2	50.0	12.0	2.19	4765	7	745R-2109		
	21	32	5.20	3	7	745-100Q32-21MD	32.0	A	115.2	50.0	12.0	2.12	4765	7	745R-2109		
	21	32	5.20	3	11	745-100Q32-21H	32.0	A	115.2	50.0	12.0	2.01	4765	11	745R-2109		
125.0	21	40	5.20	3	8	745-125Q40-21M	40.0	B	140.2	63.0	12.0	3.75	4216	8	745R-2109		
	21	40	5.20	3	8	745-125Q40-21MD	40.0	B	140.2	54.0	12.0	2.95	4216	8	745R-2109		
	21	40	5.20	3	14	745-125Q40-21H	40.0	B	140.2	63.0	12.0	3.53	4216	14	745R-2109		
160.0	21	40	5.20	3	10	745-160Q40-21M	40.0	B	175.2	63.0	12.0	5.26	3675	10	745R-2109		
	21	40	5.20	3	10	745-160Q40-21MD	40.0	B	175.2	60.0	12.0	4.70	3675	10	745R-2109		
	21	40	5.20	3	16	745-160Q40-21H	40.0	B	175.2	63.0	12.0	4.75	3675	16	745R-2109		
200.0	21	60	5.20	0	14	745-200Q60-21M	60.0	C	101.6	215.2	63.0	12.0	6.31	3292	14	745R-2109	
	21	60	5.20	0	21	745-200Q60-21H	60.0	C	101.6	215.2	63.0	12.0	6.61	3292	21	745R-2109	
250.0	21	60	5.20	0	16	745-250Q60-21M	60.0	C	101.6	264.4	63.0	12.0	9.40	2998	16	745R-2109	
	21	60	5.20	0	26	745-250Q60-21H	60.0	C	101.6	264.4	63.0	12.0	9.00	2998	26	745R-2109	

Spare parts		
DC	Shower screw	Insert screw
63.00	5512 073-01	5513 020-80
80.00	5512 073-02	5513 020-80
100.00	5512 073-05	5513 020-80
125.00-160.00	5512 098-03	5513 020-80
250.00	-	5513 020-80

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I45



L2



M1



N23



N9

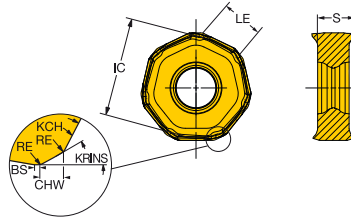
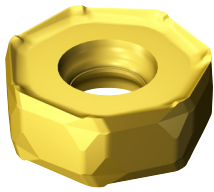


N15



# CoroMill® 745 insert for milling

KRINS 42°



		RE	KCH	CHW	Ordering code	P										M		K		S		Dimensions, mm					
						1130	4220	4230	4240	1040	2040	1020	3040	K20D	K20W	S30T	S40T	IC	LE	S	BS	BSR					
Medium	M30	21	1.00	17°	1.3	745R-2109E-M30	★	☆	★	☆					★	☆	☆	☆					21.0	8.9	9.00	0.3	25.0
		21	1.00			745R-2109E-M31	★	☆	★	☆	★	☆	☆	☆	☆	☆	☆	★	☆					21.0	7.1	9.00	1.9
	M50	21	1.00	17°	1.3	745R-2109E-M50	☆	☆	★	☆					★	☆	☆	☆					21.0	8.9	9.00	0.3	25.0
		21	1.00	17°	1.3	745L-2109E-M50			★							☆	☆	☆					21.0	8.5	9.00	0.3	25.0
Heavy	H50	21	1.00	17°	1.3	745R-2109E-H50		☆	★	☆					★	☆	☆						21.0	8.9	9.00	0.3	25.0

745R-2109E-M31 not recommended for CoroMill 745 high feed cutter with 25° entering angle.



117



1154



1175



N23



N10

# CoroMill® 360

## Heavy duty face mill

### ISO application area:



### Application

- Heavy duty face milling

### Benefits and features

- Exchangeable insert cassettes with serrated interfaces provide for safe, accurate location and easy handling
- Separate cassettes for each insert size for use in the same cutter body reduces down time and inventory
- Right- or left-hand tool design available
- Unique cassette solution



M

H



The unique cassette solution with wedge-clamped inserts gives high security and easy handling when indexing inserts. The same body is used for both cassette sizes. There is a separate wedge and cassette for respective insert size. When replacing ensure you have the correct size of each.



I21



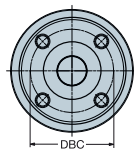
I22

# CoroMill® 360 face milling cutter

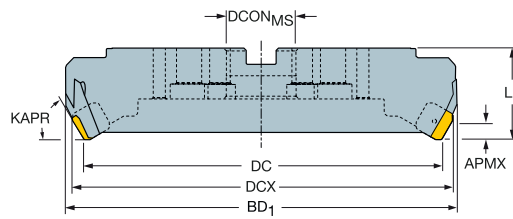
Arbor



STDNO  
KAPR



ISO6462  
60°



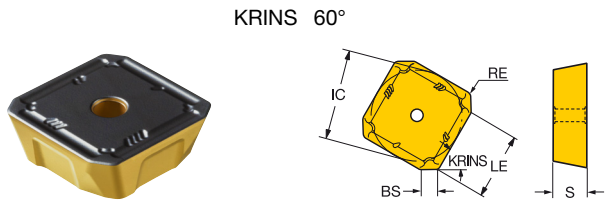
DC		CZC <sub>MS</sub>	APMX	ZADJ	Ordering code		Dimensions, mm										CICT	MID
DC	APMX	ZADJ	ZADJ	Ordering code	DCON <sub>MS</sub>	ISO	DBC	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MID		
160.0	19	40	13.0	6	6	360-160Q40-Z8D19	40.0	B	175.0	186.6	13.0	80.0	16.0	16.11	795	6	360R-1906	
	19	40	13.0	8	8	360-160Q40-Z8E19	40.0	B	175.0	186.6	13.0	80.0	16.0	10.66	795	8	360R-1906	
	28	40	18.0	8	8	360-160Q40-Z8E28	40.0	B	180.8	186.2	18.0	80.0	16.0	15.47	795	8	360R-2807	
200.0	19	60	13.0	8	8	360-200Q60-Z8D19	60.0	C	101.6	215.0	226.6	13.0	80.0	16.0	19.96	640	8	360R-1906
	19	60	13.0	10	10	360-200Q60-Z10E19	60.0	C	101.6	215.0	226.6	13.0	80.0	16.0	19.78	640	10	360R-1906
	28	60	18.0	10	10	360-200Q60-Z10E28	60.0	C	101.6	220.8	226.2	18.0	80.0	16.0	15.20	640	10	360R-2807
250.0	19	60	13.0	10	10	360-250Q60-Z10D19	60.0	C	101.6	265.0	276.6	13.0	80.0	16.0	26.77	510	10	360R-1906
	19	60	13.0	12	12	360-250Q60-Z12E19	60.0	C	101.6	265.0	276.6	13.0	80.0	16.0	27.00	510	12	360R-1906
	28	60	18.0	10	10	360-250Q60-Z10D28	60.0	C	101.6	270.8	276.2	18.0	80.0	16.0	26.50	510	10	360R-2807
	28	60	18.0	12	12	360-250Q60-Z12E28	60.0	C	101.6	270.8	276.2	18.0	80.0	16.0	26.13	510	12	360R-2807
315.0	19	60	13.0	12	12	360-315Q60-Z12D19	60.0	C	330.0	341.6	330.0	13.0	80.0	16.0	42.32	405	12	360R-1906
	28	60	18.0	12	12	360-315Q60-Z12D28	60.0	C	335.8	341.2	341.2	18.0	80.0	16.0	39.90	405	12	360R-2807
	28	60	18.0	15	15	360-315Q60-Z15E28	60.0	C	335.8	341.2	341.2	18.0	80.0	16.0	34.00	405	15	360R-2807
400.0	19	60	13.0	15	15	360-400Q60-Z15D19	60.0	C	415.0	426.6	426.6	13.0	80.0	16.0	60.00	320	15	360R-1906
	28	60	18.0	15	15	360-400Q60-Z15D28	60.0	C	420.8	426.2	426.2	18.0	80.0	16.0	58.00	320	15	360R-2807

Spare parts						
DC	APMX	Cassette	Insert wedge	Insert wedge screw	Cassette wedge	Cassette wedge screw
160.00-315.00	19	360R-CA-19	360R-IW-19	267.21-830	5431 105-08	5516 010-06
200.00-400.00	28	360R-CA-28	360R-IW-28	267.21-830	5431 105-08	5516 010-06

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 360 insert for milling



	SSC	RE	Ordering code	P						M		K		Dimensions, mm				
				4220	4330	4340	2030	2040	3040	3330	IC	LE	S	BS	BSR			
Heavy	KH	19	1.60	360R-19 06M-KH						☆	★			18.9	15.0	6.35	2.2	200.0
		28	1.70	360L-2807M-KH						★				28.5	20.0	7.94	4.6	200.0
		1.70	360R-28 07M-KH							☆	★			28.5	20.0	7.94	4.6	200.0
	MH	19	1.60	360L-1906M-MH						★				18.9	15.0	6.35	2.2	200.0
		1.60	360R-19 06M-MH					☆	★					18.9	15.0	6.35	2.2	200.0
		28	1.70	360L-2807M-MH						★				28.5	20.0	7.94	4.6	200.0
	PH	1.70	360R-28 07M-MH							★				28.5	20.0	7.94	4.6	200.0
		19	1.60	360L-1906M-PH		★								18.9	15.0	6.35	2.2	200.0
		1.60	360R-19 06M-PH	☆	★	☆								18.9	15.0	6.35	2.2	200.0
	28	1.70	360L-2807M-PH		★								28.5	20.0	7.94	4.6	200.0	
	1.70	360R-28 07M-PH	★	☆									28.5	20.0	7.94	4.6	200.0	



I21



I154



I175



N23



N10

# CoroMill® 365

Secure face milling in cast iron and steel

## ISO application area



## Application

- Face milling
- Roughing to semi-finishing

## Benefits and features

- Unique design with eight true cutting edges for high productivity machining to achieve low cost per component
- Multi-edge self-located insert provides robust and reliable machining
- Coromant Capto® coupling or Arbor mounted
- Through coolant design
- Geometry and grade laser marked on the insert for easy identification
- Wiper inserts for improved surface finish



CoroMill® 365 is the essential tool for rough to semi-finish face milling of cast iron and steel components. Use the tool for large series production and applications where high metal removal rate is critical.

## Inserts

- The tool design gives large support surface and optimal distribution of cutting forces.



I24



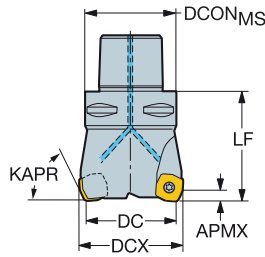
I26

# CoroMill® 365 face milling cutter

Coromant Capto®

Screw clamp design

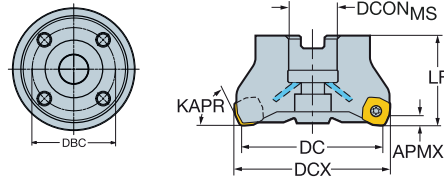
KAPR 65°



						Dimensions, mm								
DC	CZC <sub>MS</sub>	APMX	CNSC	Ordering code	DCON <sub>MS</sub>	DCX	LF	NM	KG	RPMX	CICT	MIID		
60.0	15	C6	6.0	3	5	R365-063C6-S15M	63.0	69.7	60.0	3.0	1.88	13600	5	R365-1505ZNE

Arbor  
Screw clamp design

STDNO  
KAPR ISO6462  
65°



						Dimensions, mm										
DC	CZC <sub>MS</sub>	APMX	CNSC	Ordering code	DCON <sub>MS</sub>	ISO	DBC	DCX	LF	NM	KG	RPMX	CICT	MIID		
50.0	15	22	6.0	1	5	R365-050Q22-S15H	22.0	A	56.7	50.0	3.0	0.68	15700	5	R365-1505ZNE	
63.0	15	22	6.0	1	5	R365-063Q22-S15M	22.0	A	69.7	50.0	3.0	1.00	13600	5	R365-1505ZNE	
15	22	6.0	1	6		R365-063Q22-S15H	22.0	A	69.7	50.0	3.0	0.98	13600	6	R365-1505ZNE	
80.0	15	27	6.0	1	6	R365-080Q27-S15M	27.0	A	86.7	50.0	3.0	1.70	11500	6	R365-1505ZNE	
15	27	6.0	1	8		R365-080Q27-S15H	27.0	A	86.7	50.0	3.0	1.68	11500	8	R365-1505ZNE	
100.0	15	32	6.0	1	7	R365-100Q32-S15M	32.0	A	106.7	50.0	3.0	2.20	9900	7	R365-1505ZNE	
15	32	6.0	1	10		R365-100Q32-S15H	32.0	A	106.7	50.0	3.0	2.20	9900	10	R365-1505ZNE	
125.0	15	40	6.0	1	8	R365-125Q40-S15M	40.0	B	131.7	63.0	3.0	3.94	8500	8	R365-1505ZNE	
15	40	6.0	1	12		R365-125Q40-S15H	40.0	B	131.7	63.0	3.0	3.87	8500	12	R365-1505ZNE	
160.0	15	40S	6.0	0	10	R365-160Q40-S15M	40.0	C	66.7	166.7	63.0	3.0	5.80	7500	10	R365-1505ZNE
15	40S	6.0	0	14		R365-160Q40-S15H	40.0	C	66.7	166.7	63.0	3.0	5.76	7500	14	R365-1505ZNE

Spare parts
Screw
5513 020-29

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 365 face milling cutter

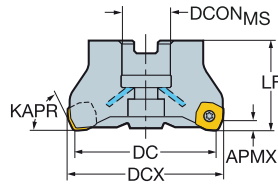
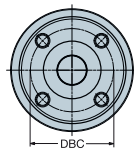
Arbor

Wedge clamp design



STDNO  
KAPR

ISO6462  
65°



					Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX	Ordering code	DCON <sub>MS</sub>	ISO	DBC	DCX	LF	NM	KG	RPMX	CICT	MIID	
80.0	15	27	R365-080Q27-W15H	27.0	A	86.7	86.7	50.0	6.0	1.79	11200	10	R365-1505ZNE	
	15	27	L365-080Q27-W15H	27.0	A	86.7	86.7	50.0	6.0	1.79	11200	10	L365-1505ZNE	
100.0	15	32	R365-100Q32-W15H	32.0	A	106.7	106.7	50.0	6.0	2.26	9900	14	R365-1505ZNE	
125.0	15	40	R365-125Q40-W15H	40.0	B	131.7	131.7	63.0	6.0	4.00	8800	18	R365-1505ZNE	
	15	40	L365-125Q40-W15H	40.0	B	131.7	131.7	63.0	6.0	4.00	8800	18	L365-1505ZNE	
160.0	15	40S	R365-160Q40-W15H	40.0	C	66.7	166.7	63.0	6.0	5.86	7700	22	R365-1505ZNE	
200.0	15	60	R365-200Q60-W15H	60.0	C	101.6	206.7	63.0	6.0	14.54	6800	28	R365-1505ZNE	
250.0	15	60	R365-250Q60-W15H	60.0	C	101.6	256.7	63.0	6.0	20.16	6100	36	R365-1505ZNE	

## Spare parts

Wedge screw	Wedge
339-831	5431 058-01

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I26



L2



N23



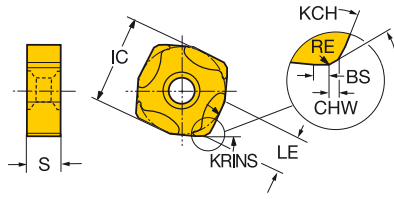
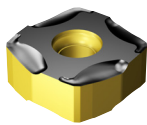
N15



N9

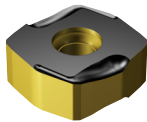
# CoroMill® 365 insert for milling

KRINS 65°

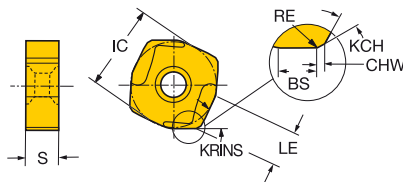


	RE	KCH	CHW	Ordering code	Dimensions, mm																	
					P	M	K	N	S	H	IC	LE	S	BS	BSR							
Light	KL	15	30°	0.7	L365-1505ZNE-KL	1130	4220	4330	1130	1020	3330	K200	K20W	1130	1130	1010	1130	15.0	6.4	5.66	1.5	150.0
		0.30	35°	0.7	R365-1505ZNE-KL	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	15.0	6.4	5.66	1.5	150.0
	PL	15	0.30	35°	0.7	R365-1505ZNE-PL	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	15.0	6.4	5.66	1.5	150.0
Medium	KM	15	0.30	35°	0.7	L365-1505ZNE-KM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	15.0	6.4	5.66	1.5	150.0
		0.30	35°	0.7	R365-1505ZNE-KM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	15.0	6.4	5.66	1.5	150.0
	PM	15	0.30	35°	0.7	R365-1505ZNE-PM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	15.0	6.4	5.66	1.5	150.0

KRINS 65°



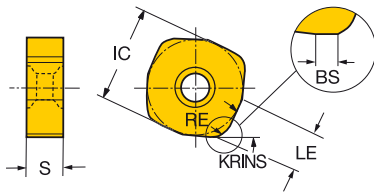
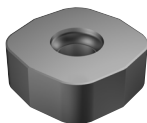
**Wiper** TECHNOLOGY



	RE	KCH	CHW	Ordering code	Dimensions, mm																
					P	M	K	H	IC	LE	S	BS	BSR								
Light	KW4	15	0.55	35°	0.8	N365-1505ZNE-KW4	1030	1130	1030	1130	1020	K20W	3220	3330	1030	1130	15.0	6.4	5.66	4.0	200.0
		0.20	35°	0.8	N365-1505ZNE-KW8	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	15.0	6.4	5.66	8.0	431.0
	PW4	15	0.55	35°	0.8	N365-1505ZNE-PW4	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	15.0	6.4	5.66	4.0	200.0
	PW8	15	0.20	35°	0.8	N365-1505ZNE-PW8	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	15.0	6.4	5.66	8.0	431.0

## Advanced cutting materials

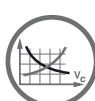
KRINS 65°



	RE	Ordering code	K		H		Dimensions, mm				
			6190	6190	IC	LE	S	BS	BSR		
Light	3.60	N365-1505ZNE	☆	☆	15.0	6.4	5.66	1.2	150.0		
			☆	☆							
Medium	3.60	N365-150536E	☆	☆	15.0	6.4	5.66				
			☆	☆							



I24



I154



I175























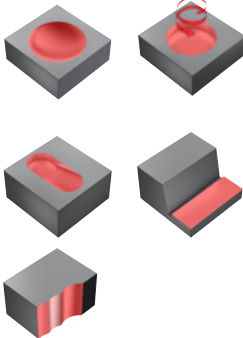
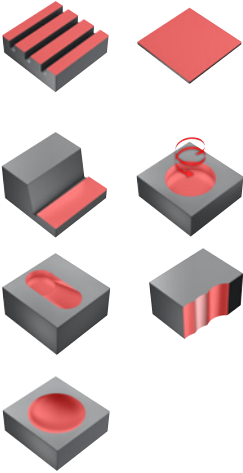
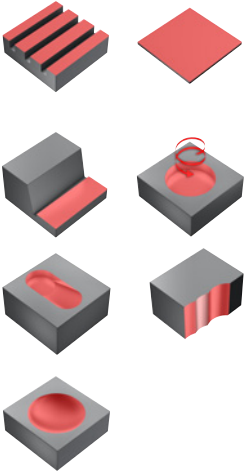

N23



N10



## High-feed milling tools

	CoroMill® 419	CoroMill® 210	CoroMill® 415	CoroMill® 745
Image				
Page	I29	I33	I38	I43
Material				
Main operation				
KAPR	19°	10°	15°	25°
DC mm	17.4 - 85.3	10.9 - 136	4.6 - 23.6	63 - 160
DCX mm	32.0 - 100.0	25 - 160	13 - 32	86.4 - 183.4
APMX mm	2	1.2 - 2	0.85 - 1.2	2.80
Insert				
Insert sizes	14	09 & 14	05 & 07	21
Couplings	Coromant Capto® Cylindrical shank Arbor	Coromant Capto® Cylindrical shank Arbor Threaded coupling Weldon	Cylindrical shank Coromant EH Threaded coupling	Coromant Capto® Arbor
Internal coolant				
Options			iLock	
Other operations				

# CoroMill® 419

## High-feed milling cutter

### Application

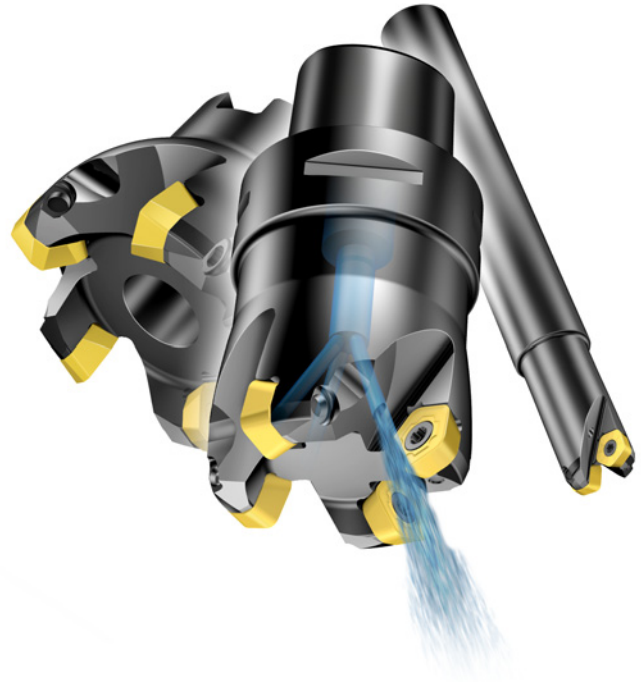
- High feed face milling
- Profiling
- Ramping
- Helical interpolation
- Machining of components requiring long overhangs
- Suitable for low-powered machines and weak fixtures
- Roughing to semi-finishing

### ISO application area:



### Benefits and features

- High productivity in applications requiring light cutting action
- Long tool life, especially in difficult-to-machine materials
- Strong and robust inserts for reliable machining
- Low power consumption
- Through coolant on all cutters enables efficient wet machining as well as compressed air cooling
- Reduced axial forces with a 19 degree entering angle and a positive axial inclination angle



[www.sandvik.coromant.com/coromill419](http://www.sandvik.coromant.com/coromill419)

### Couplings

- Coromant Capto®
- Arbor
- Cylindrical shank

### Inserts

- Five cutting edges
- Inserts with parallel land for high feed face filling and radius inserts for pocketing
- Wide range of grades and geometries

### L



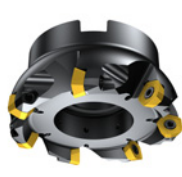
Coarse pitch

### M



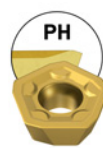
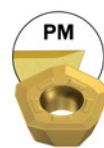
Close pitch

### H

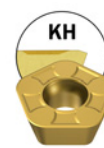


Extra close pitch

### Face milling



### Face and Profile Milling



I29



I31



N6

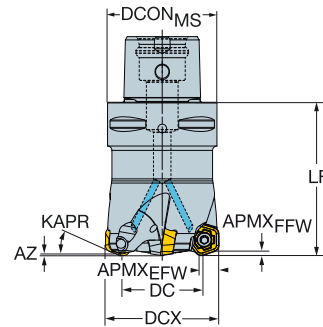
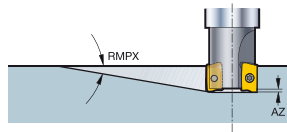
# CoroMill® 419 face milling cutter

Coromant Capto® - Internal coolant supply

High-feed milling cutter

KAPR

19°

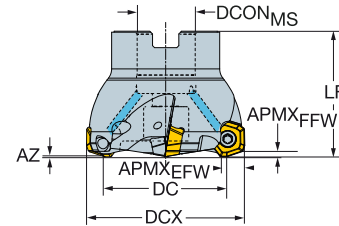
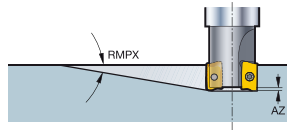


DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNCS	Ordering code	Dimensions, mm									
								DCX	LF	NM	KG	RPMX	CICT	MIID			
21.4	14	C3	8.0	2.00	9°	2.0	3	2	419-036C3-14L	32.0	36.0	50.0	5.0	0.36	22400	2	419R-1405
27.4	14	C4	8.0	2.00	8°	2.0	3	3	419-042C4-14M	40.0	42.0	70.0	5.0	0.62	19900	3	419R-1405
37.4	14	C5	8.0	2.00	8°	2.0	3	4	419-052C5-14M	50.0	52.0	70.0	5.0	1.08	17100	4	419R-1405
51.3	14	C6	8.0	2.00	6°	2.0	3	5	419-066C6-14M	63.0	66.0	70.0	5.0	1.73	14600	5	419R-1405
69.3	14	C8	8.0	2.00	5°	2.0	3	6	419-084C8-14H	80.0	84.0	70.0	5.0	3.02	12600	6	419R-1405

## Arbor - Internal coolant supply

STDNO  
KAPR

ISO 6462  
19°



DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNCS	Ordering code	Dimensions, mm										
								DCX	ISO	LF	NM	KG	RPMX	CICT	MIID			
29.4	14	16	8.0	2.00	8°	2.0	1	3	419-044Q16-14M	16.0	A	44.0	45.0	5.0	0.37	19300	3	419R-1405
35.4	14	22	8.0	2.00	8°	2.0	1	4	419-050Q22-14M	22.0	A	50.0	45.0	5.0	0.43	17600	4	419R-1405
37.4	14	22	8.0	2.00	8°	2.0	1	5	419-052Q22-14H	22.0	A	52.0	45.0	5.0	0.50	17100	5	419R-1405
39.4	14	22	8.0	2.00	8°	2.0	1	4	419-054Q22-14M	22.0	A	54.0	45.0	5.0	0.47	16800	4	419R-1405
	14	22	8.0	2.00	8°	2.0	1	5	419-054Q22-14H	22.0	A	54.0	45.0	5.0	0.47	16800	5	419R-1405
48.3	14	22	8.0	2.00	7°	2.0	1	4	419-063Q22-14L	22.0	A	63.0	50.0	5.0	0.63	15100	4	419R-1405
	14	22	8.0	2.00	7°	2.0	1	5	419-063Q22-14M	22.0	A	63.0	50.0	5.0	0.58	15100	5	419R-1405
51.3	14	22	8.0	2.00	6°	2.0	1	5	419-066Q22-14M	22.0	A	66.0	50.0	5.0	0.66	14600	5	419R-1405
	14	22	8.0	2.00	6°	2.0	1	6	419-066Q22-14H	22.0	A	66.0	50.0	5.0	0.65	14600	6	419R-1405
65.3	14	27	8.0	2.00	5°	2.0	1	5	419-080Q27-14M	27.0	A	80.0	50.0	5.0	1.07	13000	5	419R-1405
	14	27	8.0	2.00	5°	2.0	1	6	419-080Q27-14H	27.0	A	80.0	50.0	5.0	1.06	13000	6	419R-1405
69.3	14	27	8.0	2.00	5°	2.0	1	6	419-084Q27-14M	27.0	A	84.0	50.0	5.0	1.12	12600	6	419R-1405
	14	27	8.0	2.00	5°	2.0	1	7	419-084Q27-14H	27.0	A	84.0	50.0	5.0	1.15	12600	7	419R-1405
85.3	14	32	8.0	2.00	0°	2.0	1	6	419-100Q32-14M	32.0	B	100.0	50.0	5.0	1.68	11400	6	419R-1405
	14	32	8.0	2.00	0°	2.0	1	7	419-100Q32-14H	32.0	B	100.0	50.0	5.0	1.69	11400	7	419R-1405

Spare parts
Insert screw 5513 020-78

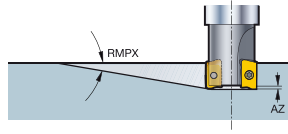
For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 419 face milling cutter

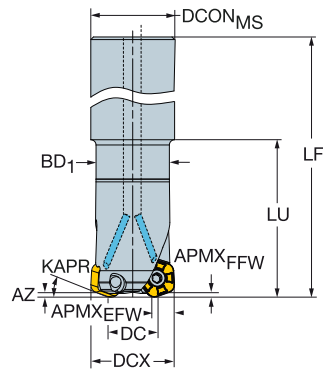
Cylindrical shank - Internal coolant supply

High-feed milling cutter



KAPR

19°



Dimensions, mm

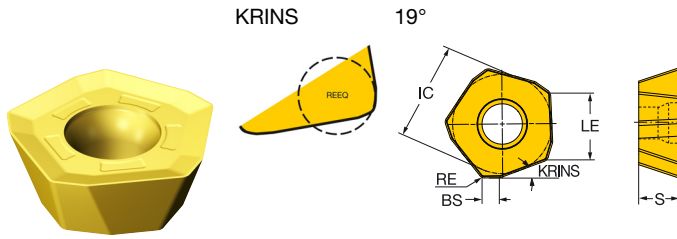
DC	CZC <sub>MS</sub>	APM <sub>EFW</sub>	APM <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code	DCON <sub>MS</sub>	DCX	BD	LB	LF	LU	NM	KG	RPMX	CICT	MIID
17.4	14	32	8.0	2.00	10°	2	419-032A32L-14L	32.0	32.0	28.0	57.0	250.0	60.0	5.0	1.40	24700	2	419R-1405
25.4	14	32	8.0	2.00	8°	3	419-040A32L-14M	32.0	40.0	28.0		250.0		5.0	1.50	20600	3	419R-1405

Spare parts
Insert screw
5513 020-78

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



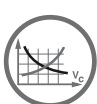
# CoroMill® 419 insert for milling



		RE	Ordering code	P		M		K		N		S		H		Dimensions, mm						
				1130	4220	4330	4340	1040	1130	2040	1020	3040	3330	1130	1130	S30T	S40T	1010	1130	IC	LE	S
Medium	MM	14	0.80	419R-1405E-MM	★	★	★	☆	☆			☆	☆	★	☆	★	☆	13.5	9.0	5.47	2.0	4.50
	PM	14	0.80	419R-1405M-PM	★	☆	★	★	☆	☆	★	☆	☆	★	☆	☆	☆	13.5	9.0	5.47	2.0	4.50
	SM	14	3.00	419N-140530E-SM	★		★	★	☆	☆			☆	☆	★	☆	☆	13.5	9.0	5.47		4.50
Heavy	KH	14	3.00	419N-140530M-KH		☆	★			☆	★	★						13.5	9.0	5.47		4.50
	PH	14	0.80	419R-1405M-PH			☆	★				★				★		13.5	9.0	5.47	2.0	4.50



I29



I154



I175



N23



N10

# CoroMill® 210

## High feed face and plunge milling

### Application

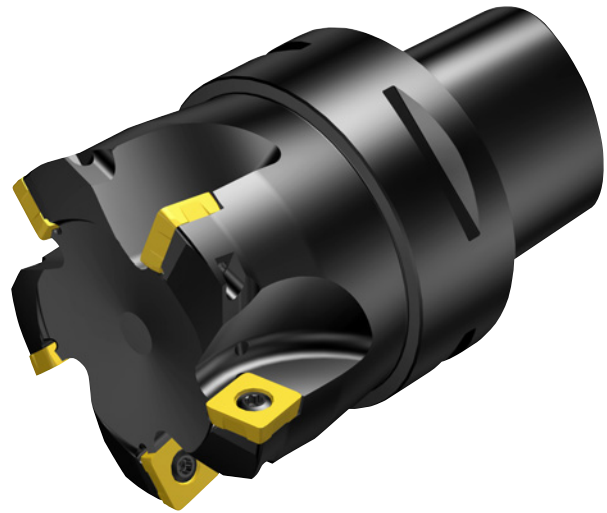
- High feed face milling
- Plunge milling
- Ramping
- Roughing to semi-finishing
- Helical interpolation
- Profiling

### ISO application area:



### Benefits and features

- High table feed due to the chip thinning effect – high productivity
- First choice face milling cutter in long overhang machining
- Multipurpose tool. Face milling, boring possibilities, ramping and plunge milling
- Internal coolant



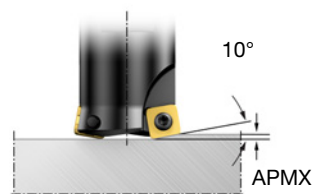
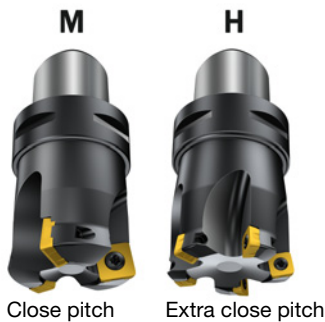
[www.sandvik.coromant.com/coromill210](http://www.sandvik.coromant.com/coromill210)

### Couplings

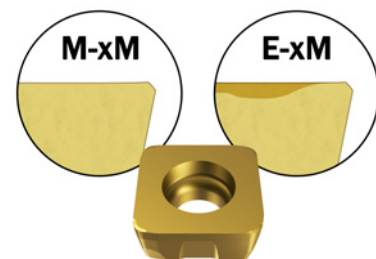
- Coromant Capto®
- Arbor
- Cylindrical shank
- Threaded coupling

### Inserts

- Four cutting edges
- Insert geometries and grades for all materials apart from ISO N
- E-xM geometry for excellent performance in titanium



The 10 degree entering angle allows extreme feed rates when face milling.



Recommended feed per tooth ( $f_z$ ) 1.5 mm for size 09 inserts and 2 mm feed per tooth ( $f_z$ ) for size 14 inserts.



I33

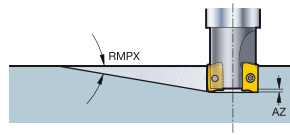


I36

# CoroMill® 210 face milling cutter

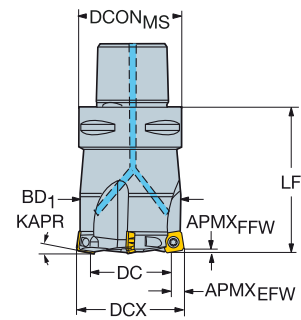
Coromant Capto® - Internal coolant supply

High-feed milling cutter



KAPR

10°



											Dimensions, mm								
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	BD	LF	NM	KG	RPMX	CICT	MIID		
21.9	09	C3	8.0	1.20	7°	1.8	3	2	R210-036C3-09M	32.0	36.0	33.0	50.0	3.0	0.44	30900	2	R210-090412M-	
	09	C3	8.0	1.20	7°	1.8	3	3	R210-036C3-09H	32.0	36.0	33.0	50.0	3.0	0.37	30900	3	R210-090412M-	
27.9	09	C4	8.0	1.20	5°	1.8	3	3	R210-042C4-09M	40.0	42.0	39.0	60.0	3.0	0.79	27600	3	R210-090412M-	
	09	C4	8.0	1.20	5°	1.8	3	4	R210-042C4-09H	40.0	42.0	39.0	60.0	3.0	0.60	27600	4	R210-090412M-	
28.0	14	C5	13.0	2.00	5°	2.0	3	3	R210-052C5-14M	50.0	52.0	47.7	70.0	5.0	1.21	20800	3	R210-140512M-	
	14	C5	13.0	2.00	3°	2.0	3	4	R210-052C5-14H	50.0	52.0	47.7	70.0	5.0	1.21	20800	4	R210-140512M-	
30.0	14	C5	13.0	2.00	5°	2.0	3	4	R210-054C5-14H	50.0	54.0	49.7	70.0	5.0	1.35	23600	4	R210-140512M-	
37.9	09	C5	8.0	1.20	3°	1.8	3	4	R210-052C5-09M	50.0	52.0	49.0	70.0	3.0	1.26	24000	4	R210-090412M-	
	09	C5	8.0	1.20	3°	1.8	3	5	R210-052C5-09H	50.0	52.0	49.0	70.0	3.0	1.20	24000	5	R210-090412M-	
39.9	09	C5	8.0	1.20	3°	1.8	3	5	R210-054C5-09H	50.0	54.0	51.0	70.0	3.0	1.15	23600	5	R210-090412M-	
42.0	14	C6	13.0	2.00	3°	2.0	3	4	R210-066C6-14M	63.0	66.0	61.7	72.0	5.0	2.02	17700	4	R210-140512M-	
	14	C6	13.0	2.00	3°	2.0	3	5	R210-066C6-14H	63.0	66.0	61.7	72.0	5.0	2.03	17700	5	R210-140512M-	
51.9	09	C6	8.0	1.20	2°	1.8	3	6	R210-066C6-09M	63.0	66.0	63.0	72.0	3.0	2.05	21300	6	R210-090412M-	
58.0	14	C8	13.0	2.00	2°	2.0	3	5	R210-082C8-14M	80.0	82.0	77.7	80.0	5.0	3.50	15100	5	R210-140512M-	
	14	C8	13.0	2.00	2°	2.0	3	6	R210-082C8-14H	80.0	82.0	77.7	80.0	5.0	3.46	15100	6	R210-140512M-	
62.0	14	C8	13.0	2.00	2°	2.0	3	6	R210-086C8-14H	80.0	86.0	81.7	80.0	5.0	3.67	14700	6	R210-140512M-	

Spare parts	
	Insert screw
09	5513 020-02
14	5513 020-50

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



136



L2



N23



N9



N15

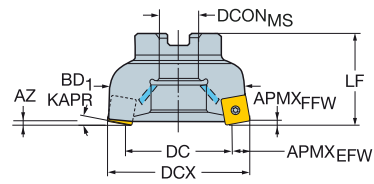
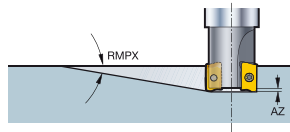
# CoroMill® 210 face milling cutter

Arbor - Internal coolant supply

High-feed milling cutter

STDNO  
KAPR

ISO6462  
10°



										Dimensions, mm									
DC	CZC <sub>MS</sub>	APM <sub>XEFW</sub>	APM <sub>XFFW</sub>	RMPX	AZ	CNSC	Ordering code		DCON <sub>MS</sub>	ISO	DCX	BD	LF	NM	KG	RPMX	CICT	MIID	
35.9	09	22	8.0	1.20	3°	1.8	1	4	R210-050Q22-09M	22.0	A	50.0	47.0	50.0	3.0	0.43	24500	4	R210-090412M-
	09	22	8.0	1.20	3°	1.8	1	5	R210-050Q22-09H	22.0	A	50.0	47.0	50.0	3.0	0.63	24500	5	R210-090412M-
39.0	14	22	13.0	2.00	3°	2.0	1	4	R210-063Q22-14M	22.0	A	63.0	58.7	50.0	5.0	0.76	18300	4	R210-140512M-
	14	27	13.0	2.00	3°	2.0	1	4	R210-063Q27-14M	27.0	A	63.0	58.7	50.0	5.0	0.81	18300	4	R210-140512M-
	14	22	13.0	2.00	3°	2.0	1	5	R210-063Q22-14H	22.0	A	63.0	58.7	50.0	5.0	0.50	18300	5	R210-140512M-
48.9	09	22	8.0	1.20	2°	1.8	1	5	R210-063Q22-09M	22.0	A	63.0	60.0	50.0	3.0	0.85	21800	5	R210-090412M-
	09	27	8.0	1.20	2°	1.8	1	5	R210-063Q27-09M	27.0	A	63.0	60.0	50.0	3.0	1.05	21800	5	R210-090412M-
	09	22	8.0	1.20	2°	1.8	1	6	R210-063Q22-09H	22.0	A	63.0	60.0	50.0	3.0	0.81	21800	6	R210-090412M-
56.0	14	27	13.0	2.00	2°	2.0	1	5	R210-080Q27-14M	27.0	A	80.0	75.7	50.0	5.0	1.10	15400	5	R210-140512M-
	14	27	13.0	2.00	2°	2.0	1	6	R210-080Q27-14H	27.0	A	80.0	75.7	50.0	5.0	1.20	15400	6	R210-140512M-
76.0	14	32	13.0	2.00	1°	2.0	1	6	R210-100Q32-14M	32.0	B	100.0	95.7	50.0	5.0	1.85	13400	6	R210-140512M-
	14	32	13.0	2.00	1°	2.0	1	7	R210-100Q32-14H	32.0	B	100.0	95.7	50.0	5.0	1.92	13400	7	R210-140512M-
101.0	14	40	13.0	2.00	1°	2.0	1	7	R210-125Q40-14M	40.0	B	125.0	120.7	63.0	5.0	3.83	11400	7	R210-140512M-
136.0	14	40	13.0	2.00	1°	2.0	1	8	R210-160Q40-14M	40.0	B	160.0	155.7	63.0	5.0	5.78	10400	8	R210-140512M-

Spare parts	
	Insert screw
09	5513 020-02
14	5513 020-50

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I36



L2



M1



N23



N9



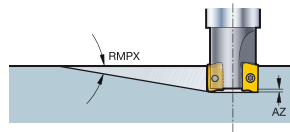
N15



# CoroMill® 210 face milling cutter

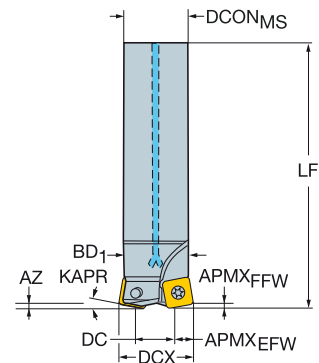
Cylindrical shank - Internal coolant supply

High-feed milling cutter



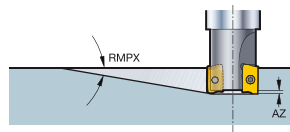
KAPR

10°



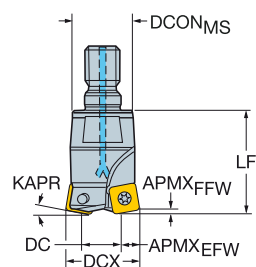
										Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID	
10.9	09	20	8.0	1.20	14°	1.8	1	2	R210-025A20-09M	20.0	25.0	22.0	35.0	180.0	3.0	0.54	17200	2	R210-090412M-
17.9	09	25	8.0	1.20	8°	1.8	1	2	R210-032A25-09M	25.0	32.0	29.0	45.0	210.0	3.0	0.88	11000	2	R210-090412M-
	09	25	8.0	1.20	8°	1.8	1	3	R210-032A25-09H	25.0	32.0	29.0	45.0	210.0	3.0	0.50	11000	3	R210-090412M-
20.9	09	32	8.0	1.20	7°	1.8	1	3	R210-035A32-09H	32.0	35.0	32.0	45.0	210.0	3.0	1.30	11000	3	R210-090412M-
27.9	09	32	8.0	1.20	5°	1.8	1	3	R210-042A32-09M	32.0	42.0	39.0	50.0	250.0	3.0	1.83	8000	3	R210-090412M-
	09	32	8.0	1.20	5°	1.8	1	4	R210-042A32-09H	32.0	42.0	39.0	50.0	250.0	3.0	1.77	8000	4	R210-090412M-

## Threaded coupling - Internal coolant supply



KAPR

10°



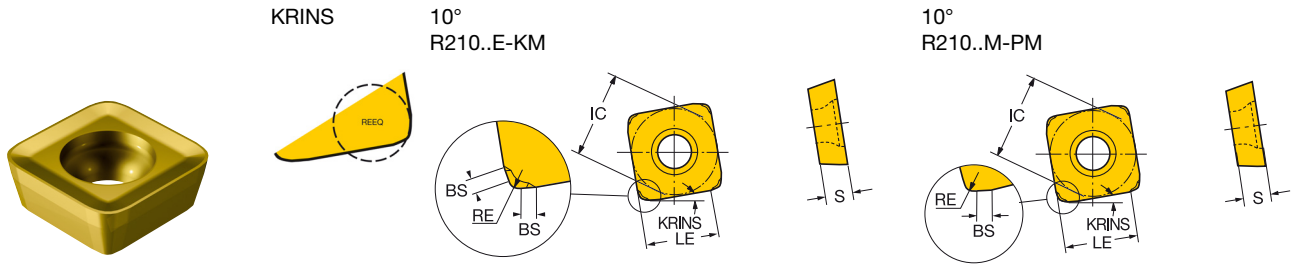
										Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	BD	LF	NM	KG	RPMX	CICT	MIID		
10.9	09	M12	8.0	1.20	14°	1.8	1	2	R210-025T12-09M	20.8	25.0	22.0	35.0	3.0	0.24	15000	2	R210-090412M-	
17.9	09	M16	8.0	1.20	8°	1.8	1	2	R210-032T16-09M	28.8	32.0	29.0	45.0	3.0	0.36	15000	2	R210-090412M-	
20.9	09	M16	8.0	1.20	7°	1.8	1	3	R210-035T16-09H	28.8	35.0	32.0	50.0	3.0	0.37	15000	3	R210-090412M-	
27.9	09	M16	8.0	1.20	5°	1.8	1	4	R210-042T16-09H	28.8	42.0	39.0	50.0	3.0	0.44	15000	4	R210-090412M-	

Spare parts
Insert screw 5513 020-02

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



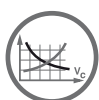
# CoroMill® 210 insert for milling



		RE	Ordering code	Dimensions, mm																				
				P			M		K		N	S		H										
				1130	4220	4330	4340	1040	1130	2040	1020	3040	3330	1130	1130	S30T	S40T	1010	1130	IC	LE	S	BS	BSR
Medium	KM	09	1.00	R210-09 04 12M-KM															9.4	6.2	4.00	0.8		2.50
		1.40	R210-09 04 14E-KM							*	*	*							9.5	5.7	4.50	0.7	50.0	2.50
		14	1.00	R210-14 05 12M-KM															14.5	11.3	4.76	0.8		3.50
		1.40	R210-14 05 14E-KM							*	*	*							14.6	10.8	5.26	0.7	50.0	3.50
		09	1.00	R210-09 04 12M-MM					*	*	*								9.4	6.2	4.00	0.8		2.50
		1.40	R210-09 04 14E-MM					*	*	*									9.5	5.7	4.50	0.7	50.0	2.50
	MM	14	1.00	R210-14 05 12M-MM					*	*	*								14.5	11.3	4.76	0.8		3.50
		1.40	R210-14 05 14E-MM					*	*	*									14.6	10.8	5.26	0.7	50.0	3.50
		09	1.00	R210-09 04 12M-PM	*	*	*	*	*	*	*		*	*	*	*	*	*	9.4	6.2	4.00	0.8		2.50
		1.40	R210-09 04 14E-PM	*	*	*	*	*	*	*	*		*	*	*	*	*	*	9.5	5.7	4.50	0.7	50.0	2.50
		14	1.00	R210-14 05 12M-PM	*	*	*	*	*	*	*		*	*	*	*	*	*	14.5	11.3	4.76	0.8		3.50
		1.40	R210-14 05 14E-PM	*	*	*	*	*	*	*	*		*	*	*	*	*	*	14.6	10.8	5.26	0.7	50.0	3.50



I33



I154



I175



N23



N10

# CoroMill® 415

Small diameter, high feed face milling cutter

## Application

- High feed face milling
- Plunge milling
- Ramping
- Roughing to semi-finishing
- Helical interpolation
- Profiling

## ISO application area:



## Benefits and features

- Versatile tool suitable for a wide range of applications
- Coolant channels for optimized chip evacuation
- Can be combined with the Coromant EH coupling and Silent Tools™ damped adaptors for vibration-free machining, high reliability and a significant productivity gain
- Unique iLock™ insert seat interface resulting in less scrap workpieces. The iLock™ insert seat also makes the small inserts easier to handle
- Tailor made options available



[www.sandvik.coromant.com/coromill415](http://www.sandvik.coromant.com/coromill415)

## Couplings

- Cylindrical shank
- Coromant EH
- Threaded coupling

## Inserts

- Four cutting edges
- The unique iLock™ solution provides easy and accurate insert indexing, increased reliability and considerably improved tool life



I38

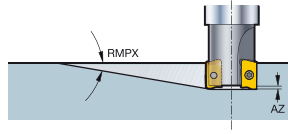


I41

# CoroMill® 415 face milling cutter

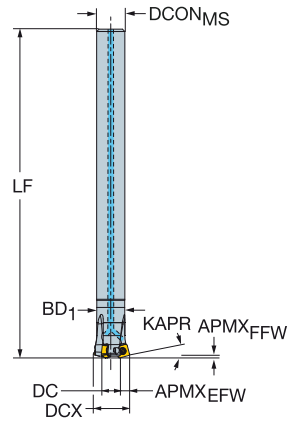
Cylindrical shank - Internal coolant supply

High-feed milling cutter



KAPR

15°



								Dimensions, mm											
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID		
4.6	05	12	3.0	0.85	0.85°	1	2	415-013A12-05H	12.0	13.0	11.0	15.0	140.0	0.6	0.16	23600	2	415N-050206M	
7.6	05	12	3.0	0.85	0.97°	1	3	415-016A12-05H	12.0	16.0	12.0	15.0	140.0	0.6	0.16	21300	3	415N-050206M	
11.6	05	16	3.0	0.85	0.62°	1	3	415-020A16-05L	16.0	20.0	16.0	15.0	200.0	0.6	0.37	19000	3	415N-050206M	
	05	16	3.0	0.85	0.62°	1	4	415-020A16-05M	16.0	20.0	16.0	15.0	200.0	0.6	0.33	19000	4	415N-050206M	
	05	16	3.0	0.85	0.62°	1	5	415-020A16-05H	16.0	20.0	16.0	15.0	200.0	0.6	0.27	19000	5	415N-050206M	
13.5	07	20	4.5	1.20	0.61°	1	4	415-025A20-07H	20.0	25.0	19.0	15.0	200.0	1.2	0.50	15700	4	415N-070310M	
16.6	05	20	3.0	0.85	0.64°	1	5	415-025A20-05M	20.0	25.0	21.0	15.0	200.0	0.6	0.50	17000	5	415N-050206M	
20.5	07	25	4.5	1.20	0.63°	1	5	415-032A25-07H	25.0	32.0	26.0	15.0	250.0	1.2	0.95	13900	5	415N-070310M	

Spare parts	
	Insert screw
05	5513 020-28
07	5513 020-56

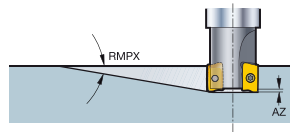
For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 415 face milling cutter

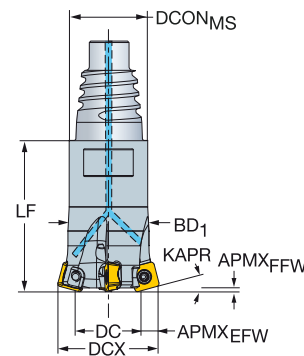
Coromant EH - Internal coolant supply

High-feed milling cutter



KAPR

15°



								Dimensions, mm												
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID			
4.6	05	E12	3.0	0.85	0.85°	1 2	415-13EH12-05H	11.7	13.0	11.0	10.0	25.0	0.6	0.14	23600	2	415N-050206M			
7.6	05	E16	3.0	0.85	0.97°	1 3	415-16EH16-05H	15.5	16.0	12.0	12.0	30.0	0.6	0.06	21300	3	415N-050206M			
8.6	07	E16	4.5	1.20	0.56°	1 2	415-20EH16-07H	15.5	20.0	14.0	12.0	35.0	1.2	0.17	17500	2	415N-070310M			
	07	E20	4.5	1.20	0.56°	1 2	415-20EH20-07H	19.3	20.0	14.0	15.0	35.0	1.2	0.13	17500	2	415N-070310M			
11.6	05	E16	3.0	0.85	0.62°	1 4	415-20EH16-05M	15.5	20.0	16.0	12.0	30.0	0.6	0.05	19000	4	415N-050206M			
	05	E20	3.0	0.85	0.62°	1 4	415-20EH20-05M	19.3	20.0	16.0	13.0	32.0	0.6	0.07	19000	4	415N-050206M			
	05	E16	3.0	0.85	0.62°	1 5	415-20EH16-05H	15.5	20.0	16.0	12.0	30.0	0.6	0.16	19000	5	415N-050206M			
	05	E20	3.0	0.85	0.62°	1 5	415-20EH20-05H	19.3	20.0	16.0	13.0	32.0	0.6	0.19	19000	5	415N-050206M			
13.5	07	E20	4.5	1.20	0.61°	1 3	415-25EH20-07M	19.3	25.0	19.0	15.0	35.0	1.2	0.08	15700	3	415N-070310M			
	07	E25	4.5	1.20	0.61°	1 3	415-25EH25-07M	24.2	25.0	19.0	18.0	40.0	1.2	0.12	15700	3	415N-070310M			
	07	E20	4.5	1.20	0.61°	1 4	415-25EH20-07H	19.3	25.0	19.0	15.0	35.0	1.2	0.20	15700	4	415N-070310M			
	07	E25	4.5	1.20	0.61°	1 4	415-25EH25-07H	24.2	25.0	19.0	18.0	40.0	1.2	0.18	15700	4	415N-070310M			
16.6	05	E20	3.0	0.85	0.64°	1 5	415-25EH20-05M	19.3	25.0	21.0	13.0	32.0	0.6	0.08	17000	5	415N-050206M			
	05	E25	3.0	0.85	0.64°	1 5	415-25EH25-05M	24.2	25.0	21.0	15.0	35.0	0.6	0.12	17000	5	415N-050206M			
	05	E20	3.0	0.85	0.64°	1 6	415-25EH20-05H	19.3	25.0	21.0	13.0	32.0	0.6	0.20	17000	6	415N-050206M			
	05	E25	3.0	0.85	0.64°	1 6	415-25EH25-05H	24.2	25.0	21.0	15.0	35.0	0.6	0.24	17000	6	415N-050206M			
20.5	07	E25	4.5	1.20	0.63°	1 4	415-32EH25-07M	24.2	32.0	26.0	18.0	40.0	1.2	0.19	13900	4	415N-070310M			
	07	E25	4.5	1.20	0.63°	1 5	415-32EH25-07H	24.2	32.0	26.0	18.0	40.0	1.2	0.16	13900	5	415N-070310M			
23.6	05	E25	3.0	0.85	0.65°	1 7	415-32EH25-05H	24.2	32.0	28.0	15.0	35.0	0.6	0.16	15000	7	415N-050206M			

Spare parts	
	Insert screw
05	5513 020-28
07	5513 020-56

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



141



L2



N23



N9



N15

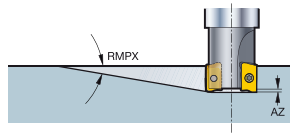


N3

# CoroMill® 415 face milling cutter

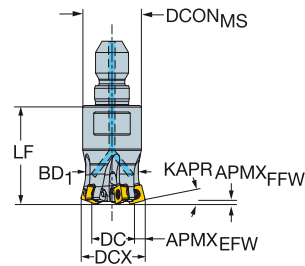
Threaded coupling - Internal coolant supply

High-feed milling cutter



KAPR

15°



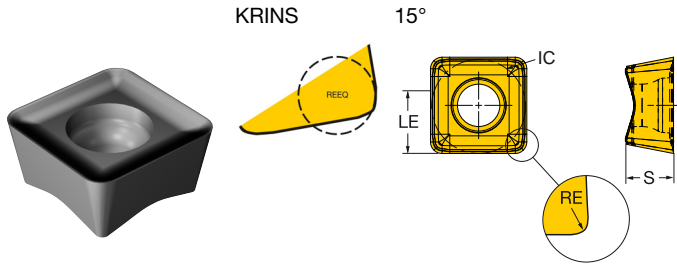
								Dimensions, mm											
DC	CZC <sub>MS</sub>	APM <sub>EFW</sub>	APM <sub>FFW</sub>	RMPX	CNSC	Ordering code	DCON <sub>MS</sub>	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID			
4.6	05	M8	3.0	0.85	0.85°	1 2	415-13T08-05H	12.8	13.0	11.0	10.0	25.0	0.6	0.02	23600	2	415N-050206M		
7.6	05	M8	3.0	0.85	0.97°	1 3	415-16T08-05H	12.8	16.0	12.0	10.0	25.0	0.6	0.03	21300	3	415N-050206M		
11.6	05	M10	3.0	0.85	0.62°	1 5	415-20T10-05H	17.8	20.0	16.0	12.0	30.0	0.6	0.05	19000	5	415N-050206M		
13.5	07	M12	4.5	1.20	0.61°	1 4	415-25T12-07H	20.8	25.0	19.0	15.0	38.0	1.2	0.09	15700	4	415N-070310M		
16.6	05	M12	3.0	0.85	0.64°	1 6	415-25T12-05H	20.8	25.0	21.0	15.0	35.0	0.6	0.10	17000	6	415N-050206M		
20.5	07	M16	4.5	1.20	0.63°	1 5	415-32T16-07H	28.8	32.0	26.0	15.0	40.0	1.2	0.19	13900	5	415N-070310M		

Spare parts	
	Insert screw
05	5513 020-28
07	5513 020-56

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 415 insert for milling



		RE	Ordering code	P M S H								Dimensions, mm						
				P		M		S		H		IC	LE	S	REEQ			
				T130	4340	T040	T130	T130	H13A	S30T	S40T	T010	T130					
Medium	M30	05	0.60	415N-05 02 06M-M30	★	☆	★	★	☆	☆	★	★	★	☆	5.0	3.8	2.21	1.50
		05	1.20	415N-05 02 12E-M30	★	★	★	★	☆	☆	★	★	★	☆	5.0	3.0	2.21	2.00
		05	1.20	415N-05 02 12M-M30	★	★	★	★	☆	☆	★	★	★	☆	5.0	3.0	2.21	2.00
		07	1.00	415N-07 03 10M-M30	★	☆	★	★	☆	☆	★	★	★	☆	7.0	5.0	3.07	2.20
		07	2.00	415N-07 03 20E-M30	★	★	★	★	☆	☆	★	★	★	☆	7.0	3.0	3.07	2.20
		07	2.00	415N-07 03 20M-M30	★	★	★	★	☆	☆	★	★	★	☆	7.0	3.0	3.07	2.80

415N-05 02 12M-M30 increases DC by 1.0 mm and reduces DCX by 0.26 mm and LF by 0.13 mm  
 415N-07 03 20M-M30 increases DC by 1.7 mm and reduces DCX by 0.44 mm and LF by 0.22 mm  
 (In comparison to using the tool with MIID)



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1154



1175



N23



N10

# CoroMill® 745

Multi-edge face milling and high feed milling concepts

## Application

- Face milling
- Roughing to semi-finishing
- High feed milling

## ISO application area:



## Benefits and features

- Multi-edge concept suitable for large batch productions, flexible transfer lines and when maximum tool utilization is important
- CoroMill 745 with 42° entering angle is used in ISO P, K, M and S applications where APMX is 5.2 mm
- CoroMill 745 high feed cutter with 25° entering angle is used as a productivity booster in ISO P and ISO K applications where APMX is 2.8 mm
- Great problem-solving abilities when machining vibration-sensitive components and in weak set-ups with the unique differential MD pitch



CoroMill® 745 face milling cutter See page I17

CoroMill® 745 high feed face milling cutter See page I43

[www.sandvik.coromant.com/coromill745](http://www.sandvik.coromant.com/coromill745)

## Couplings

- Coromant Capto®
- Arbor

## Inserts

- 14 cutting edges
- The secure tip seat and the large, robust insert with strong, light-cutting geometries are designed for reliable and predictable machining.

## Ground-breaking technology

Available with 42° entering angle for larger cutting depths and as a high feed version with 25° entering angle for an even higher metal removal rate. Same inserts are used in both cutters.



## Differential MD pitch

The unique differential MD pitch is first choice in roughing operations where light cutting action is required, e.g. in vibration-sensitive and weak set-ups. It is a perfect problem-solver when vibration is a limitation in the production. The length and weight of the cutter body has been reduced in order to boost the performance in low-productive applications. The cutter has a logarithmic differential pitch design, and the insert position is radially compensated to produce an even chip load on every insert.



I43



I45



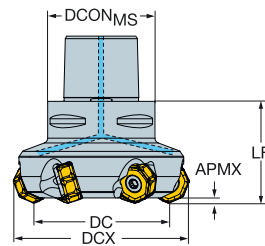
# CoroMill® 745 face milling cutter





Coromant Capto® - Internal coolant supply

High-feed milling cutter

KAPR

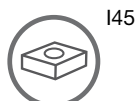
25°



						Dimensions, mm								
DC		CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC		Ordering code	DCON <sub>MS</sub>	DCX	LF			RPMX	CICT	MIID
63.0	21	C5	2.80	3	5	725-063C5-21M	50.0	86.4	60.0	12.0	1.30	5894	5	745R-2109
	21	C6	2.80	3	5	725-063C6-21M	63.0	86.4	60.0	12.0	1.70	5894	5	745R-2109
	21	C5	2.80	3	7	725-063C5-21H	50.0	86.4	60.0	12.0	1.20	5894	7	745R-2109
	21	C6	2.80	3	7	725-063C6-21H	63.0	86.4	60.0	12.0	1.60	5894	7	745R-2109
80.0	21	C6	2.80	3	5	725-080C6-21M	63.0	103.4	65.0	12.0	2.06	5324	5	745R-2109
	21	C8	2.80	3	6	725-080C8-21M	80.0	103.4	65.0	12.0	3.04	5324	6	745R-2109
	21	C6	2.80	3	9	725-080C6-21H	63.0	103.4	65.0	12.0	1.93	5324	9	745R-2109
	21	C8	2.80	3	9	725-080C8-21H	80.0	103.4	65.0	12.0	2.91	5324	9	745R-2109
100.0	21	C8	2.80	3	7	725-100C8-21M	80.0	123.4	65.0	12.0	3.67	4765	7	745R-2109
	21	C8	2.80	3	11	725-100C8-21H	80.0	123.4	65.0	12.0	3.49	4765	11	745R-2109

Spare parts
Insert screw
5513 020-80

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I45



L2



N23



N9



N15

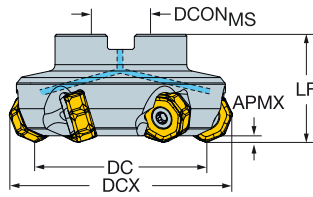
# CoroMill® 745 face milling cutter

Arbor - Internal coolant supply

High-feed milling cutter

STDNO  
KAPR

ISO 6462  
25°



						Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ISO	DCX	LF	NM	KG	RPMX	CICT	MIID		
63.0	21	22	2.80	3 5	725-063Q22-21M	22.0	A	86.4	50.0	12.0	0.90	5894	5	745R-2109	
	21	22	2.80	3 7	725-063Q22-21H	22.0	A	86.4	50.0	12.0	0.81	5894	7	745R-2109	
80.0	21	27	2.80	3 6	725-080Q27-21M	27.0	A	103.4	50.0	12.0	1.36	5324	6	745R-2109	
	21	27	2.80	3 9	725-080Q27-21H	27.0	A	103.4	50.0	12.0	1.23	5324	9	745R-2109	
100.0	21	32	2.80	3 7	725-100Q32-21M	32.0	A	123.4	50.0	12.0	2.33	4765	7	745R-2109	
	21	32	2.80	3 11	725-100Q32-21H	32.0	A	123.4	50.0	12.0	2.18	4765	11	745R-2109	
125.0	21	40	2.80	3 8	725-125Q40-21M	40.0	B	148.4	63.0	12.0	3.97	4216	8	745R-2109	
	21	40	2.80	3 14	725-125Q40-21H	40.0	B	148.4	63.0	12.0	3.17	4216	14	745R-2109	
160.0	21	40	2.80	3 10	725-160Q40-21M	40.0	B	183.4	63.0	12.0	4.86	3675	10	745R-2109	
	21	40	2.80	3 16	725-160Q40-21H	40.0	B	183.4	63.0	12.0	5.31	3675	16	745R-2109	

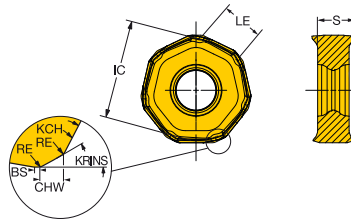
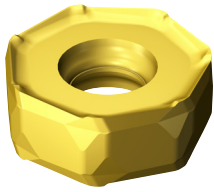
DC	Spare parts	
	Shower screw	Insert screw
63.00	5512 073-01	5513 020-80
80.00	5512 073-02	5513 020-80
100.00	5512 073-05	5513 020-80
125.00-160.00	5512 098-03	5513 020-80
250.00	-	5513 020-80

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 745 insert for milling

KRINS 42°



				Ordering code	P						K						Dimensions, mm				
					1130	4220	4230	4240	1020	3040	K20D	K20W	IC	LE	S	BS	BSR				
Medium	M30	21	1.00	17°	1.3	745R-2109E-M30	★	☆	★	☆	★	☆	☆	☆	☆	21.0	8.9	9.00	0.3	25.0	
		21	1.00	17°	1.3	745L-2109E-M50			★				☆	☆	☆	21.0	8.5	9.00	0.3	25.0	
	M50	1.00	17°	1.3	745R-2109E-M50	★	☆	★	☆	★	☆	☆	☆	☆	21.0	8.9	9.00	0.3	25.0		
Heavy	H50	21	1.00	17°	1.3	745R-2109E-H50		☆	☆	☆		☆	☆	☆	☆	21.0	8.9	9.00	0.3	25.0	



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1154



1175

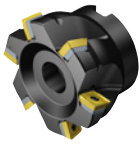


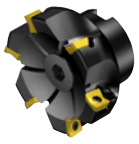








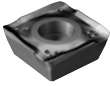
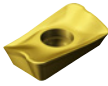

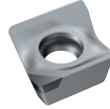





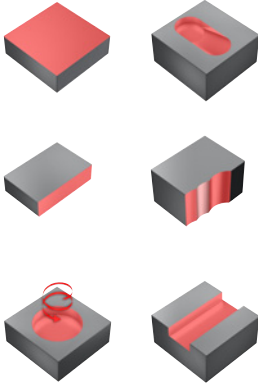




N23



N10

## Shoulder milling tools

	CoroMill® 490	CoroMill® 390	CoroMill® 690	CoroMill® Century
				
Page	I47	I57	I79	I83
Material				
Main operation				
KAPR	90°	90°	90°	90°
DC mm	20 - 250	9.7 - 200	40 - 100	40 - 200
APMX mm	5.5 - 10.0	5.8 - 85	46 - 108	11
Insert				
Insert sizes	8 & 14	07,11,17 & 18	10 & 14	11
Couplings	Coromant Capto® Coromant EH Cylindrical shank Weldon HSK Arbor	Coromant Capto® Coromant EH Cylindrical shank Arbor Weldon Threaded coupling	Coromant Capto® HSK Arbor	Coromant Capto® HSK Arbor
Internal coolant				
Options		Damped cutter bodies available		Exchangeable cassette design
Other operations				

# CoroMill® 490

Face and shoulder mill for precise profiles

## Application

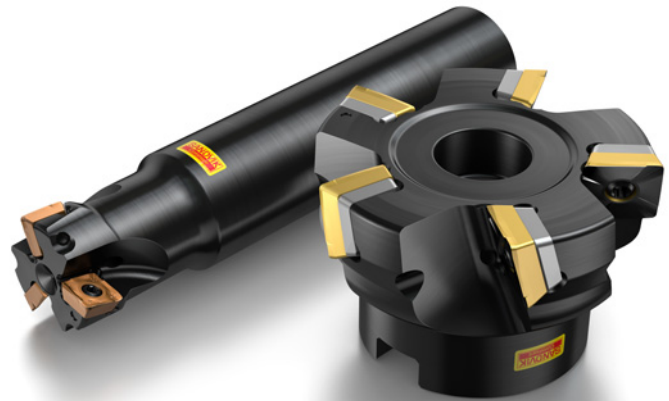
- Square shoulder milling
- Repeated shoulder milling
- Circular interpolation
- Face milling

## ISO application area:



## Benefits and features

- Great flexibility, high precision and good tolerances
- Light and quiet cutting with low cutting forces
- High productivity with outstanding insert geometry and grades
- Sharp edge lines and burr-free, smooth profiles
- Component feature finished in one pass
- True 90-degree cut without sharp steps
- Light cutting performance provides an optimal utilization of low-powered machine tools. This also facilitates use of the cutter on extended tool assemblies
- Undersized shanks for larger diameter cutters, using 8 mm inserts, enable these cutters to fit into smaller tool holders
- Oversized versions enhance the accessibility and provide natural clearance to tight fixtures



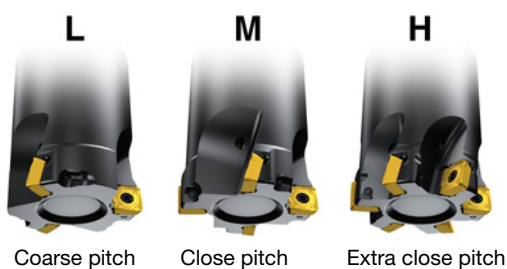
[www.sandvik.coromant.com/coromill490](http://www.sandvik.coromant.com/coromill490)

## Couplings

- Coromant Capto®
- Arbor
- Cylindrical shank
- Weldon
- Coromant EH
- HSK
- Undersized shanks for cylindrical cutters
- Oversized versions available on arbor, Coromant Capto® cutters, arbor and Coromant EH

## Inserts

- Four cutting edges
- Cemented carbide, CBN and ceramic grades



## Precision

The insert edges are slightly crowned to compensate for deflection. Due to this geometry, angular distortion during shoulder milling is minimized, and discernable steps between repeatable passes are avoided.



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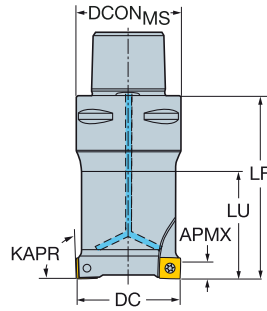


N6

# CoroMill® 490 square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



						Dimensions, mm											
DC		CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC		Ordering code	DCON <sub>MS</sub>	LB	LF	LU	NM	KG	RPMX	CICT	MID		
20.0	08	C3	5.50	3	2	490-020C3-08L	32.0	40.0	80.0	40.0	1.2	0.37	48500	2	490R-08T308		
	08	C4	5.50	3	2	490-020C4-08L	40.0	40.0	70.0	40.0	1.2	0.62	39000	2	490R-08T308		
25.0	08	C3	5.50	3	3	490-025C3-08M	32.0	60.0	80.0	60.0	1.2	0.39	40400	3	490R-08T308		
	08	C4	5.50	3	3	490-025C4-08M	40.0	45.0	70.0	45.0	1.2	0.43	39000	3	490R-08T308		
	08	C5	5.50	3	3	490-025C5-08M	50.0	50.0	75.0	50.0	1.2	0.85	28000	3	490R-08T308		
	08	C6	5.50	3	3	490-025C6-08M	63.0	53.0	80.0	53.0	1.2	1.41	20000	3	490R-08T308		
32.0	08	C3	5.50	3	4	490-032C3-08M	32.0	60.0	80.0	60.0	1.2	0.50	33900	4	490R-08T308		
	08	C4	5.50	3	4	490-032C4-08M	40.0	45.0	70.0	45.0	1.2	0.75	33900	4	490R-08T308		
	08	C5	5.50	3	4	490-032C5-08M	50.0	50.0	75.0	50.0	1.2	0.90	28000	4	490R-08T308		
	08	C6	5.50	3	4	490-032C6-08M	63.0	53.0	80.0	53.0	1.2	1.44	20000	4	490R-08T308		
36.0	08	C3	5.50	3	4	490-036C3-08M	32.0	30.0	50.0	30.0	1.2	0.55	31300	4	490R-08T308		
40.0	08	C4	5.50	3	4	490-040C4-08M	40.0	45.0	70.0	45.0	1.2	0.82	29300	4	490R-08T308		
	08	C5	5.50	3	4	490-040C5-08M	50.0	50.0	75.0	50.0	1.2	1.09	28000	4	490R-08T308		
	08	C4	5.50	3	6	490-040C4-08H	40.0	45.0	70.0	45.0	1.2	0.88	29300	6	490R-08T308		
	08	C5	5.50	3	6	490-040C5-08H	50.0	50.0	75.0	50.0	1.2	1.10	28000	6	490R-08T308		
	08	C6	5.50	3	6	490-040C6-08H	63.0	53.0	80.0	53.0	1.2	1.62	20000	6	490R-08T308		
	14	C4	10.00	3	3	490-040C4-14M	40.0	45.0	70.0	45.0	3.0	0.82	26400	3	490R-1404		
	14	C5	10.00	3	3	490-040C5-14M	50.0	50.0	75.0	50.0	3.0	1.02	26400	3	490R-1404		
	14	C6	10.00	3	3	490-040C6-14M	63.0	53.0	80.0	53.0	3.0	1.56	20000	3	490R-1404		
	14	C4	10.00	3	4	490-040C4-14H	40.0	70.0	70.0	45.0	3.0	0.82	26400	4	490R-1404		
	14	C5	10.00	3	4	490-040C5-14H	50.0	50.0	75.0	50.0	3.0	1.03	26400	4	490R-1404		
	14	C6	10.00	3	4	490-040C6-14H	63.0	53.0	80.0	53.0	3.0	1.52	20000	4	490R-1404		
44.0	08	C4	5.50	3	5	490-044C4-08M	40.0	40.0	60.0		1.2	0.83	27600	5	490R-08T308		
	08	C4	5.50	3	6	490-044C4-08H	40.0	40.0	60.0		1.2	0.79	27600	6	490R-08T308		
	14	C4	10.00	3	3	490-044C4-14M	40.0	45.0	70.0		3.0	0.89	24600	3	490R-1404		
	14	C4	10.00	3	4	490-044C4-14H	40.0	70.0	70.0		3.0	0.89	24600	4	490R-1404		
50.0	08	C5	5.50	3	5	490-050C5-08M	50.0	50.0	75.0	50.0	1.2	1.28	25500	5	490R-08T308		
	08	C6	5.50	3	5	490-050C6-08M	63.0	53.0	80.0	53.0	1.2	1.84	20000	5	490R-08T308		
	08	C5	5.50	3	7	490-050C5-08H	50.0	50.0	75.0	50.0	1.2	1.26	25500	7	490R-08T308		
	08	C6	5.50	3	7	490-050C6-08H	63.0	53.0	80.0	53.0	1.2	1.86	20000	7	490R-08T308		
	14	C5	10.00	3	4	490-050C5-14M	50.0	53.0	75.0	50.0	3.0	1.26	13700	4	490R-1404		
	14	C6	10.00	3	4	490-050C6-14M	63.0	53.0	80.0	53.0	3.0	1.80	13700	4	490R-1404		
	14	C5	10.00	3	5	490-050C5-14H	50.0	50.0	75.0	50.0	3.0	1.23	22400	5	490R-1404		
	14	C6	10.00	3	5	490-050C6-14H	63.0	53.0	80.0	53.0	3.0	1.75	20000	5	490R-1404		
54.0	08	C5	5.50	3	5	490-054C5-08M	50.0	40.0	60.0		1.2	1.34	24300	5	490R-08T308		
	08	C5	5.50	3	7	490-054C5-08H	50.0	40.0	60.0		1.2	1.34	24300	7	490R-08T308		
	14	C5	10.00	3	4	490-054C5-14M	50.0	60.0	60.0		3.0	1.31	13000	4	490R-1404		
	14	C5	10.00	3	5	490-054C5-14H	50.0	60.0	60.0		3.0	1.26	21300	5	490R-1404		
63.0	08	C6	5.50	3	6	490-063C6-08M	63.0	23.0	50.0	23.0	1.2	1.69	20000	6	490R-08T308		
	08	C6	5.50	3	8	490-063C6-08H	63.0	23.0	50.0	23.0	1.2	1.67	20000	8	490R-08T308		
	14	C6	10.00	3	5	490-063C6-14M	63.0	53.0	80.0	53.0	3.0	2.18	11700	5	490R-1404		
	14	C6	10.00	3	6	490-063C6-14H	63.0	53.0	80.0	53.0	3.0	2.16	11700	6	490R-1404		
66.0	08	C6	5.50	3	6	490-066C6-08M	63.0	28.0	50.0		1.2	1.70	20000	6	490R-08T308		
	08	C6	5.50	3	8	490-066C6-08H	63.0	28.0	50.0		1.2	1.72	20000	8	490R-08T308		
	14	C6	10.00	3	5	490-066C6-14M	63.0	65.0	65.0		3.0	1.93	11400	5	490R-1404		
	14	C6	10.00	3	6	490-066C6-14H	63.0	65.0	65.0		3.0	1.94	11400	6	490R-1404		



I55



L2



N23



N6



N9

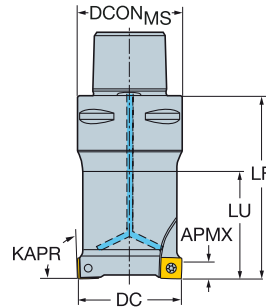


N15

# CoroMill® 490 square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



						Dimensions, mm									
DC		CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC		Ordering code	DCON <sub>MS</sub>	LB	LF	LU			RPMX	CICT	MIID
80.0	08	C8	5.50	3	8	490-080C8-08M	80.0		80.0	45.0	1.2	3.73	14000	8	490R-08T308
	08	C8	5.50	3	10	490-080C8-08H	80.0		80.0	45.0	1.2	3.76	14000	10	490R-08T308
	14	C6	10.00	3	6	490-080C6-14M	63.0	65.0	65.0	65.0	3.0	2.33	10100	6	490R-1404
	14	C8	10.00	3	6	490-080C8-14M	80.0		80.0	45.0	3.0	3.59	10100	6	490R-1404
	14	C6	10.00	3	8	490-080C6-14H	63.0	65.0	65.0	65.0	3.0	2.33	10100	8	490R-1404
	14	C8	10.00	3	8	490-080C8-14H	80.0		80.0	45.0	3.0	3.59	10100	8	490R-1404
84.0	08	C8	5.50	3	8	490-084C8-08M	80.0		60.0		1.2	3.13	14000	8	490R-08T308
	08	C8	5.50	3	10	490-084C8-08H	80.0		60.0		1.2	3.19	14000	10	490R-08T308
	14	C8	10.00	3	6	490-084C8-14M	80.0		70.0		3.0	3.39	9800	6	490R-1404
	14	C8	10.00	3	8	490-084C8-14H	80.0		70.0		3.0	3.39	9800	8	490R-1404

Spare parts			
	Insert screw	Shim	Shim screw
08	5513 020-35		
14	5513 020-72	5322 471-01	5512 090-01

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



155



L2



N23



N6



N9



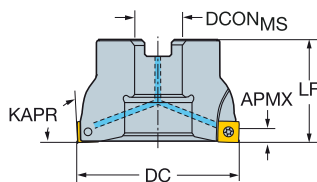
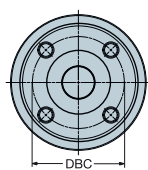
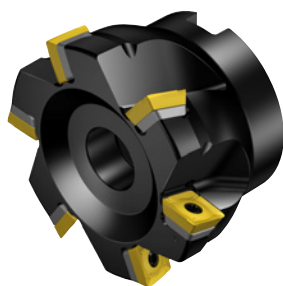
N15

# CoroMill® 490 square shoulder milling cutter

Arbor - Internal coolant supply

STDNO  
KAPR

ISO6462  
90°



						Dimensions, mm											
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ISO	DBC	LF	NM	KG	RPMX	CICT	MIID				
40.0	08	16	5.50	1	4	490-040Q16-08M	16.0	A	40.0	1.2	0.46	29300	4	490R-08T308			
	08	16	5.50	1	6	490-040Q16-08H	16.0	A	40.0	1.2	0.23	29300	6	490R-08T308			
44.0	08	16	5.50	1	5	490-044Q16-08M	16.0	A	40.0	1.2	0.50	27600	5	490R-08T308			
50.0	08	22	5.50	1	4	490-050Q22-08L	22.0	A	40.0	1.2	0.66	25500	4	490R-08T308			
	08	22	5.50	1	5	490-050Q22-08M	22.0	A	40.0	1.2	0.48	25500	5	490R-08T308			
	08	22	5.50	1	7	490-050Q22-08H	22.0	A	40.0	1.2	0.37	25500	7	490R-08T308			
	14	22	10.00	1	4	490-050Q22-14M	22.0	A	40.0	3.0	0.38	13700	4	490R-1404			
54.0	14	22	10.00	1	5	490-050Q22-14H	22.0	A	40.0	3.0	0.36	22400	5	490R-1404			
	08	22	5.50	1	5	490-054Q22-08M	22.0	A	40.0	1.2	0.69	24300	5	490R-08T308			
	14	22	10.00	1	4	490-054Q22-14M	22.0	A	40.0	3.0	0.67	13000	4	490R-1404			
	08	22	5.50	1	5	490-063Q22-08L	22.0	A	40.0	1.2	0.77	22200	5	490R-08T308			
63.0	08	22	5.50	1	6	490-063Q22-08M	22.0	A	40.0	1.2	0.53	22200	6	490R-08T308			
	08	22	5.50	1	8	490-063Q22-08H	22.0	A	40.0	1.2	0.50	22200	8	490R-08T308			
	14	22	10.00	1	5	490-063Q22-14M	22.0	A	40.0	3.0	0.51	11700	5	490R-1404			
	14	22	10.00	1	6	490-063Q22-14H	22.0	A	40.0	3.0	0.71	11700	6	490R-1404			
66.0	08	22	5.50	1	6	490-066Q22-08M	22.0	A	40.0	1.2	0.75	21600	6	490R-08T308			
	14	22	10.00	1	5	490-066Q22-14M	22.0	A	40.0	3.0	0.76	11400	5	490R-1404			
	08	27	5.50	1	6	490-080Q27-08L	27.0	A	50.0	1.2	1.43	19400	6	490R-08T308			
	08	27	5.50	1	8	490-080Q27-08M	27.0	A	50.0	1.2	1.39	19400	8	490R-08T308			
80.0	08	27	5.50	1	10	490-080Q27-08H	27.0	A	50.0	1.2	1.20	19400	10	490R-08T308			
	14	27	10.00	1	6	490-080Q27-14M	27.0	A	50.0	3.0	1.11	10100	6	490R-1404			
	14	27	10.00	1	8	490-080Q27-14H	27.0	A	50.0	3.0	1.12	10100	8	490R-1404			
	08	27	5.50	1	8	490-084Q27-08M	27.0	A	50.0	1.2	1.78	18900	8	490R-08T308			
100.0	14	27	10.00	1	6	490-084Q27-14M	27.0	A	50.0	3.0	1.61	9800	6	490R-1404			
	08	32	5.50	0	6	490-100Q32-08L	32.0	B	50.0	1.2	2.15	17100	6	490R-08T308			
	08	32	5.50	0	8	490-100Q32-08M	32.0	B	50.0	1.2	2.10	17100	8	490R-08T308			
	08	32	5.50	0	10	490-100Q32-08H	32.0	B	50.0	1.2	2.10	17100	10	490R-08T308			
	14	32	10.00	1	5	490-100Q32-14L	32.0	B	50.0	3.0	2.07	8900	5	490R-1404			
	14	32	10.00	1	7	490-100Q32-14M	32.0	B	50.0	3.0	1.99	8900	7	490R-1404			
125.0	14	32	10.00	1	10	490-100Q32-14H	32.0	B	50.0	3.0	2.00	8900	10	490R-1404			
	08	40	5.50	0	8	490-125Q40-08L	40.0	B	63.0	1.2	3.51	15200	8	490R-08T308			
	08	40	5.50	0	10	490-125Q40-08M	40.0	B	63.0	1.2	3.44	15200	10	490R-08T308			
	08	40	5.50	0	12	490-125Q40-08H	40.0	B	63.0	1.2	3.46	15200	12	490R-08T308			
	14	40	10.00	1	6	490-125Q40-14L	40.0	B	63.0	3.0	3.37	7800	6	490R-1404			
	14	40	10.00	1	8	490-125Q40-14M	40.0	B	63.0	3.0	3.05	7800	8	490R-1404			
160.0	14	40	10.00	1	12	490-125Q40-14H	40.0	B	63.0	3.0	3.29	7800	12	490R-1404			
	14	40S	10.00	0	8	490-160Q40-14L	40.0	C	66.7	63.0	3.0	5.05	6800	8	490R-1404		
	14	40S	10.00	0	12	490-160Q40-14M	40.0	C	66.7	63.0	3.0	5.01	6800	12	490R-1404		
	14	40S	10.00	0	15	490-160Q40-14H	40.0	C	66.7	63.0	3.0	5.06	6800	15	490R-1404		
200.0	14	60	10.00	0	10	490-200Q60-14L	60.0	C	101.6	63.0	3.0	13.11	6000	10	490R-1404		
	14	60	10.00	0	16	490-200Q60-14M	60.0	C	101.6	63.0	3.0	11.79	6000	16	490R-1404		
250.0	14	60	10.00	0	12	490-250Q60-14L	60.0	C	101.6	63.0	3.0	15.50	5300	12	490R-1404		
	14	60	10.00	0	18	490-250Q60-14M	60.0	C	101.6	63.0	3.0	17.52	5300	18	490R-1404		

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I55



L2



M1



N23



N6



N9



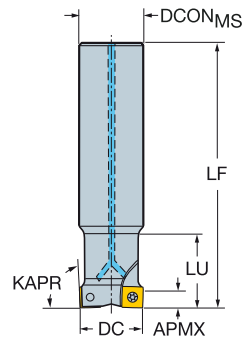
N15



# CoroMill® 490 square shoulder milling cutter

Cylindrical shank - Internal coolant supply

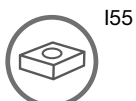
KAPR 90°



						Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	LF	LU	NM	KG	RPM	CICT	MID	
20.0	08	16	5.50	1 2	490-020A16-08L	16.0	100.0	1.2	0.24	48500	2	490R-08T308	
	08	20	5.50	1 2	490-020A20-08L	20.0	110.0	25.0	1.2	0.33	48500	2	490R-08T308
22.0	08	20	5.50	1 2	490-022A20L-08L	20.0	170.0		1.2	0.47	20300	2	490R-08T308
25.0	08	20	5.50	1 2	490-025A20-08L	20.0	110.0		1.2	0.34	40400	2	490R-08T308
	08	25	5.50	1 2	490-025A25-08L	25.0	120.0	32.0	1.2	0.49	40400	2	490R-08T308
	08	20	5.50	1 3	490-025A20-08M	20.0	110.0		1.2	0.32	40400	3	490R-08T308
	08	25	5.50	1 3	490-025A25-08M	25.0	120.0	32.0	1.2	0.46	40400	3	490R-08T308
28.0	08	25	5.50	1 2	490-028A25L-08L	25.0	210.0		1.2	0.84	11000	2	490R-08T308
32.0	08	25	5.50	1 3	490-032A25-08L	25.0	120.0		1.2	0.55	33900	3	490R-08T308
	08	32	5.50	1 3	490-032A32-08L	32.0	130.0	40.0	1.2	0.81	33900	3	490R-08T308
	08	25	5.50	1 4	490-032A25-08M	25.0	120.0		1.2	0.55	33900	4	490R-08T308
	08	32	5.50	1 4	490-032A32-08M	32.0	130.0	40.0	1.2	0.81	33900	4	490R-08T308
40.0	08	32	5.50	1 3	490-040A32-08L	32.0	170.0		1.2	1.18	20300	3	490R-08T308
	08	32	5.50	1 4	490-040A32-08M	32.0	170.0		1.2	1.16	20300	4	490R-08T308
	08	32	5.50	1 6	490-040A32-08H	32.0	170.0		1.2	1.18	20300	6	490R-08T308
	14	32	10.00	1 3	490-040A32-14M	32.0	170.0	3.0	1.12	26400	3	490R-1404	
	14	32	10.00	1 3	490-040A32L-14M	32.0	250.0	3.0	1.77	7600	3	490R-1404	
	14	32	10.00	1 4	490-040A32-14H	32.0	170.0	3.0	1.13	26400	4	490R-1404	
50.0	14	32	10.00	1 3	490-050A32-14L	32.0	120.0	3.0	1.07	13700	3	490R-1404	
	14	32	10.00	1 4	490-050A32-14M	32.0	120.0	3.0	0.90	13700	4	490R-1404	
63.0	14	32	10.00	1 4	490-063A32-14L	32.0	120.0	3.0	1.43	11700	4	490R-1404	
	14	32	10.00	1 5	490-063A32-14M	32.0	120.0	3.0	1.43	11700	5	490R-1404	

Spare parts			
	Insert screw	Shim	Shim screw
08	5513 020-35		
14	5513 020-72	5322 471-01	5512 090-01

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I55



L2



N23



N6



N9

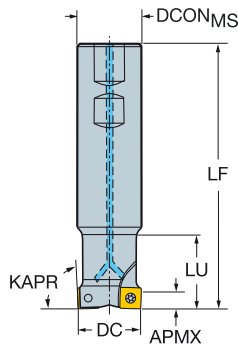


N15

# CoroMill® 490 square shoulder milling cutter

Weldon - Internal coolant supply

KAPR 90°



						Dimensions, mm											
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ISO	LB	LF	LU	NM	KG	RPMX	CICT	MIID			
20.0	08	16	5.50	1 2	490-020B16-08L	16.0	WE	25.0	74.0	25.0	1.2	0.20	48500	2	490R-08T308		
	08	20	5.50	1 2	490-020B20-08L	20.0	WE	25.0	76.0	25.0	1.2	0.25	48500	2	490R-08T308		
25.0	08	20	5.50	1 2	490-025B20-08L	20.0	WE	32.0	83.0		1.2	0.28	40400	2	490R-08T308		
	08	25	5.50	1 3	490-025B25-08M	25.0	WE	32.0	88.0	32.0	1.2	0.37	40400	3	490R-08T308		
32.0	08	25	5.50	1 3	490-032B25-08L	25.0	WE	40.0	98.0		1.2	0.46	33900	3	490R-08T308		
	08	32	5.50	1 3	490-032B32-08L	32.0	WE	40.0	100.0	40.0	1.2	0.62	33900	3	490R-08T308		
	08	25	5.50	1 4	490-032B25-08M	25.0	WE	40.0	98.0		1.2	0.47	33900	4	490R-08T308		
	08	32	5.50	1 4	490-032B32-08M	32.0	WE	40.0	100.0	40.0	1.2	0.62	33900	4	490R-08T308		
40.0	08	32	5.50	1 4	490-040B32-08M	32.0	WE	50.0	112.0		1.2	0.79	29300	4	490R-08T308		
	08	32	5.50	1 6	490-040B32-08H	32.0	WE	50.0	112.0		1.2	0.81	29300	6	490R-08T308		
	14	32	10.00	1 3	490-040B32-14M	32.0	WE	50.0	112.0		3.0	0.76	26400	3	490R-1404		
	14	32	10.00	1 4	490-040B32-14H	32.0	WE	50.0	112.0		3.0	0.77	26400	4	490R-1404		

Spare parts	
	Insert screw
08	5513 020-35
14	5513 020-72

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



155



L2



N23



N6



N9

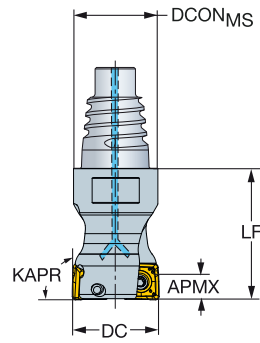


N15

# CoroMill® 490 square shoulder milling cutter

Coromant EH - Internal coolant supply

KAPR 90°



						Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code		DCON <sub>MS</sub>	LF	NM	KG	RPMX	CICT	MIID	
20.0	08	E20	5.50	1	2	490-020EH20-08L	19.3	30.0	1.2	0.14	48500	2	490R-08T308
25.0	08	E25	5.50	1	2	490-025EH25-08L	24.2	35.0	1.2	0.18	40400	2	490R-08T308
						490-025EH25-08M							
32.0	08	E25	5.50	1	3	490-032EH25-08L	24.2	35.0	1.2	0.21	33900	3	490R-08T308
						490-032EH25-08M							

Spare parts		
DC		Insert screw
20.00	08	5513 020-36
25.00-32.00	08	5513 020-35

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



155



L2



N23



N6



N9



N15

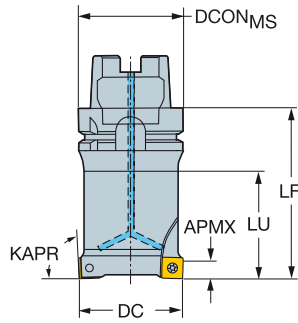


N3

# CoroMill® 490 square shoulder milling cutter

HSK - Internal coolant supply

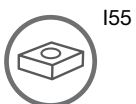
KAPR 90°



						Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	Ordering code		DCON <sub>MS</sub>	ISO	LF	LU	NM	KG	RPMX	CICT	MIID	
20.0	08	63	5.50	1	2	490-020HA06-08L	63.0	A	95.0	40.0	1.2	1.27	30000	2	490R-08T308
25.0	08	63	5.50	1	3	490-025HA06-08M	63.0	A	95.0	50.0	1.2	1.25	30000	3	490R-08T308
32.0	08	63	5.50	1	4	490-032HA06-08M	63.0	A	95.0	58.0	1.2	1.33	30000	4	490R-08T308
40.0	08	63	5.50	1	6	490-040HA06-08H	63.0	A	95.0	58.0	1.2	1.57	29300	6	490R-08T308
50.0	08	63	5.50	1	5	490-050HA06-08M	63.0	A	95.0	63.0	1.2	1.84	25500	5	490R-08T308
50.0	08	63	5.50	1	7	490-050HA06-08H	63.0	A	95.0	58.0	1.2	1.86	25500	7	490R-08T308
63.0	08	63	5.50	1	6	490-063HA06-08M	63.0	A	70.0	44.0	1.2	1.81	22200	6	490R-08T308
63.0	08	63	5.50	1	8	490-063HA06-08H	63.0	A	70.0	44.0	1.2	1.80	22200	8	490R-08T308
80.0	08	63	5.50	1	8	490-080HA06-08M	63.0	A	70.0		1.2	2.03	19400	8	490R-08T308

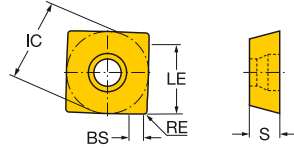
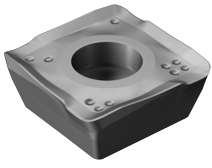
Spare parts
Insert screw
5513 020-35

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



## CoroMill® 490 insert for milling

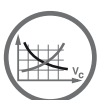
KRINS 90°



		RE	Ordering code	Dimensions, mm																															
				P				M				K				N				S				H											
				1130	4220	4330	4940	530	1040	1130	2040	4940	530	1020	3040	3220	3330	HT3A	1130	HT3A	1130	HT3A	ES30T	S40T	1010	1130	1330	IC	LE	S	BS				
Light	KL	08	490R-08T304M-KL								*	*																	8.5	5.6	3.30	1.5			
		0.80	490R-08T308M-KL								*	*																		8.5	5.6	3.30	1.2		
		0.40	490R-08T304E-ML					*	*									*	*											8.5	5.6	3.30	1.5		
		0.80	490R-08T308E-ML	*	*			*	*								*	*			*	*								8.5	5.6	3.30	1.2		
	ML	14	0.80	490R-140408E-ML					*	*						*	*			*	*									13.8	10.3	3.90	2.0		
		0.40	490R-08T304M-PL	*	*	*	*	*	*									*	*											8.5	5.6	3.30	1.5		
		0.80	490R-08T308M-PL	*	*	*	*	*	*								*	*			*	*								8.5	5.6	3.30	1.2		
		14	0.80	490R-140408M-PL	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	2.0	
	Medium	KM	08	0.80	490R-08T308M-KM							*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	1.2	
			1.20	490R-08T312M-KM								*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	0.9	
			1.60	490R-08T316M-KM								*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	0.6
		MM	08	0.80	490R-08T308E-MM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	1.2
0.80				490R-08T308M-MM					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	1.2	
1.20				490R-08T312E-MM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	0.9
1.60				490R-08T316E-MM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	0.6
14				0.80	490R-140408E-MM					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	2.0
14			0.80	490R-140408M-MM					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	2.0
			1.20	490R-140412E-MM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	1.6
			1.60	490R-140416E-MM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	1.2
			2.00	490R-140420E-MM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	0.9
			2.00	490R-140420M-MM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	0.9
			PM	08	0.80	490R-08T308M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30
1.20		490R-08T312M-PM			*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	0.9	
1.60		490R-08T316M-PM			*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	0.6
14		0.80		490R/L-140408M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	2.0
		0.80		490R-140408M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	2.0
		1.20		490R-140412M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	2.0
		1.60		490R-140416M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	1.2
		2.00		490R-140420M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	0.9
		0.80		490R-140408M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	0.9
		2.00		490R-140420M-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	0.9
Heavy		KH	08	0.80	490R-08T308M-KH							*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	1.2	
	1.60		490R-08T316M-KH								*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	0.6	
	PH	08	0.80	490R-08T308M-PH	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	1.2	
		1.60	490R-08T316M-PH	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		8.5	5.6	3.30	0.6	
		14	0.80	490R-140408M-PH	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	2.0	
		2.00	490R-140420M-PH	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*		13.8	10.3	3.90	0.9	



148



1154



1175



N23

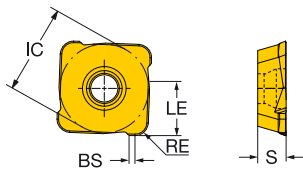
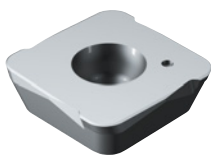


N10

# CoroMill® 490 insert for milling

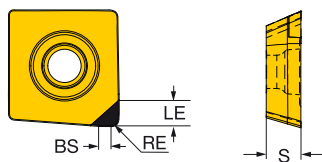
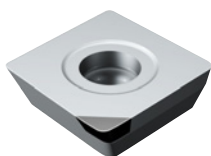
Advanced cutting materials

KRINS 90°



				K		H		Dimensions, mm			
		RE	Ordering code	0819	1619	IC	LE	S	BS		
Medium	PO	14	2.00	490R-140420E	★	★	13.8	5.0	3.90	0.8	
			2.00	490R-140408E	★		13.8	5.0	3.90	0.8	

KRINS 90°



				K		H		Dimensions, mm			
		RE	Ordering code	0860	0860	IC	LE	S	BS		
Medium	PO	14	0.80	490R-140408E	★	★	13.8	2.0	3.90	1.5	



I48



I154



I175



N23



N10

# CoroMill® 390

Versatile shoulder milling cutters with ramping capability for mixed production

## Application

- Shoulder milling
- Repeated shoulder milling
- Turn milling
- Deep shoulder milling
- Edging
- Pocketing
- Linear and helical ramping

## ISO application area:



## Benefits and features

- Close tolerances giving excellent surface finish and minimal mismatch
- Large depth of cut and steep ramping capability
- Oversized diameter for clearance is available
- Integrated damping technology Silent Tools™ for increased metal removal and improved surface finish
- Available in a shorter version for turning centres
- Internal coolant on most cutters



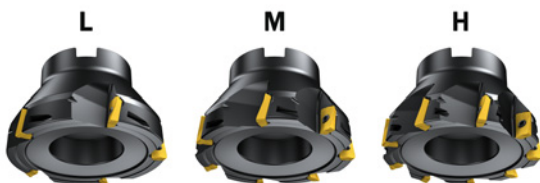
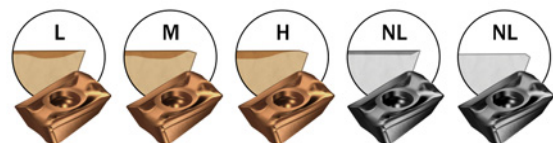
[www.sandvik.coromant.com/coromill390](http://www.sandvik.coromant.com/coromill390)

## Cutter bodies

- Coromant Capto®
- Arbor
- Cylindrical shank
- Weldon
- Coromant EH
- Threaded coupling
- Oversized versions available on Coromant Capto® cutters, arbor and Coromant EH
- Undersized shanks on cylindrical cutters

## Inserts

- Two cutting edges
- Cemented carbide and PCD grades
- The light-cutting insert geometries and high-performance grades of are designed for low cutting forces and vibration-free machining for secure milling in all materials.

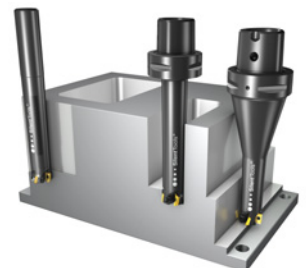


Coarse pitch

Close pitch

Extra close pitch

Silent Tools damped cutter bodies boost productivity at long overhangs



158



174

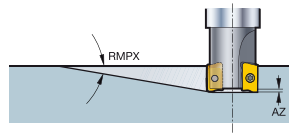


N6

# CoroMill® 390 square shoulder milling cutter

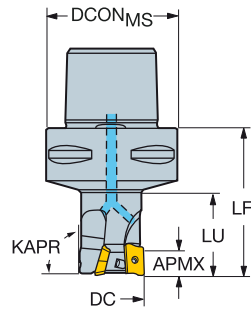
Coromant Capto® - Internal coolant supply

ENG



KAPR

90°



DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code	Dimensions, mm					CICT	MID			
								DCON <sub>MS</sub>	LF	LU	NM	KG			RPMX		
16.0	11	C3	5.5	10.00	10°	1.0	3	2	R390-016C3-11L050	32.0	50.0	25.0	1.2	0.28	39000	2	R390-11..
	11	C4	5.5	10.00	10°	1.0	3	2	R390-016C4-11L	40.0	50.0	25.0	1.2	0.41	39000	2	R390-11..
20.0	11	C3	5.5	10.00	5°	1.0	3	2	R390-020C3-11L050	32.0	50.0	25.0	1.2	0.29	34600	2	R390-11..
	11	C4	5.5	10.00	5°	1.0	3	2	R390-020C4-11L	40.0	50.0	25.0	1.2	0.42	34600	2	R390-11..
	11	C3	5.5	10.00	5°	1.0	3	3	R390-020C3-11M050	32.0	50.0	25.0	1.2	0.29	34600	3	R390-11..
	11	C5	5.5	10.00	5°	1.0	3	3	R390-020C5-11M095	50.0	95.0	40.0	1.2	1.00	34600	3	R390-11..
	11	C6	5.5	10.00	5°	1.0	3	3	R390-020C6-11M110	63.0	110.0	40.0	1.2	1.75	34600	3	R390-11..
	11	C6	5.5	10.00	5°	1.0	3	3	R390-025C6-11M110	63.0	110.0	45.0	1.2	1.60	36500	3	R390-11..
25.0	11	C3	5.5	10.00	5°	1.0	3	2	R390-025C3-11L050	32.0	50.0	32.0	1.2	0.31	36500	2	R390-11..
	11	C4	5.5	10.00	5°	1.0	3	2	R390-025C4-11L	40.0	55.0	32.0	1.2	0.42	36500	2	R390-11..
	11	C3	5.5	10.00	5°	1.0	3	3	R390-025C3-11M050	32.0	50.0	32.0	1.2	0.28	36500	3	R390-11..
	11	C4	5.5	10.00	5°	1.0	3	3	R390-025C4-11M	40.0	55.0	32.0	1.2	0.44	36500	3	R390-11..
	11	C5	5.5	10.00	5°	1.0	3	3	R390-025C5-11M095	50.0	95.0	45.0	1.2	1.06	36500	3	R390-11..
	11	C6	5.5	10.00	5°	1.0	3	3	R390-025C6-11M110	63.0	110.0	50.0	1.2	1.81	31000	3	R390-11..
32.0	11	C3	5.5	10.00	3°	1.0	3	2	R390-032C3-11L050	32.0	50.0	35.0	1.2	0.38	31000	2	R390-11..
	11	C4	5.5	10.00	3°	1.0	3	3	R390-032C4-11M	40.0	65.0	40.0	1.2	0.52	31000	3	R390-11..
	11	C5	5.5	10.00	3°	1.0	3	3	R390-032C5-11M	50.0	65.0	40.0	1.2	0.88	31000	3	R390-11..
	11	C5	5.5	10.00	3°	1.0	3	3	R390-032C5-11M095	50.0	95.0	50.0	1.2	1.10	31000	3	R390-11..
	11	C6	5.5	10.00	3°	1.0	3	3	R390-032C6-11M080	63.0	80.0	40.0	1.2	1.52	31000	3	R390-11..
	11	C6	5.5	10.00	3°	1.0	3	3	R390-032C6-11M110	63.0	110.0	50.0	1.2	1.81	31000	3	R390-11..
36.0	11	C3	5.5	10.00	2°	1.0	3	3	R390-036C3-11M050	32.0	50.0		1.2	0.38	29000	3	R390-11..
	11	C3	5.5	10.00	2°	1.0	3	3	R390-036C3-11M075	32.0	75.0		1.2	0.54	29000	3	R390-11..
40.0	11	C4	5.5	10.00	2°	1.0	3	4	R390-040C4-11M	40.0	70.0	70.0	1.2	0.82	27000	4	R390-11..
	11	C5	5.5	10.00	2°	1.0	3	4	R390-040C5-11M	50.0	75.0	50.0	1.2	1.05	27000	4	R390-11..
	11	C6	5.5	10.00	2°	1.0	3	4	R390-040C6-11M080	63.0	80.0	40.0	1.2	1.20	27000	4	R390-11..
	11	C4	5.5	10.00	2°	1.0	3	6	R390-040C4-11H	40.0	70.0	50.0	1.2	0.56	27000	6	R390-11..
	11	C5	5.5	10.00	2°	1.0	3	6	R390-040C5-11H	50.0	75.0	50.0	1.2	1.07	27000	6	R390-11..
	18	C4	1.1	15.40	6°	0.0	3	3	R390-040C4-18M060	40.0	60.0	40.0	3.0	0.48	9200	3	R390-18..
44.0	18	C5	1.1	15.40	6°	0.0	3	3	R390-040C5-18M080	50.0	80.0	40.0	3.0	1.13	9200	3	R390-18..
	18	C6	1.1	15.40	6°	0.0	3	3	R390-040C6-18M100	63.0	100.0	50.0	3.0	1.91	9200	3	R390-18..
	11	C4	5.5	10.00	1°	1.0	3	4	R390-044C4-11M060	40.0	60.0		1.2	0.77	25600	4	R390-11..
	11	C4	5.5	10.00	1°	1.0	3	4	R390-044C4-11M075	40.0	75.0		1.2	0.88	25600	4	R390-11..
	18	C4	1.1	15.40	6°	0.0	3	2	R390-044C4-18L080	40.0	80.0		3.0	1.10	8600	2	R390-18..
	18	C4	1.1	15.40	6°	0.0	3	3	R390-044C4-18M060	40.0	60.0		3.0	0.80	8600	3	R390-18..
50.0	18	C4	1.1	15.40	6°	0.0	3	3	R390-044C4-18M080	40.0	80.0		3.0	1.00	8600	3	R390-18..
	11	C5	5.5	10.00	1°	1.0	3	5	R390-050C5-11M060	50.0	60.0	40.0	1.2	1.08	23700	5	R390-11..
	11	C6	5.5	10.00	1°	1.0	3	5	R390-050C6-11M080	63.0	80.0	40.0	1.2	1.82	23700	5	R390-11..
	18	C5	1.1	15.40	5°	0.0	3	4	R390-050C5-18M060	50.0	60.0	40.0	3.0	1.08	7900	4	R390-18..
	18	C6	1.1	15.40	5°	0.0	3	4	R390-050C6-18M080	63.0	80.0	40.0	3.0	1.85	7900	4	R390-18..
	18	C6	1.1	15.40	5°	0.0	3	4	R390-050C6-18M080	63.0	80.0	40.0	3.0	1.85	7900	4	R390-18..
54.0	11	C5	5.5	10.00	1°	1.0	3	5	R390-054C5-11M060	50.0	60.0		1.2	1.09	22700	5	R390-11..
	11	C5	5.5	10.00	1°	1.0	3	5	R390-054C5-11M080	50.0	80.0		1.2	1.60	22700	5	R390-11..
	18	C5	1.1	15.40	5°	0.0	3	4	R390-054C5-18M060	50.0	60.0		3.0	1.28	7500	4	R390-18..
	18	C5	1.1	15.40	5°	0.0	3	4	R390-054C5-18M060	50.0	60.0		3.0	1.28	7500	4	R390-18..
	18	C5	1.1	15.40	5°	0.0	3	4	R390-054C5-18M080	50.0	80.0		3.0	1.58	7500	4	R390-18..
	18	C5	1.1	15.40	5°	0.0	3	4	R390-054C5-18M080	50.0	80.0		3.0	1.58	7500	4	R390-18..
63.0	11	C5	5.5	10.00	1°	1.0	3	6	R390-063C5-11M060	50.0	60.0		1.2	1.53	20700	6	R390-11..
	11	C6	5.5	10.00	1°	1.0	3	6	R390-063C6-11M080	63.0	80.0	40.0	1.2	2.25	20700	6	R390-11..
	18	C5	1.1	15.40	4°	0.0	3	5	R390-063C5-18M060	50.0	60.0		3.0	1.45	6800	5	R390-18..
18	C6	1.1	15.40	4°	0.0	3	5	R390-063C6-18M060	63.0	60.0	38.0	3.0	1.81	6800	5	R390-18..	



I74



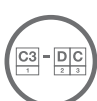
L2



N23



N6



N9

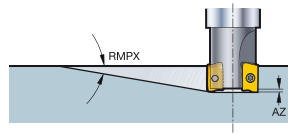


N15



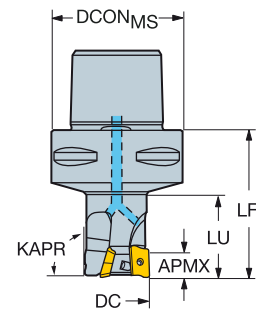
# CoroMill® 390 square shoulder milling cutter

Coromant Capto® - Internal coolant supply



KAPR

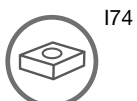
90°



DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	CNSC	CNSC	Ordering code	Dimensions, mm					CICT	MIID
										DCON <sub>MS</sub>	LF	LU	NM	KG		
66.0	11	C6	5.5	10.00	1°	1.0	3	6	R390-066C6-11M060	63.0	60.0	1.2	1.88	20200	6	R390-11..
	11	C6	5.5	10.00	1°	1.0	3	6	R390-066C6-11M080	63.0	80.0	1.2	2.30	20200	6	R390-11..
	18	C6	1.1	15.40	3°	0.0	3	5	R390-066C6-18M060	63.0	60.0	3.0	1.83	6700	5	R390-18..
80.0	11	C6	5.5	10.00	0°	1.0	3	7	R390-080C6-11M060	63.0	60.0	1.2	2.14	18200	7	R390-11..
	11	C6	5.5	10.00	0°	1.0	3	7	R390-080C6-11M080	63.0	80.0	1.2	2.71	18200	7	R390-11..
	18	C6	1.1	15.40	3°	0.0	3	6	R390-080C6-18M060	63.0	60.0	3.0	1.80	5900	6	R390-18..
84.0	18	C8	1.1	15.40	2°	0.0	3	6	R390-084C8-18M070	80.0	70.0	3.0	3.39	5800	6	R390-18..
	18	C8	1.1	15.40	2°	0.0	3	6	R390-084C8-18M100	80.0	100.0	3.0	4.50	5800	6	R390-18..

Spare parts	
DC	Insert screw
16.00-20.00	11 5513 020-36
25.00-80.00	11 5513 020-35
40.00-84.00	18 5513 020-29

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I74



L2



N23



N6



N9

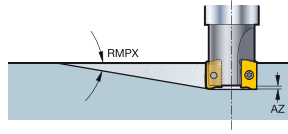


N15

# CoroMill® 390 square shoulder milling cutter

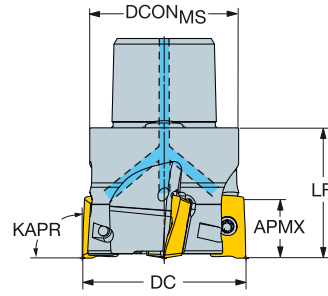
Coromant Capto® - Internal coolant supply

Short version without gripper grooves



KAPR

90°



									Dimensions, mm						
DC	CZC <sub>MS</sub>	APM <sub>EFW</sub>	APM <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code	DCON <sub>MS</sub>	LF	NM	KG	RPMX	CICT	MIID	
44.0	11	C4	5.5	10.00	1°	1.0	3 4	R390-044C4T-11H	40.0	35.0	1.2	0.40	25600	4	R390-11..
	17	C4	8.5	15.70	3°	1.5	3 4	R390-044C4T-17M	40.0	35.0	3.0	0.35	20600	4	R390-17..
54.0	11	C5	5.5	10.00	1°	1.0	3 5	R390-054C5T-11H	50.0	35.0	1.2	0.62	22700	5	R390-11..
	17	C5	8.5	15.70	2°	1.5	3 5	R390-054C5T-17M	50.0	35.0	3.0	0.94	18200	5	R390-17..

Note: Only for segment clamping.

Spare parts	
	Insert screw
11	5513 020-35
17	5513 020-39

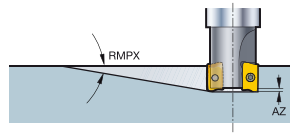
For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 390 square shoulder milling cutter

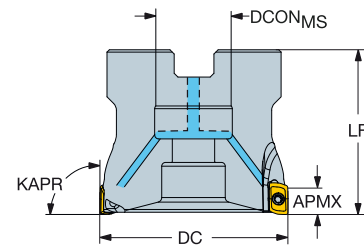
Arbor - Internal coolant supply

Lightweight shoulder milling cutter



STDNO  
KAPR

ISO6462  
90°



										Dimensions, mm							
DC	CZCMS	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code			DCON <sub>MS</sub>	ISO	LF	NM	KG	RPMX	CICT	MIID
40.0	11	16	5.5	10.00	2°	1.0	1	3	R390-040Q16LW-11L	16.0	A	30.0	1.2	0.05	10000	3	R390-11..
	11	16	5.5	10.00	2°	1.0	1	4	R390-040Q16LW-11M	16.0	A	30.0	1.2	0.05	10000	4	R390-11..
50.0	11	22	5.5	10.00	1°	1.0	1	3	R390-050Q22LW-11L	22.0	A	30.0	1.2	0.07	10000	3	R390-11..
	11	22	5.5	10.00	1°	1.0	1	4	R390-050Q22LW-11M	22.0	A	30.0	1.2	0.07	10000	4	R390-11..

Spare parts			
DC		Insert screw	Screw
40.00	11	5513 020-35	3213 010-412
50.00	11	5513 020-35	3213 010-461

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I74



L2



M1



N23



N6



N9



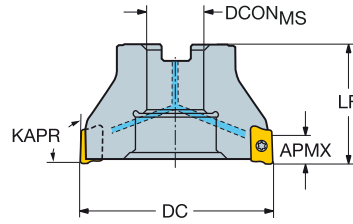
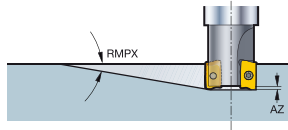
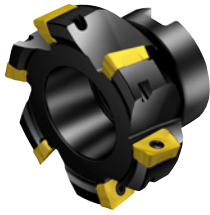
N15

# CoroMill® 390 square shoulder milling cutter

Arbor - Internal coolant supply

STDNO  
KAPR

ISO 6462  
90°



DC	CZC <sub>MS</sub>	APM <sub>KEFW</sub>	APM <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code	Dimensions, mm									
								DCON <sub>MS</sub>	ISO	LF	NM	KG	RPMX	CICT	MID		
40.0	07	16	2.0	5.80	0°	0.5	1	7	R390-040Q16-07M	16.0	A	35.0	0.5	0.20	21500	7	390R-07..
	07	16	2.0	5.80	0°	0.5	1	10	R390-040Q16-07H	16.0	A	35.0	0.5	0.20	21500	10	390R-07..
	11	16	5.5	10.00	2°	1.0	1	4	R390-040Q16-11M	16.0	A	40.0	1.2	0.44	27000	4	R390-11..
	11	16	5.5	10.00	2°	1.0	1	6	R390-040Q16-11H	16.0	A	40.0	1.2	0.50	27000	6	R390-11..
	17	16	8.5	15.70	3°	1.5	1	2	R390-040Q16-17L	16.0	A	40.0	3.0	0.38	21900	2	R390-17..
	17	16	8.5	15.70	3°	1.5	1	3	R390-040Q16-17M	16.0	A	40.0	3.0	0.46	21900	3	R390-17..
	17	16	8.5	15.70	3°	1.5	1	4	R390-040Q16-17H	16.0	A	40.0	3.0	0.20	21900	4	R390-17..
44.0	11	16	5.5	10.00	1°	1.0	1	4	R390-044Q16-11M	16.0	A	40.0	1.2	0.20	25600	4	R390-11..
	17	16	8.5	15.70	3°	1.5	1	3	R390-044Q16-17M	16.0	A	40.0	3.0	0.20	20600	3	R390-17..
50.0	11	22	5.5	10.00	1°	1.0	1	5	R390-050Q22-11M	22.0	A	40.0	1.2	0.35	23700	5	R390-11..
	11	22	5.5	10.00	1°	1.0	1	7	R390-050Q22-11H	22.0	A	40.0	1.2	0.38	23700	7	R390-11..
	17	22	8.5	15.70	2°	1.5	1	3	R390-050Q22-17L	22.0	A	40.0	3.0	0.35	19000	3	R390-17..
	17	22	8.5	15.70	2°	1.5	1	4	R390-050Q22-17M	22.0	A	40.0	3.0	0.32	19000	4	R390-17..
	17	22	8.5	15.70	2°	1.5	1	5	R390-050Q22-17H	22.0	A	40.0	3.0	0.30	19000	5	R390-17..
	18	22	1.1	15.40	5°	0.0	1	3	R390-050Q22-18L	22.0	A	40.0	3.0	0.59	7900	3	R390-18..
	18	22	1.1	15.40	5°	0.0	1	4	R390-050Q22-18M	22.0	A	40.0	3.0	0.58	7900	4	R390-18..
	18	22	1.1	15.40	5°	0.0	1	5	R390-050Q22-18H	22.0	A	40.0	3.0	0.30	7900	5	R390-18..
54.0	11	22	5.5	10.00	1°	1.0	1	5	R390-054Q22-11M	22.0	A	40.0	1.2	0.39	22600	5	R390-11..
	17	22	8.5	15.70	2°	1.5	1	4	R390-054Q22-17M	22.0	A	40.0	3.0	0.37	18200	4	R390-17..
	18	22	1.1	15.40	5°	0.0	1	4	R390-054Q22-18M	22.0	A	40.0	3.0	0.30	7500	4	R390-18..
63.0	11	22	5.5	10.00	1°	1.0	1	6	R390-063Q22-11M	22.0	A	40.0	1.2	0.68	20700	6	R390-11..
	11	22	5.5	10.00	1°	1.0	1	8	R390-063Q22-11H	22.0	A	40.0	1.2	0.48	20700	8	R390-11..
	17	22	8.5	15.70	2°	1.5	1	4	R390-063Q22-17L	22.0	A	40.0	3.0	0.50	16500	4	R390-17..
	17	22	8.5	15.70	2°	1.5	1	5	R390-063Q22-17M	22.0	A	40.0	3.0	0.48	16500	5	R390-17..
	17	22	8.5	15.70	2°	1.5	1	6	R390-063Q22-17H	22.0	A	40.0	3.0	0.68	16500	6	R390-17..
	18	22	1.1	15.40	4°	0.0	1	4	R390-063Q22-18L	22.0	A	40.0	3.0	0.81	6800	4	R390-18..
	18	22	1.1	15.40	4°	0.0	1	5	R390-063Q22-18M	22.0	A	40.0	3.0	0.70	6800	5	R390-18..
	18	22	1.1	15.40	4°	0.0	1	6	R390-063Q22-18H	22.0	A	40.0	3.0	0.70	6800	6	R390-18..
66.0	11	22	5.5	10.00	3°	1.0	1	6	R390-066Q22-11M	22.0	A	40.0	1.2	0.72	20200	6	R390-11..
	17	22	8.5	15.70	1°	1.5	1	5	R390-066Q22-17M	22.0	A	40.0	3.0	0.50	16100	5	R390-17..
	18	22	1.1	15.40	3°	0.0	1	6	R390-066Q22-18M	22.0	A	40.0	3.0	0.71	6700	5	R390-18..
80.0	11	27	5.5	10.00	0°	1.0	1	7	R390-080Q27-11M	27.0	A	50.0	1.2	1.08	18200	7	R390-11..
	11	27	5.5	10.00	0°	1.0	1	10	R390-080Q27-11H	27.0	A	50.0	1.2	0.72	18200	10	R390-11..
	17	27	8.5	15.70	1°	1.5	1	4	R390-080Q27-17L	27.0	A	50.0	3.0	1.06	14400	4	R390-17..
	17	27	8.5	15.70	1°	1.5	1	6	R390-080Q27-17M	27.0	A	50.0	3.0	0.96	14400	6	R390-17..
	17	27	8.5	15.70	1°	1.5	1	8	R390-080Q27-17H	27.0	A	50.0	3.0	0.94	14400	8	R390-17..
	18	27	1.1	15.40	3°	0.0	1	4	R390-080Q27-18L	27.0	A	50.0	3.0	1.05	5900	4	R390-18..
	18	27	1.1	15.40	3°	0.0	1	6	R390-080Q27-18M	27.0	A	50.0	3.0	1.00	5900	6	R390-18..
84.0	11	27	5.5	10.00	3°	1.0	1	7	R390-084Q27-11M	27.0	A	50.0	1.2	1.41	17700	7	R390-11..
	17	27	8.5	15.70	1°	1.5	1	6	R390-084Q27-17M	27.0	A	50.0	3.0	1.07	14100	6	R390-17..
	18	27	1.1	15.40	3°	0.0	1	6	R390-084Q27-18M	27.0	A	50.0	3.0	1.25	5800	6	R390-18..
100.0	17	32	8.5	15.70	0°	1.5	1	5	R390-100Q32-17L	32.0	B	50.0	3.0	1.77	12700	5	R390-17..
	17	32	8.5	15.70	0°	1.5	1	7	R390-100Q32-17M	32.0	B	50.0	3.0	1.73	12700	7	R390-17..
	17	32	8.5	15.70	0°	1.5	1	9	R390-100Q32-17H	32.0	B	50.0	3.0	1.57	12700	9	R390-17..
	18	32	1.1	15.40	2°	0.0	1	5	R390-100Q32-18L	32.0	B	50.0	3.0	1.83	5200	5	R390-18..
	18	32	1.1	15.40	2°	0.0	1	7	R390-100Q32-18M	32.0	B	50.0	3.0	1.75	5200	7	R390-18..
125.0	17	40	8.5	15.70	0°	1.5	1	6	R390-125Q40-17L	40.0	B	63.0	3.0	2.71	11200	6	R390-17..
	17	40	8.5	15.70	0°	1.5	1	8	R390-125Q40-17M	40.0	B	63.0	3.0	2.70	11200	8	R390-17..
	17	40	8.5	15.70	0°	1.5	1	11	R390-125Q40-17H	40.0	B	63.0	3.0	2.74	11200	11	R390-17..
	18	40	1.1	15.40	1°	0.0	1	6	R390-125Q40-18L	40.0	B	63.0	3.0	2.72	4600	6	R390-18..
	18	40	1.1	15.40	1°	0.0	1	8	R390-125Q40-18M	40.0	B	63.0	3.0	2.76	4600	8	R390-18..



174



L2



M1



N23



N6



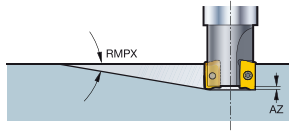
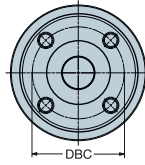
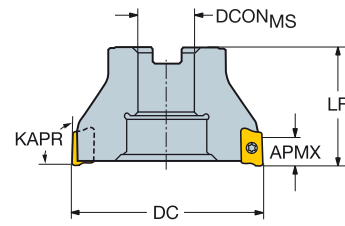
N9








N15

# CoroMill® 390 square shoulder milling cutter

Arbor

STDNO  
KAPRISO6462  
90°

										Dimensions, mm								
DC		CZC <sub>MS</sub>	APM <sub>EFW</sub>	APM <sub>FFW</sub>	RMPX	AZ	CNSC		Ordering code	DCON <sub>MS</sub>	ISO	DBC	LF			RPMX	CICT	MIID
160.0	18	40S	1.1	15.40	1°	0.0	0	8	R390-160Q40-18L	40.0	C	66.7	63.0	3.0	3.33	4000	8	R390-18..
	18	40S	1.1	15.40	1°	0.0	0	12	R390-160Q40-18M	40.0	C	66.7	63.0	3.0	4.00	4000	12	R390-18..
200.0	18	60	1.1	15.40	1°	0.0	0	10	R390-200Q60-18L	60.0	C	101.6	63.0	3.0	5.38	3600	10	R390-18..

Spare parts	
	Insert screw
07	5513 020-82
11	5513 020-35
17	5513 020-39
18	5513 020-29

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

I74



L2



M1



N23



N6



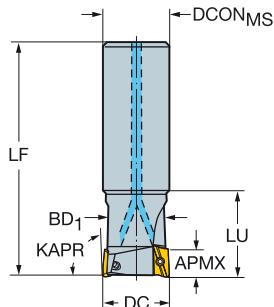
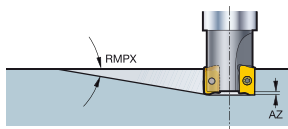
N9

# CoroMill® 390 square shoulder milling cutter

Cylindrical shank - Internal coolant supply

KAPR

90°



											Dimensions, mm								
DC		CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC			Ordering code	DCON <sub>MS</sub>	BD <sub>1</sub>	LF	LU	NM	KG	RPMX	CICT	MIID
9.7	07	10	2.0	5.80	7°	0.5	1	2	R390-0097A10-07L	10.0	9.2	60.0	15.0	0.5	0.07	55600	2	390R-07..	
10.0	07	9	2.0	5.80	7°	0.5	1	2	R390-010A09L-07L	9.0	9.3	100.0		0.5	0.08	54100	2	390R-07..	
	07	10	2.0	5.80	7°	0.5	1	2	R390-010A10-07L	10.0	9.3	60.0	15.0	0.5	0.07	54100	2	390R-07..	
11.7	07	12	2.0	5.80	5°	0.5	1	2	R390-0117A12-07L	12.0	11.0	70.0	15.0	0.5	0.09	47400	2	390R-07..	
	07	12	2.0	5.80	5°	0.5	1	3	R390-0117A12-07M	12.0	11.0	70.0	15.0	0.5	0.09	47400	3	390R-07..	
12.0	07	10	2.0	5.80	5°	0.5	1	2	R390-012A10L-07L	10.0	11.3	120.0		0.5	0.11	46500	2	390R-07..	
	07	12	2.0	5.80	5°	0.5	1	2	R390-012A12-07L	12.0	11.3	70.0	18.0	0.5	0.09	46500	2	390R-07..	
	07	12	2.0	5.80	5°	0.5	1	3	R390-012A12-07M	12.0	11.3	70.0	18.0	0.5	0.09	46500	3	390R-07..	
11	16	5.5	10.00	6°	1.0	1	1	1	R390-012A16-11L	16.0		95.0	17.2	1.2	0.24	68600	1	R390-11..	
13.7	07	14	2.0	5.80	3°	0.5	1	2	R390-0137A14-07L	14.0	12.9	80.0	15.0	0.5	0.12	42000	2	390R-07..	
	07	14	2.0	5.80	3°	0.5	1	3	R390-0137A14-07M	14.0	12.9	80.0	15.0	0.5	0.12	42000	3	390R-07..	
14.0	07	12	2.0	5.80	3°	0.5	1	3	R390-014A12L-07M	12.0	13.2	140.0		0.5	0.16	33800	3	390R-07..	
	07	14	2.0	5.80	3°	0.5	1	3	R390-014A14-07M	14.0	13.2	80.0	20.0	0.5	0.12	41400	3	390R-07..	
15.7	07	16	2.0	5.80	3°	0.5	1	3	R390-0157A16-07M	16.0	14.7	90.0	18.0	0.5	0.16	38100	3	390R-07..	
16.0	07	14	2.0	5.80	3°	0.5	1	3	R390-016A14L-07M	14.0	15.0	160.0		0.5	0.23	24100	3	390R-07..	
	07	16	2.0	5.80	3°	0.5	1	3	R390-016A16-07M	16.0	15.0	90.0	25.0	0.5	0.16	37600	3	390R-07..	
	07	16	2.0	5.80	3°	0.5	1	4	R390-016A16-07H	16.0	15.0	90.0	25.0	0.5	0.16	37600	4	390R-07..	
	11	16	5.5	10.00	10°	1.0	1	2	R390-016A16-11L	16.0		100.0	25.0	1.2	0.15	41500	2	R390-11..	
	11	16	5.5	10.00	10°	1.0	1	2	R390-016A16L-11L	16.0		145.0	25.0	1.2	0.23	31000	2	R390-11..	
18.0	11	16	5.5	10.00	7°	1.0	1	2	R390-018A16L-11L	16.0		145.0		1.2	0.20	31000	2	R390-11..	
20.0	07	20	2.0	5.80	2°	0.5	1	4	R390-020A20-07M	20.0	19.0	110.0	25.0	0.5	0.29	32500	4	390R-07..	
	07	20	2.0	5.80	2°	0.5	1	5	R390-020A20-07H	20.0	19.0	110.0	25.0	0.5	0.27	32500	5	390R-07..	
	11	20	5.5	10.00	5°	1.0	1	2	R390-020A20-11L	20.0		110.0	25.0	1.2	0.26	34600	2	R390-11..	
	11	20	5.5	10.00	5°	1.0	1	2	R390-020A20L-11L	20.0		170.0	40.0	1.2	0.50	20300	2	R390-11..	
	11	20	5.5	10.00	5°	1.0	1	3	R390-020A20-11M	20.0		110.0	25.0	1.2	0.34	34600	3	R390-11..	
22.0	11	20	5.5	10.00	5°	1.0	1	2	R390-022A20L-11L	20.0		170.0		1.2	0.41	20300	2	R390-11..	
25.0	07	25	2.0	5.80	1°	0.5	1	5	R390-025A25-07M	25.0	24.0	120.0	32.0	0.5	0.46	28200	5	390R-07..	
	07	25	2.0	5.80	1°	0.5	1	7	R390-025A25-07H	25.0	24.0	120.0	32.0	0.5	0.47	28200	7	390R-07..	
	11	25	5.5	10.00	5°	1.0	1	2	R390-025A25-11L	25.0		120.0	32.0	1.2	0.54	36500	2	R390-11..	
	11	25	5.5	10.00	5°	1.0	1	2	R390-025A25L-11L	25.0		210.0	50.0	1.2	0.83	11000	2	R390-11..	
	11	25	5.5	10.00	5°	1.0	1	3	R390-025A25-11M	25.0		120.0	32.0	1.2	0.42	36500	3	R390-11..	
	11	25	5.5	10.00	5°	1.0	1	4	R390-025A25-11H	25.0		120.0	32.0	1.2	0.54	36500	4	R390-11..	
	17	25	8.5	15.70	15°	1.5	1	2	R390-025A25-17L	25.0		120.0	32.0	3.0	0.50	30800	2	R390-17..	
	17	25	8.5	15.70	15°	1.5	1	2	R390-025A25L-17L	25.0		210.0	50.0	3.0	0.84	11000	2	R390-17..	
30.0	11	25	5.5	10.00	3°	1.0	1	2	R390-030A25L-11L	25.0		210.0		1.2	0.86	11000	2	R390-11..	
32.0	11	32	5.5	10.00	3°	1.0	1	2	R390-032A32-11L	32.0		130.0	40.0	1.2	0.74	31000	2	R390-11..	
	11	32	5.5	10.00	3°	1.0	1	2	R390-032A32L-11L	32.0		250.0	65.0	1.2	1.66	7600	2	R390-11..	
	11	32	5.5	10.00	3°	1.0	1	3	R390-032A32-11M	32.0		130.0	40.0	1.2	0.82	31000	3	R390-11..	
	11	32	5.5	10.00	3°	1.0	1	5	R390-032A32-11H	32.0		130.0	40.0	1.2	0.79	31000	5	R390-11..	
	17	32	8.5	15.70	6°	1.5	1	2	R390-032A32-17L	32.0		130.0	40.0	3.0	0.82	25600	2	R390-17..	
	17	32	8.5	15.70	6°	1.5	1	2	R390-032A32L-17L	32.0		250.0	65.0	3.0	1.67	7600	2	R390-17..	
	17	32	8.5	15.70	6°	1.5	1	3	R390-032A32-17M	32.0		130.0	40.0	3.0	0.81	25600	3	R390-17..	



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L2



N23



N6



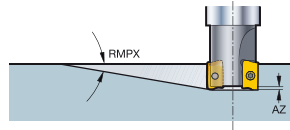
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N15

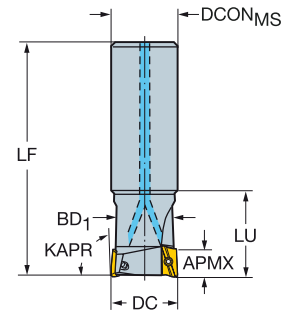
# CoroMill® 390 square shoulder milling cutter

Cylindrical shank - Internal coolant supply



KAPR

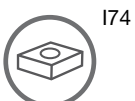
90°



											Dimensions, mm							
DC	CZC <sub>MS</sub>	APM <sub>EFW</sub>	APM <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code		DCON <sub>MS</sub>	BD <sub>1</sub>	LF	LU	NM	KG	RPMX	CICT	MIID	
40.0	11	32	5.5	10.00	2°	1.0	1	2	R390-040A32-11L	32.0	170.0	1.2	1.19	27000	2	R390-11..		
11	32	5.5	10.00	2°	1.0	1	2	R390-040A32L-11L	32.0	250.0	1.2	1.82	7600	2	R390-11..			
11	32	5.5	10.00	2°	1.0	1	4	R390-040A32-11M	32.0	170.0	1.2	1.16	27000	4	R390-11..			
11	32	5.5	10.00	2°	1.0	1	6	R390-040A32-11H	32.0	170.0	1.2	1.19	27000	6	R390-11..			
17	32	8.5	15.70	3°	1.5	1	2	R390-040A32-17L	32.0	170.0	3.0	1.19	21900	2	R390-17..			
17	32	8.5	15.70	3°	1.5	1	2	R390-040A32L-17L	32.0	250.0	3.0	1.84	7600	2	R390-17..			
17	32	8.5	15.70	3°	1.5	1	3	R390-040A32-17M	32.0	170.0	3.0	1.14	21900	3	R390-17..			
17	32	8.5	15.70	3°	1.5	1	4	R390-040A32-17H	32.0	170.0	3.0	1.14	21900	4	R390-17..			

		Spare parts	
DC	Insert screw		
10.00-25.00	07	5513 020-82	
12.00-22.00	11	5513 020-36	
25.00-40.00	11	5513 020-35	
25.00	17	5513 020-37	
32.00-40.00	17	5513 020-39	

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



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L2



N23



N6



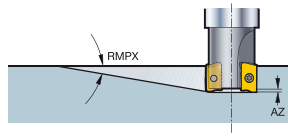
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N15

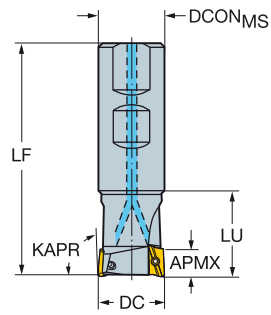
# CoroMill® 390 square shoulder milling cutter

Weldon - Internal coolant supply



KAPR

90°



										Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC			Ordering code	DCON <sub>MS</sub>	ISO	LF	LU	NM	KG	RPMX	CICT	MIID	
12.0	11	16	5.5	10.00	6°	1.0	1	1	R390-012B16-11L	16.0	WE	68.0	17.2	1.2	0.18	68600	1	R390-11..	
16.0	11	16	5.5	10.00	10°	1.0	1	2	R390-016B16-11L	16.0	WE	73.0	25.0	1.2	0.11	41500	2	R390-11..	
20.0	11	20	5.5	10.00	5°	1.0	1	2	R390-020B20-11L	20.0	WE	81.0	25.0	1.2	0.19	34600	2	R390-11..	
	11	20	5.5	10.00	5°	1.0	1	3	R390-020B20-11M	20.0	WE	81.0	25.0	1.2	0.29	34600	3	R390-11..	
25.0	11	25	5.5	10.00	5°	1.0	1	2	R390-025B25-11L	25.0	WE	88.0	32.0	1.2	0.41	36500	2	R390-11..	
	11	25	5.5	10.00	5°	1.0	1	3	R390-025B25-11M	25.0	WE	88.0	32.0	1.2	0.38	36500	3	R390-11..	
	11	25	5.5	10.00	5°	1.0	1	4	R390-025B25-11H	25.0	WE	88.0	32.0	1.2	0.38	36500	4	R390-11..	
	17	25	8.5	15.70	15°	1.5	1	2	R390-025B25-17L	25.0	WE	88.0	32.0	3.0	0.41	30800	2	R390-17..	
32.0	11	32	5.5	10.00	3°	1.0	1	2	R390-032B32-11L	32.0	WE	100.0	40.0	1.2	0.65	31000	2	R390-11..	
	11	32	5.5	10.00	3°	1.0	1	3	R390-032B32-11M	32.0	WE	100.0	40.0	1.2	0.68	31000	3	R390-11..	
	11	32	5.5	10.00	3°	1.0	1	5	R390-032B32-11H	32.0	WE	100.0	40.0	1.2	0.65	31000	5	R390-11..	
	17	32	8.5	15.70	6°	1.5	1	2	R390-032B32-17L	32.0	WE	100.0	40.0	3.0	0.64	25600	2	R390-17..	
	17	32	8.5	15.70	6°	1.5	1	3	R390-032B32-17M	32.0	WE	100.0	40.0	3.0	0.62	25600	3	R390-17..	
40.0	11	32	5.5	10.00	2°	1.0	1	4	R390-040B32-11M	32.0	WE	110.0		1.2	0.81	27000	4	R390-11..	
	11	32	5.5	10.00	2°	1.0	1	6	R390-040B32-11H	32.0	WE	110.0		1.2	0.84	27000	6	R390-11..	
	17	32	8.5	15.70	3°	1.5	1	2	R390-040B32-17L	32.0	WE	110.0		3.0	0.82	21900	2	R390-17..	
	17	32	8.5	15.70	3°	1.5	1	3	R390-040B32-17M	32.0	WE	110.0		3.0	0.80	21900	3	R390-17..	
	17	32	8.5	15.70	3°	1.5	1	4	R390-040B32-17H	32.0	WE	110.0		3.0	0.80	21900	4	R390-17..	

Spare parts		
DC		Insert screw
12.00-20.00	11	5513 020-36
25.00-40.00	11	5513 020-35
25.00	17	5513 020-37
32.00-40.00	17	5513 020-39

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



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L2



N23



N6



N9

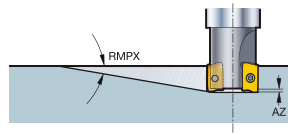


N15



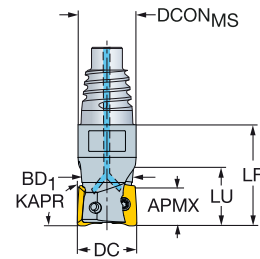
# CoroMill® 390 square shoulder milling cutter

Coromant EH - Internal coolant supply



KAPR

90°



DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	CNSC	Ordering code	Dimensions, mm										
									DC	BD	LB	LF	LU	NM	KG	RPMX	CICT	MIID	
9.7	07	E10	2.0	5.80	7°	0.5	1	2	R390-0097EH10-07L	9.7	9.2	12.5	20.0	12.5	0.5	0.12	55600	2	390R-07..
10.0	07	E10	2.0	5.80	7°	0.5	1	2	R390-010EH10-07L	9.7	9.3	12.5	20.0	12.5	0.5	0.07	54100	2	390R-07..
11.7	07	E12	2.0	5.80	5°	0.5	1	2	R390-0117EH12-07L	11.7	11.0	11.9	20.0	11.9	0.5	0.04	47400	2	390R-07..
12.0	07	E12	2.0	5.80	5°	0.5	1	2	R390-012EH12-07L	11.7	11.3	11.9	20.0	11.9	0.5	0.12	46500	2	390R-07..
	07	E12	2.0	5.80	5°	0.5	1	3	R390-012EH12-07M	11.7	11.3	11.9	20.0	11.9	0.5	0.07	46500	3	390R-07..
13.7	07	E12	2.0	5.80	3°	0.5	1	2	R390-0137EH12-07L	11.7	12.9	20.0	20.0		0.5	0.13	42000	2	390R-07..
	07	E12	2.0	5.80	3°	0.5	1	3	R390-0137EH12-07M	11.7	12.9	20.0	20.0		0.5	0.12	42000	3	390R-07..
14.0	07	E12	2.0	5.80	3°	0.5	1	3	R390-014EH12-07M	11.7	13.2	20.0	20.0		0.5	0.07	41400	3	390R-07..
15.7	07	E16	2.0	5.80	3°	0.5	1	3	R390-0157EH16-07M	15.5	14.7	15.7	25.0	15.7	0.5	0.10	38100	3	390R-07..
16.0	07	E16	2.0	5.80	3°	0.5	1	3	R390-016EH16-07M	15.5	15.0	15.7	25.0	15.7	0.5	0.09	37600	3	390R-07..
	07	E16	2.0	5.80	3°	0.5	1	4	R390-016EH16-07H	15.5	15.0	15.7	25.0	15.7	0.5	0.14	37600	4	390R-07..
	11	E16	5.5	10.00	10°	1.0	1	2	R390-016EH16-11L	15.5			27.0		1.2	0.08	41500	2	R390-11..
18.0	07	E16	2.0	5.80	2°	0.5	1	3	R390-018EH16-07M	15.5	17.0	25.0	25.0		0.5	0.10	34800	3	390R-07..
	11	E16	5.5	10.00	5°	1.0	1	2	R390-018EH16-11L	15.5			27.0		1.2	0.11	31000	2	R390-11..
20.0	07	E20	2.0	5.80	2°	0.5	1	4	R390-020EH20-07M	19.3	19.0	14.4	25.0	14.4	0.5	0.10	32500	4	390R-07..
	07	E20	2.0	5.80	2°	0.5	1	5	R390-020EH20-07H	19.3	19.0	14.4	25.0	14.4	0.5	0.16	32500	5	390R-07..
	11	E20	5.5	10.00	5°	1.0	1	2	R390-020EH20-11L	19.3			30.0		1.2	0.13	34600	2	R390-11..
	11	E20	5.5	10.00	5°	1.0	1	3	R390-020EH20-11M	19.3			30.0		1.2	0.13	34600	3	R390-11..
22.0	11	E20	5.5	10.00	5°	1.0	1	2	R390-022EH20-11L	19.3			30.0		1.2	0.14	36500	2	R390-11..
	11	E20	5.5	10.00	5°	1.0	1	3	R390-022EH20-11M	19.3			30.0		1.2	0.14	36500	3	R390-11..
25.0	07	E20	2.0	5.80	1°	0.5	1	5	R390-025EH20-07M	19.3	24.0	25.0	25.0		0.5	0.07	28200	5	390R-07..
	07	E25	2.0	5.80	1°	0.5	1	5	R390-025EH25-07M	24.2	24.0	13.9	25.0	13.9	0.5	0.20	28200	5	390R-07..
	07	E20	2.0	5.80	1°	0.5	1	7	R390-025EH20-07H	19.3	24.0	25.0	25.0		0.5	0.07	28200	7	390R-07..
	07	E25	2.0	5.80	1°	0.5	1	7	R390-025EH25-07H	24.2	24.0	13.9	25.0	13.9	0.5	0.20	28200	7	390R-07..
	11	E25	5.5	10.00	5°	1.0	1	2	R390-025EH25-11L	24.2			35.0		1.2	0.13	36400	2	R390-11..
	11	E25	5.5	10.00	5°	1.0	1	3	R390-025EH25-11M	24.2			35.0		1.2	0.14	36400	3	R390-11..
	11	E25	5.5	10.00	5°	1.0	1	4	R390-025EH25-11H	24.2			35.0		1.2	0.19	36400	4	R390-11..
	17	E25	8.5	15.70	15°	1.5	1	2	R390-025EH25-17L	24.2			40.0		3.0	0.20	30800	2	R390-17..
28.0	11	E25	5.5	10.00	1°	1.0	1	2	R390-028EH25-11L	24.2			35.0		1.2	0.20	31000	2	R390-11..
	11	E25	5.5	10.00	2°	1.0	1	3	R390-028EH25-11M	24.2			35.0		1.2	0.20	31000	3	R390-11..
32.0	07	E25	2.0	5.80	1°	0.5	1	6	R390-032EH25-07M	24.2	30.4	25.0	25.0		0.5	0.12	24400	6	390R-07..
	07	E25	2.0	5.80	1°	0.5	1	8	R390-032EH25-07H	24.2	30.4	25.0	25.0		0.5	0.12	24400	8	390R-07..
	11	E25	5.5	10.00	3°	1.0	1	2	R390-032EH25-11L	24.2			35.0		1.2	0.23	31000	2	R390-11..
	11	E25	5.5	10.00	3°	1.0	1	3	R390-032EH25-11M	24.2			35.0		1.2	0.21	31000	3	R390-11..
	11	E25	5.5	10.00	3°	1.0	1	5	R390-032EH25-11H	24.2			35.0		1.2	0.21	31000	5	R390-11..
	17	E25	8.5	15.70	6°	1.5	1	2	R390-032EH25-17L	24.2			40.0		3.0	0.22	25600	2	R390-17..
	17	E25	8.5	15.70	6°	1.5	1	3	R390-032EH25-17M	24.2			40.0		3.0	0.18	25600	3	R390-17..

Spare parts	
DC	Insert screw
10.00-32.00	07 5513 020-82
16.00-22.00	11 5513 020-36
25.00-32.00	11 5513 020-35
25.00	17 5513 020-37
32.00	17 5513 020-39

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I74



L2



N23



N6



N9



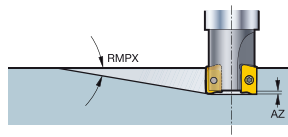
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N3

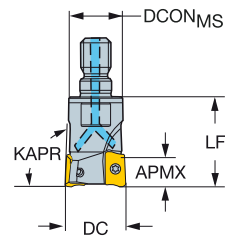
# CoroMill® 390 square shoulder milling cutter

Threaded coupling - Internal coolant supply



KAPR

90°



									Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC		Ordering code	DCON <sub>MS</sub>	LF	NM	KG	RPMX	CICT	MIID	
16.0	11	M8	5.5	10.00	10°	1.0	0	2	R390-16T08-11L	12.8	25.0	1.2	0.13	10900	2	R390-11..
20.0	11	M10	5.5	10.00	5°	1.0	1	2	R390-20T10-11L	17.8	30.0	1.2	0.16	9900	2	R390-11..
	11	M10	5.5	10.00	5°	1.0	1	3	R390-20T10-11M	17.8	30.0	1.2	0.18	9900	3	R390-11..
25.0	11	M12	5.5	10.00	5°	1.0	1	2	R390-25T12-11L	20.8	35.0	1.2	0.20	8100	2	R390-11..
	11	M12	5.5	10.00	5°	1.0	1	3	R390-25T12-11M	20.8	35.0	1.2	0.20	8100	3	R390-11..
32.0	11	M16	5.5	10.00	3°	1.0	1	2	R390-32T16-11L	28.8	45.0	1.2	0.32	9100	2	R390-11..
	11	M16	5.5	10.00	3°	1.0	1	3	R390-32T16-11M	28.8	45.0	1.2	0.31	9100	3	R390-11..
35.0	11	M16	5.5	10.00	3°	1.0	1	2	R390-35T16-11L	28.8	45.0	1.2	0.39	9100	2	R390-11..
	11	M16	5.5	10.00	3°	1.0	1	3	R390-35T16-11M	28.8	45.0	1.2	0.34	9100	3	R390-11..
40.0	11	M16	5.5	10.00	2°	1.0	1	2	R390-40T16-11L	28.8	45.0	1.2	0.40	9100	2	R390-11..
	11	M16	5.5	10.00	2°	1.0	1	4	R390-40T16-11M	28.8	45.0	1.2	0.40	9100	4	R390-11..
42.0	11	M16	5.5	10.00	1°	1.0	1	4	R390-42T16-11M	28.8	45.0	1.2	0.40	9100	4	R390-11..

Spare parts		
DC		Insert screw
16.00-20.00	11	5513 020-36
25.00-42.00	11	5513 020-35

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I74



N23



N6



N9



N15



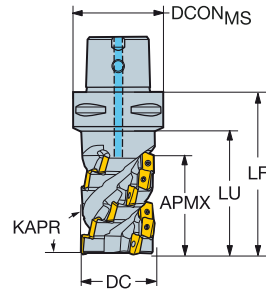
N3

# CoroMill® 390 long edge square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR

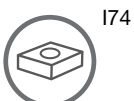
90°



DC	CZC <sub>MS</sub>	APM <sub>FFW</sub>	CNSC	Ordering code	Dimensions, mm							CICT	MID	
					DCON <sub>MS</sub>	LF	LU	NM	KG	RPMX				
32.0	11	C5	36.00	3	2	R390-032C5-36L	50.0	71.7	46.0	1.2	1.12	21700	8	R390-11..
	11	C5	36.00	3	3	R390-032C5-36M	50.0	71.7	45.0	1.2	0.60	21700	12	R390-11..
	11	C5	54.00	3	2	R390-032C5-54L	50.0	89.4	63.0	1.2	1.14	21700	12	R390-11..
	11	C6	63.00	3	2	R390-032C6-63L	63.0	100.2	72.0	1.2	1.51	21700	14	R390-11..
	11	C6	45.00	3	3	R390-032C6-45M	63.0	82.5	54.0	1.2	1.40	21700	15	R390-11..
	11	C5	54.00	3	3	R390-032C5-54M	50.0	89.4	63.0	1.2	1.16	21700	18	R390-11..
36.0	11	C3	36.00	3	2	R390-036C3-36L	32.0	66.7	66.0	1.2	0.70	20200	8	R390-11..
	11	C3	36.00	3	3	R390-036C3-36M	32.0	66.7	66.0	1.2	0.65	20200	12	R390-11..
	11	C5	54.00	3	3	R390-040C5-54M	50.0	89.4	63.0	1.2	0.80	18900	18	R390-11..
40.0	11	C6	63.00	3	3	R390-040C6-63M	63.0	100.2	72.0	1.2	1.28	18900	21	R390-11..
	11	C5	54.00	3	4	R390-040C5-54H	50.0	89.4	63.0	1.2	1.31	18900	24	R390-11..
	11	C6	63.00	3	4	R390-040C6-63H	63.0	100.2	72.0	1.2	1.65	18900	28	R390-11..
	11	C4	45.00	3	3	R390-044C4-45M	40.0	80.5		1.2	0.97	17800	15	R390-11..
	18	C4	43.00	3	2	R390-044C4-43L	40.0	78.6		3.0	0.90	8600	6	R390-18..
44.0	18	C5	43.00	3	2	R390-044C5-43L	50.0	78.6	53.0	3.0	1.29	9200	6	R390-18..
	18	C5	57.00	3	2	R390-044C5-57L	50.0	92.6	67.0	3.0	1.36	9200	8	R390-18..
	18	C6	57.00	3	2	R390-044C6-57L	63.0	94.6	67.0	3.0	1.69	9200	8	R390-18..
	11	C5	36.00	3	3	R390-050C5-36L	50.0	71.7	50.0	1.2	1.31	16600	12	R390-11..
	11	C5	36.00	3	4	R390-050C5-36M	50.0	71.7	50.0	1.2	1.44	16600	16	R390-11..
	11	C5	54.00	3	3	R390-050C5-54L	50.0	89.4	67.0	1.2	1.20	16600	18	R390-11..
50.0	11	C5	36.00	3	5	R390-050C5-36H	50.0	71.7	50.0	1.2	1.29	16600	20	R390-11..
	11	C5	54.00	3	4	R390-050C5-54M	50.0	89.4	67.0	1.2	1.59	16600	24	R390-11..
	11	C6	63.00	3	4	R390-050C6-63M	63.0	100.2	72.0	1.2	1.99	16600	28	R390-11..
	11	C6	63.00	3	5	R390-050C6-63H	63.0	100.2	72.0	1.2	2.00	16600	35	R390-11..
	18	C5	43.00	3	2	R390-050C5-43L	50.0	78.6	53.0	3.0	1.00	7900	6	R390-18..
	18	C6	43.00	3	3	R390-050C6-43M	63.0	80.6	53.0	3.0	1.70	7900	9	R390-18..
	18	C6	71.00	3	2	R390-050C6-71L	63.0	108.7	81.0	3.0	2.04	7900	10	R390-18..
	18	C8	57.00	3	3	R390-050C8-57M	80.0	102.6	67.0	3.0	2.76	7900	12	R390-18..
	18	C6	71.00	3	3	R390-050C6-71M	63.0	108.7	81.0	3.0	1.50	7900	15	R390-18..
	54.0	11	C5	54.00	3	4	R390-054C5-54M	50.0	89.4		1.2	1.70	16000	24
18		C5	43.00	3	3	R390-054C5-43M	50.0	78.6		3.0	1.00	7500	9	R390-18..
18		C6	43.00	3	4	R390-063C6-43M	63.0	80.6	53.0	3.0	2.09	6800	12	R390-18..
63.0	18	C6	57.00	3	3	R390-063C6-57L	63.0	94.6	67.0	3.0	2.36	6800	12	R390-18..
	18	C8	57.00	3	4	R390-063C8-57M	80.0	102.6	67.0	3.0	3.19	6800	16	R390-18..
	18	C8	85.00	3	3	R390-063C8-85L	80.0	130.7	95.0	3.0	3.73	6800	18	R390-18..
	18	C6	45.00	3	4	R390-066C6-45M	63.0	82.5		1.2	2.00	13900	20	R390-11..
66.0	18	C6	57.00	3	3	R390-066C6-57L	63.0	94.6		3.0	2.47	6700	12	R390-18..
	18	C8	71.00	3	3	R390-080C8-71L	80.0	116.7	81.0	3.0	4.64	5900	15	R390-18..
	18	C8	57.00	3	5	R390-080C8-57H	80.0	102.6	67.0	3.0	4.04	5900	20	R390-18..
84.0	18	C8	57.00	3	4	R390-084C8-57M	80.0	102.6		3.0	4.15	5800	16	R390-18..
100.0	18	C8	57.00	3	4	R390-100C8-57M	80.0	102.6		3.0	5.46	5200	16	R390-18..
	18	C8	71.00	3	4	R390-100C8-71M	80.0	116.7		3.0	6.01	5200	20	R390-18..
	18	C8	57.00	3	6	R390-100C8-57H	80.0	102.6		3.0	5.08	5200	24	R390-18..

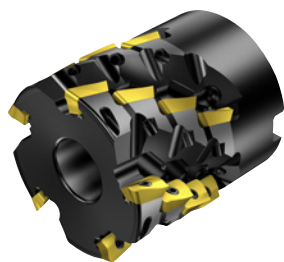
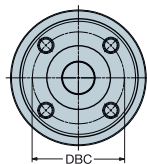
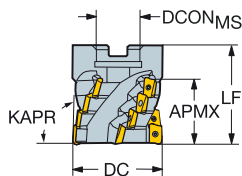
Spare parts	
	Insert screw
11	5513 024-01
18	5513 036-01

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 390 long edge square shoulder milling cutter

Arbor

STDNO  
KAPRISO6462  
90°

						Dimensions, mm								
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>		Ordering code	DCON <sub>MS</sub>	ISO	DBC	LF	NM	KG	RPMX	CICT	MID	
40.0	11	16	36.00	3	R390-040Q16-36M	16.0	A	56.7	1.2	0.80	18900	12	R390-11..	
	11	16	36.00	4	R390-040Q16-36H	16.0	A	56.7	1.2	0.30	18900	16	R390-11..	
44.0	11	16	45.00	3	R390-044Q16-45M	16.0	A	65.5	1.2	0.98	17800	15	R390-11..	
	18	16	43.00	2	R390-044Q16-43L	16.0	A	68.6	3.0	0.91	8600	6	R390-18..	
50.0	11	22	36.00	4	R390-050Q22-36M	22.0	A	56.7	1.2	0.94	16600	16	R390-11..	
	11	22	54.00	3	R390-050Q22-54L	22.0	A	74.4	1.2	1.09	16600	18	R390-11..	
	11	22	36.00	5	R390-050Q22-36H	22.0	A	56.7	1.2	0.99	16600	20	R390-11..	
	18	22	57.00	2	R390-050Q22-57L	22.0	A	82.6	3.0	1.09	7900	8	R390-18..	
54.0	11	22	36.00	4	R390-054Q22-36M	22.0	A	56.7	1.2	1.08	16000	16	R390-11..	
	18	22	57.00	2	R390-054Q22-57L	22.0	A	82.6	3.0	0.91	7500	8	R390-18..	
63.0	18	27	57.00	3	R390-063Q27-57L	27.0	A	82.6	3.0	1.58	6800	12	R390-18..	
80.0	18	32	71.00	3	R390-080Q32-71L	32.0	A	96.7	3.0	2.88	5900	15	R390-18..	
100.0	18	40	57.00	4	R390-100Q40-57M	40.0	B	82.6	3.0	3.37	5200	16	R390-18..	
125.0	18	40	43.00	6	R390-125Q40-43L	40.0	B	68.6	3.0	5.00	4600	18	R390-18..	
160.0	18	40S	43.00	8	R390-160Q40-43L	40.0	C	66.7	68.6	3.0	7.21	4000	24	R390-18..

Spare parts	
	Insert screw
11	5513 024-01
18	5513 036-01

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

I74



L2



M1



N23



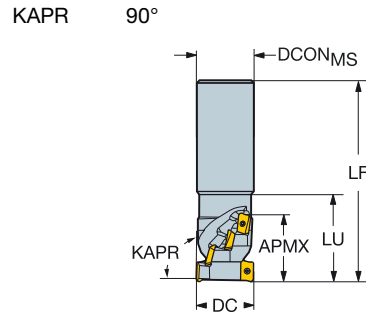
N6



N9

# CoroMill® 390 long edge square shoulder milling cutter

Cylindrical shank



						Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	APMX	Ordering code	DCON <sub>MS</sub>	LF	LU	NM	KG	RPMX	CICT	MIID	
32.0	11	25	36.00	2	R390-032A25-36L	25.0	108.7	48.0	1.2	0.59	21700	8	R390-11..
	11	32	36.00	2	R390-032A32-36L	32.0	112.7	48.0	1.2	0.74	21700	8	R390-11..
40.0	11	40	45.00	3	R390-040A40-45M	40.0	131.5	58.0	1.2	1.23	18900	15	R390-11..

Spare parts
Insert screw
5513 024-01

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I74



L2



N23



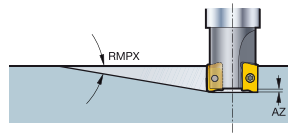
N6



N9

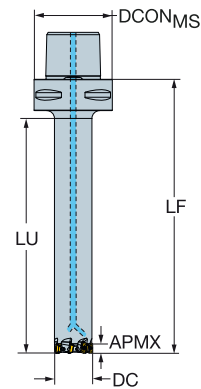
# CoroMill® 390 damped square shoulder milling cutter

Coromant Capto® - Internal coolant supply



KAPR

90°



										Dimensions, mm							
DC	CZC <sub>MS</sub>	APMX <sub>FW</sub>	APMX <sub>FW</sub>	RMPX	AZ	CNSC	Ordering code			DCON <sub>MS</sub>	LF	LU	NM	KG	RPMX	CICT	MIID
20.0	07	C5	2.0	5.80	2°	0.5	3	5	R390-020C5D-07H145	50.0	145.0	120.0	0.5	0.92	20000	5	390R-07..
	07	C6	2.0	5.80	2°	0.5	3	5	R390-020C6D-07H147	63.0	147.0	120.0	0.5	1.25	20000	5	390R-07..
	11	C5	5.5	10.00	5°	1.0	3	2	R390-020C5D-11L145	50.0	145.0	120.0	1.2	0.91	20000	2	R390-11..
	11	C6	5.5	10.00	5°	1.0	3	2	R390-020C6D-11L147	63.0	147.0	120.0	1.2	1.24	20000	2	R390-11..
25.0	07	C5	2.0	5.80	1°	0.5	3	7	R390-025C5D-07H175	50.0	175.0	150.0	0.5	1.19	20000	7	390R-07..
	07	C6	2.0	5.80	1°	0.5	3	7	R390-025C6D-07H177	63.0	177.0	150.0	0.5	1.52	20000	7	390R-07..
	11	C5	5.5	10.00	5°	1.0	3	2	R390-025C5D-11L175	50.0	175.0	150.0	1.2	1.19	20000	2	R390-11..
	11	C6	5.5	10.00	5°	1.0	3	2	R390-025C6D-11L177	63.0	177.0	150.0	1.2	1.53	20000	2	R390-11..
32.0	07	C5	2.0	5.80	1°	0.5	3	8	R390-032C5D-07H217	50.0	217.0	192.0	0.5	1.82	15000	8	390R-07..
	07	C6	2.0	5.80	1°	0.5	3	8	R390-032C6D-07H219	63.0	219.0	192.0	0.5	2.15	15000	8	390R-07..
	11	C5	5.5	10.00	3°	1.0	3	2	R390-032C5D-11L217	50.0	217.0	192.0	1.2	1.83	15000	2	R390-11..
	11	C6	5.5	10.00	3°	1.0	3	2	R390-032C6D-11L219	63.0	219.0	192.0	1.2	2.17	15000	2	R390-11..

		Spare parts	
DC	Insert screw		
20.00-32.00	07	5513 020-82	
20.00	11	5513 020-36	
25.00-32.00	11	5513 020-35	

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I74



L2



N23



N6



N9



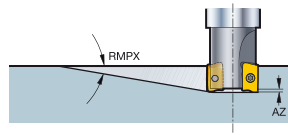
N15



L109

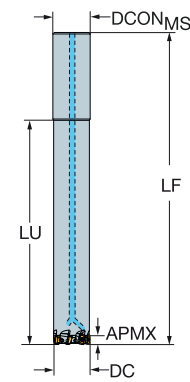
# CoroMill® 390 damped square shoulder milling cutter

Cylindrical shank - Internal coolant supply



KAPR

90°



										Dimensions, mm							
DC		CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC		Ordering code	DCON <sub>MS</sub>	LF	LU			RPMX	CICT	MIID
20.0	07	20	2.0	5.80	2°	0.5	1	5	R390-020A20D-07H	20.0	173.0	120.0	0.5	0.71	20000	5	390R-07..
	11	20	5.5	10.00	5°	1.0	1	2	R390-020A20D-11L	20.0	171.0	120.0	1.2	0.73	20000	2	R390-11..
25.0	07	25	2.0	5.80	1°	0.5	1	7	R390-025A25D-07H	25.0	208.0	150.0	0.5	0.96	20000	7	390R-07..
	11	25	5.5	10.00	5°	1.0	1	2	R390-025A25D-11L	25.0	208.0	150.0	1.2	0.95	20000	2	R390-11..
32.0	07	32	2.0	5.80	1°	0.5	1	8	R390-032A32D-07H	32.0	254.0	192.0	0.5	1.74	15000	8	390R-07..
	11	32	5.5	10.00	3°	1.0	1	2	R390-032A32D-11L	32.0	254.0	192.0	1.2	1.48	15000	2	R390-11..

		Spare parts	
DC		Insert screw	
20.00-32.00	07	5513 020-82	
20.00	11	5513 020-36	
25.00-32.00	11	5513 020-35	

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I74



L2



N23



N6



N9



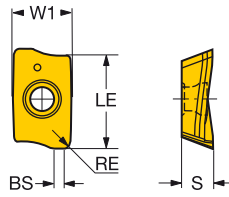
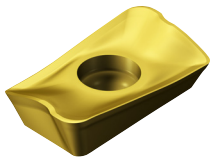
N15



L109

# CoroMill® 390 insert for milling

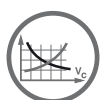
KRINS 90°



	RE	Ordering code	P		M		K		N		S		H		Dimensions, mm																			
			1130	4220	4330	4340	530	1040	1130	2040	530	1020	3040	3330	H13A	1130	530	H13A	1130	H13A	ES30T	S40T	1010	1130	530	W1	LE	S	BS					
KL	07	0.40	390R-070204E-KL					*																				4.0	5.9	2.40	0.7			
		0.80	390R-070208E-KL					*																					4.0	5.9	2.40	0.7		
	11	0.80	R390-11 T3 08E-KL										*																6.8	10.0	3.59	1.5		
		0.80	R390-11 T3 08M-KL					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	1.2	
	17	0.80	R390-17 04 08E-KL										*																9.6	15.7	4.76	1.5		
		0.80	R390-17 04 08M-KL					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76	1.5	
	18	0.80	R390-18 06 08H-KL					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
		1.20	R390-18 06 12H-KL					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
		3.10	R390-18 06 31H-KL					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
	ML	07	0.20	390R-070202E-ML					*																					4.0	5.9	2.40	0.7	
			0.40	390R-070204E-ML					*						*															4.0	5.9	2.40	0.7	
			0.80	390R-070208E-ML					*						*															4.0	5.9	2.40	0.7	
			1.20	390R-070212E-ML					*						*															4.0	5.9	2.40	0.7	
			1.60	390R-070216E-ML					*						*															4.0	5.9	2.40	0.2	
		11	0.80	R390-11 T3 08E-ML					*	*													*	*	*	*	*	*	*	6.8	10.0	3.59	1.5	
			1.60	R390-11 T3 16E-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	0.8
			2.40	R390-11 T3 24E-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	
			3.10	R390-11 T3 31E-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	
17		0.80	R390-17 04 08E-ML					*	*													*	*	*	*	*	*	*	9.6	15.7	4.76	1.5		
18		0.80	R390-18 06 08H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
		1.20	R390-18 06 12H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
		1.60	R390-18 06 16H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
		2.00	R390-18 06 20H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
		2.40	R390-18 06 24H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
		3.10	R390-18 06 31H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
		4.00	R390-18 06 40H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
		5.00	R390-18 06 50H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0	
	6.00	R390-18 06 60H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0		
	6.40	R390-18 06 64H-ML					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.0		
NL	07	0.20	390R-070202E-NL																										4.0	5.9	2.40	0.7		
		0.40	390R-070204E-NL																										4.0	5.9	2.40	0.7		
		0.80	390R-070208E-NL																										4.0	5.9	2.40	0.7		
	11	0.40	R390-11 T3 04E-NL																			*	*	*	*	*	*	*	6.8	10.0	3.59	0.9		
		0.80	R390-11 T3 08E-NL																			*	*	*	*	*	*	*	6.8	10.0	3.59	1.5		
		2.00	R390-11 T3 20E-NL																			*	*	*	*	*	*	*	6.8	10.0	3.59			
		3.10	R390-11 T3 31E-NL																			*	*	*	*	*	*	*	6.8	10.0	3.59			
	17	0.80	R390-17 04 08E-NL																			*	*	*	*	*	*	*	9.6	15.7	4.76	1.5		
		2.00	R390-17 04 20E-NL																			*	*	*	*	*	*	*	9.6	15.7	4.76	0.3		
		3.10	R390-17 04 31E-NL																			*	*	*	*	*	*	*	9.6	15.7	4.76			
	4.00	R390-17 04 40E-NL																			*	*	*	*	*	*	*	9.6	15.7	4.76				
	5.00	R390-17 04 50E-NL																			*	*	*	*	*	*	*	9.6	15.7	4.76				



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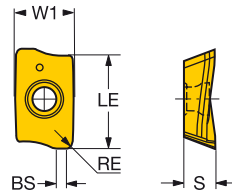
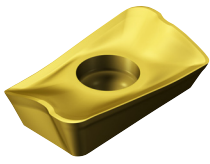


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## CoroMill® 390 insert for milling

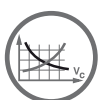
KRINS 90°



	RE	Ordering code	Dimensions, mm																													
			P				M				K				N				S				H									
			1130	420	430	490	530	1040	1130	2040	530	1020	3040	3330	H13A	1130	530	H13A	1130	H13A	ES30T	S40T	1010	1130	530	W1	LE	S	BS			
Light	PL	07 0.20	390R-070202E-PL	★																						4.0	5.9	2.40	0.7			
		0.40	390R-070204E-PL	★																							4.0	5.9	2.40	0.7		
		0.80	390R-070208E-PL	★																								4.0	5.9	2.40	0.7	
		1.20	390R-070212E-PL	★																								4.0	5.9	2.40	0.7	
		1.60	390R-070216E-PL	★																								4.0	5.9	2.40	0.2	
		11 0.40	R390-11 T3 04E-PL	★																	★	★						6.8	10.0	3.59	0.9	
	0.80	R390-11 T3 08E-PL	★																			★	★				6.8	10.0	3.59	1.5		
	0.80	R390-11 T3 08M-PL	★	★																		★	★				6.8	10.0	3.59	1.2		
	17 0.80	R390-17 04 08E-PL	★																				★	★				9.6	15.7	4.76	1.5	
	0.80	R390-17 04 08M-PL	★	★																			★	★				9.6	15.7	4.76	1.5	
	18 0.80	R390-18 06 08H-PL	★	★																			★	★				11.0	15.4	6.33	1.0	
	1.20	R390-18 06 12H-PL	★	★																			★	★				11.0	15.4	6.33	1.0	
	1.60	R390-18 06 16H-PL	★	★																			★	★				11.0	15.4	6.33	1.0	
	2.00	R390-18 06 20H-PL	★																					★	★				11.0	15.4	6.33	1.0
	2.40	R390-18 06 24H-PL	★																					★	★				11.0	15.4	6.33	1.0
	3.10	R390-18 06 31H-PL	★																					★	★				11.0	15.4	6.33	1.0
	4.00	R390-18 06 40H-PL	★																					★	★				11.0	15.4	6.33	1.0
	5.00	R390-18 06 50H-PL	★																					★	★				11.0	15.4	6.33	1.0
6.00	R390-18 06 60H-PL	★																					★	★				11.0	15.4	6.33	1.0	
6.40	R390-18 06 64H-PL	★																					★	★				11.0	15.4	6.33	1.0	
Medium	KM	07 0.40	390R-070204M-KM							★																	4.0	5.9	2.40	0.7		
		0.80	390R-070208M-KM								★																	4.0	5.9	2.40	0.7	
		1.60	390R-070216M-KM									★																4.0	5.9	2.40	0.2	
		11 0.20	R390-11 T3 02E-KM																									6.8	10.0	3.59	0.7	
		0.40	R390-11 T3 04M-KM									★																6.8	10.0	3.59	0.9	
		0.80	R390-11 T3 08M-KM										★															6.8	10.0	3.59	1.2	
		1.20	R390-11 T3 12E-KM																									6.8	10.0	3.59	0.8	
		1.60	R390-11 T3 16E-KM																									6.8	10.0	3.59	0.8	
		1.60	R390-11 T3 16M-KM																									6.8	10.0	3.59	0.4	
		2.00	R390-11 T3 20E-KM																									6.8	10.0	3.59	0.4	
		2.40	R390-11 T3 24E-KM																									6.8	10.0	3.59		
		3.10	R390-11 T3 31E-KM																									6.8	10.0	3.59		
	3.10	R390-11 T3 31M-KM																									6.8	10.0	3.59			
	17 0.40	R390-17 04 04E-KM																									9.6	15.7	4.76	1.0		
	0.40	R390-17 04 04M-KM																									9.6	15.7	4.76	1.0		
	0.80	R390-17 04 08M-KM																									9.6	15.7	4.76	1.5		
	1.20	R390-17 04 12E-KM																									9.6	15.7	4.76	1.1		
	1.60	R390-17 04 16E-KM																									9.6	15.7	4.76	0.7		
	1.60	R390-17 04 16M-KM																									9.6	15.7	4.76	0.7		
	2.00	R390-17 04 20E-KM																									9.6	15.7	4.76	0.3		
	2.40	R390-17 04 24E-KM																									9.6	15.7	4.76			
	3.10	R390-17 04 31E-KM																									9.6	15.7	4.76			
	3.10	R390-17 04 31M-KM																									9.6	15.7	4.76			
	4.00	R390-17 04 40E-KM																									9.6	15.7	4.76			
	4.80	R390-17 04 48E-KM																									9.6	15.7	4.76			
	5.00	R390-17 04 50E-KM																									9.6	15.7	4.76			
	6.00	R390-17 04 60E-KM																									9.6	15.7	4.76			
	6.35	R390-17 04 64E-KM																									9.6	15.7	4.76			
	18 0.80	R390-18 06 08M-KM																									11.0	15.4	6.33	1.1		
	1.20	R390-18 06 12M-KM																									11.0	15.4	6.33	1.1		
1.60	R390-18 06 16M-KM																									11.0	15.4	6.33	1.1			
2.00	R390-18 06 20M-KM																									11.0	15.4	6.33	0.5			
3.10	R390-18 06 31M-KM																									11.0	15.4	6.33	0.5			
KMR 18 1.20	R390-18 06 12M-KMR																									11.0	15.4	6.33	0.3			



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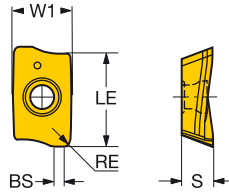
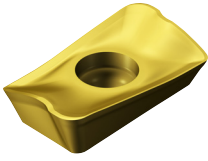
N23



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# CoroMill® 390 insert for milling

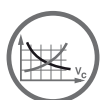
KRINS 90°



RE	Ordering code	Dimensions, mm																														
		P			M			K			N		S		H																	
		1130	4220	4330	4340	530	1040	1130	2040	530	1020	3330	H13A	1130	530	1130	H13A	H13A	ES30T	ES40T	1010	1130	530									
07	0.20	390R-070202M-MM				*													*							4.0	5.9	2.40	0.7			
	0.40	390R-070204E-MM				*													*								4.0	5.9	2.40	0.7		
	0.40	390R-070204M-MM				*													*								4.0	5.9	2.40	0.7		
	0.80	390R-070208E-MM				*													*								4.0	5.9	2.40	0.7		
	0.80	390R-070208M-MM				*													*								4.0	5.9	2.40	0.7		
	1.20	390R-070212M-MM				*													*								4.0	5.9	2.40	0.7		
	1.60	390R-070216M-MM				*													*								4.0	5.9	2.40	0.2		
Medium	MM	11	0.20	R390-11 T3 02E-MM			*													*							6.8	10.0	3.59	0.7		
			0.80	R390-11 T3 08M-MM				*	*												*	*						6.8	10.0	3.59	1.2	
			1.20	R390-11 T3 12E-MM				*													*								6.8	10.0	3.59	0.8
			1.60	R390-11 T3 16E-MM				*													*								6.8	10.0	3.59	0.4
			2.00	R390-11 T3 20E-MM				*													*								6.8	10.0	3.59	
			2.40	R390-11 T3 24E-MM				*													*								6.8	10.0	3.59	
		3.10	R390-11 T3 31E-MM				*													*								6.8	10.0	3.59		
		0.40	R390-17 04 04E-MM				*														*	*						9.6	15.7	4.76	1.0	
		0.80	R390-17 04 08M-MM				*	*	*												*	*						9.6	15.7	4.76	1.5	
		1.20	R390-17 04 12E-MM				*														*							9.6	15.7	4.76	1.1	
		1.60	R390-17 04 16E-MM				*														*							9.6	15.7	4.76	0.7	
		2.00	R390-17 04 20E-MM				*														*							9.6	15.7	4.76	0.3	
	2.40	R390-17 04 24E-MM				*														*							9.6	15.7	4.76			
	3.10	R390-17 04 31E-MM				*														*							9.6	15.7	4.76			
	4.00	R390-17 04 40E-MM				*														*							9.6	15.7	4.76			
	4.80	R390-17 04 48E-MM				*														*							9.6	15.7	4.76			
	5.00	R390-17 04 50E-MM				*														*							9.6	15.7	4.76			
	6.00	R390-17 04 60E-MM				*														*							9.6	15.7	4.76			
	6.35	R390-17 04 64E-MM				*														*							9.6	15.7	4.76			
MMR	18	0.80	R390-18 06 08M-MM				*	*																				11.0	15.4	6.33	1.1	
		1.20	R390-18 06 12M-MM				*	*	*																			11.0	15.4	6.33	1.1	
		1.60	R390-18 06 16M-MM				*	*	*	*																			11.0	15.4	6.33	1.1
		2.00	R390-18 06 20M-MM				*	*	*	*	*																		11.0	15.4	6.33	0.5
		3.10	R390-18 06 31M-MM				*	*	*	*	*	*																	11.0	15.4	6.33	0.5
	1.20	R390-18 06 12M-MMR				*	*																					11.0	15.4	6.33	0.3	



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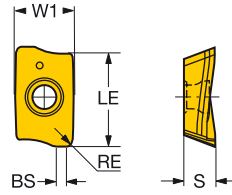
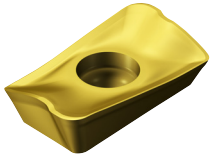
N23



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## CoroMill® 390 insert for milling

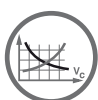
KRINS 90°



		RE	Ordering code	Dimensions, mm																													
				P				M				K				N				S				H									
				1130	4220	4330	4340	1040	1130	2040	530	1020	3040	3330	H13A	1130	530	H13A	1130	H13A	ES30T	ES40T	1010	1130	530	W1	LE	S	BS				
Medium	PM	07	0.20 390R-070202M-PM	*		*																							4.0	5.9	2.40	0.7	
			0.40 390R-070204M-PM	*	*	*																								4.0	5.9	2.40	0.7
			0.80 390R-070208M-PM	*	*	*	*																							4.0	5.9	2.40	0.7
			1.20 390R-070212M-PM	*	*	*	*																							4.0	5.9	2.40	0.7
			1.60 390R-070216M-PM	*	*	*	*																							4.0	5.9	2.40	0.2
			0.20 R390-11 T3 02E-PM	*		*	*																							6.8	10.0	3.59	0.7
			0.40 R390-11 T3 04M-PM	*	*	*	*																							6.8	10.0	3.59	0.9
			0.80 R390-11 T3 08M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	1.2
			1.20 R390-11 T3 12E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	0.8
			1.60 R390-11 T3 16E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	0.4
			1.60 R390-11 T3 16M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	0.4
			2.00 R390-11 T3 20E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	
			2.40 R390-11 T3 24E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	
			3.10 R390-11 T3 31E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	
			3.10 R390-11 T3 31M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	6.8	10.0	3.59	
		0.40 R390-17 04 04E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76	1.0	
		0.40 R390-17 04 04M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76	1.0	
		0.80 R390-17 04 08M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76	1.5	
		1.20 R390-17 04 12E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76	1.1	
		1.60 R390-17 04 16E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76	0.7	
		1.60 R390-17 04 16M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76	0.7	
		2.00 R390-17 04 20E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76	0.3	
		2.40 R390-17 04 24E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76		
		3.10 R390-17 04 31E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76		
		3.10 R390-17 04 31M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76		
		4.00 R390-17 04 40E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76		
		4.80 R390-17 04 48E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76		
		5.00 R390-17 04 50E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76		
		6.00 R390-17 04 60E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76		
		6.35 R390-17 04 64E-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	9.6	15.7	4.76		
		0.80 R390-18 06 08M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.1	
		1.20 R390-18 06 12M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.1	
		1.60 R390-18 06 16M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	1.1	
		2.00 R390-18 06 20M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	0.5	
		3.10 R390-18 06 31M-PM	*	*	*	*													*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	0.5	
		1.20 R390-18 06 12M-PMR	*	*	*	*													*	*	*	*	*	*	*	*	*	*	11.0	15.4	6.33	0.3	
Heavy	KH	11	1.00 R390-11 T3 10M-KH								*	*	*															6.8	10.0	3.59	1.0		
			0.80 R390-17 04 08M-KH								*	*	*															9.6	15.7	4.76	1.5		
			1.00 R390-11 T3 10M-MH				*	*	*																				6.8	10.0	3.59	1.0	
	PH	11	1.00 R390-11 T3 10M-PH	*	*	*	*						*								*	*	*					6.8	10.0	3.59	1.0		
			0.80 R390-17 04 08M-PH	*	*	*	*						*								*	*	*					9.6	15.7	4.76	1.5		
			1.60 R390-17 04 16M-PH	*	*	*	*						*								*	*	*					9.6	15.7	4.76	1.5		



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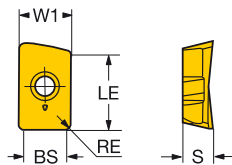
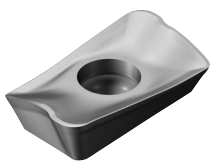
N23



N10

# CoroMill® 390 insert for milling

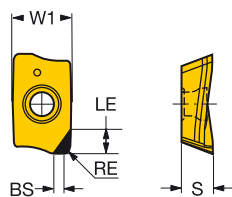
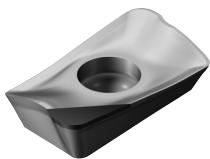
KRINS 90°



**Wiper** TECHNOLOGY

				P	M	K	N	S	H	Dimensions, mm			
				1130	1130	1020	1130	1130	1130	W1	LE	S	BS
Light	PLW	18	1.60	R390-18 06 16H-KTW	*	*	*	*	*	11.0	15.4	6.33	8.6
		11	0.80	R390-11 T3 08E-PLW	*	*	*	*	*	6.8	10.0	3.59	5.0
		18	1.60	R390-18 06 16H-PTW	*	*	*	*	*	11.0	15.4	6.33	8.6

KRINS 90°



## Advanced cutting materials

				N	Dimensions, mm				
				CD10	W1	LE	S	BS	
Light	NL	11	0.40	R390-11T304E-P4-NL	*	6.8	4.0	3.59	2.2
		17	0.80	R390-170408E-P6-NL	*	9.6	6.0	4.76	1.8



158



1154



1175



N23



N10



N2

# CoroMill® 690

The cutting edge for titanium milling

## Application

- 2D profile milling of titanium
- Edging and full slotting

## ISO application area:

**S**

## Benefits and features

- High-productivity milling of titanium
- iLock™ interface gives a secure process, increased feed and longer tool life
- Cutting fluid supply, individual to each insert pocket
- Fully controlled flow and pressure through threaded holes - either for nozzles or plug screws
- Unique end- and side inserts for optimum performance



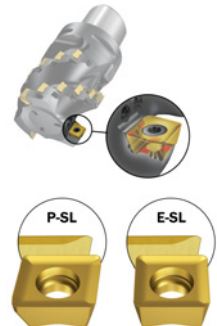
[www.sandvik.coromant.com/coromill690](http://www.sandvik.coromant.com/coromill690)

## Couplings

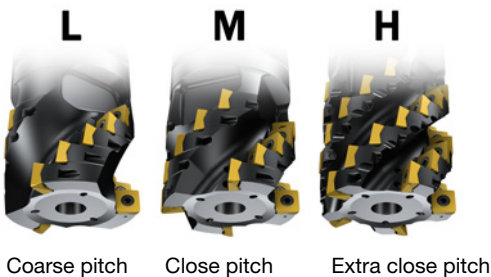
- Coromant Capto®
- Arbor
- HSK
- Oversized version available

## Inserts

- Four cutting edges
- SL geometry optimized for titanium



P-SL = Side (or Periphery) insert  
E-SL = End insert



Coarse pitch

Close pitch

Extra close pitch

## Coolant supply

During cutting, the chips can be prone to sticking to the cutting edge. This means that the next cutter rotation is re-cutting the chip. By equipping every insert pocket with threaded coolant holes with nozzles for high pressure coolant delivery, you can apply maximum coolant where required. This effectively eliminates the problem for a constant cutting edge performance. Supplying cutting fluid to all the insert pockets in the long edge cutter requires high pump volumes and pressure capability.



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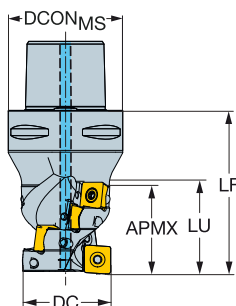


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# CoroMill® 690 long edge square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



								Dimensions, mm								
DC	APMX <sub>FW</sub>	CZC <sub>MS</sub>	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	LF	LU	NM	KG	RPMX	CICT	MID <sub>E</sub>	MID <sub>P</sub>	
40.0	53.0	10E 10P	C6	3	2	690-040C6-1053H	63.0	40.0	95.0	55.0	3.0	1.54	5000	10	690-100508M-E-SL	690-100510M-P-SL
44.0	46.0	10E 10P	C4	3	3	690-044C4-1046H	40.0	44.0	82.0	3.0	0.81	5000	15	690-100508M-E-SL	690-100510M-P-SL	
50.0	53.0	10E 10P	C5	3	3	690-050C5-1053H	50.0	50.0	90.0	70.0	3.0	1.16	5000	3	690-100508M-E-SL	690-100510M-P-SL
54.0	53.0	10E 10P	C5	3	3	690-054C5-1053H	50.0	54.0	90.0	3.0	1.31	5000	3	690-100508M-E-SL	690-100510M-P-SL	
	61.0	14E 14P	C5	3	3	690-054C5-1461H	50.0	54.0	97.0	5.0	1.39	5000	3	690-140608M-E-SL	690-140610M-P-SL	
63.0	60.0	10E 10P	C6	3	3	690-063C6-1060M	63.0	63.0	100.0	78.0	3.0	2.21	5000	3	690-100508M-E-SL	690-100510M-P-SL
	61.0	14E 14P	C6	3	3	690-063C6-1461H	63.0	63.0	103.0	79.0	5.0	2.13	5000	3	690-140608M-E-SL	690-140610M-P-SL
	112.0	10E 10P	C6	3	4	690-063C6-10112H	63.0	63.0	156.0	134.0	3.0	2.85	5000	56	690-100508M-E-SL	690-100510M-P-SL
66.0	49.0	14E 14P	C6	3	3	690-066C6-1449H	63.0	66.0	90.0	5.0	2.01	5000	3	690-140608M-E-SL	690-140610M-P-SL	
	53.0	10E 10P	C6	3	4	690-066C6-1053H	63.0	66.0	92.0	3.0	2.19	5000	24	690-100508M-E-SL	690-100510M-P-SL	
	105.0	10E 10P	C6	3	4	690-066C6-10105H	63.0	66.0	150.0	3.0	2.88	5000	52	690-100508M-E-SL	690-100510M-P-SL	
80.0	73.0	14E 14P	C8	3	4	690-080C8-1473H	80.0	80.0	128.0	92.0	5.0	4.24	5000	4	690-140608M-E-SL	690-140610M-P-SL
84.0	61.0	14E 14P	C8	3	4	690-084C8-1461M	80.0	84.0	110.0	5.0	3.93	5000	4	690-140608M-E-SL	690-140610M-P-SL	
	61.0	14E 14P	C8	3	3	690-084C8-1461L	80.0	84.0	112.0	5.0	3.99	5000	3	690-140608M-E-SL	690-140610M-P-SL	
	84.0	14E 14P	C8	3	5	690-084C8-1484H	80.0	84.0	132.0	5.0	4.57	5000	5	690-140608M-E-SL	690-140610M-P-SL	
100.0	108.0	14E 14P	C8	3	4	690-100C8-14108M	80.0	100.0	160.0	5.0	6.80	5000	4	690-140608M-E-SL	690-140610M-P-SL	

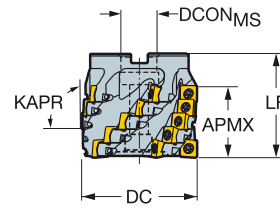
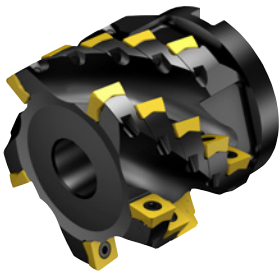
Spare parts			
DC	Insert screw	Plug screw	
40.00	10	5513 020-68	3214 010-202
44.00	10	5513 020-68	3214 010-202
50.00-66.00	10	5513 020-68	3214 010-253
54.00-100.00	14	5513 020-55	3214 010-253

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 690 long edge square shoulder milling cutter

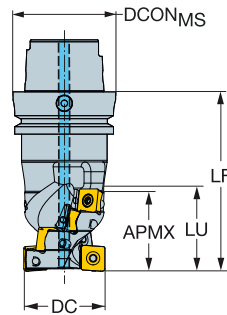
Arbor

STDNO  
KAPRISO6462  
90°

							Dimensions, mm									
DC	APMX <sub>FFW</sub>	10E	10P	CZC <sub>MS</sub>	Ordering code		DCON <sub>MS</sub>	ISO	DCX	LF	NM	KG	RPMX	CICT	MIID <sub>E</sub>	MIID <sub>P</sub>
50.0	46.0	10E	10P	22	3	690-050Q22-1046H	22.0	A	50.0	75.0	3.0	0.98	5000	3	690-100508M-E-SL	690-100510M-P-SL
63.0	46.0	10E	10P	27	3	690-063Q27-1046M	27.0	A	63.0	80.0	3.0	1.48	5000	3	690-100508M-E-SL	690-100510M-P-SL
	49.0	14E	14P	27	3	690-063Q27-1449H	27.0	A	63.0	80.0	5.0	1.30	5000	9	690-140608M-E-SL	690-140610M-P-SL
80.0	61.0	14E	14P	32	3	690-080Q32-1461M	32.0	A	80.0	98.0	5.0	2.42	5000	3	690-140608M-E-SL	690-140610M-P-SL
100.0	61.0	14E	14P	32	5	690-100Q32-1461H	32.0	A	100.0	90.0	5.0	3.56	5000	5	690-140608M-E-SL	690-140610M-P-SL

### HSK - Internal coolant supply

KAPR 90°



							Dimensions, mm									
DC	APMX <sub>FFW</sub>	10E	10P	CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCX	LF	LU	NM	KG	RPMX	CICT	MIID <sub>E</sub>	MIID <sub>P</sub>
63.0	105.0	10E	10P	125	1	690-063HA12-10105H	125.0	63.0	180.0	110.0	3.0	7.51	5000	4	690-100508M-E-SL	690-100510M-P-SL

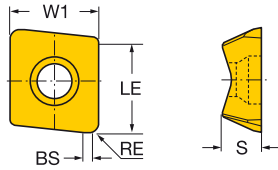
Spare parts			
DC	Insert screw	Plug screw	
50.00-63.00	10	5513 020-68	3214 010-253
63.00-100.00	14	5513 020-55	3214 010-253

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

**SANDVIK**  
Coromant

# CoroMill® 690 insert for milling

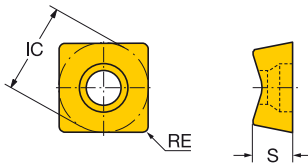
KRINS 90°



## End insert

	RE	Ordering code	S				Dimensions, mm					
			1030	2040	S30T	S40T	W1	LE	S	BS		
Light SL	10E	0.80	690-100508M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0	
		1.20	690-100512M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0	
		1.60	690-100516M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0	
		2.00	690-100520M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0	
		3.10	690-100531M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0	
		14E	0.80	690-140608M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
			1.20	690-140612M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
			1.60	690-140616M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
			2.00	690-140620M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
			2.40	690-140624M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
			3.10	690-140631M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
			5.00	690-140650M-E-SL	☆	☆	★	☆	14.5	15.7	6.35	1.0
			6.00	690-140660M-E-SL	☆	☆	★	☆	14.5	16.5	6.35	1.0
			6.35	690-140664M-E-SL	☆	☆	★	☆	14.5	16.7	6.35	1.0

KRINS 90°



## Peripheral insert

	RE	Ordering code	S				Dimensions, mm			
			1030	2040	S30T	S40T	IC	LE	S	
Light SL	10P	1.00	690-100510M-P-SL	☆	☆	★	☆	10.0	9.0	5.20
	14P	1.00	690-140610M-P-SL	☆	☆	★	☆	14.5	13.5	6.35



180



1154



1175



N23



N10



# CoroMill® Century

Light cutting face mill for high speed finishing

## Application

- Square shoulder milling
- Face milling

## ISO application area:



## Benefits and features

- High speed machining security by design
- Intensified chip evacuation through accelerated cutting fluid
- Easy setting to micro precision within 0.1 mm setting range
- High-alloy aluminium body with Arbor mounting
- Wiper insert option for high feed finishing



[www.sandvik.coromant.com/coromillcentury](http://www.sandvik.coromant.com/coromillcentury)

## Couplings

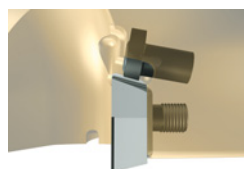
- Coromant Capto®
- Arbor
- HSK

## Inserts

- One or two cutting edges
- Wide assortment of corner radii and chamfer
- Insert geometries and grades for all materials including PCD and CBN

## Micro setting

Micro precision setting of insert within 0.1 mm setting range on cassette solution.

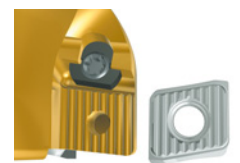


## Macro setting

Macro setting of insert within 1 mm setting range.

## Insert setting

Serrated insert location gives very high security against insert movement.



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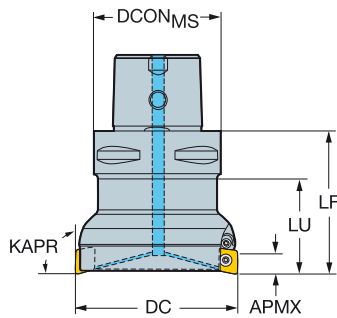


N6

# CoroMill® Century square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



						Dimensions, mm								
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	ZADJ	Ordering code	DCON <sub>MS</sub>	LF	LU	NM	KG	RPMX	CICT	MIID	
40.0	11	C3	11.00	3	3	R590-040C3-11M	32.0	55.0	40.0	3.0	0.65	48000	3	R590-1105..
40.0	11	C4	11.00	3	3	R590-040C4-11M	40.0	63.0	40.0	3.0	0.83	39000	3	R590-1105..
50.0	11	C5	11.00	3	4	R590-050C5-11M	50.0	63.0	40.0	3.0	1.38	28000	4	R590-1105..
63.0	11	C5	11.00	3	5	R590-063C5-11M	50.0	63.0	40.0	3.0	1.50	28000	5	R590-1105..
80.0	11	C6	11.00	3	6	R590-080C6-11M	63.0	71.0	40.0	3.0	2.38	20000	6	R590-1105..

Spare parts		
Insert screw	Setting device	Setting device screw
5513 020-25	5513 014-021	5513 014-02

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



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L2



N23



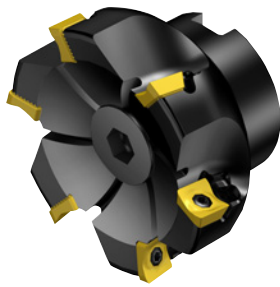
N9



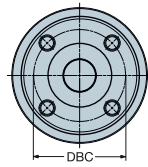
N15

# CoroMill® Century square shoulder milling cutter

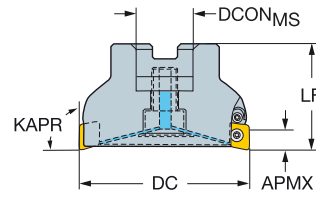
Arbor - Internal coolant supply



STDNO  
KAPR



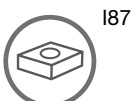
ISO6462  
90°



							Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	ZADJ	Ordering code	DCON <sub>MS</sub>	ISO	DBC	LF	NM	KG	RPMX	CICT	MIID		
50.0	11	22	11.00	1	4	R590-050Q22S-11M	22.0	A	40.0	3.0	0.68	41600	4	R590-1105..		
63.0	11	22	11.00	1	5	R590-063Q22S-11M	22.0	A	40.0	3.0	0.81	35100	5	R590-1105..		
80.0	11	27	11.00	1	6	R590-080Q27A-11M	27.0	A	50.0	3.0	1.04	27500	6	R590-1105..		
	11	27	11.00	1	6	R590-080Q27S-11M	27.0	A	50.0	3.0	1.57	27500	6	R590-1105..		
100.0	11	32	11.00	1	6	R590-100Q32A-11M	32.0	A	50.0	3.0	1.37	23800	6	R590-1105..		
	11	32	11.00	1	6	R590-100Q32S-11M	32.0	A	50.0	3.0	2.21	23800	6	R590-1105..		
125.0	11	40	11.00	1	8	R590-125Q40A-11M	40.0	B	63.0	3.0	1.84	20700	8	R590-1105..		
	11	40	11.00	1	8	R590-125Q40S-11M	40.0	B	63.0	3.0	3.34	20700	8	R590-1105..		
160.0	11	40	11.00	1	10	R590-160Q40A-11M	40.0	B	63.0	3.0	2.74	17900	10	R590-1105..		
	11	40	11.00	1	10	R590-160Q40S-11M	40.0	B	63.0	3.0	5.65	17900	10	R590-1105..		
200.0	11	60	11.00	0	16	R590-200Q60A-11M	60.0	C	101.6	63.0	3.0	7.26	15700	16	R590-1105..	
	11	60	11.00	0	16	R590-200Q60S-11M	60.0	C	101.6	63.0	3.0	12.00	15700	16	R590-1105..	

Spare parts					
DC	Insert screw	Shower screw	Setting device	Setting device screw	
50.00-63.00	11 5513 020-25	5512 087-01	5513 014-021	5513 014-02	
80.00	11 5513 020-25	5512 087-02	5513 014-021	5513 014-02	
100.00	11 5513 020-25	5512 087-03	5513 014-021	5513 014-02	
125.00-160.00	11 5513 020-25	5512 098-03	5513 014-021	5513 014-02	
200.00	11 5513 020-25		5513 014-021	5513 014-02	

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



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L2



M1



N23



N9

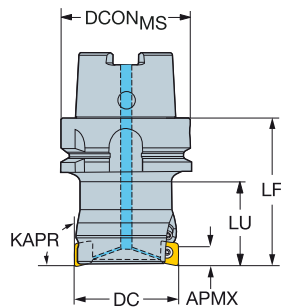


N15

# CoroMill® Century square shoulder milling cutter

HSK - Internal coolant supply

KAPR 90°



							Dimensions, mm								
DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC	ZADJ	Ordering code	DCON <sub>MS</sub>	ISO	LF	LU	NM	KG	RPMX	CICT	MIID	
40.0	11	63	11.00	1 3 3	R590-040HA06-11M	63.0	A	71.0	40.0	3.0	1.41	20000	3	R590-1105..	
50.0	11	63	11.00	1 4 4	R590-050HA06-11M	63.0	A	71.0	40.0	3.0	1.58	20000	4	R590-1105..	

Spare parts		
Insert screw	Setting device	Setting device screw
5513 020-25	5513 014-021	5513 014-02

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



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L2



N23



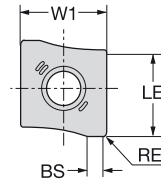
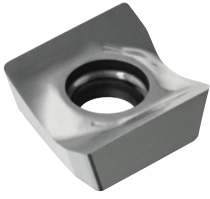
N9



N15

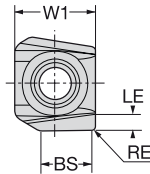
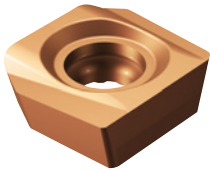
## CoroMill® Century insert for milling

KRINS 90°



		RE	Ordering code	K			N		H		Dimensions, mm			
				1020	H10	H10	1130	1130	1130	W1	LE	S	BS	
Light	KL	11	0.80	R590-110508H-KL	★						11.5	11.0	5.00	1.7
	NL	11	0.40	R590-110504H-NL		☆	★				11.5	11.0	5.00	2.0
	PL	11	0.80	R590-110508H-PL					☆		11.5	11.0	5.00	1.7

KRINS 90°



TECHNOLOGY  
**Wiper**

		RE	Ordering code	P		M		K		N		S		H		Dimensions, mm				
				1130	1130	1130	1020	1130	H10	1130	1130	1130	W1	LE	S	BS	BSR			
Light	KTW	11	0.40	R590-110504H-KTW												11.5	11.0	5.00	7.0	
	KW	11	0.80	R590-110508H-KW										☆		11.5	11.0	5.00	7.0	500.0
	NW	11	0.40	R590-110504H-NW										☆	☆	11.5	11.0	5.00	7.0	500.0
	PTW	11	0.40	R590-110504H-PTW	☆	☆			☆			☆	☆			11.5	11.0	5.00	7.0	
	PW	11	0.80	R590-110508H-PW	☆	☆			☆			☆	☆			11.5	11.0	5.00	7.0	500.0

Make sure to choose working insert and wiper insert with the same RE/KCH values



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1154



1175



N23



N6



N10

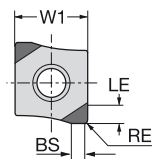
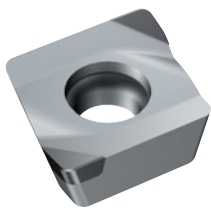


N2

# CoroMill® Century insert for milling

Advanced cutting materials

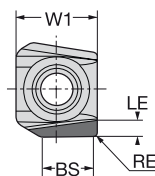
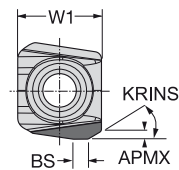
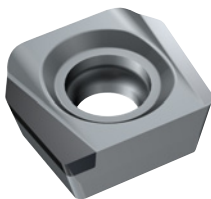
KRINS 90°



		RE	KCH	CHW	Ordering code	K		H				
						CB50	CB50	W1	LE	S	BS	BSR
Light	KL	11	30°	1.0	L590-1105H-ZC2-KL	☆	☆	11.5	3.0	5.00	2.3	200.0
			60°	1.5	R590-1105H-ZC2-KL	☆	☆	11.5	3.0	5.00	2.3	200.0
Medium	KM	11	0.80		R590-110508H-PR2-KM	☆	☆	11.5	2.0	5.00	1.5	25.0

KRINS 90°  
R/L590..H-Z..-KW

90°  
R590..PR2-KW



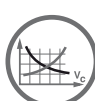
**Wiper** TECHNOLOGY

		RE	KCH	CHW	Ordering code	K		H				
						CB50	CB50	W1	LE	S	BS	BSR
Light	KW	11	30°	1.0	L590-1105H-ZC2-KW	☆	☆	11.5	3.0	5.00	5.9	390.0
			60°	1.5	R590-1105H-ZC2-KW	☆	☆	11.5	3.0	5.00	5.9	390.0
	NW	11	0.80		R590-110508H-PR2-KW	☆	☆	11.5	2.0	5.00	7.1	393.0

Make sure to choose working insert and wiper insert with the same RE/KCH values



I84



I154



I175



N23



N6



N10

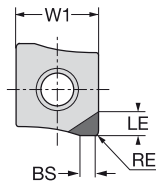


N2

# CoroMill® Century insert for milling

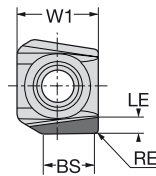
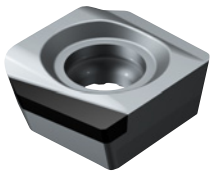
Advanced cutting materials

KRINS 90°



		N					Dimensions, mm				
Light	NL	RE	KCH	CHW	Ordering code	CD10	W1	LE	S	BS	BSR
			45°	1.0	R590-1105H-PC5-NL	★	11.5	6.0	5.00	1.5	200.0
		0.40			R590-1105H-PR2-NL	★	11.5	3.0	5.00	2.2	200.0
		0.40			R590-1105H-PR5-NL	★	11.5	6.0	5.00	2.2	200.0
			45°	0.3	R590-1105H-PS2-NL	★	11.5	3.0	5.00	2.2	200.0
			45°	0.1	R590-1105H-PS5-NL	★	11.5	6.0	5.00	2.2	200.0

KRINS 90°



**Wiper** TECHNOLOGY

		N					Dimensions, mm				
Light	NW	RE	KCH	CHW	Ordering code	CD10	W1	LE	S	BS	BSR
		0.40			R590-1105H-RR2-NW	☆	11.5	3.0	5.00	6.8	500.0
			45°	0.3	R590-1105H-RS2-NW	☆	11.5	3.0	5.00	7.0	500.0

Make sure to choose working insert and wiper insert with the same RE/KCH values



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1154



1175



N23



N6







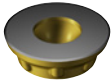




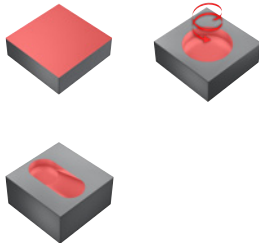
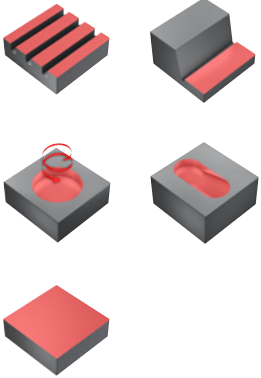
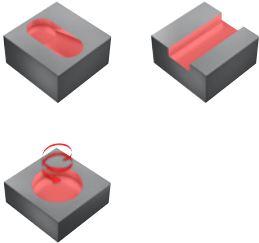


N10



N2

## Profile milling tools

	CoroMill® 300	CoroMill® 200	CoroMill® 216
			
Page	I91	I100	I105
Material	<b>P</b> <b>M</b> <b>K</b> <b>N</b> <b>S</b> <b>H</b>	<b>P</b> <b>M</b> <b>K</b> <b>N</b> <b>S</b> <b>H</b>	<b>P</b> <b>M</b> <b>K</b> <b>N</b> <b>S</b> <b>H</b>
Main operation			
KAPR	0°	0°	90°
DC mm	5 - 180	15 - 140	10 - 50
DCX mm	10 - 200	25 - 160	10 - 50
APMX mm	2.5 - 10	5 - 10	8.6 - 44.6
Insert			
Insert sizes	05,07,08,10,12,16 & 20	10,12,16 & 20	10,12,16,20,25,30,32,40 & 50
Couplings	Coromant Capto® Coromant EH Cylindrical Arbor Weldon Threaded coupling	Cylindrical shank Arbor	Coromant Capto® Cylindrical shank Coromant EH Threaded coupling Weldon
Internal coolant			
Options		Shim protection tipseat	
Other operations			



# CoroMill® 300

Light cutting face and profile milling cutters

## Application

- Full slot milling
- Face milling
- Ramping
- Profiling
- Pocket milling

## ISO application area:



## Benefits and features

- Universal product with a wide application window
- Large assortment covering many applications
- Cutters with positive design have light cutting action and generates low cutting forces, which allows for extra close pitched face mill versions with small inserts for high productivity at high speeds combined with high table feeds
- End mills with great accessibility and cutting action in all feed directions for multi-axis machining of complicated forms



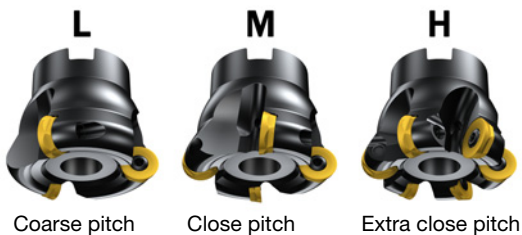
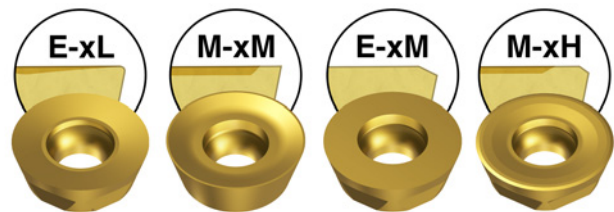
[www.sandvik.coromant.com/coromill300](http://www.sandvik.coromant.com/coromill300)

## Couplings

- Coromant Capto®
- Arbor
- Cylindrical shank
- Weldon
- Coromant EH
- Threaded couplings and grades for all materials

## Inserts

- Insert geometries and grades for all materials



Coarse pitch

Close pitch

Extra close pitch

Specific insert indexing solution for size 20 inserts prevents insert movement and enables all cutting edges to be utilized.



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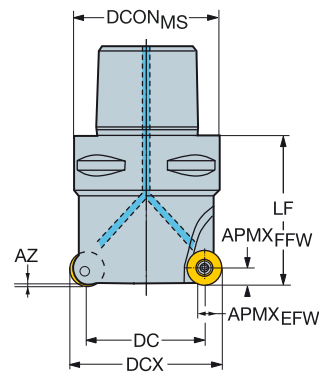
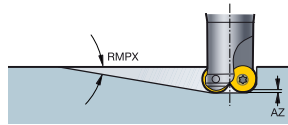


N6

# CoroMill® 300 face milling cutter

Coromant Capto® - Internal coolant supply

Positive design



										Dimensions, mm								
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	BD	LF	NM	KG	RPMX	CICT	MIID	
23.0	12	C3	9.0	6.00	10°	3.0	3	R300-035C3-12M	32.0	35.0	28.3	43.0	3.0	0.36	32900	3	R300-1240..	
	12	C3	9.0	6.00	10°	3.0	3	R300-035C3-12H	32.0	35.0	28.3	43.0	3.0	0.30	32900	4	R300-1240..	
25.0	10	C3	7.5	5.00	7°	2.3	3	R300-035C3-10H	32.0	35.0	29.1	40.0	3.0	0.36	43200	4	R300-1032..	
27.0	08	C3	6.0	4.00	4°	1.9	3	R300-035C3-08M	32.0	35.0	30.3	40.0	1.2	0.31	33800	4	R300-0828..	
	08	C3	6.0	4.00	4°	1.9	3	R300-035C3-08H	32.0	35.0	30.3	40.0	1.2	0.31	33800	5	R300-0828..	
30.0	12	C4	9.0	6.00	7°	3.0	3	R300-042C4-12M	40.0	42.0	35.3	50.0	3.0	0.60	28300	3	R300-1240..	
	12	C4	9.0	6.00	7°	3.0	3	R300-042C4-12H	40.0	42.0	35.3	50.0	3.0	0.58	28300	4	R300-1240..	
32.0	10	C4	7.5	5.00	5°	2.3	3	R300-042C4-10H	40.0	42.0	36.1	50.0	3.0	0.58	37200	5	R300-1032..	
34.0	08	C4	6.0	4.00	3°	1.9	3	R300-042C4-08H	40.0	42.0	37.3	50.0	1.2	0.40	29800	6	R300-0828..	
36.0	16	C5	12.0	8.00	7°	3.8	3	R300-052C5-16M	50.0	52.0	40.9	60.0	5.0	1.04	20600	4	R300-1648..	
	16	C5	12.0	8.00	7°	3.8	3	R300-052C5-16H	50.0	52.0	40.9	60.0	5.0	1.04	20600	5	R300-1648..	
40.0	12	C5	9.0	6.00	5°	3.0	3	R300-052C5-12M	50.0	52.0	45.3	50.0	3.0	0.98	24400	4	R300-1240..	
	12	C5	9.0	6.00	5°	3.0	3	R300-052C5-12H	50.0	52.0	45.3	50.0	3.0	0.99	24000	5	R300-1240..	
44.0	08	C5	6.0	4.00	2°	1.9	3	R300-052C5-08H	50.0	52.0	47.3	50.0	1.2	1.00	26100	8	R300-0828..	
46.0	20	C6	15.0	10.00	9°	6.0	3	R300-066C6-20M	63.0	66.0	60.0	80.0	7.5	1.88	18478	4	R300-2060..	
	20	C6	15.0	10.00	9°	6.0	3	R300-066C6-20H	63.0	66.0	60.0	80.0	7.5	1.83	18478	5	R300-2060..	
50.0	16	C6	12.0	8.00	4°	3.8	3	R300-066C6-16M	63.0	66.0	54.9	60.0	5.0	1.77	17600	5	R300-1648..	
	16	C6	12.0	8.00	4°	3.8	3	R300-066C6-16H	63.0	66.0	54.9	60.0	5.0	1.75	17600	6	R300-1648..	
54.0	12	C6	9.0	6.00	3°	3.0	3	R300-066C6-12M	63.0	66.0	59.3	50.0	3.0	1.65	21700	5	R300-1240..	
	12	C6	9.0	6.00	3°	3.0	3	R300-066C6-12H	63.0	66.0	59.3	50.0	3.0	1.67	21700	7	R300-1240..	
58.0	08	C6	6.0	4.00	1°	1.9	3	R300-066C6-08H	63.0	66.0	61.3	50.0	1.2	1.65	23100	10	R300-0828..	
60.0	20	C6	15.0	10.00	6°	6.0	3	R300-080C6-20M	63.0	80.0	80.0	80.0	7.5	2.24	15622	5	R300-2060..	
	20	C6	15.0	10.00	6°	6.0	3	R300-080C6-20H	63.0	80.0	80.0	80.0	7.5	2.20	15622	6	R300-2060..	
64.0	16	C6	12.0	8.00	3°	3.8	3	R300-080C6-16M	63.0	80.0	68.9	60.0	5.0	2.02	15400	5	R300-1648..	
	16	C6	12.0	8.00	3°	3.8	3	R300-080C6-16H	63.0	80.0	68.9	60.0	5.0	2.02	15400	7	R300-1648..	
68.0	12	C6	9.0	6.00	2°	3.0	3	R300-080C6-12M	63.0	80.0	73.3	50.0	3.0	1.82	18900	6	R300-1240..	
	12	C6	9.0	6.00	2°	3.0	3	R300-080C6-12H	63.0	80.0	73.3	50.0	3.0	1.72	18900	8	R300-1240..	
72.0	08	C6	6.0	4.00	1°	1.9	3	R300-080C6-08H	63.0	80.0	75.3	50.0	1.2	1.84	20500	12	R300-0828..	
80.0	20	C8	15.0	10.00	4°	6.0	3	R300-100C8-20M	80.0	100.0	80.0	80.0	7.5	3.72	12843	6	R300-2060..	
	20	C8	15.0	10.00	4°	6.0	3	R300-100C8-20H	80.0	100.0	80.0	80.0	7.5	3.48	12843	7	R300-2060..	

Spare parts	
	Insert screw
08	5513 020-56
10	5513 020-09
12	5513 020-09
16	5513 020-50
20	5513 020-31

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I99



L2



N23



N6



N9

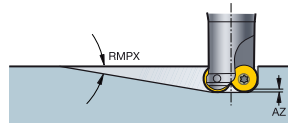


N15

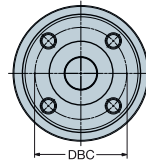
# CoroMill® 300 face milling cutter

Arbor - Internal coolant supply

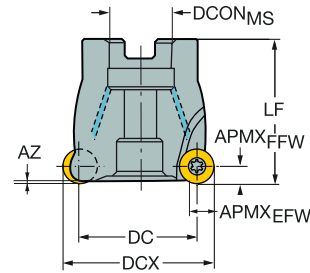
Positive design



STDNO



ISO6462



										Dimensions, mm									
DC		CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC		Ordering code	DCON <sub>MS</sub>	ISO	DBC	DCX	LF			RPMX	CICT	MID
32.0	08	16	6.0	4.00	3°	1.9	1	5	R300-040Q16-08M	16.0	A	40.0	40.0	1.2	0.44	30800	5	R300-0828..	
	08	16	6.0	4.00	3°	1.9	1	6	R300-040Q16-08H	16.0	A	40.0	40.0	1.2	0.20	30800	6	R300-0828..	
38.0	12	22	9.0	6.00	5°	3.0	1	4	R300-050Q22-12M	22.0	A	50.0	50.0	3.0	0.44	25000	4	R300-1240..	
	12	22	9.0	6.00	5°	3.0	1	5	R300-050Q22-12H	22.0	A	50.0	50.0	3.0	0.40	25000	5	R300-1240..	
40.0	12	22	9.0	6.00	5°	3.0	1	4	R300-052Q22-12M	22.0	A	52.0	50.0	3.0	0.79	24400	4	R300-1240..	
	12	22	9.0	6.00	5°	3.0	1	5	R300-052Q22-12H	22.0	A	52.0	50.0	3.0	0.46	24400	5	R300-1240..	
42.0	08	22	6.0	4.00	2°	1.9	1	8	R300-050Q22-08H	22.0	A	50.0	50.0	1.2	0.45	26700	8	R300-0828..	
44.0	08	22	6.0	4.00	2°	1.9	1	8	R300-052Q22-08H	22.0	A	52.0	50.0	1.2	0.85	26100	8	R300-0828..	
47.0	16	22	12.0	8.00	5°	3.8	1	4	R300-063Q22-16M	22.0	A	63.0	50.0	5.0	0.72	18200	4	R300-1648..	
	16	22	12.0	8.00	5°	3.8	1	6	R300-063Q22-16H	22.0	A	63.0	50.0	5.0	0.86	18200	6	R300-1648..	
51.0	12	22	9.0	6.00	3°	3.0	1	4	R300-063Q22-12L	22.0	A	63.0	50.0	3.0	0.97	22100	4	R300-1240..	
	12	22	9.0	6.00	3°	3.0	1	5	R300-063Q22-12M	22.0	A	63.0	50.0	3.0	0.60	22100	5	R300-1240..	
	12	22	9.0	6.00	3°	3.0	1	7	R300-063Q22-12H	22.0	A	63.0	50.0	3.0	0.57	22100	7	R300-1240..	
55.0	08	22	6.0	4.00	1°	1.9	1	10	R300-063Q22-08H	22.0	A	63.0	50.0	1.2	0.82	23700	10	R300-0828..	
60.0	20	27	15.0	10.00	6°	6.0	1	5	R300-080Q27-20M	27.0	A	80.0	50.0	7.5	0.95	15622	5	R300-2060..	
	20	27	15.0	10.00	6°	6.0	1	6	R300-080Q27-20H	27.0	A	80.0	50.0	7.5	1.07	15622	6	R300-2060..	
64.0	16	27	12.0	8.00	3°	3.8	1	5	R300-080Q27-16M	27.0	A	80.0	50.0	5.0	0.98	15400	5	R300-1648..	
	16	27	12.0	8.00	3°	3.8	1	7	R300-080Q27-16H	27.0	A	80.0	50.0	5.0	1.15	15400	7	R300-1648..	
68.0	12	27	9.0	6.00	2°	3.0	1	6	R300-080Q27-12M	27.0	A	80.0	50.0	3.0	0.90	18900	6	R300-1240..	
	12	27	9.0	6.00	2°	3.0	1	8	R300-080Q27-12H	27.0	A	80.0	50.0	3.0	1.06	18900	8	R300-1240..	
72.0	08	27	6.0	4.00	1°	1.9	1	12	R300-080Q27-08H	27.0	A	80.0	50.0	1.2	1.31	20500	12	R300-0828..	
80.0	20	32	15.0	10.00	4°	6.0	1	5	R300-100Q32-20L	32.0	A	100.0	63.0	7.5	2.46	12843	5	R300-2060..	
	20	32	15.0	10.00	4°	6.0	1	6	R300-100Q32-20M	32.0	A	100.0	63.0	7.5	2.40	12843	6	R300-2060..	
	20	32	15.0	10.00	4°	6.0	1	7	R300-100Q32-20H	32.0	A	100.0	63.0	7.5	2.41	12843	7	R300-2060..	
84.0	16	32	12.0	8.00	2°	3.8	1	6	R300-100Q32-16M	32.0	A	100.0	50.0	5.0	1.68	13300	6	R300-1648..	
	16	32	12.0	8.00	2°	3.8	1	8	R300-100Q32-16H	32.0	A	100.0	50.0	5.0	1.67	13300	8	R300-1648..	
105.0	20	40	15.0	10.00	3°	6.0	1	7	R300-125Q40-20M	40.0	B	125.0	63.0	7.5	3.03	10768	7	R300-2060..	
	20	40	15.0	10.00	3°	6.0	1	9	R300-125Q40-20H	40.0	B	125.0	63.0	7.5	2.93	10768	9	R300-2060..	
109.0	16	32	12.0	8.00	1°	3.8	1	8	R300-125Q32-16M	32.0	A	125.0	63.0	5.0	2.55	11900	8	R300-1648..	
	16	32	12.0	8.00	1°	3.8	1	10	R300-125Q32-16H	32.0	A	125.0	63.0	5.0	2.88	11900	10	R300-1648..	
140.0	20	40	15.0	10.00	2°	6.0	1	9	R300-160Q40-20M	40.0	B	160.0	63.0	7.5	4.93	9106	9	R300-2060..	
	20	40	15.0	10.00	2°	6.0	1	11	R300-160Q40-20H	40.0	B	160.0	63.0	7.5	4.83	9106	11	R300-2060..	
180.0	20	60	15.0	10.00	1°	6.0	0	11	R300-200Q60-20M	60.0	C	101.6	200.0	63.0	7.5	11.20	7799	11	R300-2060..

Spare parts	
	Insert screw
08	5513 020-56
12	5513 020-09
16	5513 020-50
20	5513 020-31

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



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L2



M1



N23



N6



N9

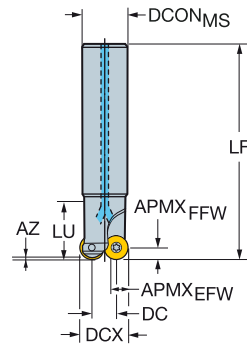
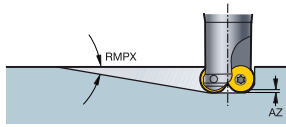


N15

# CoroMill® 300 face milling cutter

Cylindrical shank - Internal coolant supply

Positive design



										Dimensions, mm									
DC	CZC <sub>MS</sub>	APM <sub>EFW</sub>	APM <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID	
15.0	10	20	7.5	5.00	13°	2.3	1	2	R300-025A20-10M	20.0	25.0	19.1	33.0	150.0	3.0	0.50	2850	2	R300-1032..
17.0	08	20	6.0	4.00	8°	1.9	1	3	R300-025A20-08M	20.0	25.0	20.3	25.0	150.0	1.2	0.44	7200	3	R300-0828..
20.0	12	25	9.0	6.00	12°	3.0	1	2	R300-032A25-12M	25.0	32.0	25.3	25.0	190.0	3.0	0.82	8900	2	R300-1240..
	12	25	9.0	6.00	12°	3.0	1	3	R300-032A25-12H	25.0	32.0	25.3	25.0	150.0	3.0	0.65	3550	3	R300-1240..
22.0	10	25	7.5	5.00	7°	2.3	1	3	R300-032A25-10M	25.0	32.0	26.1	25.0	190.0	3.0	0.82	1470	3	R300-1032..
	10	25	7.5	5.00	7°	2.3	1	4	R300-032A25-10H	25.0	32.0	26.1	25.0	150.0	3.0	0.70	2850	4	R300-1032..
24.0	08	25	6.0	4.00	5°	1.9	1	4	R300-032A25-08M	25.0	32.0	27.3	25.0	190.0	1.2	0.79	9000	4	R300-0828..
	08	25	6.0	4.00	5°	1.9	1	5	R300-032A25-08H	25.0	32.0	27.3	25.0	150.0	1.2	0.61	3590	5	R300-0828..
28.0	12	32	9.0	6.00	8°	3.0	1	3	R300-040A32-12M	32.0	40.0	33.3	25.0	250.0	3.0	1.78	1140	3	R300-1240..
	12	32	9.0	6.00	8°	3.0	1	4	R300-040A32-12H	32.0	40.0	33.3	25.0	150.0	3.0	1.01	2850	4	R300-1240..

		Spare parts
DC		Insert screw
17.00-24.00	08	5513 020-56
15.00	10	5513 020-43
22.00	10	5513 020-09
20.00-28.00	12	5513 020-09

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I99



L2



N23



N6



N9

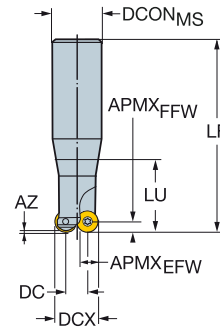
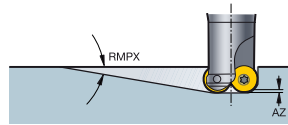


N15

# CoroMill® 300 face milling cutter

Cylindrical shank

Neutral design



										Dimensions, mm									
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	AZ	Ordering code	DCON <sub>MS</sub>	DCX	BD	LB	LF	LU	NM	KG	RPMX	CICT	MIID	
5.0	05	16	3.8	2.50	20°	1.8	2	R300-010A16L-05L	16.0	10.0	9.1	18.0	160.0	25.4	0.6	0.32	15900	2	R300-0517..
	07 20	16	5.3	3.50	20°	1.0	2	R300-012A16L-07L	16.0	12.0	10.4	21.0	200.0	37.8	0.9	0.38	8900	2	R300-0720..
8.0	07 24	20	5.3	3.50	20°	0.9	2	R300-015A20L-07L	20.0	15.0	13.4	25.0	200.0	43.8	0.9	0.54	12700	2	R300-0724..
	08	20	6.0	4.00	20°	1.8	2	R300-016A20L-08L	20.0	16.0	14.1	25.0	200.0	51.9	1.2	0.54	12700	2	R300-0828..
10.0	10	25	7.5	5.00	20°	3.4	2	R300-020A25L-10L	25.0	20.0	18.1	30.0	250.0	48.8	3.0	0.87	8100	2	R300-1032..
12.0	12	25	9.0	6.00	20°	2.7	2	R300-024A25L-12L	25.0	24.0	22.1	30.0	250.0	76.0	3.0	1.20	8900	2	R300-1240..
13.0	12	32	9.0	6.00	20°	1.4	2	R300-025A32L-12L	32.0	25.0	23.1	30.0	250.0	42.9	3.0	1.69	15800	2	R300-1240..
16.0	16	32	12.0	8.00	20°	4.8	2	R300-032A32L-16L	32.0	32.0	29.0	40.0	250.0	72.2	5.0	1.76	8700	2	R300-1648..

		Spare parts
DC		Insert screw
5.00	05	5513 020-40
5.00	07 20	5513 020-41
8.00	07 24	5513 020-42
8.00	08	5513 020-36
10.00	10	5513 020-43
12.00-13.00	12	5513 020-39
16.00	16	5513 020-50

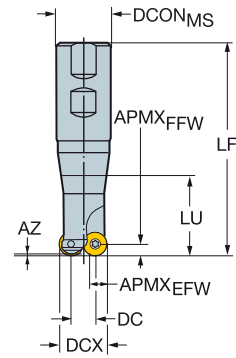
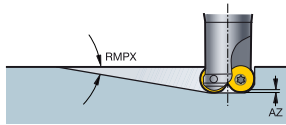
For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 300 face milling cutter

Weldon

Neutral design



										Dimensions, mm										
DC	CZC <sub>MS</sub>	APM <sub>EFW</sub>	APM <sub>FFW</sub>	RMPX	AZ		Ordering code	DCON <sub>MS</sub>	ISO	DCX	BD	LB	LF	LU			RPMX	CICT	MIID	
5.0	07 20	16	5.3	3.50	20°	1.0	2	R300-012B16L-07L	16.0	WE	12.0	10.4	21.0	109.0	37.6	0.9	0.24	34000	2	R300-0720..
8.0	07 24	20	5.3	3.50	20°	0.9	2	R300-015B20L-07L	20.0	WE	15.0	13.4	25.0	131.0	43.6	0.9	0.38	25000	2	R300-0724..
	08	20	6.0	4.00	20°	1.8	2	R300-016B20L-08L	20.0	WE	16.0	14.1	25.0	131.0	51.6	1.2	0.38	24700	2	R300-0828..
10.0	10	25	7.5	5.00	20°	3.4	2	R300-020B25L-10L	25.0	WE	20.0	18.1	30.0	137.0	48.4	3.0	0.58	34000	2	R300-1032..
13.0	12	32	9.0	6.00	20°	1.4	2	R300-025B32L-12L	32.0	WE	25.0	23.1	30.0	141.0	42.8	3.0	0.82	20200	2	R300-1240..

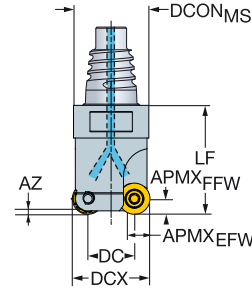
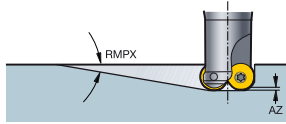
Spare parts		
DC		Insert screw
5.00	07 20	5513 020-41
8.00	07 24	5513 020-42
8.00	08	5513 020-36
10.00	10	5513 020-43
13.00	12	5513 020-39

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 300 face milling cutter

Coromant EH - Internal coolant supply



## Neutral design

									Dimensions, mm											
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID		
5.0	05	E10	3.8	2.50	20°	1.8	1	2	R300-10EH10-05L	9.7	10.0	9.0	13.1	20.0	0.6	0.06	20000	2	R300-0517..	
	07	20	E12	5.3	3.50	20°	1.0	1	2	R300-12EH12-07L	11.7	12.0	10.3	17.5	25.0	0.9	0.07	20000	2	R300-0720..
7.0	05	E12	3.8	2.50	10°	1.0	1	3	R300-12EH12-05M	11.7	12.0	11.0	12.5	20.0	0.6	0.10	20000	3	R300-0517..	
8.0	07	20	E12	5.3	3.50	20°	1.1	1	3	R300-15EH12-07M	11.7	15.0	13.3	17.5	25.0	0.9	0.10	20000	3	R300-0720..
	07	24	E12	5.3	3.50	20°	0.9	1	2	R300-15EH12-07L	11.7	15.0	13.3	17.5	25.0	0.9	0.10	20000	2	R300-0724..
	08	E16	6.0	4.00	20°	1.8	1	2	R300-16EH16-08L	15.5	16.0	14.0	21.3	30.0	1.2	0.09	20000	2	R300-0828..	
9.0	07	20	E16	5.3	3.50	15°	0.9	1	3	R300-16EH16-07M	15.5	16.0	14.3	16.3	25.0	0.9	0.11	20000	3	R300-0720..
10.0	10	E20	7.5	5.00	20°	3.4	1	2	R300-20EH20-10L	19.3	20.0	18.0	25.0	35.0	3.0	0.12	20000	2	R300-1032..	
12.0	08	E20	6.0	4.00	12°	1.5	1	3	R300-20EH20-08M	19.3	20.0	18.0	20.0	30.0	1.2	0.13	20000	3	R300-0828..	
	12	E20	9.0	6.00	20°	2.7	1	2	R300-24EH20-12L	19.3	24.0	22.0	25.0	35.0	3.0	0.17	15000	2	R300-1240..	
15.0	10	E25	7.5	5.00	15°	1.1	1	2	R300-25EH25-10L	24.2	25.0	23.0	24.5	35.0	3.0	0.20	15000	2	R300-1032..	
	10	E25	7.5	5.00	15°	1.3	1	3	R300-25EH25-10M	24.2	25.0	23.0	24.5	35.0	3.0	0.19	15000	3	R300-1032..	
16.0	16	E25	12.0	8.00	20°	4.8	1	2	R300-32EH25-16L	24.2	32.0	28.9	29.5	40.0	5.0	0.23	15000	2	R300-1648..	
20.0	12	E25	9.0	6.00	15°	1.4	1	3	R300-32EH25-12M	24.2	32.0	30.0	24.5	35.0	3.0	0.21	15000	3	R300-1240..	
22.0	10	E25	7.5	5.00	10°	1.7	1	4	R300-32EH25-10H	24.2	32.0	30.0	24.5	35.0	3.0	0.23	15000	4	R300-1032..	

## Positive design

									Dimensions, mm										
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code		DCON <sub>MS</sub>	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID	
17.0	08	E25	6.0	4.00	5°	0.6	1	3	R300-25EH25-08M	24.2	25.0	20.3	24.5	35.0	1.2	0.17	15000	3	R300-0828..
24.0	08	E25	6.0	4.00	5°	2.0	1	4	R300-32EH25-08M	24.2	32.0	27.3	24.5	35.0	1.2	0.21	15000	4	R300-0828..
	08	E25	6.0	4.00	5°	2.0	1	5	R300-32EH25-08H	24.2	32.0	27.3	24.5	35.0	1.2	0.20	15000	5	R300-0828..

## Neutral design

		Spare parts
DC		Insert screw
5.00-9.00	07 20	5513 020-41
8.00	07 24	5513 020-42
5.00-7.00	05	5513 020-40
8.00-12.00	08	5513 020-36
10.00-22.00	10	5513 020-43
12.00-20.00	12	5513 020-39
16.00	16	5513 020-50

## Positive design

Spare parts
Insert screw
5513 020-56

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



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L2



N23



N6



N9



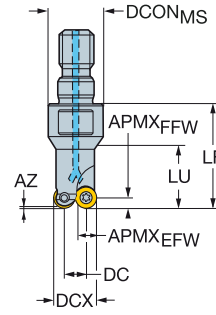
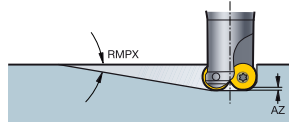
N15



N3

# CoroMill® 300 face milling cutter

Threaded coupling - Internal coolant supply



## Neutral design

										Dimensions, mm										
DC	CZC <sub>MS</sub>	APM <sub>EFW</sub>	APM <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code	DCON <sub>MS</sub>	DCX	BD	LB	LF	LU	NM	KG	RPMX	CICT	MIID		
5.0	07 20	M8	5.3	3.50	20°	1.0	0	2	R300-12T08-07L	12.8	12.0	10.4	21.0	25.0	17.3	0.9	0.09	9100	2	R300-0720..
7.0	05	M8	3.8	2.50	10°	1.0	0	3	R300-12T08-05M	12.8	12.0	11.1	18.0	25.0		0.6	0.05	9100	3	R300-0517..
8.0	07 24	M8	5.3	3.50	20°	0.9	0	2	R300-15T08-07L	12.8	15.0	13.4		25.0		0.9	0.10	9100	2	R300-0724..
	08	M8	6.0	4.00	20°	1.8	0	2	R300-16T08-08L	12.8	16.0	14.0		25.0		1.2	0.05	9100	2	R300-0828..
10.0	10	M10	7.5	5.00	20°	3.4	1	2	R300-20T10-10L	17.8	20.0	18.1		30.0		3.0	0.09	9100	2	R300-1032..
12.0	08	M10	6.0	4.00	12°	1.5	1	3	R300-20T10-08M	17.8	20.0	18.1		30.0		1.2	0.03	9100	3	R300-0828..
	12	M12	9.0	6.00	20°	2.7	1	2	R300-24T12-12L	20.8	24.0	22.1		35.0		3.0	0.18	9100	2	R300-1240..
15.0	10	M12	7.5	5.00	15°	1.1	1	2	R300-25T12-10L	20.8	25.0	23.1		35.0		3.0	0.16	9100	2	R300-1032..
	10	M12	7.5	5.00	15°	1.3	1	3	R300-25T12-10M	20.8	25.0	23.1		35.0		3.0	0.20	9100	3	R300-1032..
20.0	12	M16	9.0	6.00	15°	1.4	1	3	R300-32T16-12M	28.8	32.0	30.1		45.0		3.0	0.31	9100	3	R300-1240..
22.0	10	M16	7.5	5.00	10°	1.7	1	4	R300-32T16-10H	28.8	32.0	30.1		45.0		3.0	0.33	9100	4	R300-1032..
23.0	12	M16	9.0	6.00	16°	5.0	1	3	R300-35T16-12M	28.8	35.0	33.1		45.0		3.0	0.34	9100	3	R300-1240..
25.0	10	M16	7.5	5.00	10°	3.6	1	4	R300-35T16-10H	28.8	35.0	33.1		45.0		3.0	0.38	9100	4	R300-1032..
28.0	12	M16	9.0	6.00	13°	5.0	1	4	R300-40T16-12M	28.8	40.0	38.1		45.0		3.0	0.35	9100	4	R300-1240..
30.0	10	M16	7.5	5.00	8°	3.6	1	5	R300-40T16-10H	28.8	40.0	38.1		45.0		3.0	0.37	9100	5	R300-1032..
	12	M16	9.0	6.00	12°	5.0	1	4	R300-42T16-12M	28.8	42.0	40.1		45.0		3.0	0.04	9100	4	R300-1240..
32.0	10	M16	7.5	5.00	7°	3.6	1	5	R300-42T16-10H	28.8	42.0	40.1		45.0		3.0	0.41	9100	5	R300-1032..

## Positive design

										Dimensions, mm										
DC	CZC <sub>MS</sub>	APM <sub>EFW</sub>	APM <sub>FFW</sub>	RMPX	AZ	CNSC	Ordering code	DCON <sub>MS</sub>	DCX	BD	LB	LF	LU	NM	KG	RPMX	CICT	MIID		
17.0	08	M12	6.0	4.00	8°	1.9	1	3	R300-25T12-08M	20.8	25.0	20.3	18.0	35.0		1.2	0.18	9100	3	R300-0828..
24.0	08	M16	6.0	4.00	5°	1.9	1	4	R300-32T16-08M	28.8	32.0	27.3	28.0	45.0		1.2	0.30	9100	4	R300-0828..
	08	M16	6.0	4.00	5°	1.9	1	5	R300-32T16-08H	28.8	32.0	27.3	28.0	45.0		1.2	0.30	9100	5	R300-0828..
32.0	08	M16	6.0	4.00	3°	1.9	1	6	R300-40T16-08H	28.8	40.0	35.3	28.0	45.0		1.2	0.38	9100	6	R300-0828..

## Neutral design

		Spare parts
DC		Insert screw
5.00	07 20	5513 020-41
8.00	07 24	5513 020-42
7.00	05	5513 020-40
8.00-12.00	08	5513 020-36
10.00-32.00	10	5513 020-43
12.00-30.00	12	5513 020-39

## Positive design

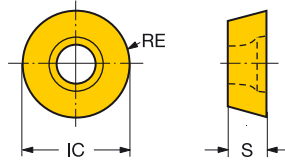
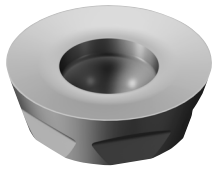
Spare parts
Insert screw
5513 020-56

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

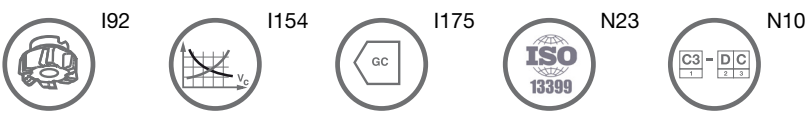




# CoroMill® 300 insert for milling



	RE	Ordering code	Dimensions, mm																				
			P			M			K			N			S			H					
			1130	4270	4330	4340	1040	2040	1020	3040	3350	1130	H13A	1130	H13A	H13A	S30T	S40T	1010	1130	IC	S	
Light	08	4.00	R300-0828E-KL										*		*							8.0	2.78
		4.00	R300-0828E-PL	*				*					*		*		*	*	*	*	*	8.0	2.78
	10	5.00	R300-1032E-KL										*		*							10.0	3.18
		5.00	R300-1032E-PL	*				*					*		*		*	*	*	*	*	10.0	3.18
	12	6.00	R300-1240E-ML				*	*														12.0	3.97
		6.00	R300-1240E-PL	*		*		*	*				*		*		*	*	*	*	*	12.0	3.97
	16	8.00	R300-1648E-ML				*	*														16.0	4.76
		8.00	R300-1648E-PL	*		*		*	*				*		*		*	*	*	*	*	16.0	4.76
	20	10.00	R300-2060E-ML				*	*														20.0	6.48
		10.00	R300-2060E-PL	*		*		*	*				*		*		*	*	*	*	*	20.0	6.48
Medium	05	2.50	R300-0517E-PM	*		*	*					*		*		*						5.0	1.70
	07 20	3.50	R300-0720E-MM				*	*														7.0	1.99
	07 20	3.50	R300-0720E-PM	*		*	*					*		*		*						7.0	1.99
	07 24	3.50	R300-0724E-MM				*	*														7.0	2.38
	07 24	3.50	R300-0724E-PM	*		*	*					*		*		*						7.0	2.38
	08	4.00	R300-0828E-KM						*													8.0	2.78
		4.00	R300-0828E-MM				*	*														8.0	2.78
		4.00	R300-0828E-PM	*		*	*	*					*		*		*	*	*	*	*	8.0	2.78
		4.00	R300-0828M-MM				*	*														8.0	2.78
		4.00	R300-0828M-PM	*		*	*	*					*		*		*	*	*	*	*	8.0	2.78
10	5.00	R300-1032E-MM				*	*														10.0	3.18	
	5.00	R300-1032E-PM	*		*	*	*					*		*		*	*	*	*	*	10.0	3.18	
	5.00	R300-1032M-MM				*	*														10.0	3.18	
	5.00	R300-1032M-PM	*		*	*	*					*		*		*	*	*	*	*	10.0	3.18	
12	6.00	R300-1240E-KM						*		*											12.0	3.97	
	6.00	R300-1240E-MM				*	*														12.0	3.97	
	6.00	R300-1240E-PM	*		*	*	*					*		*		*	*	*	*	*	12.0	3.97	
	6.00	R300-1240M-MM				*	*														12.0	3.97	
	6.00	R300-1240M-PM	*	*	*	*	*					*		*		*	*	*	*	*	12.0	3.97	
16	8.00	R300-1648E-MM				*	*														16.0	4.76	
	8.00	R300-1648E-PM	*		*	*	*					*		*		*	*	*	*	*	16.0	4.76	
	8.00	R300-1648M-MM				*	*														16.0	4.76	
	8.00	R300-1648M-PM	*	*	*	*	*					*		*		*	*	*	*	*	16.0	4.76	
20	10.00	R300-2060E-MM				*	*														20.0	6.48	
	10.00	R300-2060E-PM	*		*	*	*					*		*		*	*	*	*	*	20.0	6.48	
	10.00	R300-2060M-MM				*	*														20.0	6.48	
	10.00	R300-2060M-PM	*	*	*	*	*					*		*		*	*	*	*	*	20.0	6.48	
Heavy	08	4.00	R300-0828M-KH							*	*										8.0	2.78	
		4.00	R300-0828M-MH				*	*													8.0	2.78	
		4.00	R300-0828M-PH	*	*	*	*	*				*		*		*	*	*	*	*	8.0	2.78	
	10	5.00	R300-1032M-KH						*												10.0	3.18	
		5.00	R300-1032M-MH				*	*													10.0	3.18	
		5.00	R300-1032M-PH	*	*	*	*	*				*		*		*	*	*	*	*	10.0	3.18	
	12	6.00	R300-1240M-KH						*	*	*										12.0	3.97	
		6.00	R300-1240M-MH				*	*													12.0	3.97	
		6.00	R300-1240M-PH	*	*	*	*	*				*		*		*	*	*	*	*	12.0	3.97	
	16	8.00	R300-1648M-KH						*	*	*										16.0	4.76	
	8.00	R300-1648M-MH				*	*													16.0	4.76		
	8.00	R300-1648M-PH	*	*	*	*	*				*		*		*	*	*	*	*	16.0	4.76		
20	10.00	R300-2060M-KH						*	*	*										20.0	6.48		
	10.00	R300-2060M-MH				*	*													20.0	6.48		
	10.00	R300-2060M-PH	*	*	*	*	*				*		*		*	*	*	*	*	20.0	6.48		



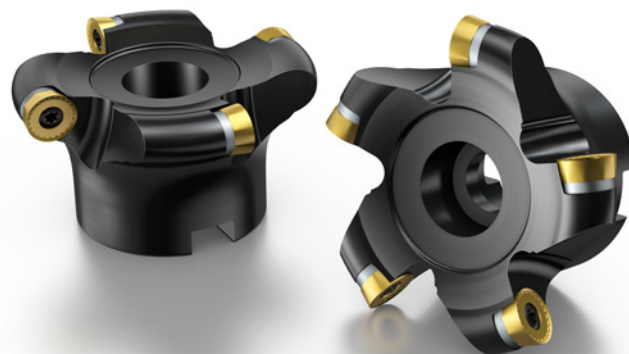
# CoroMill® 200

Robust face milling and profile cutter

## Application

- Full slot milling
- Face milling
- Ramping
- Profiling
- Pocket milling

## ISO application area:



## Benefits and features

- Process security and reliability
- High metal removal rate
- Shim protection available

[www.sandvik.coromant.com/coromill200](http://www.sandvik.coromant.com/coromill200)

## Couplings

- Arbor
- Cylindrical shank

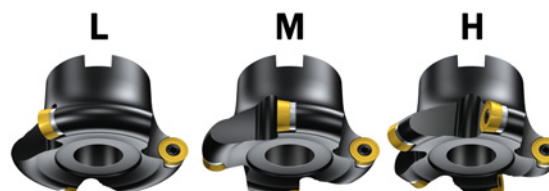
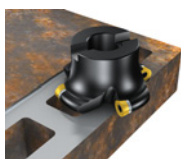
## Inserts

- 8 cutting edges
- Insert geometries and grades for all materials
- Insert geometries for high chip removal rates – large AP and  $f_z$



## Reliability and process security

Strong cutting edges make the cutter resistant to tough conditions with interruptions (holes, gaps etc.) and/or abrasive scale (skin).



Coarse pitch

Close pitch

Extra close pitch



I101

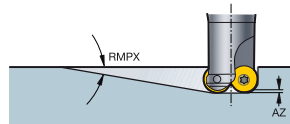


I103

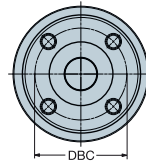
I 100

# CoroMill® 200 face milling cutter

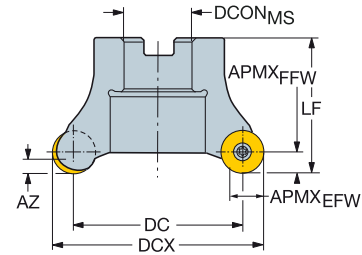
Arbor



STDNO



ISO6462



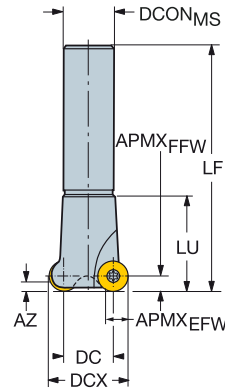
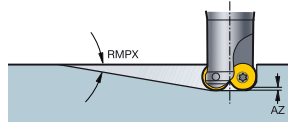
										Dimensions, mm											
DC		CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ			Ordering code	DCON <sub>MS</sub>	ISO	DBC	DCX	BD	LF			RPMX	CICT	MIID	
38.0	12	22	9.0	6.00	6°	3.7		3	R200-038Q22-12L	22.0	A	50.0	50.0	50.0	3.0	0.65	18800	3	RCKT 12 04 M0		
	12	22	9.0	6.00	6°	3.7		4	R200-038Q22-12M	22.0	A	50.0	50.0	50.0	3.0	0.66	18800	4	RCKT 12 04 M0		
	12	22	9.0	6.00	6°	3.7		5	R200-038Q22-12H	22.0	A	50.0	50.0	50.0	3.0	0.78	18800	5	RCKT 12 04 M0		
40.0	12	22	9.0	6.00	6°	3.7		3	R200-040Q22-12L	22.0	A	52.0	52.0	50.0	3.0	0.70	18000	3	RCKT 12 04 M0		
	12	22	9.0	6.00	6°	3.7		4	R200-040Q22-12M	22.0	A	52.0	52.0	50.0	3.0	0.68	18000	4	RCKT 12 04 M0		
	12	22	9.0	6.00	6°	3.7		5	R200-040Q22-12H	22.0	A	52.0	52.0	50.0	3.0	0.66	18000	5	RCKT 12 04 M0		
47.0	16	22	12.0	8.00	7°	4.9		4	R200-047Q22-16M	22.0	A	63.0	63.0	50.0	5.0	0.80	15300	4	RCKT 16 06 M0		
50.0	16	27	12.0	8.00	6°	4.9		4	R200-050Q27-16M	27.0	A	66.0	66.0	50.0	5.0	0.86	14500	4	RCKT 16 06 M0		
	16	27	12.0	8.00	6°	4.9		5	R200-050Q27-16H	27.0	A	66.0	66.0	50.0	5.0	0.75	14500	5	RCKT 16 06 M0		
51.0	12	22	9.0	6.00	4°	3.7		3	R200-051Q22-12L	22.0	A	63.0	63.0	50.0	3.0	0.81	16200	3	RCKT 12 04 M0		
	12	22	9.0	6.00	4°	3.7		4	R200-051Q22-12M	22.0	A	63.0	63.0	50.0	3.0	0.74	16200	4	RCKT 12 04 M0		
	12	22	9.0	6.00	4°	3.7		5	R200-051Q22-12H	22.0	A	63.0	63.0	50.0	3.0	0.82	16200	5	RCKT 12 04 M0		
60.0	20	27	15.0	10.00	7°	6.1		3	R200-060Q27-20L	27.0	A	80.0	80.0	50.0	7.5	1.00	10600	3	RCKT 20 06 M0		
	20	27	15.0	10.00	7°	6.1		4	R200-060Q27-20M	27.0	A	80.0	80.0	50.0	7.5	0.89	10600	4	RCKT 20 06 M0		
64.0	16	27	12.0	8.00	5°	4.9		4	R200-064Q27-16L	27.0	A	80.0	80.0	50.0	5.0	1.16	13100	4	RCKT 16 06 M0		
	16	27	12.0	8.00	5°	4.9		5	R200-064Q27-16M	27.0	A	80.0	80.0	50.0	5.0	1.02	13100	5	RCKT 16 06 M0		
	16	27	12.0	8.00	5°	4.9		6	R200-064Q27-16H	27.0	A	80.0	80.0	50.0	5.0	0.96	13100	6	RCKT 16 06 M0		
68.0	12	27	9.0	6.00	3°	3.7		4	R200-068Q27-12L	27.0	A	80.0	80.0	50.0	3.0	1.05	14000	4	RCKT 12 04 M0		
	12	27	9.0	6.00	3°	3.7		6	R200-068Q27-12M	27.0	A	80.0	80.0	50.0	3.0	0.92	14000	6	RCKT 12 04 M0		
80.0	20	32	15.0	10.00	5°	6.1		4	R200-080Q32-20L	32.0	B	100.0	100.0	63.0	7.5	1.73	9200	4	RCKT 20 06 M0		
	20	32	15.0	10.00	5°	6.1		6	R200-080Q32-20M	32.0	B	100.0	100.0	63.0	7.5	1.54	9200	6	RCKT 20 06 M0		
84.0	16	32	12.0	8.00	3°	4.9		6	R200-084Q32-16M	32.0	B	100.0	100.0	50.0	5.0	1.62	11400	6	RCKT 16 06 M0		
88.0	12	32	9.0	6.00	2°	3.7		4	R200-088Q32-12L	32.0	B	100.0	100.0	50.0	3.0	1.66	12300	4	RCKT 12 04 M0		
	12	32	9.0	6.00	2°	3.7		6	R200-088Q32-12M	32.0	B	100.0	100.0	50.0	3.0	1.50	12300	6	RCKT 12 04 M0		
105.0	20	32	15.0	10.00	3°	6.1		5	R200-105Q32-20L	32.0	B	125.0	125.0	63.0	7.5	2.44	8000	5	RCKT 20 06 M0		
	20	32	15.0	10.00	3°	6.1		6	R200-105Q32-20M	32.0	B	125.0	125.0	63.0	7.5	2.28	8000	6	RCKT 20 06 M0		
109.0	16	32	12.0	8.00	2°	4.9		5	R200-109Q32-16L	32.0	B	125.0	125.0	50.0	5.0	2.26	10000	5	RCKT 16 06 M0		
	16	32	12.0	8.00	2°	4.9		6	R200-109Q32-16M	32.0	B	125.0	125.0	50.0	5.0	2.33	10000	6	RCKT 16 06 M0		
140.0	20	40S	15.0	10.00	2°	6.1		6	R200-140Q40-20L	40.0	C	66.7	160.0	160.0	63.0	7.5	3.72	6900	6	RCKT 20 06 M0	
	20	40S	15.0	10.00	2°	6.1		8	R200-140Q40-20M	40.0	C	66.7	160.0	160.0	63.0	7.5	3.60	6900	8	RCKT 20 06 M0	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 200 face milling cutter

Cylindrical shank



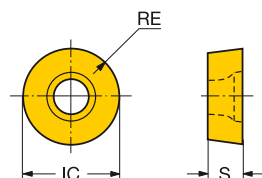
								Dimensions, mm											
DC	CZC <sub>MS</sub>	APMX <sub>EFW</sub>	APMX <sub>FFW</sub>	RMPX	AZ	Ordering code		DCON <sub>MS</sub>	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID		
15.0	10	20	7.5	5.00	13°	2.9	2	R200-015A20-10M	20.0	25.0	25.0	25.0	150.0	3.0	0.54	37500	2	RCKT 10 T3 M0	
	10	20	7.5	5.00	13°	2.9	3	R200-015A20-10H	20.0	25.0	25.0	25.0	150.0	3.0	0.49	37500	3	RCKT 10 T3 M0	
20.0	12	25	9.0	6.00	13°	3.7	2	R200-020A25-12M	25.0	32.0	32.0	32.0	190.0	3.0	0.84	31100	2	RCKT 12 04 M0	
	12	25	9.0	6.00	13°	3.7	3	R200-020A25-12H	25.0	32.0	32.0	32.0	190.0	3.0	0.86	31100	3	RCKT 12 04 M0	
24.0	16	32	12.0	8.00	13°	4.9	2	R200-024A32-16L	32.0	40.0	40.0	40.0	240.0	5.0	1.72	21800	2	RCKT 16 06 M0	
	16	32	12.0	8.00	13°	4.9	3	R200-024A32-16M	32.0	40.0	40.0	40.0	240.0	5.0	1.64	21800	3	RCKT 16 06 M0	
28.0	12	32	9.0	6.00	9°	3.7	2	R200-028A32-12L	32.0	40.0	40.0	40.0	240.0	3.0	1.76	26300	2	RCKT 12 04 M0	
	12	32	9.0	6.00	9°	3.7	3	R200-028A32-12M	32.0	40.0	40.0	40.0	240.0	3.0	1.74	26300	3	RCKT 12 04 M0	
30.0	20	32	15.0	10.00	13°	6.1	2	R200-030A32-20L	32.0	50.0	50.0	50.0	240.0	7.5	1.88	20900	2	RCKT 20 06 M0	
	20	32	15.0	10.00	13°	6.1	3	R200-030A32-20M	32.0	50.0	50.0	50.0	240.0	7.5	1.79	20900	3	RCKT 20 06 M0	
34.0	16	32	12.0	8.00	11°	4.9	3	R200-034A32-16M	32.0	50.0	50.0	50.0	240.0	5.0	1.81	18300	3	RCKT 16 06 M0	
38.0	12	32	9.0	6.00	6°	3.7	3	R200-038A32-12L	32.0	50.0	50.0	50.0	240.0	3.0	1.86	22500	3	RCKT 12 04 M0	
	12	32	9.0	6.00	6°	3.7	4	R200-038A32-12M	32.0	50.0	50.0	50.0	240.0	3.0	1.84	22500	4	RCKT 12 04 M0	

Spare parts	
	Insert screw
10	5513 020-09
12	5513 020-09
16	5513 020-07
20	5513 020-08

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



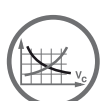
# CoroMill® 200 insert for milling



		RE	Ordering code	Dimensions, mm																												
				P				M				K				N				S				H								
				1130	4220	4330	4340	530	1040	1130	2040	530	1020	3040	3220	3330	H3A	1130	530	H10F	H3A	1130	H10F	H3A	S30T	S40T	1010	1130	530	IC	S	
Light	KL	10	5.00	RCHT 10 T3 M0-KL										*									*						10.0	3.97		
		12	6.00	RCHT 12 04 M0-KL											*								*							12.0	4.76	
		16	8.00	RCHT 16 06 M0-KL											*								*							16.0	6.35	
		20	10.00	RCHT 20 06 M0-KL											*								*							20.0	6.35	
	ML	10	5.00	RCHT 10 T3 M0-ML					*	*																				10.0	3.97	
		12	6.00	RCHT1204M0-ML					*	*																				12.0	4.76	
		16	8.00	RCHT 16 06 M0-ML					*	*																				16.0	6.35	
		20	10.00	RCHT 20 06 M0-ML					*	*																				20.0	6.35	
	PL	10	5.00	RCHT 10 T3 M0-PL	*				*	*				*	*			*		*		*		*	*	*	*	*	*	10.0	3.97	
		12	6.00	RCHT 12 04 M0-PL	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	12.0	4.76
		16	8.00	RCHT 16 06 M0-PL	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	16.0	6.35
		20	10.00	RCHT 20 06 M0-PL	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	20.0	6.35
Medium	KM	10	5.00	RCKT 10 T3 M0-KM							*	*	*	*	*														10.0	3.97		
		12	6.00	RCKT 12 04 M0-KM							*	*	*	*	*														12.0	4.76		
		16	8.00	RCKT 16 06 M0-KM							*	*	*	*	*														16.0	6.35		
		20	10.00	RCKT 20 06 M0-KM							*	*	*	*	*														20.0	6.35		
	MM	10	5.00	RCKT 10 T3 M0-MM					*	*	*	*	*	*	*															10.0	3.97	
		12	6.00	RCKT 12 04 M0-MM					*	*	*	*	*	*	*															12.0	4.76	
		16	8.00	RCKT 16 06 M0-MM					*	*	*	*	*	*	*															16.0	6.35	
		20	10.00	RCKT 20 06 M0-MM					*	*	*	*	*	*	*															20.0	6.35	
	PM	10	5.00	RCKT 10 T3 M0-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	10.0	3.97
		12	6.00	RCKT 12 04 M0-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	12.0	4.76
		16	8.00	RCKT 16 06 M0-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	16.0	6.35
		20	10.00	RCKT 20 06 M0-PM	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	20.0	6.35
WM	10	5.00	RCKT 10 T3 M0-WM					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	10.0	3.97	
	12	6.00	RCKT 12 04 M0-WM					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	12.0	4.76	
	16	8.00	RCKT 16 06 M0-WM					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	16.0	6.35	
	20	10.00	RCKT 20 06 M0-WM					*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	20.0	6.35	
KH	10	5.00	RCKT 10 T3 M0-KH							*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	10.0	3.97	
	12	6.00	RCKT 12 04 M0-KH							*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	12.0	4.76	
	16	8.00	RCKT 16 06 M0-KH							*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	16.0	6.35	
	20	10.00	RCKT 20 06 M0-KH							*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	20.0	6.35	
PH	10	5.00	RCKT 10 T3 M0-PH	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	10.0	3.97	
	12	6.00	RCKT 12 04 M0-PH	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	12.0	4.76	
	16	8.00	RCKT 16 06 M0-PH	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	16.0	6.35	
	20	10.00	RCKT 20 06 M0-PH	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	*	20.0	6.35	



1101



1154



1175



N23

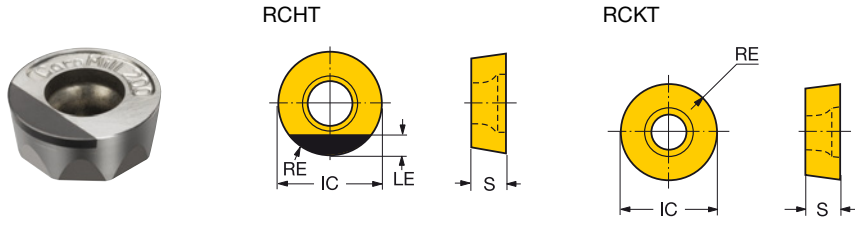


N10



# CoroMill® 200 insert for milling

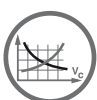
Advanced cutting materials



				Dimensions, mm							
		RE	Ordering code	K	H	IC	LE	S			
		12	6.00	RCHT 12 04 MO	6190	CB50	6190	CB50	12.0	3.0	4.76
Light	PO	12	6.00	RCHT 12 04 MO	☆	☆	☆	☆	12.0	3.0	4.76
		16	8.00	RCKT 16 06 MO	☆	☆	☆	☆	16.0	6.35	
Medium	SK15	12	6.00	RCKT 12 04 MO	☆	☆	☆	☆	12.0		4.76
		16	8.00	RCKT 16 06 MO	☆	☆	☆	☆	16.0		6.35



I101



I154



I175



N23



N10

# CoroMill® 216

A metal remover for rough and semi-finish profiling

## Application

- Profiling
- Copy milling
- Contour milling
- Roughing to semi-finishing

## ISO application area:



## Benefits and features

- Maximum security and reliability
- High metal removal rate
- Easy to apply



[www.sandvik.coromant.com/coromill216](http://www.sandvik.coromant.com/coromill216)

## Couplings

- Coromant Capto®
- Cylindrical shank
- Weldon
- Coromant EH
- Threaded coupling

## Inserts

- Two cutting edges
- Insert geometries and grades for all materials



inserts for higher security



inserts with sharper edges and higher precision

## Insert location

Same inserts for both central and peripheral locations.



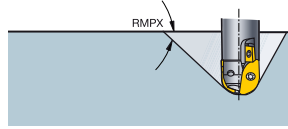
I106



I111

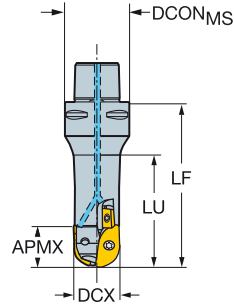
# CoroMill® 216 ball nose milling cutter

Coromant Capto® - Internal coolant supply



KAPR

90°



										Dimensions, mm												
DC	APMX <sub>FW</sub>	APMX <sub>EFW</sub>			CZC <sub>MS</sub>	RMPX	AZ	CNSC		Ordering code	DCON <sub>MS</sub>	DCX	BD <sub>i</sub>	LF	LU			RPMX	CICT <sub>BALL</sub>	MID <sub>BALL</sub>	CICT <sub>SP</sub>	MID <sub>SP</sub>
30.0	28.3	15.0	30		C3	85°	15.0	3	2	R216-30C3-070	32.0	30.0	26.8	70.0	50.6	5.0	0.39	18500	2	R216-30 06		
32.0	28.6	16.0	32		C3	85°	16.0	3	2	R216-32C3-070	32.0	32.0	29.0	70.0		5.0	0.42	18500	2	R216-32 06		
40.0	31.6	20.0	40		C4	85°	20.0	3	2	R216-40C4-080	40.0	40.0	37.0	80.0		7.5	0.87	8000	2	R216-40 07		
50.0	44.6	25.0	50	16	C5	85°	25.0	3	2	R216-50C5-125	50.0	50.0	46.4	125.0		10.0	1.65	7000	2	R216-50 07	2	APMT 160408-M

Spare parts			
	Insert screw	Shim	Protection insert screw
30	5513 020-07		
32	5513 020-07		
40	5513 020-31		
50	5513 021-03	5322 475-01	5513 020-09

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I111



L2



N23



N9

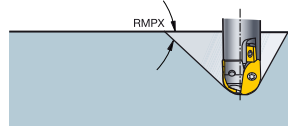


N15



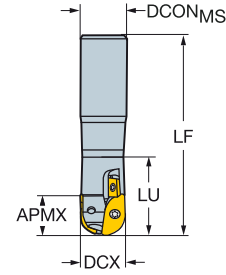
# CoroMill® 216 ball nose milling cutter

Cylindrical shank - Internal coolant supply



KAPR

90°



										Dimensions, mm												
DC	APMX <sub>FFW</sub>	APMX <sub>EFW</sub>		CZC <sub>MS</sub>	RMPX	AZ	CNSC		Ordering code	DCON <sub>MS</sub>	DCX	BD <sub>1</sub>	LF	LU			RPMX	CICT <sub>BALL</sub>	MID <sub>BALL</sub>	CICT <sub>SP</sub>	MID <sub>SP</sub>	
10.0	8.6	5.0	10	16	85°	5.0	0	2	R216-10A16-050	16.0	10.0	9.2	160.0	22.1	0.6	0.31	15900	2	R216-10 02			
12.0	10.8	6.0	12	20	85°	6.0	0	2	R216-12A20-045	20.0	12.0	10.8	200.0	22.0	1.2	0.54	21000	2	R216-12 02			
16.0	14.4	8.0	16	20	85°	8.0	1	2	R216-16A20-045	20.0	16.0	14.7	200.0	29.6	1.2	0.54	20000	2	R216-16 03			
20.0	17.9	10.0	20	25	85°	10.0	1	2	R216-20A25-055	25.0	20.0	18.4	200.0	36.5	2.0	0.68	24000	2	R216-20 T3			
25.0	22.3	12.5	25	32	85°	12.5	1	2	R216-25A32-065	32.0	25.0	23.2	250.0	43.4	3.0	1.69	24000	2	R216-25 04			
30.0	26.9	15.0	30	16	32	85°	15.0	1	2	R216-30A32-070	32.0	30.0	26.8	250.0	60.4	5.0	1.74	19500	2	R216-30 06	1	APMT 160408-M
32.0	28.6	16.0	32	32	85°	16.0	1	2	R216-32A32-070	32.0	32.0	29.0	250.0	70.0	5.0	1.56	18500	2	R216-32 06			

Spare parts			
		Insert screw	Protection insert screw
10		5513 020-40	
12		5513 020-36	
16		5513 020-36	
20		5513 020-16	
25		5513 020-52	
30	16	5513 020-07	5513 020-09
32		5513 020-07	

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I111



L2



N23



N9



N15

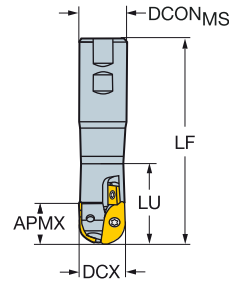
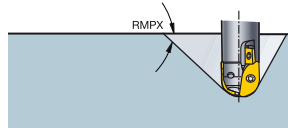


# CoroMill® 216 ball nose milling cutter

Weldon - Internal coolant supply

KAPR

90°



										Dimensions, mm													
DC	APMX <sub>FW</sub>	APMX <sub>EW</sub>		CZC <sub>MS</sub>	RMPX	AZ	CNSC		Ordering code	DCON <sub>MS</sub>	ISO	DCX	BD <sub>1</sub>	LF	LU			RPMX	CICT <sub>BALL</sub>	MID <sub>BALL</sub>	CICT <sub>SP</sub>	MID <sub>SP</sub>	
12.0	10.8	6.0	12	20	85°	6.0	0	2	<b>R216-12B20-060</b>	20.0	WE	12.0	10.8	111.0	24.0	1.2	0.30	21000	2	R216-12 02			
10.8	6.0	12	20	85°	6.0	0	2	<b>R216-12B20-040</b>	20.0	WE	12.0	10.8	91.0	21.2	1.2	0.27	21000	2	R216-12 02				
16.0	14.4	8.0	16	20	85°	8.0	1	2	<b>R216-16B20-040</b>	20.0	WE	16.0	14.7	91.0	28.2	1.2	0.28	20000	2	R216-16 03			
	14.4	8.0	16	20	85°	8.0	1	2	<b>R216-16B20-060</b>	20.0	WE	16.0	14.7	111.0	33.8	1.2	0.31	20000	2	R216-16 03			
20.0	17.9	10.0	20	25	85°	10.0	1	2	<b>R216-20B25-050</b>	25.0	WE	20.0	18.4	107.0	35.2	2.0	0.42	24000	2	R216-20 T3			
	17.9	10.0	20	25	85°	10.0	1	2	<b>R216-20B25-070</b>	25.0	WE	20.0	18.4	127.0	40.6	2.0	0.47	24000	2	R216-20 T3			
25.0	22.3	12.5	25	25	85°	12.5	1	2	<b>R216-25B25-060</b>	25.0	WE	25.0	23.2	117.0	60.0	3.0	0.49	24000	2	R216-25 04			
	22.3	12.5	25	25	85°	12.5	1	2	<b>R216-25B25-080</b>	25.0	WE	25.0	23.2	137.0	80.0	3.0	0.55	24000	2	R216-25 04			
30.0	26.9	15.0	30	16	32	85°	15.0	1	2	<b>R216-30B32-070</b>	32.0	WE	30.0	26.8	131.0	60.4	5.0	0.78	19500	2	R216-30 06	1	APMT 160408-M
	26.9	15.0	30	16	32	85°	15.0	1	2	<b>R216-30B32-100</b>	32.0	WE	30.0	26.8	161.0	90.4	5.0	0.86	19500	2	R216-30 06	1	APMT 160408-M
32.0	28.6	16.0	32	32	85°	16.0	1	2	<b>R216-32B32-100</b>	32.0	WE	32.0	29.0	161.0	100.0	5.0	0.87	18500	2	R216-32 06			
	28.6	16.0	32	32	85°	16.0	1	2	<b>R216-32B32-070</b>	32.0	WE	32.0	29.0	131.0	70.0	5.0	0.77	18500	2	R216-32 06			
40.0	36.5	20.0	40	16	40	85°	20.0	1	2	<b>R216-40B40-100</b>	40.0	WE	40.0	37.0	171.0	100.0	7.5	1.37	8000	2	R216-40 07	2	APMT 160408-M
	36.5	20.0	40	16	40	85°	20.0	1	2	<b>R216-40B40-150</b>	40.0	WE	40.0	37.0	221.0	150.0	7.5	1.94	8000	2	R216-40 07	2	APMT 160408-M
50.0	44.6	25.0	50	40	85°	25.0	1	2	<b>R216-50B40-100</b>	40.0	WE	50.0	47.0	171.0	100.0	10.0	1.88	7000	2	R216-50 07	2	APMT 160408-M	
	44.6	25.0	50	16	50	85°	25.0	1	2	<b>R216-50B50-125</b>	50.0	WE	50.0	46.4	206.0	125.0	10.0	2.80	7000	2	R216-50 07	2	APMT 160408-M
	44.6	25.0	50	16	50	85°	25.0	1	2	<b>R216-50B50-175</b>	50.0	WE	50.0	46.4	256.0	175.0	10.0	3.43	7000	2	R216-50 07	2	APMT 160408-M

Spare parts				
	Insert screw	Shim	Shim screw	Protection insert screw
12	5513 020-36			
16	5513 020-36			
20	5513 020-16			
25	5513 020-52			
32	5513 020-07			
30 16	5513 020-07			5513 020-09
40 16	5513 020-31			5513 020-09
50 16	5513 021-03	5322 475-01	5513 020-09	

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I111



L2



N23



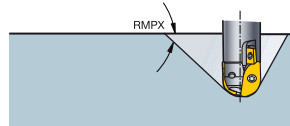
N9



N15

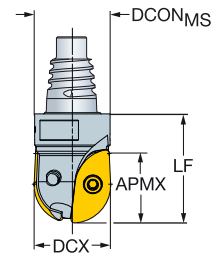
# CoroMill® 216 ball nose milling cutter

Coromant EH - Internal coolant supply



KAPR

90°



DC	CZC <sub>MS</sub>	APMX <sub>FFW</sub>	RMPX	CN5C	Ordering code	Dimensions, mm								
						DCON <sub>MS</sub>	LF	NM	KG	RPMX	CICT	MIID		
10.0	10	E10	8.60	85°	0	2	R216-10EH10	9.7	20.0	0.6	0.09	12700	2	R216-10 02
12.0	12	E12	10.80	85°	0	2	R216-12EH12	11.7	20.0	1.2	0.09	12700	2	R216-12 02
16.0	16	E16	14.40	85°	1	2	R216-16EH16	15.5	25.0	1.2	0.11	12700	2	R216-16 03
20.0	20	E20	17.90	85°	1	2	R216-20EH20	19.3	30.0	2.0	0.13	12700	2	R216-20 T3
25.0	25	E25	22.30	85°	1	2	R216-25EH25	24.2	35.0	3.0	0.17	12700	2	R216-25 04
30.0	30	E25	26.90	85°	1	2	R216-30EH25	24.2	50.0	5.0	0.20	12700	2	R216-30 06
32.0	32	E25	28.60	85°	1	2	R216-32EH25	24.2	50.0	5.0	0.24	12700	2	R216-32 06

Spare parts	
	Insert screw
10	5513 020-40
12	5513 020-36
16	5513 020-36
20	5513 020-16
25	5513 020-52
30	5513 020-07
32	5513 020-07

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I111



L2



N23



N9



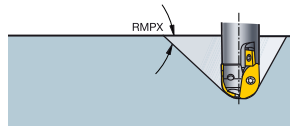
N15



N3

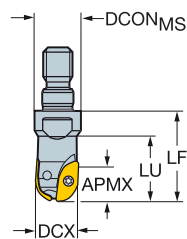
# CoroMill® 216 ball nose milling cutter

Threaded coupling - Internal coolant supply



KAPR

90°



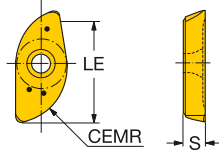
DC	CZC <sub>MS</sub>	APM <sub>XEFW</sub>	APM <sub>FEFW</sub>	RMPX	AZ	CNSC	Ordering code	Dimensions, mm						CICT	MID			
								DCON <sub>MS</sub>	BD <sub>1</sub>	LF	LU	NM	KG			RPMX		
10.0	10	M8	5.0	8.60	85°	5.0	0	2	R216-10T08	12.8	9.2	25.0	17.8	0.6	0.05	12700	2	R216-10 02
12.0	12	M8	6.0	10.80	85°	6.0	0	2	R216-12T08	12.8	10.8	25.0	18.3	1.2	0.09	12700	2	R216-12 02
16.0	16	M8	8.0	14.40	85°	8.0	0	2	R216-16T08	12.8	14.7	25.0		1.2	0.11	12700	2	R216-16 03
20.0	20	M10	10.0	17.90	85°	10.0	1	2	R216-20T10	17.8	18.4	30.0		2.0	0.14	12700	2	R216-20 T3
25.0	25	M12	12.5	22.30	85°	12.5	1	2	R216-25T12	20.8	23.2	35.0		3.0	0.17	12700	2	R216-25 04
30.0	30	M16	15.0	26.90	85°	15.0	1	2	R216-30T16	28.8	26.8	45.0		5.0	0.25	12700	2	R216-30 06
32.0	32	M16	16.0	28.60	85°	16.0	1	2	R216-32T16	28.8	29.0	45.0		5.0	0.26	12700	2	R216-32 06

Spare parts	
	Insert screw
10	5513 020-40
12	5513 020-36
16	5513 020-36
20	5513 020-16
25	5513 020-52
30	5513 020-07
32	5513 020-07

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

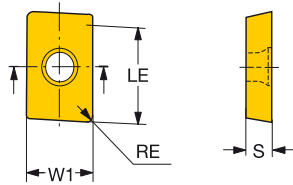
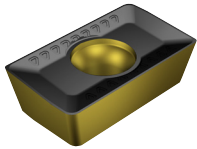


# CoroMill® 216 ball nose insert



Medium	CEMR	Ordering code	Dimensions, mm																
			P			M			K		N		S		H		LE	S	
			1130	4220	4340	1130	2040	4340	4220	4340	H13A	H13A	1130	H13A	S30T	1010			1130
10	4.9	R216-10 02 E-M	★			☆	★					☆	★		☆	★	☆	8.6	1.70
12	5.9	R216-12 02 E-M	★			☆	★					☆	★		☆	★	☆	10.8	2.38
	6.0	R216-12 02 M-M	★		★	☆	★					☆	★		☆	★	☆	10.8	2.38
16	7.8	R216-16 03 E-M	★			☆	★					☆	★		☆	★	☆	14.4	3.18
	8.0	R216-16 03 M-M	★	☆	★	☆	★					☆	★		☆	★	☆	14.4	3.18
20	9.8	R216-20 T3 E-M	★			☆	★					☆	★		☆	★	☆	17.9	3.97
	10.0	R216-20 T3 M-M	★	☆	★	☆	★					☆	★		☆	★	☆	17.9	3.97
25	12.3	R216-25 04 E-M	★			☆	★					☆	★		☆	★	☆	22.3	4.76
	12.5	R216-25 04 M-M	★	☆	★	☆	★					☆	★		☆	★	☆	22.3	4.76
30	14.7	R216-30 06 E-M	★			☆	★					☆	★		☆	★	☆	26.9	6.35
	15.0	R216-30 06 M-M	★	☆	★	☆	★					☆	★		☆	★	☆	26.9	6.35
32	15.7	R216-32 06 E-M	★			☆	★					☆	★		☆	★	☆	28.6	6.35
	16.0	R216-32 06 M-M	★	☆	★	☆	★					☆	★		☆	★	☆	28.6	6.35
40	19.7	R216-40 07 E-M	★			☆	★					☆	★		☆	★	☆	36.5	7.94
	20.0	R216-40 07 M-M	★	★	★	☆	★					☆	★		☆	★	☆	36.5	7.94
50	24.6	R216-50 07 E-M	★			☆	★					☆	★		☆	★	☆	44.6	7.94
	25.0	R216-50 07 M-M	★	★	★	☆	★					☆	★		☆	★	☆	44.6	7.94

## Shank protection insert



Medium	W1	RE	Ordering code	Dimensions, mm					
				P	M	K			
				4340	4340	4340			
	16	0.80	APMT 16 04 08-M	☆	☆	☆	9.2	16.0	4.76



1106



1154



1175
















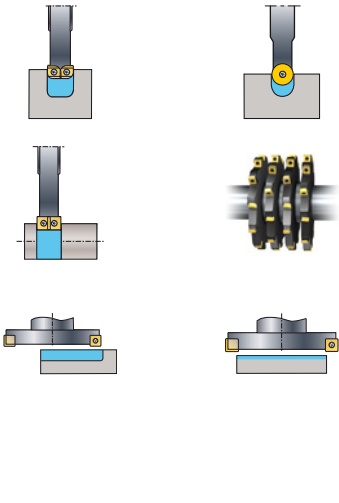
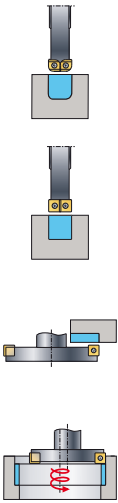
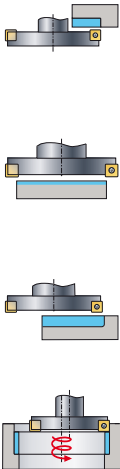
N23



N10



# Disc milling tools

				CoroMill® 331		
	Adjustable full side and face disc milling cutter			Full side and face disc milling cutter		Adjustable half side and face disc milling cutter
						
Page	I121-I123			I125		I126-I127
Material						
Main operation						
KAPR	90°			90°		90°
DC mm	80 - 315			40 - 125		80 - 315
APMX mm	6.0 - 26.5			6.0 - 10		7.6 - 10.6
CDX mm	114.5			34		114.5
Insert	 N331.1A	 R/L331.1A	 RCHT, RCKT	 N331.1A	 N331.1A	 R/L331.1A
Insert sizes	04,05,08,11 & 14	* 04,05,08,11 & 14	10,12 & 16	04,05 & 08	11	* 04,05,08,11 & 14
Couplings	Arbor Cylindrical Bore with keyway Weldon			Arbor Cylindrical Bore with keyway		Arbor Cylindrical Bore with keyway Weldon
Other operations						

\* R/L331.1A insert – only with Tailor made cutter

# CoroMill® 331

## Multi-purpose side and face milling cutter

### Application

- Grooving
- Parting off
- Double half side milling
- Shoulder milling
- Face milling
- Gang milling
- Circular ramping

### ISO application area:



### Benefits and features

- Wide range of mounting options
- Wedge type cassette locking
- Accuracy, security and stability due to serrations
- Sometimes that exact dimension you require might be missing.  
If so, simply turn to our Tailor Made service.
- Easy setting for desired width
- Spring-loaded cassette
- Security with pin-controlled setting range
- Internal coolant



[www.sandvik.coromant.com/coromill331](http://www.sandvik.coromant.com/coromill331)

### Couplings

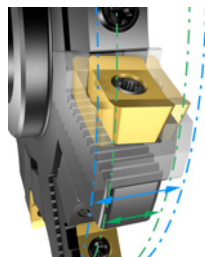
- Bore with keyway
- Arbor
- Cylindrical shank
- Adjustable pockets for high precision
- Fixed pockets for high teeth density

### Inserts

- Light cutting insert with H tolerance for most materials
- Round insert options and a vast assortment of corner radii
- Inserts with eight edges for face milling operations available.
- Insert geometries and grades for all materials



Accuracy, security and stability due to serrations.



### Wide setting range

Adjustable pockets for flexibility.



1116

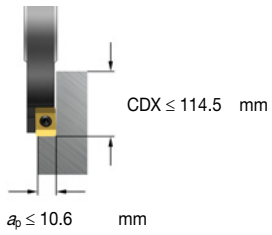


1130

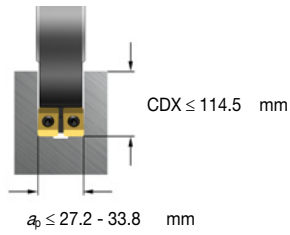


N6

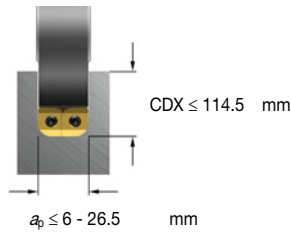
Half side



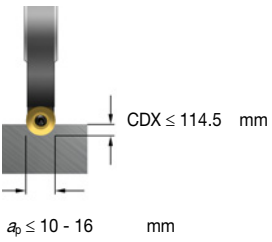
Double half side



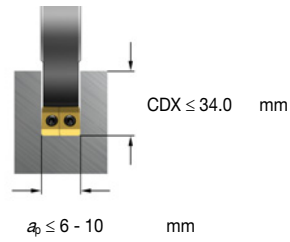
Full slot with radius



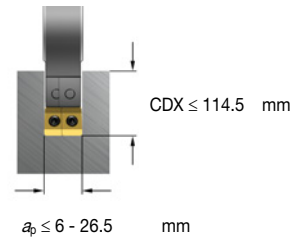
Full radius



Full slot fixed pocket



Full slot cassette



*Tailor Made*

Cassette cutters are delivered set to min. groove width. Tailor Made for cutters set to other widths.

Cutters for different groove widths and available inserts

Cutter bodies		Insert size	Neutral inserts		Right and left hand inserts				
Groove width range mm	Cutter versions (end of code)		Radius (RE) 0.5 mm	Radius (RE) 0.8 mm	Radius (RE) 1.52 mm	Radius (RE) 2.29 mm	Radius (RE) 3.05 mm	Radius (RE) 4.83 mm	Radius (RE) 6.35 mm
6-8	CM	04							
8-10	DM	05							
10-12	EM	08							
12-15	FM	08							
15-17.5	KM	11							
17.5-20.5	LM	11							
20.5-23.5	QM	14							
23.5-26.5	RM	14							

*Tailor Made*

Other insert radii available as Tailor Made.

J

K

L

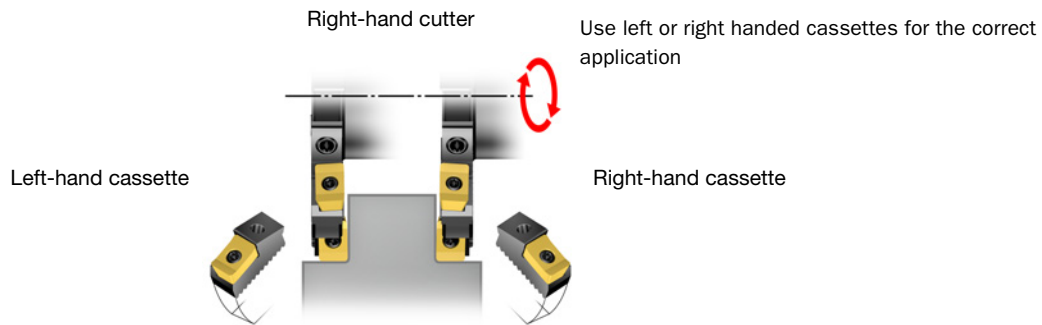
M

N

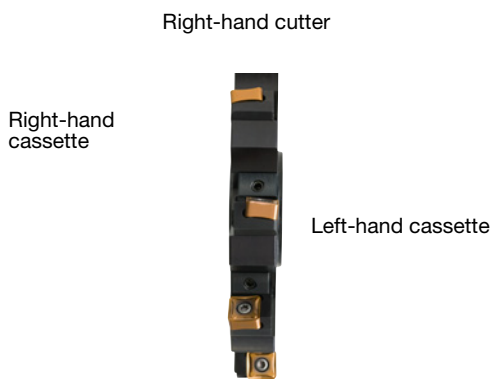


# Cutter bodies, cassettes and inserts to combine for all applications

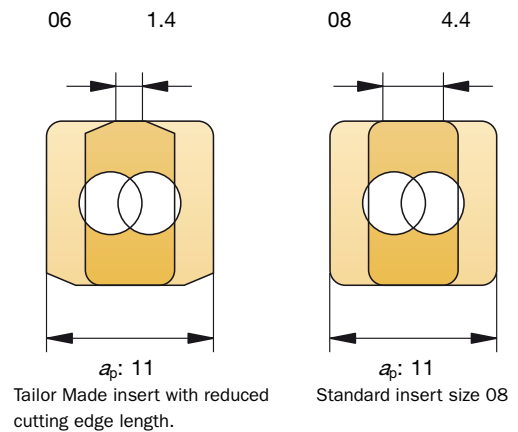
## Half side and face mill



## Full side and face mill



*Tailor Made*

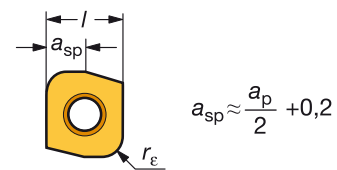


## Reduced cutting edge length for Tailor Made inserts

When slotting use the smallest width of the cutter.  
The overlap is the most critical factor to optimize.

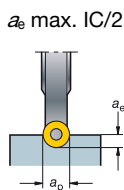
Reduced cutting edge length reduces overlapping, which in turn reduces wear in the overlapping zone, producing better chip control and reducing power consumption by up to 10%.

Tailor Made insert options with reduced cutting edge length and available on request.



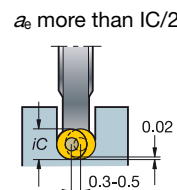
## Facilitated chip evacuation

### Full slot milling with round insert cutter



Max. axial depth of cut  $a_p = IC$   
Max. radial depth of cut  $a_e = IC/2$

Note: The contact length of the cutting edge is 180°

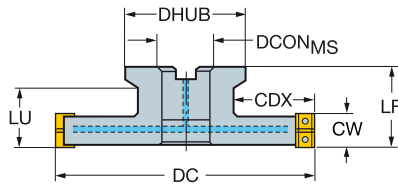


For slots deeper than  $IC/2$ , a 0.3 - 0.5 mm adjustment of each cassette is recommended. This will widen the slot 0.3 - 0.5 mm and reduce the contact length for each insert to 90°, which produces a more favorable chip formation and evacuation, and reduces vibration and power consumption.

# CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462  
KAPR 90°



										Dimensions, mm												
CW	CWX	DC	CDX	CZC <sub>MS</sub>	CNSC	Ordering code				DCON <sub>MS</sub>	ISO	LF	LU	DHUB	BAR	NM	KG	RPMX	CICT	MIID		
6.00	8.0	80	20.0	04	27	1	3	R331.32C-080Q27CM				27.0	A	50.00	26	51.0	80	0.8	0.51	19300	6	N331.1A-04
		100	22.0	04	27	1	4	R331.32C-100Q27CM				27.0	A	50.00		51.0	80	0.8	0.75	17100	8	N331.1A-04
		125	29.5	04	32	1	5	R331.32C-125Q32CM				32.0	B	50.00		61.0	80	0.8	0.92	15100	10	N331.1A-04
		160	41.0	04	40	1	6	R331.32C-160Q40CM				40.0	B	50.00		73.0	80	0.8	1.38	13200	12	N331.1A-04
8.00	10.0	80	20.0	05	27	1	3	R331.32C-080Q27DM				27.0	A	50.00		51.0	80	1.2	0.54	15000	6	N331.1A-05
		100	22.0	05	27	1	4	R331.32C-100Q27DM				27.0	A	50.00		51.0	80	1.2	1.01	13200	8	N331.1A-05
		125	29.5	05	32	1	5	R331.32C-125Q32DM				32.0	B	50.00		61.0	80	1.2	1.09	11700	10	N331.1A-05
		160	41.0	05	40	1	6	R331.32C-160Q40DM				40.0	B	50.00	26	73.0	80	1.2	1.53	10200	12	N331.1A-05
10.00	12.0	80	20.0	08	27	1	3	R331.32C-080Q27EM				27.0	A	50.00	26	51.0	80	1.2	0.70	18100	6	N331.1A-08
		100	22.0	08	27	1	4	R331.32C-100Q27EM				27.0	A	50.00		51.0	80	1.2	1.10	15900	8	N331.1A-08
		125	29.5	08	32	1	5	R331.32C-125Q32EM				32.0	B	50.00		61.0	80	1.2	1.30	14100	10	N331.1A-08
		160	41.0	08	40	1	6	R331.32C-160Q40EM				40.0	B	50.00		73.0	80	1.2	1.98	12400	12	N331.1A-08
12.00	15.0	80	20.0	08	27	1	3	R331.32C-080Q27FM				27.0	A	50.00	26	51.0	80	1.2	0.62	18100	6	N331.1A-08
		100	22.0	08	27	1	4	R331.32C-100Q27FM				27.0	A	50.00		51.0	80	1.2	0.92	15900	8	N331.1A-08
		125	29.5	08	32	1	5	R331.32C-125Q32FM				32.0	B	50.00		61.0	80	1.2	1.21	14100	10	N331.1A-08
		160	41.0	08	40	1	6	R331.32C-160Q40FM				40.0	B	50.00		73.0	80	1.2	1.94	12400	12	N331.1A-08
15.00	17.5	100	25.5	11	27	1	3	R331.32C-100Q27KM				27.0	A	50.00	32.5	51.0	80	3.0	0.98	14000	6	N331.1A-11
		125	29.5	11	32	1	4	R331.32C-125Q32KM				32.0	B	50.00		61.0	80	3.0	1.23	12400	8	N331.1A-11
		160	41.0	11	40	1	5	R331.32C-160Q40KM				40.0	B	50.00		73.0	80	3.0	2.17	10800	10	N331.1A-11
17.50	20.5	125	29.5	11	32	1	4	R331.32C-125Q32LM				32.0	B	50.00		61.0	80	3.0	1.42	12400	8	N331.1A-11
		160	41.0	11	40	1	5	R331.32C-160Q40LM				40.0	B	50.00		73.0	80	3.0	2.35	10800	10	N331.1A-11
20.50	23.5	160	41.0	14	40	1	5	R331.32C-160Q40QM				40.0	B	50.00		73.0	80	3.0	2.63	9000	10	N331.1A-14
23.50	26.5	160	41.0	14	40	1	5	R331.32C-160Q40RM				40.0	B	50.00		73.0	80	3.0	3.00	9000	10	N331.1A-14

Spare parts				
CW	DC	Insert screw	Wedge	Screw
6.00	80.00-100.00	5513 020-19	5431 105-07	5516 014-06
6.00	125.00	5513 020-19	5431 105-07	5516 014-06
6.00	160.00	5513 020-19	5431 105-07	5516 014-06
7.90	160.00	5513 020-34	5431 105-06	5516 014-05
8.00	80.00-100.00	5513 020-34	5431 105-06	5516 014-05
8.00	125.00	5513 020-34	5431 105-06	5516 014-05
10.00	80.00-100.00	5513 020-24	5431 105-01	269-832
10.00	125.00	5513 020-24	5431 105-01	269-832
10.00	160.00	5513 020-24	5431 105-01	269-832
12.00	80.00-100.00	5513 020-24	5431 105-02	269-832
12.00	125.00	5513 020-24	5431 105-02	269-832
12.00	160.00	5513 020-24	5431 105-02	269-832
15.00	100.00	5513 020-29	5431 105-04	339-831
15.00	125.00	5513 020-29	5431 105-04	339-831
15.00	160.00	5513 020-29	5431 105-04	339-831
17.50	125.00	5513 020-29	5431 105-04	5516 010-02
17.50	160.00	5513 020-29	5431 105-04	5516 010-02
20.50	160.00	5513 020-29	5431 105-05	5516 010-02
23.50	160.00	5513 020-29	5431 105-05	5516 010-02

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

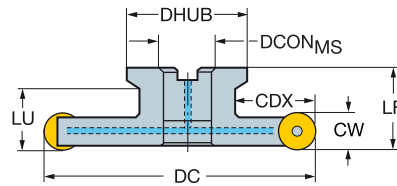
Accessories	
CZC <sub>MS</sub>	Coolant screw
27	5512 098-05
32	5512 098-04
40	5512 098-03



# CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462



							Dimensions, mm												
CW	DC	CDX	CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ISO	LF	LU	DHUB	BAR	NM	KG	RPMX	RE	CICT	MIID		
10.00	82	21.6	10	27	1	6	R331.32C-082Q27EMQ	27.0	A	50.00	26	51.0	80	1.2	0.59	19500	5.0	6	RCKT 10 T3 M0
	102	23.0	10	27	1	8	R331.32C-102Q27EMQ	27.0	A	50.00		51.0	80	3.0	0.95	15900	5.0	8	RCKT 10 T3 M0
	127	30.5	10	32	1	10	R331.32C-127Q32EMQ	32.0	B	50.00		61.0	80	3.0	1.20	14100	5.0	10	RCKT 10 T3 M0
	162	42.0	10	40	1	12	R331.32C-162Q40EMQ	40.0	B	50.00		73.0	80	3.0	1.85	12400	5.0	12	RCKT 10 T3 M0
12.00	82	21.0	12	27	1	6	R331.32C-082Q27FMQ	27.0	A	50.00	26	51.0	80	3.0	0.66	18100	6.0	6	RCKT 12 04 M0
	102	23.0	12	27	1	8	R331.32C-102Q27FMQ	27.0	A	50.00		51.0	80	3.0	1.00	15900	6.0	8	RCKT 12 04 M0
	127	30.5	12	32	1	10	R331.32C-127Q32FMQ	32.0	B	50.00		61.0	80	3.0	1.29	14100	6.0	10	RCKT 12 04 M0
	162	42.0	12	40	1	12	R331.32C-162Q40FMQ	40.0	B	50.00		73.0	80	3.0	2.03	12400	6.0	12	RCKT 12 04 M0
16.00	102	26.5	16	27	1	6	R331.32C-102Q27KMQ	27.0	A	50.00	32.5	51.0	80	5.0	0.90	14000	8.0	6	RCKT 16 06 M0
	127	30.5	16	32	1	8	R331.32C-127Q32KMQ	32.0	B	50.00		61.0	80	5.0	1.38	12400	8.0	8	RCKT 16 06 M0
	162	42.0	16	40	1	10	R331.32C-162Q40KMQ	40.0	B	50.00		73.0	80	5.0	2.22	10800	8.0	10	RCKT 16 06 M0

Spare parts					
CW	DC	Cassette neutral	Insert screw	Wedge	Screw
10.0	82.00	5521 250-02	5513 020-09	5431 105-01	269-832
10.0	102.00	5521 250-02	5513 020-09	5431 105-01	5516 010-02
10.0	127.00-162.00	5521 250-02	5513 020-09	5431 105-01	339-831
12.0	82.00	5521 250-03	5513 020-09	5431 105-02	269-832
12.0	102.00	5521 250-03	5513 020-09	5431 105-02	5516 010-02
12.0	127.00-162.00	5521 250-03	5513 020-09	5431 105-02	339-831
16.0	102.00-162.00	5521 250-05	5513 020-07	5431 105-04	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

Accessories	
CZC <sub>MS</sub>	Coolant screw
27	5512 098-05
32	5512 098-04
40	5512 098-03



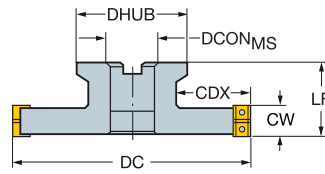
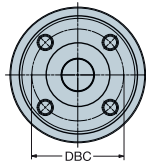
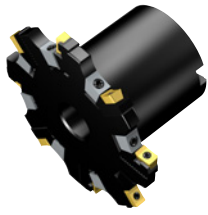
**SANDVIK**  
Coromant

# CoroMill® 331 adjustable full side and face disc milling cutter





Arbor

STDNO  
KAPR

ISO6462  
90°



N331.1A

								Dimensions, mm									
CW	CWX	DC	CDX			Ordering code		DCON <sub>MS</sub>	ISO	DBC	LF	DHUB			RPMX	CICT	MIID
6.00	8.0	200	51.0	04	40S	8	R331.32-200Q40CM06.00	40.0	C	66.7	63.10	96.0	0.8	6.70	11700	16	N331.1A-04
8.00	10.0	200	51.0	05	40S	8	R331.32-200Q40DM08.00	40.0	C	66.7	63.10	96.0	1.2	8.61	9100	16	N331.1A-05
10.00	12.0	200	51.0	08	40S	8	R331.32-200Q40EM10.00	40.0	C	66.7	63.00	96.0	1.2	8.88	11000	16	N331.1A-08
12.00	15.0	200	51.0	08	40S	8	R331.32-200Q40FM12.00	40.0	C	66.7	63.00	96.0	1.2	7.64	11000	16	N331.1A-08
15.00	17.5	200	51.0	11	40S	6	R331.32-200Q40KM15.00	40.0	C	66.7	63.00	96.0	3.0	9.46	9600	12	N331.1A-11
	250	56.0	11	60	8	8	R331.32-250Q60KM15.00	60.0	C	101.6	63.00	136.0	3.0	12.73	8500	16	N331.1A-11
	315	88.5	11	60	10	10	R331.32-315Q60KM15.00	60.0	C	101.6	63.00	136.0	3.0	18.32	7600	20	N331.1A-11
17.50	20.5	200	51.0	11	40S	6	R331.32-200Q40LM17.50	40.0	C	66.7	63.00	96.0	3.0	8.44	9600	12	N331.1A-11
	250	56.0	11	60	8	8	R331.32-250Q60LM17.50	60.0	C	101.6	63.00	136.0	3.0	12.76	8500	16	N331.1A-11
	315	88.5	11	60	10	10	R331.32-315Q60LM17.50	60.0	C	101.6	63.00	136.0	3.0	20.00	7600	20	N331.1A-11
20.50	23.5	200	51.0	14	40S	6	R331.32-200Q40QM20.50	40.0	C	66.7	63.00	96.0	3.0	10.30	8000	12	N331.1A-14
	250	56.0	14	60	8	8	R331.32-250Q60QM20.50	60.0	C	101.6	63.00	136.0	3.0	13.30	7100	16	N331.1A-14
	315	88.5	14	60	10	10	R331.32-315Q60QM20.50	60.0	C	101.6	63.00	136.0	3.0	19.20	6300	20	N331.1A-14
23.50	26.5	200	51.0	14	40S	6	R331.32-200Q40RM23.50	40.0	C	66.7	63.00	96.0	3.0	10.80	8000	12	N331.1A-14
	250	56.0	14	60	8	8	R331.32-250Q60RM23.50	60.0	C	101.6	63.00	136.0	3.0	14.00	7100	16	N331.1A-14
	315	88.5	14	60	10	10	R331.32-315Q60RM23.50	60.0	C	101.6	63.00	136.0	3.0	20.44	6300	20	N331.1A-14

		Spare parts		
CW	DC	Insert screw	Wedge	Screw
6.00	200.00	5513 020-19	5431 105-07	5516 014-06
8.00	200.00	5513 020-34	5431 105-06	5516 014-04
10.00	200.00	5513 020-24	5431 105-01	339-831
12.00	200.00	5513 020-24	5431 105-02	339-831
15.00-17.50	200.00-315.00	5513 020-29	5431 105-04	339-831
20.50-23.50	200.00-315.00	5513 020-29	5431 105-05	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



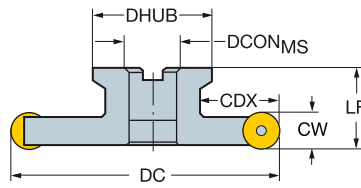
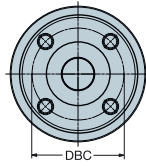
# CoroMill® 331 adjustable full side and face disc milling cutter





Arbor



STDNO

ISO6462

RCKT  
RCHT

		Dimensions, mm															
CW	DC	CDX		CZC <sub>MS</sub>		Ordering code	DCON <sub>MS</sub>	ISO	DBC	LF	DHUB			RPMX	RE	CICT	MIID
10.00	202	52.0	10	40S	16	R331.32-202Q40EMQ	40.0	C	66.7	63.00	96.0	3.0	8.79	11000	5.0	16	RCKT 10 T3 M0
12.00	202	52.0	12	40S	16	R331.32-202Q40FMQ	40.0	C	66.7	63.00	96.0	3.0	9.07	11000	6.0	16	RCKT 12 04 M0
16.00	202	52.0	16	40S	12	R331.32-202Q40KMQ	40.0	C	66.7	63.50	96.0	5.0	10.00	9600	8.0	12	RCKT 16 06 M0

		Spare parts		
CW	DC	Insert screw	Wedge	Screw
10.00	202.00	5513 020-09	5431 105-01	339-831
12.00	202.00	5513 020-09	5431 105-02	339-831
16.00	202.00	5513 020-07	5431 105-04	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

1103



L2



M1



N23

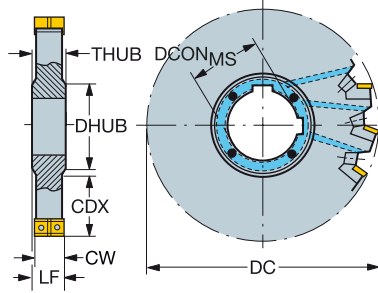


N6

# CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway - Internal coolant supply

KAPR 90°



										Dimensions, mm										
CW	CWX	DC	CDX		CZC <sub>MS</sub>	CNSC		Ordering code		DCON <sub>MS</sub>	LF	DRVCT	DHUB	THUB				RPMX	CICT	MIID
6.00	8.0	80	19.5	04	27	1	3	N331.32C-080S27CM		27.0	10.00	1	39.0	14.0	80	0.8	0.37	19300	6	N331.1A-04
		100	25.5	04	32	1	4	N331.32C-100S32CM		32.0	10.00	1	47.0	14.0	80	0.8	0.49	17100	8	N331.1A-04
		125	34.0	04	40	1	5	N331.32C-125S40CM		40.0	10.00	2	55.0	14.0	80	0.8	0.63	15100	10	N331.1A-04
		160	51.5	04	40	1	6	N331.32C-160S40CM		40.0	10.00	2	55.0	14.0	80	0.8	1.02	13200	12	N331.1A-04
8.00	10.0	80	19.5	05	27	1	3	N331.32C-080S27DM		27.0	12.00	1	39.0	16.0	80	1.2	0.46	15000	6	N331.1A-05
		100	25.5	05	32	1	4	N331.32C-100S32DM		32.0	12.00	1	47.0	16.0	80	1.2	0.59	13200	8	N331.1A-05
		125	34.0	05	40	1	5	N331.32C-125S40DM		40.0	12.00	2	55.0	16.0	80	1.2	0.75	11700	10	N331.1A-05
		160	51.5	05	40	1	6	N331.32C-160S40DM		40.0	12.00	2	55.0	16.0	80	1.2	1.24	10200	12	N331.1A-05
10.00	12.0	80	19.5	08	27	1	3	N331.32C-080S27EM		27.0	13.00	1	39.0	16.0	80	1.2	0.42	18100	6	N331.1A-08
		100	25.5	08	32	1	4	N331.32C-100S32EM		32.0	13.00	1	47.0	16.0	80	1.2	0.62	15900	8	N331.1A-08
		125	34.0	08	40	1	5	N331.32C-125S40EM		40.0	13.00	2	55.0	16.0	80	1.2	0.93	14100	10	N331.1A-08
		160	51.5	08	40	1	6	N331.32C-160S40EM		40.0	13.00	2	55.0	16.0	80	1.2	1.46	12400	12	N331.1A-08
12.00	15.0	80	19.5	08	27	1	3	N331.32C-080S27FM		27.0	14.00	1	39.0	16.0	80	1.2	0.52	18100	6	N331.1A-08
		100	25.5	08	32	1	4	N331.32C-100S32FM		32.0	14.00	1	47.0	16.0	80	1.2	0.69	15900	8	N331.1A-08
		125	34.0	08	40	1	5	N331.32C-125S40FM		40.0	14.00	2	55.0	16.0	80	1.2	1.04	14100	10	N331.1A-08
		160	51.5	08	40	1	6	N331.32C-160S40FM		40.0	14.00	2	55.0	16.0	80	1.2	1.68	12400	12	N331.1A-08
15.00	17.5	100	25.5	11	32	1	3	N331.32C-100S32KM		32.0	16.75	1	47.0	18.5	80	3.0	0.82	14000	6	N331.1A-11
		125	34.0	11	40	1	4	N331.32C-125S40KM		40.0	16.75	1	55.0	18.5	80	3.0	1.23	12400	8	N331.1A-11
		160	51.5	11	40	1	5	N331.32C-160S40KM		40.0	16.75	2	55.0	18.5	80	3.0	2.01	10800	10	N331.1A-11
17.50	20.5	125	34.0	11	40	1	4	N331.32C-125S40LM		40.0	19.50	1	55.0	21.5	80	3.0	1.41	12400	8	N331.1A-11
		160	51.5	11	40	1	5	N331.32C-160S40LM		40.0	19.50	2	55.0	21.5	80	3.0	2.20	10800	10	N331.1A-11
20.50	23.5	160	51.5	14	40	1	5	N331.32C-160S40QM		40.0	22.50	2	55.0	24.5	80	3.0	2.55	9000	10	N331.1A-14
23.50	26.5	160	51.5	14	40	1	5	N331.32C-160S40RM		40.0	25.50	2	55.0	27.5	80	3.0	2.78	9000	10	N331.1A-14

Spare parts				
CW	DC	Insert screw	Wedge	Screw
6.0	80-160	5513 020-19	5431 105-07	5516 014-06
8.0	80-160	5513 020-34	5431 105-06	5516 014-05
10.0	80-160	5513 020-24	5431 105-01	269-832
12.0	80-160	5513 020-24	5431 105-02	269-832
15.0	100-160	5513 020-29	5431 105-04	5516 010-02
17.5	125-160	5513 020-29	5431 105-04	5516 010-02
20.5	160	5513 020-29	5431 105-05	5516 010-02
23.5	160	5513 020-29	5431 105-05	5516 010-02

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

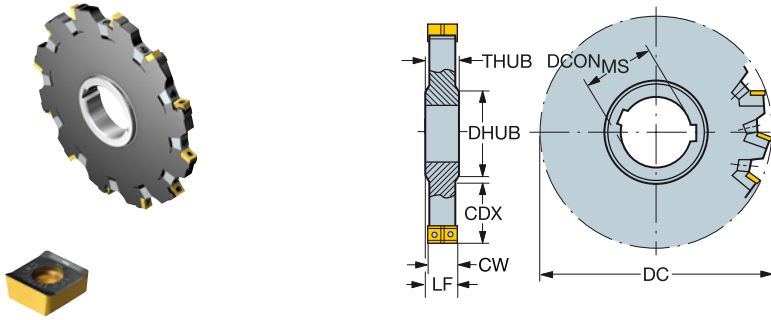
Accessories		
CZC <sub>MS</sub>	Coolant screw set	Spacing ring set
27	5512 076-101	5549 091-032
32	5512 076-102	5549 091-042
40	5512 076-103	5549 091-052








# CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway

KAPR 90°



N331.1A

								Dimensions, mm											
CW	CWX	DC	CDX				Ordering code	DCON <sub>MS</sub>	LF	DRVCT	DHUB	THUB			RPMX	CICT	MIID		
6.00	8.0	200	64.5	04	50	8	N331.32-200S50CM06.00	50.0	10.00	2	69.0	14.0	0.8	1.34	11700	16	N331.1A-04		
8.00	10.0	200	64.5	05	50	8	N331.32-200S50DM08.00	50.0	12.00	2	69.0	16.0	1.2	1.67	9100	16	N331.1A-05		
10.00	12.0	200	64.5	08	50	8	N331.32-200S50EM10.00	50.0	13.00	2	69.0	16.0	1.2	1.98	11000	16	N331.1A-08		
12.00	15.0	200	64.5	08	50	8	N331.32-200S50FM12.00	50.0	14.00	2	69.0	16.0	1.2	2.38	11000	16	N331.1A-08		
15.00	17.5	200	64.5	11	50	6	N331.32-200S50KM15.00	50.0	16.75	2	69.0	18.5	3.0	2.88	9600	12	N331.1A-11		
		250	89.5	11	50	8	N331.32-250S50KM15.00	50.0	16.75	2	69.0	18.5	3.0	7.74	8500	16	N331.1A-11		
		315	114.5	11	60	10	N331.32-315S60KM15.00	60.0	16.75	2	84.0	18.5	3.0	13.20	7600	20	N331.1A-11		
17.50	20.5	200	64.5	11	50	6	N331.32-200S50LM17.50	50.0	19.50	2	69.0	21.5	3.0	3.29	9600	12	N331.1A-11		
		250	89.5	11	50	8	N331.32-250S50LM17.50	50.0	19.50	2	69.0	21.5	3.0	8.42	8500	16	N331.1A-11		
		315	114.5	11	60	10	N331.32-315S60LM17.50	60.0	19.50	2	84.0	21.5	3.0	12.94	7600	20	N331.1A-11		
20.50	23.5	200	64.5	14	50	6	N331.32-200S50QM20.50	50.0	22.50	2	69.0	24.5	3.0	3.86	8000	12	N331.1A-14		
		250	89.5	14	50	8	N331.32-250S50QM20.50	50.0	22.50	2	69.0	24.5	3.0	7.10	7100	16	N331.1A-14		
		315	114.5	14	60	10	N331.32-315S60QM20.50	60.0	22.50	2	84.0	24.5	3.0	14.28	6300	20	N331.1A-14		
23.50	26.5	200	64.5	14	50	6	N331.32-200S50RM23.50	50.0	25.50	2	69.0	27.5	3.0	4.35	8000	12	N331.1A-14		
		250	89.5	14	50	8	N331.32-250S50RM23.50	50.0	25.50	2	69.0	27.5	3.0	10.16	7100	16	N331.1A-14		
		315	114.5	14	60	10	N331.32-315S60RM23.50	60.0	25.50	2	84.0	27.5	3.0	19.26	6300	20	N331.1A-14		

Spare parts				
CW	DC	Insert screw	Wedge	Screw
6.00	200.00	5513 020-19	5431 105-07	5516 014-06
8.00	200.00	5513 020-34	5431 105-06	5516 014-04
10.00	200.00	5513 020-24	5431 105-01	5516 010-02
12.00	200.00	5513 020-24	5431 105-02	5516 010-02
15.00-17.50	200.00-315.00	5513 020-29	5431 105-04	339-831
20.50-23.50	200.00-315.00	5513 020-29	5431 105-05	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

1130



L2



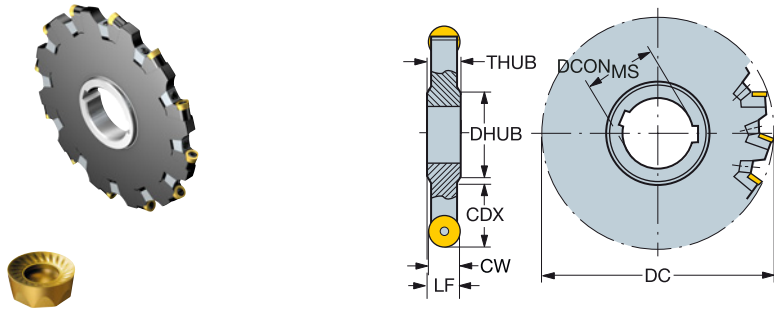
N23








N6

# CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway



RCKT  
RCHT

						Dimensions, mm											
CW	DC	CDX				Ordering code	DCON <sub>MS</sub>	LF	DRVCT	DHUB	THUB			RPMX	RE	CICT	MIID
10.00	82	20.5	10	27	6	N331.32-082S27EMQ	27.0	13.00	1	39.0	16.0	3.0	0.56	18100	5.0	6	RCKT 10 T3 M0
	102	26.5	10	32	8	N331.32-102S32EMQ	32.0	13.00	1	47.0	16.0	3.0	0.50	15900	5.0	8	RCKT 10 T3 M0
	127	35.0	10	40	10	N331.32-127S40EMQ	40.0	13.00	2	55.0	16.0	3.0	1.03	14100	5.0	10	RCKT 10 T3 M0
	162	52.5	10	40	12	N331.32-162S40EMQ	40.0	13.00	2	55.0	16.0	3.0	1.51	12400	5.0	12	RCKT 10 T3 M0
	202	65.5	10	50	16	N331.32-202S50EMQ	50.0	13.00	2	69.0	16.0	3.0	2.03	11000	5.0	16	RCKT 10 T3 M0
12.00	82	20.5	12	27	6	N331.32-082S27FMQ	27.0	14.00	1	39.0	16.0	3.0	0.62	18100	6.0	6	RCKT 12 04 M0
	102	26.5	12	32	8	N331.32-102S32FMQ	32.0	14.00	1	47.0	16.0	3.0	0.89	15900	6.0	8	RCKT 12 04 M0
	127	35.0	12	40	10	N331.32-127S40FMQ	40.0	14.00	2	55.0	16.0	3.0	1.15	14100	6.0	10	RCKT 12 04 M0
	162	52.5	12	40	12	N331.32-162S40FMQ	40.0	14.00	2	55.0	16.0	3.0	1.73	12400	6.0	12	RCKT 12 04 M0
	202	65.5	12	50	16	N331.32-202S50FMQ	50.0	14.00	2	69.0	16.0	3.0	3.21	11000	6.0	16	RCKT 12 04 M0
16.00	102	26.5	16	32	6	N331.32-102S32KMQ	32.0	17.25	1	47.0	18.5	5.0	0.96	14000	8.0	6	RCKT 16 06 M0
	127	35.0	16	40	8	N331.32-127S40KMQ	40.0	17.25	1	55.0	18.5	5.0	1.27	12400	8.0	8	RCKT 16 06 M0
	162	52.5	16	40	10	N331.32-162S40KMQ	40.0	17.25	2	55.0	18.5	5.0	1.97	10800	8.0	10	RCKT 16 06 M0
	202	65.5	16	50	12	N331.32-202S50KMQ	50.0	17.25	2	69.0	18.5	5.0	3.20	9600	8.0	12	RCKT 16 06 M0

Spare parts				
CW	DC	Insert screw	Wedge	Screw
10.00	82.00	5513 020-09	5431 105-01	269-832
10.00	102.00-202.00	5513 020-09	5431 105-01	339-831
12.00	82.00	5513 020-09	5431 105-02	269-832
12.00	102.00-202.00	5513 020-09	5431 105-02	339-831
16.00	102.00	5513 020-07	5431 105-04	5516 010-02
16.00	127.00-202.00	5513 020-07	5431 105-04	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

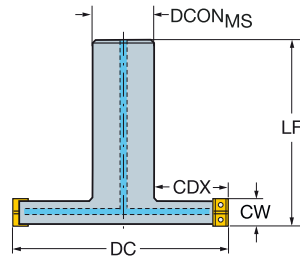
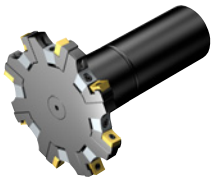









# CoroMill® 331 adjustable full side and face disc milling cutter

Cylindrical shank - Internal coolant supply

KAPR 90°



											Dimensions, mm							
CW	CWX	DC	CDX		CZC <sub>MS</sub>	CNSC		Ordering code	DCON <sub>MS</sub>	LF				RPMX	CICT	MIID		
6.00	8.0	80	23.0	04	32	1	3	R331.32C-080A32CM	32.0	115.00	80	0.8	0.90	19300	6	N331.1A-04		
		100	28.0	04	40	1	4	R331.32C-100A40CM	40.0	125.00	80	0.8	1.50	17100	8	N331.1A-04		
8.00	10.0	80	23.0	05	32	1	3	R331.32C-080A32DM	32.0	115.00	80	1.2	1.02	15000	6	N331.1A-05		
		100	28.0	05	40	1	4	R331.32C-100A40DM	40.0	125.00	80	1.2	1.65	13200	8	N331.1A-05		
10.00	12.0	80	23.0	08	32	1	3	R331.32C-080A32EM	32.0	115.00	80	1.2	1.04	18100	6	N331.1A-08		
		100	28.0	08	40	1	4	R331.32C-100A40EM	40.0	125.00	80	1.2	1.72	15900	8	N331.1A-08		

		Spare parts		
CW	DC	Insert screw	Wedge	Screw
6.0	80-100	5513 020-19	5431 105-07	5516 014-06
8.0	80-100	5513 020-34	5431 105-06	5516 014-05
10.0	80-100	5513 020-24	5431 105-01	269-832

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I130



L2



N23

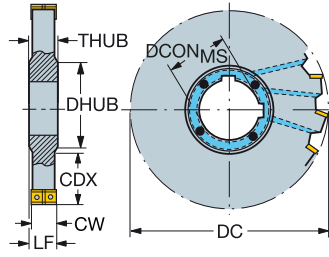







N6

# CoroMill® 331 full side and face disc milling cutter

Bore with keyway - Internal coolant supply

KAPR 90°



							Dimensions, mm											
CW	DC	CDX		CZC <sub>MS</sub>	CNSC		Ordering code	DCON <sub>MS</sub>	LF	DRVCT	DHUB	THUB				RPMX	CICT	MIID
6.00	100	25.5	04	32	4	5	N331.35C-100S32CM060	32.0	7.00	2	47.0	8.0	80	0.8	0.21	17000	10	N331.1A-04
8.00	100	25.5	05	32	4	5	N331.35C-100S32DM080	32.0	9.00	2	47.0	10.0	80	1.2	0.28	13000	10	N331.1A-05
	125	34.0	05	40	4	6	N331.35C-125S40DM080	40.0	9.00	2	55.0	10.0	80	1.2	0.47	15000	12	N331.1A-05
10.00	125	34.0	08	40	4	6	N331.35C-125S40EM100	40.0	11.00	2	55.0	12.0	80	1.2	0.61	11500	12	N331.1A-08

Spare parts		
CW	DC	Insert screw
6.0	100.00	5513 020-19
8.0	100.00-125.00	5513 020-34
10.0	125.00	5513 020-24

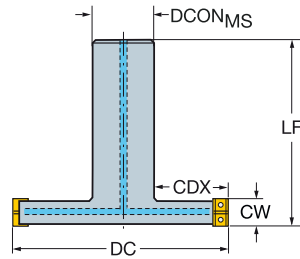
For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)








# CoroMill® 331 full side and face disc milling cutter

Cylindrical shank - Internal coolant supply

KAPR 90°



							Dimensions, mm									
CW	DC	CDX		CZC <sub>MS</sub>	CNSC		Ordering code	DCON <sub>MS</sub>	LF	 BAR	 NM	 KG	RPMX	CICT	MIID	
6.00	40	11.0	04	16	1	2	R331.35C-040A16CM060	16.0	120.00	80	0.8	0.19	29500	4	N331.1A-04	
	50	14.0	04	20	1	3	R331.35C-050A20CM060	20.0	130.00	80	0.8	0.33	25000	6	N331.1A-04	
	63	18.0	04	25	1	3	R331.35C-063A25CM060	25.0	140.00	80	0.8	0.58	22000	6	N331.1A-04	
8.00	40	11.0	04	16	1	4	R331.35C-080A32CM060	32.0	150.00	80	0.8	1.03	19000	8	N331.1A-04	
	50	14.0	05	16	1	2	R331.35C-040A16DM080	16.0	120.00	80	1.2	0.19	22300	4	N331.1A-05	
	50	14.0	05	20	1	3	R331.35C-050A20DM080	20.0	130.00	80	1.2	0.34	19500	6	N331.1A-05	
8.00	63	18.0	05	25	1	3	R331.35C-063A25DM080	25.0	140.00	80	1.2	0.60	17000	6	N331.1A-05	
	80	23.0	05	32	1	4	R331.35C-080A32DM080	32.0	150.00	80	1.2	1.06	15000	8	N331.1A-05	
	10.00	40	11.0	08	16	1	2	R331.35C-040A16EM100	16.0	120.00	80	1.2	0.20	27000	4	N331.1A-08
10.00	50	14.0	08	20	1	3	R331.35C-050A20EM100	20.0	130.00	80	1.2	0.42	23500	6	N331.1A-08	
	63	18.0	08	25	1	3	R331.35C-063A25EM100	25.0	140.00	80	1.2	0.62	21000	6	N331.1A-08	
	80	23.0	08	32	1	4	R331.35C-080A32EM100	32.0	150.00	80	1.2	1.11	18000	8	N331.1A-08	

Spare parts		
CW	DC	Insert screw
6.0	40.00-80.00	5513 020-19
8.0	40.00-80.00	5513 020-34
10.0	40.00-80.00	5513 020-24

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

1130



L2



N23



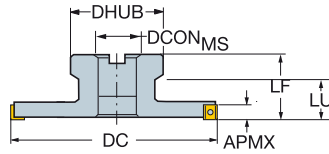
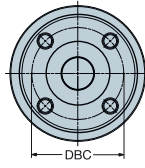
N6

# CoroMill® 331 adjustable half side and face disc milling cutter

Arbor

STDNO  
KAPR

ISO6462  
90°



N331.1A

						Dimensions, mm											
DC	CZC <sub>MS</sub>	APMX	Ordering code	DCON <sub>MS</sub>	ISO	DBC	LF	LU	DHUB	NM	KG	RPMX	CICT	MIID			
80	08	27	7.6	6	R331.52-080Q27FMR	27.0	A	63.00	40	54.0	1.2	1.12	18100	6	N331.1A-08		
80	08	27	7.6	6	R331.52-080Q27EMR	27.0	A	63.00	40	54.0	1.2	0.80	18100	6	N331.1A-08		
100	08	27	7.6	8	R331.52-100Q27FMR	27.0	A	63.00		54.0	1.2	1.30	15900	8	N331.1A-08		
125	08	32	7.6	10	R331.52-125Q32FMR	32.0	B	63.00		64.0	1.2	1.95	14100	10	N331.1A-08		
125	08	32	7.6	10	R331.52-125Q32EMR	32.0	B	63.00		64.0	1.2	1.86	14100	10	N331.1A-08		
160	08	40	7.6	12	R331.52-160Q40EMR	40.0	B	63.00		76.0	1.2	2.69	12400	12	N331.1A-08		
100	11	27	10.6	6	R331.52-100Q27KMR	27.0	A	63.00	40	54.0	3.0	1.77	14000	6	N331.1A-11		
125	11	32	10.6	8	R331.52-125Q32KMR	32.0	B	63.00		64.0	3.0	2.30	12000	8	N331.1A-11		
160	11	40	10.6	10	R331.52-160Q40KMR	40.0	B	63.00		76.0	3.0	3.30	10800	10	N331.1A-11		
200	11	40S	10.6	12	R331.52-200Q40MMR	40.0	C	66.7	63.00	96.0	3.0	11.50	9600	12	N331.1A-11		

Spare parts			
Ordering code	Insert screw	Wedge	Screw
R331.52-080Q27EMR	5513 020-24	5431 105-01	269-832
R331.52-080Q27FMR	5513 020-24	5431 105-02	269-832
R331.52-100Q27FMR	5513 020-24	5431 105-02	5516 010-02
R331.52-125Q32EMR	5513 020-24	5431 105-01	339-831
R331.52-125Q32FMR	5513 020-24	5431 105-02	339-831
R331.52-160Q40EMR	5513 020-24	5431 105-01	339-831
R331.52-160Q40FMR	5513 020-24	5431 105-02	339-831
R331.52-100Q27KMR	5513 020-29	5431 105-04	339-831
R331.52-125Q32KMR	5513 020-29	5431 105-04	339-831
R331.52-160Q40KMR	5513 020-29	5431 105-04	339-831
R331.52-200Q40MMR	5513 020-29	5431 105-03	339-831
R331.52-250Q60MMR	5513 020-29	5431 105-03	339-831
R331.52-315Q60NMR	5513 020-29	5431 105-04	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I130



L2



M1



N23

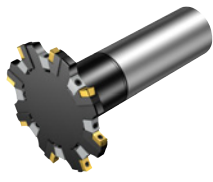


N6

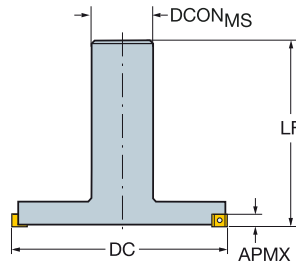
# CoroMill® 331 adjustable half side and face disc milling cutter

Cylindrical shank

KAPR 90°



N331.1A



					Dimensions, mm							
DC		CZC <sub>MS</sub>	APMX		Ordering code	DCON <sub>MS</sub>	LF			RPMX	CICT	MIID
100	08	42	7.6	8	R331.52-100A42EMR	42.0	152.00	1.2	1.90	15900	8	N331.1A-08

## Spare parts

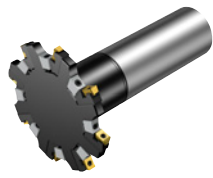
Insert screw	Wedge	Screw
5513 020-24	5431 105-01	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

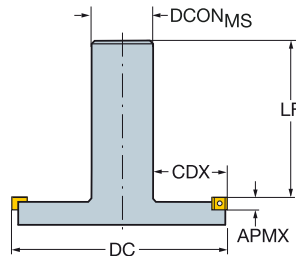
# CoroMill® 331 adjustable half side and back face disc milling cutter

Cylindrical shank

KAPR 90°



N331.1A



						Dimensions, mm							
DC	CDX		CZC <sub>MS</sub>	APMX		Ordering code	DCON <sub>MS</sub>	LF			RPMX	CICT	MIID
80	19.5	08	32	7.6	6	R331.52-080A32EML	32.0	122.00	1.2	1.19	18100	6	N331.1A-08
100	25.5	08	42	7.6	8	R331.52-100A42EML	42.0	142.00	1.2	1.90	15900	8	N331.1A-08

## Spare parts

Insert screw	Wedge	Screw
5513 020-24	5431 105-01	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

1130



L2



M1



N23

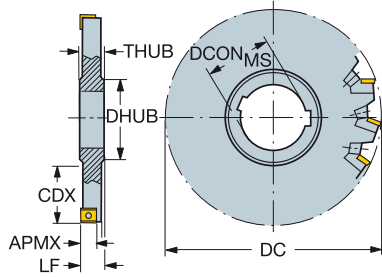


N6

# CoroMill® 331 adjustable half side and back face disc milling cutter

Bore with keyway

KAPR 90°



N331.1A

						Dimensions, mm											
DC	CDX	CZC <sub>MS</sub>	APMX	Ordering code		DCON <sub>MS</sub>	LF	DRVCT	DHUB	THUB	NM	KG	RPMX	CICT	MIID		
80	19.5	08	27	7.6	6	R/L331.52-080S27EM	27.0	13.00	1	39.0	16.0	1.2	0.54	18100	6	N331.1A-08	
80	19.5	08	27	7.6	6	R/L331.52-080S27FM	27.0	14.00	1	39.0	16.0	1.2	0.56	18100	6	N331.1A-08	
100	25.5	08	32	7.6	8	R/L331.52-100S32EM	32.0	13.00	1	47.0	16.0	1.2	0.84	15900	8	N331.1A-08	
100	25.5	08	32	7.6	8	R/L331.52-100S32FM	32.0	14.00	1	47.0	16.0	1.2	0.60	15900	8	N331.1A-08	
125	34.0	08	40	7.6	10	R/L331.52-125S40EM	40.0	13.00	2	55.0	16.0	1.2	1.02	14100	10	N331.1A-08	
125	34.0	08	40	7.6	10	R/L331.52-125S40FM	40.0	14.00	2	55.0	16.0	1.2	1.13	14100	10	N331.1A-08	
160	51.5	08	40	7.6	12	R/L331.52-160S40EM	40.0	13.00	2	55.0	16.0	1.2	1.50	12400	12	N331.1A-08	
160	51.5	08	40	7.6	12	R/L331.52-160S40FM	40.0	14.00	2	55.0	16.0	1.2	1.73	12400	12	N331.1A-08	
100	25.5	11	32	10.6	6	L331.52-100S32KM	32.0	16.75	1	47.0	18.5	3.0	0.94	14000	6	N331.1A-11	
125	34.0	11	40	10.6	8	R/L331.52-125S40KM	40.0	16.75	1	55.0	18.5	3.0	1.30	12000	8	N331.1A-11	
160	51.5	11	40	10.6	10	R/L331.52-160S40KM	40.0	16.75	2	55.0	18.5	3.0	2.00	10000	10	N331.1A-11	
200	64.5	11	50	10.6	12	R/L331.52-200S50MM	50.0	29.20	2	69.0	31.2	3.0	9.90	9600	12	N331.1A-11	
250	89.5	11	50	10.6	16	L331.52-250S50MM	50.0	29.20	2	69.0	31.2	3.0	12.96	8500	16	N331.1A-11	
315	114.5	11	60	10.6	20	R/L331.52-315S60NM	60.0	32.80	2	84.0	34.8	3.0	17.30	7600	20	N331.1A-11	

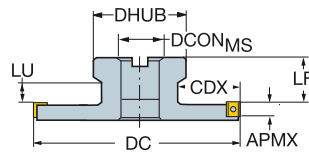
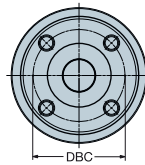
Spare parts			
Ordering code	Insert screw	Wedge	Screw
R/L331.52-125S40EM	5513 020-24	5431 105-01	339-831
R/L331.52-125S40FM	5513 020-24	5431 105-02	339-831
R/L331.52-160S40EM	5513 020-24	5431 105-01	339-831
R/L331.52-160S40FM	5513 020-24	5431 105-02	339-831
R/L331.52-080S27EM	5513 020-24	5431 105-01	269-832
R/L331.52-080S27FM	5513 020-24	5431 105-02	269-832
R/L331.52-100S32EM	5513 020-24	5431 105-01	339-831
R/L331.52-100S32FM	5513 020-24	5431 105-02	339-831
R/L331.52-160S40KM	5513 020-29	5431 105-04	339-831
R/L331.52-200S50MM	5513 020-29	5431 105-03	339-831
R/L331.52-250S50MM	5513 020-29	5431 105-03	339-831
R/L331.52-315S60NM	5513 020-29	5431 105-04	339-831
R/L331.52-100S32KM	5513 020-29	5431 105-04	5516 010-02
R/L331.52-125S40KM	5513 020-29	5431 105-04	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)







# CoroMill® 331 adjustable half side and back face disc milling cutter

Arbor

STDNO  
KAPRISO6462  
90°

N331.1A

						Dimensions, mm											
DC	CDX		CZC <sub>MS</sub>	APMX		Ordering code	DCON <sub>MS</sub>	ISO	DBC	LF	LU	DHUB			RPMX	CICT	MIID
80	20.0	08	27	7.6	6	R331.52-080Q27EML	27.0	A	53.00	30	54.0	1.2	0.80	18100	6	N331.1A-08	
80	20.0	08	27	7.6	6	R331.52-080Q27FML	27.0	A	51.00	28	54.0	1.2	0.98	18100	6	N331.1A-08	
100	22.0	08	27	7.6	8	R331.52-100Q27EML	27.0	A	53.00		54.0	1.2	1.20	15900	8	N331.1A-08	
100	22.0	08	27	7.6	8	R331.52-100Q27FML	27.0	A	51.00		54.0	1.2	1.30	15900	8	N331.1A-08	
125	29.5	08	32	7.6	10	R331.52-125Q32EML	32.0	B	51.00		64.0	1.2	1.95	14100	10	N331.1A-08	
125	29.5	08	32	7.6	10	R331.52-125Q32FML	32.0	B	53.00		64.0	1.2	1.81	14100	10	N331.1A-08	
160	41.0	08	40	7.6	12	R331.52-160Q40EML	40.0	B	51.00		76.0	1.2	2.90	12400	12	N331.1A-08	
160	41.0	08	40	7.6	12	R331.52-160Q40FML	40.0	B	53.00		76.0	1.2	2.60	12400	12	N331.1A-08	
100	25.7	11	27	10.6	6	R331.52-100Q27KML	27.0	A	48.00	25	54.0	3.0	1.77	14000	6	N331.1A-11	
125	29.5	11	32	10.6	8	R331.52-125Q32KML	32.0	B	48.00		64.0	3.0	2.09	12000	8	N331.1A-11	
160	41.0	11	40	10.6	10	R331.52-160Q40KML	40.0	B	48.00		76.0	3.0	3.02	10800	10	N331.1A-11	
200	51.0	11	40S	10.6	12	R331.52-200Q40MML	40.0	C	66.7	35.80		96.0	3.0	11.12	9600	12	N331.1A-11

Ordering code	Spare parts		
	Insert screw	Wedge	Screw
R331.52-080Q27EML	5513 020-24	5431 105-01	269-832
R331.52-080Q27FML	5513 020-24	5431 105-02	269-832
R331.52-100Q27EML	5513 020-24	5431 105-01	5516 010-02
R331.52-100Q27FML	5513 020-24	5431 105-02	5516 010-02
R331.52-125Q32EML	5513 020-24	5431 105-01	339-831
R331.52-125Q32FML	5513 020-24	5431 105-02	339-831
R331.52-160Q40EML	5513 020-24	5431 105-01	339-831
R331.52-160Q40FML	5513 020-24	5431 105-02	339-831
R331.52-100Q27KML	5513 020-29	5431 105-04	339-831
R331.52-125Q32KML	5513 020-29	5431 105-04	339-831
R331.52-160Q40KML	5513 020-29	5431 105-04	339-831
R331.52-200Q40MML	5513 020-29	5431 105-03	339-831
R331.52-250Q60MML	5513 020-29	5431 105-03	339-831
R331.52-315Q60NML	5513 020-29	5431 105-04	339-831

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

1130



L2



M1



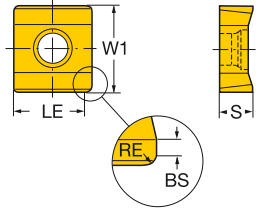
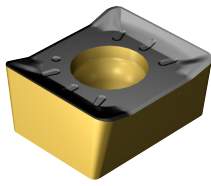
N23



N6

# CoroMill® 331 insert for side and face milling

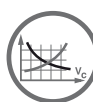
KRINS 90°



	RE	Ordering code	P		M		K		N		S		H		Dimensions, mm														
			1130	4330	4940	530	1040	1130	2040	530	1020	3040	3220	3330	1130	H10	H13A	1130	2040	H13A	S30T	1130	530	W1	LE	S	BS		
			☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
Light	04	0.50	N331.1A-04 35 05E-KL					★	☆	☆	☆														9.5	4.6	3.50	0.4	
		0.50	N331.1A-04 35 05H-NL	☆	☆									☆	★											9.5	4.6	3.50	0.2
		0.50	N331.1A-04 35 05H-PL			☆																				9.5	4.6	3.50	0.4
		0.50	N331.1A-04 35 05H-WL	☆										☆												9.5	4.6	3.50	0.4
		0.50	N331.1A-043505E-L30				☆	☆																		9.5	4.6	3.49	0.4
		0.50	N331.1A-043505E-L50	★			★	☆	☆																	9.5	4.6	3.49	0.4
		0.80	N331.1A-05 45 08E-KL						★	☆	☆	☆														9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08H-NL	☆										☆	★											9.5	5.7	4.45	0.8
		0.80	N331.1A-05 45 08H-PL	☆	☆	☆																				9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08H-WL	☆										☆												9.5	5.7	4.45	1.2
		0.80	N331.1A-054508E-L30				☆	☆																		9.5	5.7	4.49	1.2
		0.80	N331.1A-054508E-L50	★			★	☆	☆																	9.5	5.7	4.49	1.2
Light	08	0.80	N331.1A-08 45 08E-KL					★	☆	☆	☆														9.5	7.7	4.45	1.2	
		0.80	N331.1A-08 45 08H-NL	☆									☆	★												9.5	7.7	4.45	0.9
		0.80	N331.1A-08 45 08H-PL	☆	☆	☆																				9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08H-WL	☆									☆													9.5	7.7	4.45	1.2
		2.00	N331.1A-08 45 20E-KL						★																	9.5	6.5	4.50	1.2
		2.00	N331.1A-08 45 20H-PL	★																						9.5	6.5	4.50	1.2
		0.80	N331.1A-084508E-L30				☆	☆																		9.5	7.7	4.49	1.2
		0.80	N331.1A-084508E-L50	★			★	☆	☆																	9.5	7.7	4.49	1.2
		0.80	N331.1A-11 50 08E-KL						★	☆	☆	☆														11.5	10.7	4.95	1.2
		0.80	N331.1A-11 50 08H-NL	☆										☆	★											11.5	10.7	4.95	1.3
		0.80	N331.1A-11 50 08H-PL	☆	☆	☆																				11.5	10.7	4.95	1.2
		0.80	N331.1A-11 50 08H-WL	☆										☆												11.5	10.7	4.95	1.2
Medium	04	0.50	N331.1A-04 35 05M-KM						☆	☆	☆	☆													9.5	4.6	3.50	0.4	
		0.50	N331.1A-04 35 05M-PM	☆	☆	☆																				9.5	4.6	3.50	0.4
		0.50	N331.1A-043505E-M30	★	★					★	★															9.5	4.6	3.50	0.4
	05	0.80	N331.1A-05 45 08E-KM							☆	☆	☆	☆													9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08H-PM	☆																						9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08M-KM							☆	☆	☆	☆													9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08M-PM	☆	☆																					9.5	5.7	4.45	1.2
		0.80	N331.1A-054508E-M30	★	★					★	★															9.5	5.7	4.50	1.2
	08	0.80	N331.1A-08 45 08E-KM							☆	☆	☆	☆													9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08H-PM	☆																						9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08H-WM				☆							☆												9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08M-KM							☆	☆	☆	☆													9.5	7.7	4.45	1.2
	0.80	N331.1A-08 45 08M-PM	☆	☆																					9.5	7.7	4.45	1.2	
	2.00	N331.1A-08 45 20E-KM							★	★															9.5	6.5	4.45	1.2	
	2.00	N331.1A-08 45 20H-PM	★	★																					9.5	6.5	4.45	1.2	
	0.80	N331.1A-084508E-M30	★	★					★	★															9.5	7.7	4.50	1.2	



I116



I154



I175



N23



N6

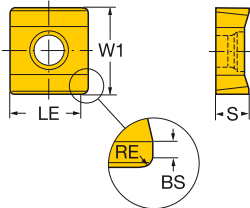
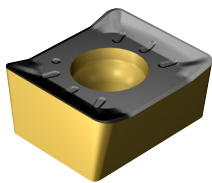


N10



CoroMill® 331 insert for side and face milling

KRINS 90°



	RE	Ordering code	P		M		K		N		S		H		Dimensions, mm																
			1130	4930	4940	530	1040	1130	2040	530	1020	3040	3320	3330	1130	530	H10	H13A	1130	2040	H13A	S30T	1130	530	W1	LE	S	BS			
Medium	11	0.80	N331.1A-11 50 08E-KM																							11.5	10.7	4.95	1.2		
		0.80	N331.1A-11 50 08H-PM	☆																							11.5	10.7	4.95	1.2	
		0.80	N331.1A-11 50 08H-WM		☆																							11.5	10.7	4.95	1.2
		0.80	N331.1A-11 50 08M-KM							☆	☆	☆	☆															11.5	10.7	4.95	1.2
		0.80	N331.1A-11 50 08M-PM		☆	☆																						11.5	10.7	4.95	1.2
		2.00	N331.1A-11 50 20E-KM							★	★																	11.5	9.5	4.95	1.2
	2.00	N331.1A-11 50 20H-PM	★	★			☆																				11.5	9.5	4.95	1.2	
	0.80	N331.1A-115008E-M30	★	★					★	★																	11.5	10.7	5.00	1.2	
	14	0.80	N331.1A-14 50 08E-KM																									11.5	13.7	4.95	1.2
		0.80	N331.1A-14 50 08H-PM		☆																							11.5	13.7	4.95	1.2
		0.80	N331.1A-14 50 08H-WM																									11.5	13.7	4.95	1.2
		0.80	N331.1A-14 50 08M-KM																									11.5	13.7	4.95	1.2
0.80		N331.1A-14 50 08M-PM		☆	☆																						11.5	13.7	4.95	1.2	
0.80		N331.1A-145008E-M30	★	★					★	★																	11.5	13.7	5.00	1.2	



1116



1154



1175



N23



N6



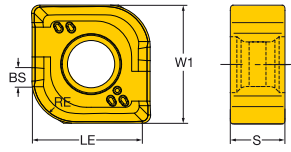
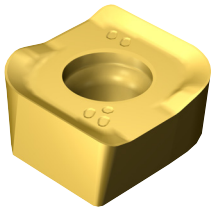
N10



# CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor made.

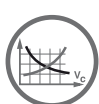
KRINS 90°



		SSC	RE	Ordering code	P		M					K	N	S		H	Dimensions, mm			
					1130	4330	1040	1130	2040	S30T	1020	3040	1130	1130	2040	S30T	1130	W1	LE	S
Light	L50	11	3.05	R/L331.1A-115030E-L50	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	11.5	10.7	5.00	1.3
			4.00	R/L331.1A-115040E-L50	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	11.5	10.7	5.00	1.4
			4.83	R/L331.1A-115048E-L50	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	11.5	10.7	5.00	1.5
			6.35	R/L331.1A-115063E-L50	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	11.5	10.7	5.00	1.6
Medium	M30	11	1.52	R/L331.1A-115015E-M30	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	11.5	10.7	5.00	1.2
			2.29	R/L331.1A-115023E-M30	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	11.5	10.7	5.00	1.2
			3.05	R/L331.1A-115030E-M30	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	11.5	10.7	5.00	1.3
	WM	08	4.00	R/L331.1A-08 45 40H-WM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	9.5	7.7	4.45	1.4
		11	4.00	R/L331.1A-11 50 40H-WM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	11.5	10.7	4.95	1.4
		14	4.00	R/L331.1A-14 50 40H-WM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	11.5	13.7	4.95	1.4



I116



I154



I175



N23



N6

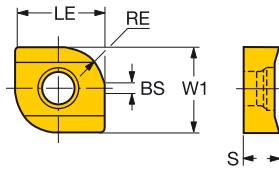
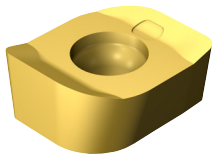


N10

# CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor made.

KRINS 90°

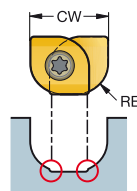


Light	WL	RE	Ordering code	Dimensions, mm															
				P		M		K		N		S		H					
				1130	4340	1040	1130	1025	4340	1130	H10F	1040	1130	S30T	H10F	1130	W1	LE	S
04	1.52	L331.1A-04 35 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	4.6	3.50	0.4	
	2.29	L331.1A-04 35 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	4.6	3.50	0.4	
	1.52	R331.1A-04 35 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	4.6	3.50	0.4	
	2.29	R331.1A-04 35 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	4.6	3.50	0.4	
	05	1.52	L331.1A-05 45 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	5.7	4.45	1.2
		2.29	L331.1A-05 45 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	5.7	4.45	1.2
		3.05	L331.1A-05 45 30H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	5.7	4.45	1.3
		1.52	R331.1A-05 45 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	5.7	4.45	1.2
		2.29	R331.1A-05 45 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	5.7	4.45	1.2
		3.05	R331.1A-05 45 30H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	5.7	4.45	1.3
	08	1.52	L331.1A-08 45 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	7.7	4.45	1.2
		2.29	L331.1A-08 45 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	7.7	4.45	1.2
3.05		L331.1A-08 45 30H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	7.7	4.45	1.3	
1.52		R331.1A-08 45 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	7.7	4.45	1.2	
2.29		R331.1A-08 45 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	7.7	4.45	1.2	
3.05		R331.1A-08 45 30H-WL	*	*	*	*	*	*	*	*	*	*	*	*	9.5	7.7	4.45	1.3	
11	1.52	L331.1A-11 50 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.2	
	2.29	L331.1A-11 50 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.2	
	3.05	L331.1A-11 50 30H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.3	
	4.83	L331.1A-11 50 48H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.5	
	6.35	L331.1A-11 50 63H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.6	
	1.52	R331.1A-11 50 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.2	
	2.29	R331.1A-11 50 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.2	
	3.05	R331.1A-11 50 30H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.3	
	4.83	R331.1A-11 50 48H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.5	
	6.35	R331.1A-11 50 63H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	10.7	4.95	1.6	
	14	1.52	L331.1A-14 50 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.2
		2.29	L331.1A-14 50 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.2
3.05		L331.1A-14 50 30H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.3	
4.83		L331.1A-14 50 48H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.5	
6.35		L331.1A-14 50 63H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.6	
1.52		R331.1A-14 50 15H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.2	
2.29		R331.1A-14 50 23H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.2	
3.05		R331.1A-14 50 30H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.3	
4.83	R331.1A-14 50 48H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.5		
6.35	R331.1A-14 50 63H-WL	*	*	*	*	*	*	*	*	*	*	*	*	11.5	13.7	4.95	1.6		

## Limitations when using inserts with large corner radius

Full slot milling

Insert size	Calculated CW
04	$CW = RE + 4.6$
05	$CW = RE + 6$
08	$CW = RE + 8$
11	$CW = RE + 11$



1116



1154



1175



N23



N6

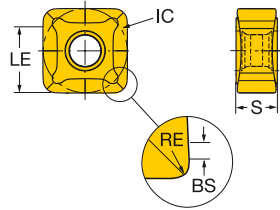
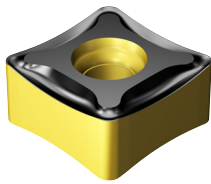


N10



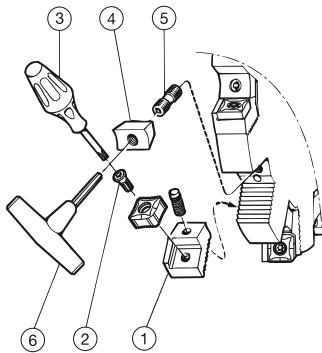
# CoroMill® 331 insert for side and face milling

KRINS 88°



	RE	Ordering code	Dimensions, mm							IC	LE	S	BS					
			1130	4220	4330	4340	1130	1020	3040					3330	1130	1130	1130	
Medium PM	13	0.80	N331.1D-136508E-PM	☆		★	☆	☆	☆	★	☆	☆	☆	☆	13.4	11.4	6.55	1.2
		0.80	N331.1D-136508M-PM		☆	★				☆	☆	☆	☆	☆	13.4	11.4	6.55	1.2
		1.20	N331.1D-136512M-PM		☆					☆	☆	☆	☆	☆	13.4	11.0	6.55	1.2
		2.00	N331.1D-136520E-PM	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	13.4	10.2	6.55	1.2
		2.00	N331.1D-136520M-PM		☆					☆	☆	☆	☆	☆	13.4	10.2	6.55	1.2

These double sided inserts need optional cassettes. See below for more information.



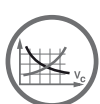
Note that the diameter of the cutter increases by 3.2 mm when using the cassettes for double sided inserts.

Cutter type	1	1	2	3	4	5	6
	Cassette Right	Cassette Left	Screw	Key (Torx Plus)	Torque wrench <sup>1)</sup>	Wedge	Screw
QM (a <sub>b</sub> 20.5–23.5 mm)	5321 260-01	5321 260-02	5513 020-25	5680 046-02 (15IP)	5680 100-06	5431 105-05	339-831
RM (a <sub>b</sub> 23.5–26.5 mm)	5321 260-01	5321 260-02	5513 020-25	5680 046-02 (15IP)	5680 100-06	5431 105-05	339-831

1) Optional part to be ordered separately.



I116



I154



I175



N23

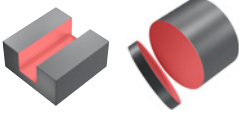
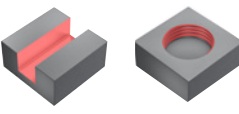
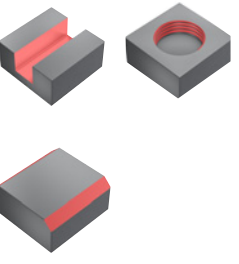


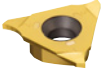




N6



N10

## Groove- thread- and chamfer milling tools

	CoroMill® QD	CoroMill® 328	CoroMill® 327	CoroMill® 495
Page	Groove milling I136	Groove milling I142 Thread milling I148	Groove milling I145 Thread milling I149 Chamfer milling I150	Chamfer milling I151
Material	<b>P M K N S H</b>	<b>P M K N S</b>	<b>P M K N S</b>	<b>P M K N S</b>
Main operation				
DC mm	63 - 315	39 - 80	9.7 - 34.7	12 - 63
APMX mm		6	6 - 10	3.8 - 7.7
CW mm	2 - 6.35	1.3 - 5.15	0.7 - 5.15	
CDX mm	21.0 - 117.5	3.0 - 5.0	0.5 - 10.0	
Insert				
Insert sizes	E,F,G,H,J,K	13	06, 09, 12, 14	09
Couplings	Arbor with driving screws Cylindrical shank	Bore with keyway Weldon Arbor	Coromant Capto® Short Weldon Integrated ER collets	Coromant Capto® Cylindrical shank Weldon Coromant EH
Internal coolant	✓	✗	✓	✓
Options				Angles available: 15°, 30°, 45°, 60°

# CoroMill® QD

## High-security groove milling and parting off

### Application

- Deep grooving
- Parting off
- External and internal machining
- Roughing to finishing

### ISO application area:



### Benefits and features

- Quality grooves without chip issues
- Very secure tools with great reliability
- Quick and easy insert changes



[www.sandvik.coromant.com/coromillqd](http://www.sandvik.coromant.com/coromillqd)

### Couplings

- Cylindrical shank
- Arbor

### Inserts

E- and M-tolerance inserts for a wide range of widths and materials. Inserts with extra long parallel land available for extra high-quality surface finish. Available in steel milling grade GC1130 with Zertivo™ technology for long and predictable tool life.

### Driving collar

By using driving collars for extra stability, groove milling with high cutting depth/width ratio (exceeding 15) can be performed with maintained excellent quality.

Smaller driving collars can be used together with face mill adapters in large machining centers as a cost-efficient solution.



### Internal coolant

The internal coolant solution provides great chip evacuation. By getting rid of chip issues, surface quality is improved and machining security ensured. Internal coolant also helps regulate the heat at the cutting zone, which is especially beneficial for ISO S materials.



I137



I140

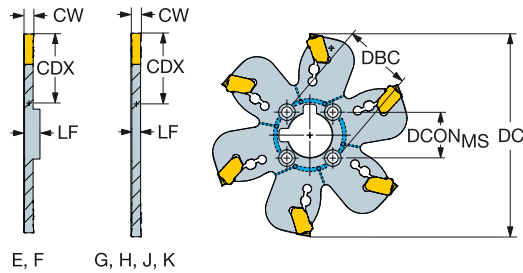


N6

# CoroMill® QD indexable grooving and parting off cutter

Arbor - Internal coolant supply

KAPR 90°



SSC: E, F G, H, J, K

							Dimensions, mm									
CW	DC	CDX	SSC	CZC <sub>MS</sub>	CNSC		Ordering code	DCON <sub>MS</sub>	DBC	LF	DRVCT			RPMX	MIID	
2.00	80	24.0	E	X10	4	5	QD-EC080X10-M	10.0	22.0	2.65	0	50	0.12	4300	QD-NE-0200-020E-PM	
	100	30.0	E	X22	4	8	QD-EC100X22-M	22.0	32.0	2.65	2	50	0.14	3900	QD-NE-0200-020E-PM	
	125	31.0	E	X32	4	10	QD-EC125X32-M	32.0	45.0	2.65	2	50	0.25	3500	QD-NE-0200-020E-PM	
	160	40.0	E	X40	4	12	QD-EC160X40-M	40.0	63.0	2.65	2	50	0.32	3000	QD-NE-0200-020E-PM	
2.50	80	24.0	F	X10	4	5	QD-FC080X10-M	10.0	22.0	2.65	0	50	0.13	5000	QD-NF-0250-020E-PM	
	100	30.0	F	X22	4	8	QD-FC100X22-M	22.0	32.0	2.65	2	50	0.15	4400	QD-NF-0250-020E-PM	
	125	31.0	F	X32	4	10	QD-FC125X32-M	32.0	45.0	2.65	2	50	0.28	4000	QD-NF-0250-020E-PM	
	160	40.0	F	X40	4	12	QD-FC160X40-M	40.0	63.0	2.65	2	50	0.36	3500	QD-NF-0250-020E-PM	
3.00	80	24.0	G	X10	4	5	QD-GC080X10-M	10.0	22.0	2.70	0	70	0.14	6100	QD-NG-0300-020E-PM	
	100	30.0	G	X22	4	8	QD-GC100X22-M	22.0	32.0	2.70	2	70	0.17	5500	QD-NG-0300-020E-PM	
	125	31.0	G	X32	4	10	QD-GC125X32-M	32.0	45.0	2.70	2	70	0.30	4900	QD-NG-0300-020E-PM	
	160	40.0	G	X40	4	12	QD-GC160X40-M	40.0	63.0	2.70	2	70	0.40	4300	QD-NG-0300-020E-PM	
4.00	80	24.0	H	X10	4	4	QD-HC080X10-M	10.0	22.0	3.65	0	70	0.14	5000	QD-NH-0400-025E-PM	
	100	30.0	H	X22	4	6	QD-HC100X22-M	22.0	32.0	3.65	2	70	0.19	4400	QD-NH-0400-025E-PM	
	125	31.0	H	X32	4	8	QD-HC125X32-M	32.0	45.0	3.65	2	70	0.33	4000	QD-NH-0400-025E-PM	
	160	40.0	H	X40	4	12	QD-HC160X40-M	40.0	63.0	3.65	2	70	0.48	3500	QD-NH-0400-025E-PM	
5.00	100	30.0	J	X22	4	6	QD-JC100X22-M	22.0	32.0	4.65	2	70	0.22	3800	QD-NJ-0500-030E-PM	
	125	31.0	J	X32	4	8	QD-JC125X32-M	32.0	45.0	4.65	2	70	0.39	3400	QD-NJ-0500-030E-PM	
	160	40.0	J	X40	4	10	QD-JC160X40-M	40.0	63.0	4.65	2	70	0.56	3000	QD-NJ-0500-030E-PM	
6.00	100	30.0	K	X22	4	6	QD-KC100X22-M	22.0	32.0	5.65	2	70	0.24	3900	QD-NK-0600-035E-PM	
	125	31.0	K	X32	4	8	QD-KC125X32-M	32.0	45.0	5.65	2	70	0.44	3500	QD-NK-0600-035E-PM	
	160	40.0	K	X40	4	10	QD-KC160X40-M	40.0	63.0	5.65	2	70	0.65	3000	QD-NK-0600-035E-PM	

Note: coupling X40 uses cap screws, these are included with the adaptor.

Spare parts	
DC	Screw
80.00	5513 015-11
100.00	5513 015-10
125.00	5513 015-09

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



1140



L2



N23



N6

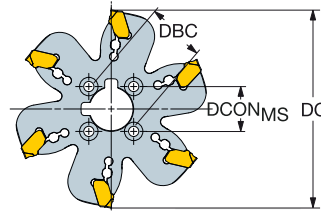
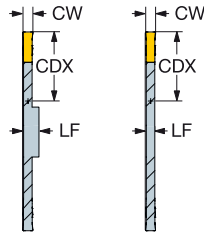


N15

# CoroMill® QD indexable grooving and parting off cutter

Arbor

KAPR 90°



SSC: E, F G, H, J, K

		Dimensions, mm											
CW	DC	CDX	SSC	CZC <sub>MS</sub>		Ordering code	DCON <sub>MS</sub>	DBC	LF	DRVCT		RPMX	MIID
2.00	80	24.0	E	X10	5	QD-E-080X10-M	10.0	22.0	2.65	0	0.12	4300	QD-NE-0200-020E-PM
	100	30.0	E	X22	8	QD-E-100X22-M	22.0	32.0	2.65	2	0.14	3900	QD-NE-0200-020E-PM
	125	31.0	E	X32	10	QD-E-125X32-M	32.0	45.0	2.65	2	0.25	3500	QD-NE-0200-020E-PM
	160	40.0	E	X40	12	QD-E-160X40-M	40.0	63.0	2.65	2	0.32	3000	QD-NE-0200-020E-PM
	200	60.0	E	X40	16	QD-E-200X40-M	40.0	63.0	2.65	2	0.64	2700	QD-NE-0200-020E-PM
2.50	80	24.0	F	X10	5	QD-F-080X10-M	10.0	22.0	2.65	0	0.13	5000	QD-NF-0250-020E-PM
	100	30.0	F	X22	8	QD-F-100X22-M	22.0	32.0	2.65	2	0.16	4400	QD-NF-0250-020E-PM
	125	31.0	F	X32	10	QD-F-125X32-M	32.0	45.0	2.65	2	0.28	4000	QD-NF-0250-020E-PM
	160	40.0	F	X40	12	QD-F-160X40-M	40.0	63.0	2.65	2	0.36	3500	QD-NF-0250-020E-PM
	200	60.0	F	X40	16	QD-F-200X40-M	40.0	63.0	2.65	2	0.73	3100	QD-NF-0250-020E-PM
	250	85.0	F	X40	20	QD-F-250X40-M	40.0	63.0	2.70	2	0.98	2800	QD-NF-0250-020E-PM
3.00	80	24.0	G	X10	5	QD-G-080X10-M	10.0	22.0	2.70	0	0.14	6100	QD-NG-0300-020E-PM
	100	30.0	G	X22	8	QD-G-100X22-M	22.0	32.0	2.70	2	0.17	5500	QD-NG-0300-020E-PM
	125	31.0	G	X32	10	QD-G-125X32-M	32.0	45.0	2.70	2	0.30	4900	QD-NG-0300-020E-PM
	160	40.0	G	X40	12	QD-G-160X40-M	40.0	63.0	2.70	2	0.40	4300	QD-NG-0300-020E-PM
	200	60.0	G	X40	16	QD-G-200X40-M	40.0	63.0	2.70	2	0.79	3800	QD-NG-0300-020E-PM
	250	85.0	G	X40	20	QD-G-250X40-M	40.0	63.0	2.70	2	1.09	3400	QD-NG-0300-020E-PM
	315	117.5	G	X40	24	QD-G-315X40-M	40.0	63.0	2.70	2	1.90	3100	QD-NG-0300-020E-PM
4.00	80	24.0	H	X10	4	QD-H-080X10-M	10.0	22.0	3.65	0	0.15	5000	QD-NH-0400-025E-PM
	100	30.0	H	X22	6	QD-H-100X22-M	22.0	32.0	3.65	2	0.19	4400	QD-NH-0400-025E-PM
	125	31.0	H	X32	8	QD-H-125X32-M	32.0	45.0	3.65	2	0.34	4000	QD-NH-0400-025E-PM
	160	40.0	H	X40	12	QD-H-160X40-M	40.0	63.0	3.65	2	0.48	3500	QD-NH-0400-025E-PM
	200	60.0	H	X40	14	QD-H-200X40-M	40.0	63.0	3.65	2	0.94	3100	QD-NH-0400-025E-PM
	250	85.0	H	X40	20	QD-H-250X40-M	40.0	63.0	3.65	2	1.41	2800	QD-NH-0400-025E-PM
	315	117.5	H	X40	24	QD-H-315X40-M	40.0	63.0	3.65	2	2.39	2500	QD-NH-0400-025E-PM
5.00	100	30.0	J	X22	6	QD-J-100X22-M	22.0	32.0	4.65	2	0.22	3800	QD-NJ-0500-030E-PM
	125	31.0	J	X32	8	QD-J-125X32-M	32.0	45.0	4.65	2	0.39	3400	QD-NJ-0500-030E-PM
	160	40.0	J	X40	10	QD-J-160X40-M	40.0	63.0	4.65	2	0.55	3000	QD-NJ-0500-030E-PM
	200	60.0	J	X40	14	QD-J-200X40-M	40.0	63.0	4.65	2	1.10	2700	QD-NJ-0500-030E-PM
	250	85.0	J	X40	18	QD-J-250X40-M	40.0	63.0	4.65	2	1.62	2400	QD-NJ-0500-030E-PM
	315	117.5	J	X40	24	QD-J-315X40-M	40.0	63.0	4.65	2	2.85	2100	QD-NJ-0500-030E-PM
6.00	100	30.0	K	X22	6	QD-K-100X22-M	22.0	32.0	5.65	2	0.25	3900	QD-NK-0600-035E-PM
	125	31.0	K	X32	8	QD-K-125X32-M	32.0	45.0	5.65	2	0.44	3500	QD-NK-0600-035E-PM
	160	40.0	K	X40	10	QD-K-160X40-M	40.0	63.0	5.65	2	0.65	3000	QD-NK-0600-035E-PM
	200	60.0	K	X40	14	QD-K-200X40-M	40.0	63.0	5.65	2	1.27	2700	QD-NK-0600-035E-PM
	250	85.0	K	X40	18	QD-K-250X40-M	40.0	63.0	5.65	2	1.92	2400	QD-NK-0600-035E-PM
	315	117.5	K	X40	24	QD-K-315X40-M	40.0	63.0	5.65	2	3.32	2200	QD-NK-0600-035E-PM

Note: coupling X40 uses cap screws, these are included with the adaptor.

Spare parts	
DC	Screw
80.00	5513 015-11
100.00	5513 015-10
125.00	5513 015-09

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

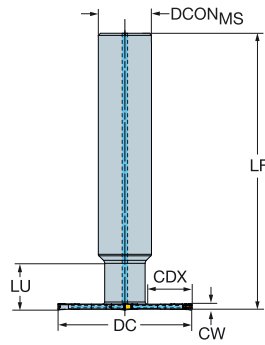
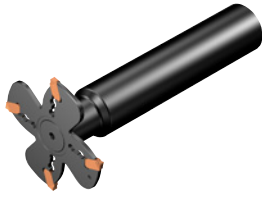







# CoroMill® QD indexable grooving and parting off cutter

Cylindrical shank - Internal coolant supply

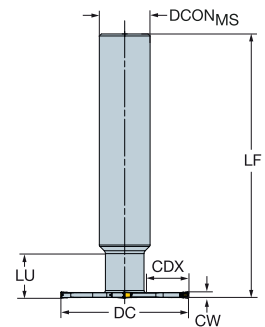
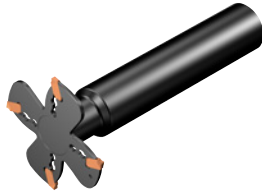
KAPR 90°





							Dimensions, mm									
CW	DC	CDX	SSC	CZC <sub>MS</sub>	CNSC		Ordering code	DCON <sub>MS</sub>	LF	LU			RPMX	BD	LB	MIID
2.00	63	21.0	E	25	4	4	QD-EC063A25-M	25.0	130.00	23	70	0.67	4900	19.0	21.8	QD-NE-0200-020E-PM
2.50	63	21.0	F	25	4	4	QD-FC063A25-M	25.0	130.00	23	70	0.68	5600	19.0	22.3	QD-NF-0250-020E-PM
3.00	63	21.0	G	25	4	4	QD-GC063A25-M	25.0	130.00	24	70	0.68	6900	19.0	22.7	QD-NG-0300-020E-PM
5.00	80	26.5	J	32	4	4	QD-JC080A32-M	32.0	130.00	26	70	1.05	4200	25.0	24.7	QD-NJ-0500-030E-PM
6.00	80	26.5	K	32	4	4	QD-KC080A32-M	32.0	130.00	27	70	1.06	4300	25.0	25.7	QD-NK-0600-035E-PM

## Cylindrical shank

KAPR 90°



							Dimensions, mm									
CW	DC	CDX	SSC	CZC <sub>MS</sub>	CNSC		Ordering code	DCON <sub>MS</sub>	LF	LU		RPMX	BD	LB	MIID	
2.00	63	21.0	E	25	4	4	QD-E-063A25-M	25.0	130.00	23	0.69	4900	19.0	21.8	QD-NE-0200-020E-PM	
2.50	63	21.0	F	25	4	4	QD-F-063A25-M	25.0	130.00	23	0.68	5600	19.0	22.3	QD-NF-0250-020E-PM	
3.00	63	21.0	G	25	4	4	QD-G-063A25-M	25.0	130.00	24	0.70	6900	19.0	22.7	QD-NG-0300-020E-PM	
5.00	80	26.5	J	32	4	4	QD-J-080A32-M	32.0	130.00	26	1.08	4200	25.0	24.7	QD-NJ-0500-030E-PM	
6.00	80	26.5	K	32	4	4	QD-K-080A32-M	32.0	130.00	27	1.07	4300	25.0	25.7	QD-NK-0600-035E-PM	

### Spare parts

Coolant plug  
5643 028-02

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I140



L2



N23

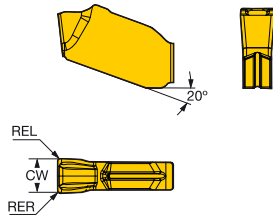
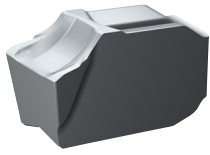


N6



N15

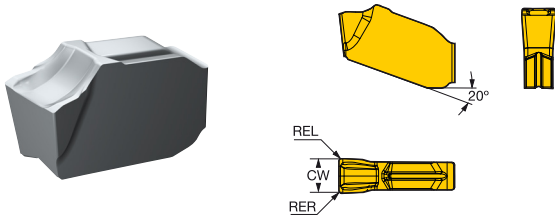
# CoroMill® QD insert for grooving



SSC	CW	REL	RER	Ordering code	Dimensions, mm															
					P		M		K		N		S		H					
					1130	4340	1040	1130	2040	1020	3330	1130	H13A	1130	H13A	S30T	S40T	1130	AN	CWTOLL
E	2.00	0.10	0.10	QD-NE-0200-010E-NL													7°	0.005	0.055	
	2.00	0.20	0.20	QD-NE-0200-020E-KL													7°	0.005	0.055	
	2.00	0.20	0.20	QD-NE-0200-020E-ML				*									7°	0.005	0.055	
	2.00	0.20	0.20	QD-NE-0200-020E-PL	*	*		*								*	7°	0.005	0.055	
	2.00	0.20	0.20	QD-NE-0200-020E-SL	*	*		*							*	*	7°	0.005	0.055	
	F	2.39	0.10	0.10	QD-NF-0239-010E-NL													7°	0.005	0.055
		2.39	0.20	0.20	QD-NF-0239-020E-KL						*							7°	0.005	0.055
		2.39	0.20	0.20	QD-NF-0239-020E-ML			*	*									7°	0.005	0.055
		2.39	0.20	0.20	QD-NF-0239-020E-PL	*	*		*								*	7°	0.005	0.055
		2.39	0.20	0.20	QD-NF-0239-020E-SL	*	*		*						*	*	7°	0.005	0.055	
		2.50	0.10	0.10	QD-NF-0250-010E-NL							*						7°	0.005	0.055
		2.50	0.20	0.20	QD-NF-0250-020E-KL				*	*								7°	0.005	0.055
2.50		0.20	0.20	QD-NF-0250-020E-ML			*	*									7°	0.005	0.055	
2.50		0.20	0.20	QD-NF-0250-020E-PL	*	*		*							*	7°	0.005	0.055		
2.50		0.20	0.20	QD-NF-0250-020E-SL	*	*		*						*	*	7°	0.005	0.055		
G		3.00	0.10	0.10	QD-NG-0300-010E-NL								*					7°	0.005	0.055
		3.00	0.20	0.20	QD-NG-0300-020E-KL						*							7°	0.005	0.055
	3.00	0.20	0.20	QD-NG-0300-020E-ML			*	*									7°	0.005	0.055	
	3.00	0.20	0.20	QD-NG-0300-020E-PL	*	*		*							*	7°	0.005	0.055		
	3.00	0.20	0.20	QD-NG-0300-020E-SL	*	*		*						*	*	7°	0.005	0.055		
	3.18	0.10	0.10	QD-NG-0318-010E-NL							*						7°	0.005	0.055	
	3.18	0.20	0.20	QD-NG-0318-020E-KL				*	*								7°	0.005	0.055	
	3.18	0.20	0.20	QD-NG-0318-020E-ML			*	*									7°	0.005	0.055	
	3.18	0.20	0.20	QD-NG-0318-020E-PL	*	*		*							*	7°	0.005	0.055		
	3.18	0.20	0.20	QD-NG-0318-020E-SL	*	*		*						*	*	7°	0.005	0.055		
	H	4.00	0.15	0.15	QD-NH-0400-015E-NL						*		*					7°	0.005	0.055
		4.00	0.25	0.25	QD-NH-0400-025E-KL				*	*								7°	0.005	0.055
4.00		0.25	0.25	QD-NH-0400-025E-ML			*	*									7°	0.005	0.055	
4.00		0.25	0.25	QD-NH-0400-025E-PL	*	*		*							*	7°	0.005	0.055		
4.00		0.25	0.25	QD-NH-0400-025E-SL	*	*		*						*	*	7°	0.005	0.055		
J	4.76	0.20	0.20	QD-NJ-0476-020E-NL						*		*					7°	0.005	0.055	
	4.76	0.30	0.30	QD-NJ-0476-030E-KL				*	*								7°	0.005	0.055	
	4.76	0.30	0.30	QD-NJ-0476-030E-ML			*	*									7°	0.005	0.055	
	4.76	0.30	0.30	QD-NJ-0476-030E-PL	*	*		*							*	7°	0.005	0.055		
	4.76	0.30	0.30	QD-NJ-0476-030E-SL	*	*		*						*	*	7°	0.005	0.055		
	5.00	0.20	0.20	QD-NJ-0500-020E-NL							*		*				7°	0.005	0.055	
	5.00	0.30	0.30	QD-NJ-0500-030E-KL				*	*								7°	0.005	0.055	
	5.00	0.30	0.30	QD-NJ-0500-030E-ML			*	*									7°	0.005	0.055	
	5.00	0.30	0.30	QD-NJ-0500-030E-PL	*	*		*							*	7°	0.005	0.055		
	5.00	0.30	0.30	QD-NJ-0500-030E-SL	*	*		*						*	*	7°	0.005	0.055		
K	6.00	0.25	0.25	QD-NK-0600-025E-NL						*		*					7°	0.005	0.055	
	6.00	0.35	0.35	QD-NK-0600-035E-KL				*	*								7°	0.005	0.055	
	6.00	0.35	0.35	QD-NK-0600-035E-ML			*	*									7°	0.005	0.055	
	6.00	0.35	0.35	QD-NK-0600-035E-PL	*	*		*							*	7°	0.005	0.055		
	6.00	0.35	0.35	QD-NK-0600-035E-SL	*	*		*						*	*	7°	0.005	0.055		
	6.35	0.25	0.25	QD-NK-0635-025E-NL							*		*				7°	0.005	0.055	
	6.35	0.35	0.35	QD-NK-0635-035E-KL				*	*								7°	0.005	0.055	
	6.35	0.35	0.35	QD-NK-0635-035E-ML			*	*									7°	0.005	0.055	
	6.35	0.35	0.35	QD-NK-0635-035E-PL	*	*		*							*	7°	0.005	0.055		
	6.35	0.35	0.35	QD-NK-0635-035E-SL	*	*		*						*	*	7°	0.005	0.055		



# CoroMill® QD insert for grooving



SSC	CW	REL	RER	Ordering code	Material										Dimensions, mm					
					P		M		K		N		S		H		AN	CWTOLL	CWTOLLU	
					1130	4340	1040	1130	2040	1020	3330	1130	H13A	H19A	S30T	SA0T				1130
Medium	E	2.00	0.20	0.20	QD-NE-0200-020E-MM													7°	0.005	0.055
		2.00	0.20	0.20	QD-NE-0200-020E-PM	★												7°	0.005	0.055
		2.00	0.20	0.20	QD-NE-0200-020E-SM										★			7°	0.005	0.055
		2.00	0.20	0.20	QD-NE-0200-020M-PM	☆	☆											7°	0.005	0.105
		2.00	0.35	0.35	QD-NE-0200-035M-KM													7°	0.005	0.105
	F	2.39	0.20	0.20	QD-NF-0239-020E-MM			★										7°	0.005	0.055
		2.39	0.20	0.20	QD-NF-0239-020E-PM	★	☆											7°	0.005	0.055
		2.39	0.20	0.20	QD-NF-0239-020E-SM										★			7°	0.005	0.055
		2.39	0.20	0.20	QD-NF-0239-020M-PM	☆	☆											7°	0.005	0.105
		2.39	0.35	0.35	QD-NF-0239-035M-KM													7°	0.005	0.105
		2.50	0.20	0.20	QD-NF-0250-020E-MM			★										7°	0.005	0.055
		2.50	0.20	0.20	QD-NF-0250-020E-PM	★	☆											7°	0.005	0.055
		2.50	0.20	0.20	QD-NF-0250-020E-SM										★			7°	0.005	0.055
		2.50	0.20	0.20	QD-NF-0250-020M-PM	☆	☆											7°	0.005	0.105
		2.50	0.35	0.35	QD-NF-0250-035M-KM													7°	0.005	0.105
	G	3.00	0.20	0.20	QD-NG-0300-020E-MM			★										7°	0.005	0.055
		3.00	0.20	0.20	QD-NG-0300-020E-PM	★	☆											7°	0.005	0.055
		3.00	0.20	0.20	QD-NG-0300-020E-SM										★			7°	0.005	0.055
		3.00	0.20	0.20	QD-NG-0300-020M-PM	☆	☆											7°	0.005	0.105
		3.00	0.35	0.35	QD-NG-0300-035M-KM													7°	0.005	0.105
	3.18	0.20	0.20	QD-NG-0318-020E-MM			★										7°	0.005	0.055	
	3.18	0.20	0.20	QD-NG-0318-020E-PM	★	☆											7°	0.005	0.055	
	3.18	0.20	0.20	QD-NG-0318-020E-SM										★			7°	0.005	0.055	
	3.18	0.20	0.20	QD-NG-0318-020M-PM	☆	☆											7°	0.005	0.105	
	3.18	0.35	0.35	QD-NG-0318-035M-KM													7°	0.005	0.105	
H	4.00	0.25	0.25	QD-NH-0400-025E-MM			★										7°	0.005	0.055	
	4.00	0.25	0.25	QD-NH-0400-025E-PM	★	☆											7°	0.005	0.055	
	4.00	0.25	0.25	QD-NH-0400-025E-SM										★			7°	0.005	0.055	
	4.00	0.25	0.25	QD-NH-0400-025M-PM	☆	☆											7°	0.005	0.105	
	4.00	0.40	0.40	QD-NH-0400-040M-KM													7°	0.005	0.105	
J	4.76	0.30	0.30	QD-NJ-0476-030E-MM			★										7°	0.005	0.055	
	4.76	0.30	0.30	QD-NJ-0476-030E-PM	★	☆											7°	0.005	0.055	
	4.76	0.30	0.30	QD-NJ-0476-030E-SM										★			7°	0.005	0.055	
	4.76	0.30	0.30	QD-NJ-0476-030M-PM	☆	☆											7°	0.005	0.105	
	4.76	0.45	0.45	QD-NJ-0476-045M-KM													7°	0.005	0.105	
	5.00	0.30	0.30	QD-NJ-0500-030E-MM			★										7°	0.005	0.055	
	5.00	0.30	0.30	QD-NJ-0500-030E-PM	★	☆											7°	0.005	0.055	
	5.00	0.30	0.30	QD-NJ-0500-030E-SM										★			7°	0.005	0.055	
	5.00	0.30	0.30	QD-NJ-0500-030M-PM	☆	☆											7°	0.005	0.105	
	5.00	0.45	0.45	QD-NJ-0500-045M-KM													7°	0.005	0.105	
K	6.00	0.35	0.35	QD-NK-0600-035E-MM			★										7°	0.005	0.055	
	6.00	0.35	0.35	QD-NK-0600-035E-PM	★	☆											7°	0.005	0.055	
	6.00	0.35	0.35	QD-NK-0600-035E-SM										★			7°	0.005	0.055	
	6.00	0.35	0.35	QD-NK-0600-035M-PM	☆	☆											7°	0.005	0.105	
	6.00	0.50	0.50	QD-NK-0600-050M-KM													7°	0.005	0.105	
	6.35	0.35	0.35	QD-NK-0635-035E-MM			★										7°	0.005	0.055	
	6.35	0.35	0.35	QD-NK-0635-035E-PM	★	☆											7°	0.005	0.055	
	6.35	0.35	0.35	QD-NK-0635-035E-SM										★			7°	0.005	0.055	
	6.35	0.35	0.35	QD-NK-0635-035M-PM	☆	☆											7°	0.005	0.105	
	6.35	0.50	0.50	QD-NK-0635-050M-KM													7°	0.005	0.105	
Heavy	E	2.00	0.35	0.35	QD-NE-0200-035M-PH	☆	★										7°	0.005	0.105	
	F	2.39	0.35	0.35	QD-NF-0239-035M-PH	☆	★										7°	0.005	0.105	
		2.50	0.35	0.35	QD-NF-0250-035M-PH	☆	★										7°	0.005	0.105	
	G	3.00	0.35	0.35	QD-NG-0300-035M-PH	☆	★										7°	0.005	0.105	
		3.18	0.35	0.35	QD-NG-0318-035M-PH	☆	★										7°	0.005	0.105	
	H	4.00	0.40	0.40	QD-NH-0400-040M-PH	☆	★										7°	0.005	0.105	
	J	4.76	0.45	0.45	QD-NJ-0476-045M-PH	☆	★										7°	0.005	0.105	
	5.00	0.45	0.45	QD-NJ-0500-045M-PH	☆	★										7°	0.005	0.105		
K	6.00	0.50	0.50	QD-NK-0600-050M-PH	☆	★										7°	0.005	0.105		
	6.35	0.50	0.50	QD-NK-0635-050M-PH	☆	★										7°	0.005	0.105		



1137



1154



1175



N23



N6



N10

# CoroMill® 328

Grooving, threading and circlip grooving

## Application

- Thread milling
- Grooving
- Circlip grooving

## ISO application area:



## Benefits and features

- Inserts mounted in pockets for safe and stable mounting
- Large programme of inserts covering circlips, slots, threads, etc.
- Sharp precision-ground insert
- Different thread pitches possible with one tool
- Excellent for both internal and external machining
- Comes in four tool holder sizes with the same insert size
- Sharp cutting edges for high quality grooves without burr
- One grade; PVD coated GC1025 for all materials
- Multiple edges for economic machining



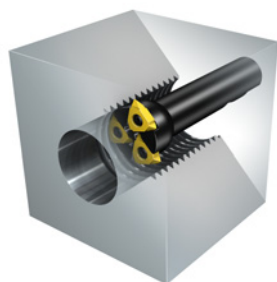
[www.sandvik.coromant.com/coromill328](http://www.sandvik.coromant.com/coromill328)

## Couplings

- Arbor
- Weldon
- Bore with keyway

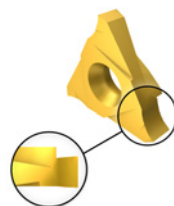
## Inserts

- Three cutting edges

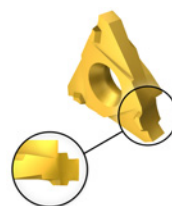


Thread forms: V-profile 60°, M 60° and UN 60°

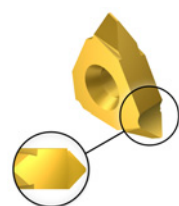
Circlip grooving



Circlip grooving with chamfer



Thread milling



I143

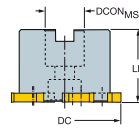
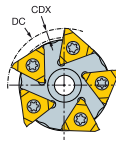


I144





# CoroMill® 328 groove milling cutter

Arbor

STDNO ISO6462  
KAPR 90°

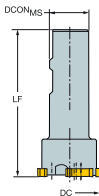
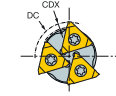


Dimensions, mm





CW	DC	CDX		CZC <sub>MS</sub>		Ordering code	DCON <sub>MS</sub>	ISO	LF	DHUB			RPMX	BD	LB	MIID
1.30	63	5.0	13	22	5	328-063Q22-13M	22.0	A	40.00	51.0	6.5	0.84	11900	51.0	40.0	328R13-130 00-GM

Weldon

KAPR 90°

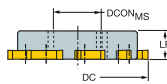
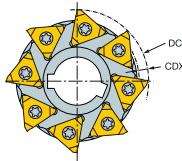


Dimensions, mm





CW	DC	CDX		CZC <sub>MS</sub>		Ordering code	DCON <sub>MS</sub>	ISO	LF			RPMX	BD	LB	MIID
1.30	39	3.0	13	25	2	328-039B25-13M	25.0	WE	125.00	6.5	0.59	19300	32.0	69.0	328R13-130 00-GM
	44	4.0	13	25	3	328-044B25-13M	25.0	WE	125.00	6.5	0.61	17100	34.0	69.0	328R13-130 00-GM

Bore with keyway

KAPR 90°



Dimensions, mm

CW	DC	CDX		CZC <sub>MS</sub>		Ordering code	DCON <sub>MS</sub>	LF	DRVCT	DHUB			RPMX	BD	LB	MIID
1.30	63	5.0	13	22	5	328-063S22-13M	22.0	14.00	1	51.0	6.5	0.22	11900	51.0	14.0	328R13-130 00-GM
	80	5.0	13	27	8	328-080S27-13M	27.0	16.00	1	68.0	6.5	0.64	9400	68.0	16.0	328R13-130 00-GM

Spare parts

Insert screw  
5513 039-05

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



I144



L2



M1

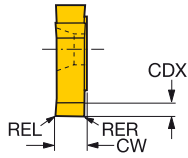
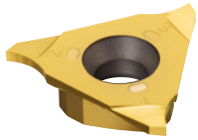


N23



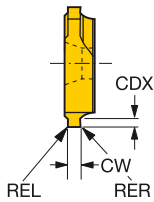
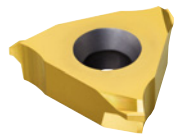
N12

# CoroMill® 328 insert for groove milling



## For circlip grooves

						P	M	K	N	S	H	Dimensions, mm				
						1025	1025	1025	1025	1025		AN	CWTOLL	CWTOLU	RETOLL	RETOLU
SSC	CW	REL	RER	CDX	Ordering code	☆	☆	☆	☆	☆	☆					
Medium	13	1.30	0.10	0.10	5.00	328R13-130 00-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		1.60	0.10	0.10	5.00	328R13-160 00-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		1.85	0.15	0.15	5.00	328R13-185 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.15	0.15	0.15	5.00	328R13-215 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.65	0.15	0.15	5.00	328R13-265 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		3.15	0.15	0.15	5.00	328R13-315 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		4.15	0.15	0.15	5.00	328R13-415 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
	5.15	0.15	0.15	5.00	328R13-515 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050	

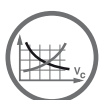


## For circlip grooves and chamfering

						P	M	K	N	S	H	Dimensions, mm				
						1025	1025	1025	1025	1025		AN	CWTOLL	CWTOLU	RETOLL	RETOLU
SSC	CW	REL	RER	CDX	Ordering code	☆	☆	☆	☆	☆	☆					
Medium	13	1.85	0.15	0.15	1.25	328R13-185 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.15	0.15	0.15	1.50	328R13-215 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.65	0.15	0.15	1.50	328R13-265 4515-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.65	0.15	0.15	1.75	328R13-265 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		3.15	0.15	0.15	1.75	328R13-315 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		4.15	0.15	0.15	2.00	328R13-415 4520-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		4.15	0.15	0.15	2.50	328R13-415 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		5.15	0.15	0.15	3.00	328R13-515 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050



I143



I154



I175



N23



N12

# CoroMill® 327

## Groove- and thread milling cutters

### Application

- Thread milling
- Groove milling
- Circlip grooving
- Chamfering

### ISO application area:



### Benefits and features

- Low cutting forces
- Sharp cutting edges for high quality grooves without burr
- Multiple edges for highly productive and economic machining
- Large programme with different shank lengths and diameters
- Large programme of inserts covering for instance circlips, o-rings, slots and threads
- Secure locking of insert
- Through coolant
- Different thread pitches possible with one tool



[www.sandvik.coromant.com/coromill327](http://www.sandvik.coromant.com/coromill327)

### Couplings

- Coromant Capto®
- Integrated ER collets
- Weldon steel or solid carbide shanks

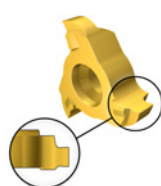
### Inserts

- Insert geometries and one grade for all materials
- Sharp precision-ground insert
- Three or six teeth
- Thread forms: V-profile 60°, M 60°, UN 60° and Whitworth 55°

Grooving and circlip  
grooving



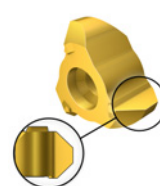
Circlip grooving with  
chamfer



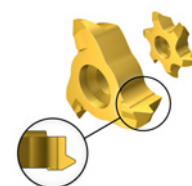
Grooving full radius



Chamfer milling



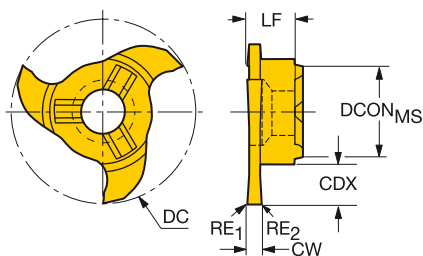
Thread milling



I146

# CoroMill® 327 solid carbide head for grooving

ENG



						P	M	K	N	S	Dimensions, mm					
						1025	1025	1025	1025	1025	DCON <sub>Ms</sub>	DC	LF	CWTOLL	CWTOLU	RPMX
CW	RE <sub>1</sub>	RE <sub>2</sub>	CZC <sub>Ms</sub>	CDX	ZEFP	Ordering code					DCON <sub>Ms</sub>	DC	LF	CWTOLL	CWTOLU	RPMX
1.00	0.00	0.00	6.0	1.5	3	327R06-10 10000-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.000	0.020	50000
1.50	0.20	0.20	6.0	1.5	3	327R06-10 15002-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.000	0.020	50000
2.00	0.20	0.20	6.0	1.5	3	327R06-10 20002-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.000	0.020	50000
2.50	0.20	0.20	6.0	1.5	3	327R06-10 25002-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.000	0.020	50000
1.50	0.10	0.10	9.0	3.5	6	327R09-18 15001-GMM	☆	☆	☆	☆	9.00	17.70	5.75	0.000	0.020	50000
1.50	0.20	0.20	9.0	3.5	3	327R09-18 15002-GM	☆	☆	☆	☆	9.00	17.70	5.75	0.000	0.020	50000
2.00	0.20	0.20	9.0	3.5	3	327R09-18 20002-GM	☆	☆	☆	☆	9.00	17.70	5.75	0.000	0.020	50000
2.00	0.20	0.20	9.0	3.5	6	327R09-18 20002-GMM	☆	☆	☆	☆	9.00	17.70	5.75	0.000	0.020	50000
2.50	0.20	0.20	9.0	3.5	3	327R09-18 25002-GM	☆	☆	☆	☆	9.00	17.70	5.75	0.000	0.020	50000
2.50	0.20	0.20	9.0	3.5	6	327R09-18 25002-GMM	☆	☆	☆	☆	9.00	17.70	5.75	0.000	0.020	50000
3.00	0.20	0.20	9.0	3.5	3	327R09-18 30002-GM	☆	☆	☆	☆	9.00	17.70	5.75	0.000	0.020	50000
3.00	0.20	0.20	9.0	3.5	6	327R09-18 30002-GMM	☆	☆	☆	☆	9.00	17.70	5.75	0.000	0.020	50000
1.50	0.20	0.20	12.0	4.5	3	327R12-22 15002-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.000	0.020	50000
2.00	0.20	0.20	12.0	4.5	3	327R12-22 20002-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.000	0.020	50000
2.50	0.20	0.20	12.0	4.5	3	327R12-22 25002-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.000	0.020	50000
3.00	0.20	0.20	12.0	4.5	3	327R12-22 30002-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.000	0.020	50000
4.00	0.20	0.20	12.0	4.5	3	327R12-22 40002-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.000	0.020	50000
1.50	0.10	0.10	12.0	6.5	6	327R12-28 15001-GMM	☆	☆	☆	☆	12.00	27.70	6.45	0.000	0.020	50000
2.00	0.20	0.20	12.0	6.4	6	327R12-28 20002-GMM	☆	☆	☆	☆	12.00	27.70	6.40	0.000	0.020	50000
2.50	0.20	0.20	12.0	6.5	6	327R12-28 25002-GMM	☆	☆	☆	☆	12.00	27.70	6.25	0.000	0.020	50000
3.00	0.20	0.20	12.0	6.5	6	327R12-28 30002-GMM	☆	☆	☆	☆	12.00	27.70	6.25	0.000	0.020	50000
4.00	0.20	0.20	12.0	6.5	6	327R12-28 40002-GMM	☆	☆	☆	☆	12.00	27.70	6.25	0.000	0.020	50000
1.50	0.00	0.00	14.0	6.5	3	327R14-28 15000-GM	☆	☆	☆	☆	14.30	27.70	6.50	0.000	0.020	50000
2.00	0.20	0.20	14.0	6.5	3	327R14-28 20002-GM	☆	☆	☆	☆	14.30	27.70	6.50	0.000	0.020	50000
2.50	0.20	0.20	14.0	6.5	3	327R14-28 25002-GM	☆	☆	☆	☆	14.30	27.70	6.50	0.000	0.020	50000
3.00	0.20	0.20	14.0	6.5	3	327R14-28 30002-GM	☆	☆	☆	☆	14.30	27.70	6.50	0.000	0.020	50000
3.50	0.20	0.20	14.0	6.5	3	327R14-28 35002-GM	☆	☆	☆	☆	14.30	27.70	6.50	0.000	0.020	50000
4.00	0.20	0.20	14.0	6.5	3	327R14-28 40002-GM	☆	☆	☆	☆	14.30	27.70	6.50	0.000	0.020	50000
1.50	0.10	0.10	14.0	10.0	6	327R14-35 15001-GMM	☆	☆	☆	☆	14.30	34.70	6.25	0.000	0.020	50000
2.00	0.20	0.20	14.0	10.0	6	327R14-35 20002-GMM	☆	☆	☆	☆	14.30	34.70	6.25	0.000	0.020	50000
2.50	0.20	0.20	14.0	10.0	6	327R14-35 25002-GMM	☆	☆	☆	☆	14.30	34.70	6.25	0.000	0.020	50000
3.00	0.20	0.20	14.0	10.0	6	327R14-35 30002-GMM	☆	☆	☆	☆	14.30	34.70	6.25	0.000	0.020	50000

## For circlip grooves

						P	M	K	N	S	Dimensions, mm					
						1025	1025	1025	1025	1025	DCON <sub>Ms</sub>	DC	LF	CWTOLL	CWTOLU	RPMX
CW	RE <sub>1</sub>	RE <sub>2</sub>	CZC <sub>Ms</sub>	CDX	ZEFP	Ordering code					DCON <sub>Ms</sub>	DC	LF	CWTOLL	CWTOLU	RPMX
0.70	0.00	0.00	6.0	1.5	3	327R06-10 07000-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.050	0.070	50000
0.80	0.00	0.00	6.0	1.5	3	327R06-10 08000-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.050	0.070	50000
0.90	0.00	0.00	6.0	1.5	3	327R06-10 09000-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.050	0.070	50000
1.10	0.00	0.00	6.0	1.5	3	327R06-10 11000-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.090	0.110	50000
1.30	0.00	0.00	6.0	1.5	3	327R06-10 13000-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.090	0.110	50000
1.60	0.00	0.00	6.0	1.5	3	327R06-10 16000-GM	☆	☆	☆	☆	6.00	9.70	3.50	0.090	0.110	50000
1.10	0.00	0.00	9.0	3.5	3	327R09-18 11000-GM	☆	☆	☆	☆	9.00	17.70	5.75	0.090	0.110	50000
1.30	0.00	0.00	9.0	3.5	3	327R09-18 13000-GM	☆	☆	☆	☆	9.00	17.70	5.75	0.090	0.110	50000
1.60	0.00	0.00	9.0	3.5	3	327R09-18 16000-GM	☆	☆	☆	☆	9.00	17.70	5.75	0.090	0.110	50000
1.60	0.00	0.00	12.0	4.5	3	327R12-22 16000-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.090	0.110	50000
1.85	0.15	0.15	12.0	4.5	3	327R12-22 18502-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.090	0.110	50000
2.15	0.20	0.20	12.0	4.5	3	327R12-22 21502-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.090	0.110	50000
2.65	0.15	0.15	12.0	4.5	3	327R12-22 26502-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.090	0.110	50000
3.15	0.15	0.15	12.0	4.5	3	327R12-22 31502-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.090	0.110	50000
4.15	0.15	0.15	12.0	4.5	3	327R12-22 41502-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.090	0.110	50000
5.15	0.15	0.15	12.0	4.5	3	327R12-22 51502-GM	☆	☆	☆	☆	12.00	21.70	5.70	0.090	0.110	50000



L2



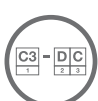
I154



I175



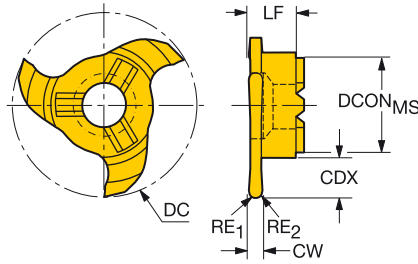
N23



N11

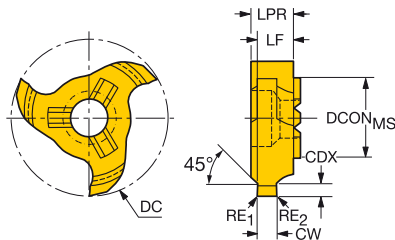


# CoroMill® 327 solid carbide head for grooving



## For full radius grooves

							P	M	K	N	S	Dimensions, mm					
CW	RE <sub>1</sub>	RE <sub>2</sub>	CZC <sub>MS</sub>	CDX	ZEFP	Ordering code	1025	1025	1025	1025	1025	DCON <sub>MS</sub>	DC	LF	CWTOLL	CWTOLU	RPMX
2.20	1.10	1.10	6.0	2.5	3	327R06-12 22011-RM	☆	☆	☆	☆	☆	6.00	11.70	3.50	0.000	0.030	50000
2.20	1.10	1.10	9.0	3.5	3	327R09-18 22011-RM	☆	☆	☆	☆	☆	9.00	17.70	5.75	0.000	0.030	50000
1.00	0.50	0.50	12.0	4.5	3	327R12-22 10005-RM	☆	☆	☆	☆	☆	12.00	21.70	5.75	0.000	0.030	50000
2.00	1.00	1.00	12.0	4.5	3	327R12-22 20010-RM	☆	☆	☆	☆	☆	12.00	21.70	5.75	0.000	0.030	50000
3.00	1.50	1.50	12.0	4.5	3	327R12-22 30015-RM	☆	☆	☆	☆	☆	12.00	21.70	5.75	0.000	0.030	50000
4.00	2.00	2.00	12.0	4.5	3	327R12-22 40020-RM	☆	☆	☆	☆	☆	12.00	21.70	5.75	0.000	0.030	50000

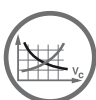


## Circlip grooves with chamfer

							P	M	K	N	S	Dimensions, mm						
CW	RE <sub>1</sub>	RE <sub>2</sub>	CZC <sub>MS</sub>	CDX	ZEFP	Ordering code	1025	1025	1025	1025	1025	DCON <sub>MS</sub>	DC	LF	LPR	CWTOLL	CWTOLU	RPMX
1.10	0.00	0.00	12.0	0.5	3	327R12-22 11045-GC	☆	☆	☆	☆	☆	12.00	21.70	5.00	5.80	0.090	0.110	50000
1.30	0.00	0.00	12.0	0.7	3	327R12-22 13045-GC	☆	☆	☆	☆	☆	12.00	21.70	5.20	5.80	0.090	0.110	50000
1.60	0.00	0.00	12.0	1.0	3	327R12-22 16045-GC	☆	☆	☆	☆	☆	12.00	21.70	5.00	5.80	0.090	0.110	50000
1.85	0.15	0.15	12.0	1.3	3	327R12-22 18545-GC	☆	☆	☆	☆	☆	12.00	21.70	5.20	5.80	0.090	0.110	50000
2.15	0.15	0.15	12.0	1.5	3	327R12-22 21545-GC	☆	☆	☆	☆	☆	12.00	21.70	5.30	5.85	0.090	0.110	50000
2.65	0.15	0.15	12.0	1.5	3	327R12-22 26545-GC	☆	☆	☆	☆	☆	12.00	21.70	5.00	5.80	0.090	0.110	50000
3.15	0.20	0.20	12.0	1.8	3	327R12-22 31545-GC	☆	☆	☆	☆	☆	12.00	21.70	5.30	5.80	0.090	0.110	50000
4.15	0.20	0.20	12.0	2.0	3	327R12-22 41545-GC	☆	☆	☆	☆	☆	12.00	21.70	5.30	5.85	0.090	0.110	50000
1.30	0.00	0.00	12.0	0.8	3	327R12-221304508-GC	☆	☆	☆	☆	☆	12.00	21.70	5.20	5.80	0.090	0.110	50000
1.60	0.00	0.00	12.0	0.8	3	327R12-221604508-GC	☆	☆	☆	☆	☆	12.00	21.70	5.00	5.80	0.090	0.110	50000
2.65	0.15	0.15	12.0	1.8	3	327R12-222654518-GC	☆	☆	☆	☆	☆	12.00	21.70	5.00	5.80	0.090	0.110	50000
4.15	0.20	0.20	12.0	2.5	3	327R12-224154525-GC	☆	☆	☆	☆	☆	12.00	21.70	5.30	5.85	0.090	0.110	50000



L2



I154



I175



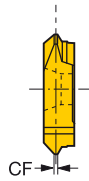
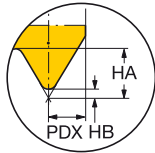
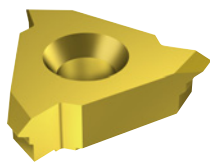
N23



N11

# CoroMill® 328 insert for thread milling

For internal threads



## Metric 60° Full form

SSC	TP	NT	Ordering code	P	M	K	N	S	H	Dimensions, mm			
				1025	1025	1025	1025	1025	1025	CF	HA	HB	PDX
13	1.50	1	328R13-150 MM-TH	☆	☆	☆	☆	☆	☆	0.2	0.97	0.16	0.85
	2.00	1	328R13-200 MM-TH	☆	☆	☆	☆	☆	☆	0.3	1.30	0.22	1.05
	3.00	1	328R13-300 MM-TH	☆	☆	☆	☆	☆	☆	0.4	1.95	0.32	1.35
	3.50	1	328R13-350 MM-TH	☆	☆	☆	☆	☆	☆	0.4	2.27	0.38	1.55
	4.00	1	328R13-400 MM-TH	☆	☆	☆	☆	☆	☆	0.5	2.60	0.43	1.75
	4.50	1	328R13-450 MM-TH	☆	☆	☆	☆	☆	☆	0.6	2.92	0.49	1.95
	5.00	1	328R13-500 MM-TH	☆	☆	☆	☆	☆	☆	0.6	3.25	0.54	2.05
	5.50	1	328R13-550 MM-TH	☆	☆	☆	☆	☆	☆	0.7	3.57	0.60	2.30
	6.00	1	328R13-600 MM-TH	☆	☆	☆	☆	☆	☆	0.8	3.90	0.65	2.45

## UN 60° Full form

SSC	TPI	NT	Ordering code	P	M	K	N	S	H	Dimensions, mm			
				1025	1025	1025	1025	1025	1025	CF	HA	HB	PDX
13	16.0	1	328R13-16 UN-TH	☆	☆	☆	☆	☆	☆	0.2	1.02	0.16	0.80
	12.0	1	328R13-12 UN-TH	☆	☆	☆	☆	☆	☆	0.3	1.38	0.23	1.00
	8.0	1	328R13-08 UN-TH	☆	☆	☆	☆	☆	☆	0.4	2.06	0.34	1.40
	4.0	1	328R13-04 UN-TH	☆	☆	☆	☆	☆	☆	0.8	4.12	0.68	2.55

## V-profile 60°

SSC	TPN	TPX	TPIN	TPIX	NT	Ordering code	P	M	K	N	S	H	Dimensions, mm			
							1025	1025	1025	1025	1025	1025	CF	HA	HB	PDX
13	1.5	3.5	7.0	16.0	1	328R13-150 VM-TH	☆	☆	☆	☆	☆	☆	0.2	2.31	0.13	1.95
	4.0	6.0	4.0	6.0	1	328R13-400 VM-TH	☆	☆	☆	☆	☆	☆	0.5	4.06	0.41	2.60



I143



I154



I175



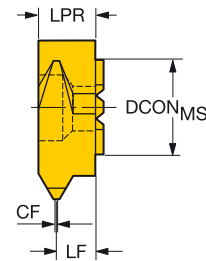
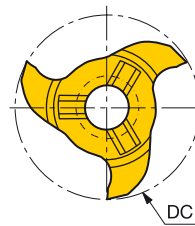
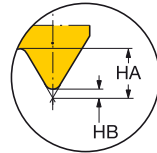
N23



N12

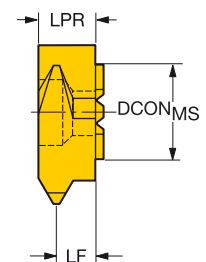
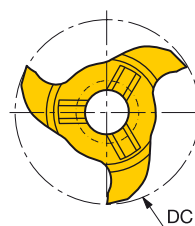
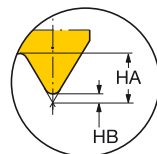
# CoroMill® 327 solid carbide head for thread milling

For internal threads



## V-profile 60° Non-topping

TPN	TPX	TPIN	TPIX	DC	CZC <sub>MS</sub>	ZEFP	Ordering code	Dimensions, mm										
								P	M	K	N	S	DCON <sub>MS</sub>	CF	HA	HB	LF	LPR
1.0	2.0	12.0	24.0	11.70	6.0	3	327R06-12 100VM-TH	☆	☆	☆	☆	☆	6.00	0.1	1.36	0.11	2.8	3.60
1.0	2.0	12.0	24.0	17.70	9.0	3	327R09-18 100VM-TH	☆	☆	☆	☆	☆	9.00	0.1	1.30	0.11	4.7	5.85
1.0	2.0	12.0	24.0	17.70	9.0	6	327R09-18 100VM-THM	☆	☆	☆	☆	☆	9.00	0.1	1.30	0.11	5.0	5.85
1.0	2.0	12.0	24.0	21.70	12.0	3	327R12-22 100VM-TH	☆	☆	☆	☆	☆	12.00	0.1	1.30	0.11	4.6	5.80
1.0	2.0	12.0	24.0	21.70	12.0	6	327R12-22 100VM-THM	☆	☆	☆	☆	☆	12.00	0.1	1.36	0.11	5.1	6.35
2.5	3.0	8.0	10.0	11.70	6.0	3	327R06-12 250VM-TH	☆	☆	☆	☆	☆	6.00	0.3	2.00	0.22	2.2	3.60
2.5	3.5	7.0	10.0	17.70	9.0	3	327R09-18 250VM-TH	☆	☆	☆	☆	☆	9.00	0.3	2.88	0.22	4.2	5.85
2.5	3.5	7.0	10.0	17.70	9.0	6	327R09-18 250VM-THM	☆	☆	☆	☆	☆	9.00	0.3	2.88	0.22	4.3	5.85
2.5	4.5	5.0	10.0	21.70	12.0	3	327R12-22 250VM-TH	☆	☆	☆	☆	☆	12.00	0.3	2.92	0.22	3.7	5.60
2.5	4.5	5.0	10.0	21.70	12.0	6	327R12-22 250VM-THM	☆	☆	☆	☆	☆	12.00	0.3	2.92	0.22	4.2	6.05



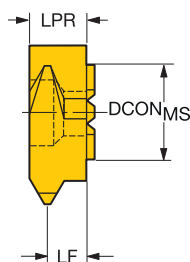
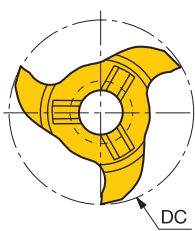
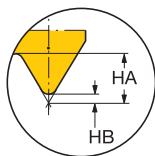
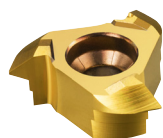
## Metric 60° Full form

TP	DC	CZC <sub>MS</sub>	ZEFP	Ordering code	Dimensions, mm									
					P	M	K	N	S	DCON <sub>MS</sub>	HA	HB	LF	LPR
1.50	17.70	9.0	3	327R09-18 150MM-TH	☆	☆	☆	☆	☆	9.00	0.97	0.16	4.8	5.85
1.50	17.70	9.0	6	327R09-18 150MM-THM	☆	☆	☆	☆	☆	9.00	0.97	0.16	5.0	5.85
2.00	17.70	9.0	3	327R09-18 200MM-TH	☆	☆	☆	☆	☆	9.00	1.30	0.22	4.6	5.85
2.00	17.70	9.0	6	327R09-18 200MM-THM	☆	☆	☆	☆	☆	9.00	1.30	0.22	4.8	5.85
3.00	17.70	9.0	3	327R09-18 300MM-TH	☆	☆	☆	☆	☆	9.00	1.95	0.32	4.3	5.85
3.00	17.70	9.0	6	327R09-18 300MM-THM	☆	☆	☆	☆	☆	9.00	1.95	0.32	4.6	5.85
3.50	17.70	9.0	3	327R09-18 350MM-TH	☆	☆	☆	☆	☆	9.00	2.27	0.38	4.0	5.85
3.50	17.70	9.0	6	327R09-18 350MM-THM	☆	☆	☆	☆	☆	9.00	2.27	0.38	4.0	5.85
1.50	21.70	12.0	3	327R12-22 150MM-TH	☆	☆	☆	☆	☆	12.00	0.97	0.16	4.8	5.80
1.75	21.70	12.0	3	327R12-22 175MM-TH	☆	☆	☆	☆	☆	12.00	1.14	0.19	4.7	5.80
2.00	21.70	12.0	3	327R12-22 200MM-TH	☆	☆	☆	☆	☆	12.00	1.30	0.22	4.6	5.80
3.00	21.70	12.0	3	327R12-22 300MM-TH	☆	☆	☆	☆	☆	12.00	1.95	0.32	4.3	5.80
3.50	21.70	12.0	3	327R12-22 350MM-TH	☆	☆	☆	☆	☆	12.00	2.27	0.38	4.0	5.80
4.00	21.70	12.0	3	327R12-22 400MM-TH	☆	☆	☆	☆	☆	12.00	2.60	0.43	3.9	5.80
4.50	21.70	12.0	3	327R12-22 450MM-TH	☆	☆	☆	☆	☆	12.00	2.92	0.49	3.7	5.70



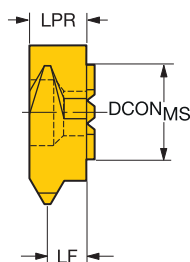
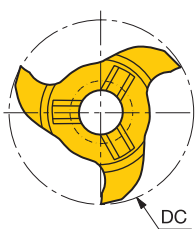
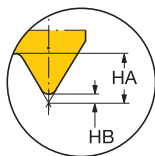
# CoroMill® 327 solid carbide head for thread milling

For internal threads



UN 60° Full form

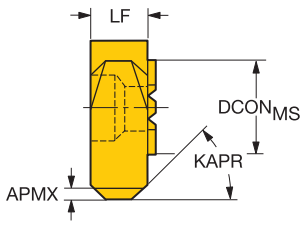
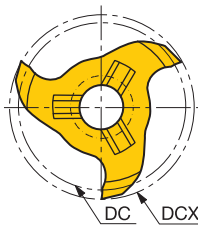
TPI	DC	CZC <sub>MS</sub>	APMX	ZEFP	Ordering code	P	M	K	N	S	Dimensions, mm				
						1025	1025	1025	1025	1025	DCON <sub>MS</sub>	HA	HB	LF	LPR
20	17.70	9.0	0.69	3	327R09-18 20UN-TH	☆	☆	☆	☆	☆	9.00	0.82	0.14	5.2	5.85
18	17.70	9.0	0.76	3	327R09-18 18UN-TH	☆	☆	☆	☆	☆	9.00	0.92	0.15	5.0	5.85
16	17.70	9.0	0.86	3	327R09-18 16UN-TH	☆	☆	☆	☆	☆	9.00	1.03	0.17	5.0	5.85
16	17.70	9.0	0.86	6	327R09-18 16UN-THM	☆	☆	☆	☆	☆	9.00	1.03	0.17	5.0	5.85
14	17.70	9.0	0.99	3	327R09-18 14UN-TH	☆	☆	☆	☆	☆	9.00	1.18	0.20	5.0	5.85
14	17.70	9.0	0.99	6	327R09-18 14UN-THM	☆	☆	☆	☆	☆	9.00	1.18	0.20	5.0	5.85
12	17.70	9.0	1.14	3	327R09-18 12UN-TH	☆	☆	☆	☆	☆	9.00	1.37	0.23	4.9	5.85
12	17.70	9.0	1.14	6	327R09-18 12UN-THM	☆	☆	☆	☆	☆	9.00	1.37	0.23	4.9	5.85
11	17.70	9.0	1.24	3	327R09-18 11UN-TH	☆	☆	☆	☆	☆	9.00	1.50	0.25	4.8	5.85
11	17.70	9.0	1.24	6	327R09-18 11UN-THM	☆	☆	☆	☆	☆	9.00	1.50	0.25	4.8	5.85
10	17.70	9.0	1.37	3	327R09-18 10UN-TH	☆	☆	☆	☆	☆	9.00	1.65	0.27	4.7	5.85
8	17.70	9.0	1.73	3	327R09-18 08UN-TH	☆	☆	☆	☆	☆	9.00	2.06	0.34	4.4	5.85
8	17.70	9.0	1.73	6	327R09-18 08UN-THM	☆	☆	☆	☆	☆	9.00	2.06	0.34	4.4	5.85



Whitworth 55° Full form

TPI	DC	CZC <sub>MS</sub>	ZEFP	Ordering code	P	M	K	N	S	Dimensions, mm				
					1025	1025	1025	1025	1025	DCON <sub>MS</sub>	HA	HB	LF	LPR
19	11.70	6.0	3	327R06-12 19WH-TH	☆	☆	☆	☆	☆	6.00	1.07	0.21	2.5	3.60
19	17.70	9.0	3	327R09-18 19WH-TH	☆	☆	☆	☆	☆	9.00	1.07	0.21	4.9	5.85
14	11.70	6.0	3	327R06-12 14WH-TH	☆	☆	☆	☆	☆	6.00	1.45	0.29	2.3	3.60
14	17.70	9.0	3	327R09-18 14WH-TH	☆	☆	☆	☆	☆	9.00	1.45	0.29	4.6	5.85
11	11.70	6.0	3	327R06-12 11WH-TH	☆	☆	☆	☆	☆	6.00	1.85	0.37	2.0	3.60
11	17.70	9.0	3	327R09-18 11WH-TH	☆	☆	☆	☆	☆	9.00	1.85	0.37	4.4	5.85

# CoroMill® 327 solid carbide head for chamfering



KAPR	CZC <sub>MS</sub>	APMX	ZEFP	Ordering code	P	M	K	Dimensions, mm				
					1025	1025	1025	DCON <sub>MS</sub>	DC	DCX	LF	RPMX
45°	6.0	0.80	3	327R06-12 12045-CH	☆	☆	☆	6.00	10.10	11.7	3.60	80000
45°	12.0	1.70	3	327R12-22 20045-CH	☆	☆	☆	12.00	18.30	21.7	5.85	80000



L2



I154



I175



N23



N11

# CoroMill® 495

## Versatile chamfer cutter

### Application

- Chamfering of holes and along edges
- Typical operations are chamfers, back chamfers, preparation for welding and deburring

### ISO application area:



### Benefits and features

- Versatile tool for many different chamfer operations
- Flexible inserts capable to perform in several workpiece materials
- High machine utilization thanks to few tool changes
- Indexable inserts with four cutting edges
- Cutter bodies with high number of inserts in relation to body size



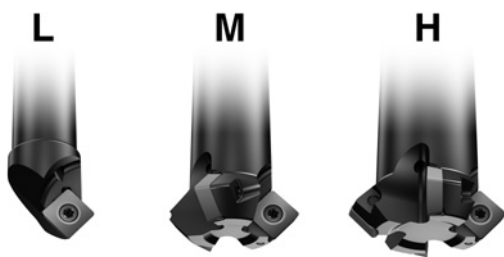
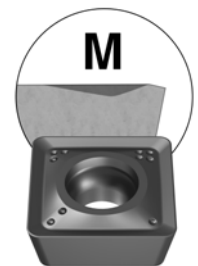
[www.sandvik.coromant.com/coromill495](http://www.sandvik.coromant.com/coromill495)

### Couplings

- Coromant Capto®
- Cylindrical shank
- Coromant EH

### Inserts

- Insert geometries and grades for all materials
- Four cutting edges



Coarse pitch

Close pitch

Extra close pitch



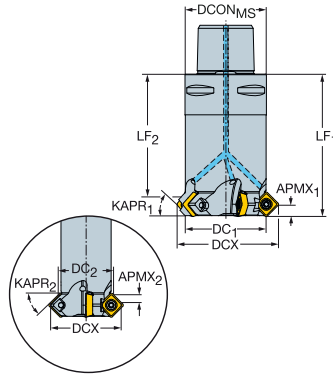
I152



I153

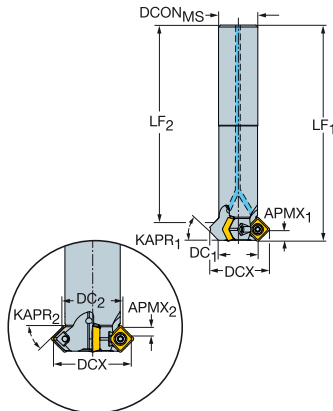
# CoroMill® 495 chamfer milling cutter

Coromant Capto® - Internal coolant supply



KAPR <sub>1</sub> KAPR <sub>2</sub>		CZC <sub>MS</sub>	APMX <sub>1</sub>	APMX <sub>2</sub>	CNSC	Ordering code	Dimensions, mm										CICT	MIID			
45°	45°	09	C4	5.4	5.4	3	5	495-040C4-4509H	DCON <sub>MS</sub>	DC <sub>1</sub>	DC <sub>2</sub>	DCX	BD	LF <sub>1</sub>	LF <sub>2</sub>	BAR	NM	KG	RPMX		
45°	45°	09	C5	5.4	5.4	3	6	495-050C5-4509H	50.0	50.5	50.5	61.9	49.7	75.0	63.2	20	1.4	1.58	5300	5	495-09T3M-XL
45°	45°	09	C6	5.4	5.4	3	7	495-063C6-4509H	63.0	63.5	63.5	74.9	62.7	80.0	68.2	20	1.4	2.43	4700	6	495-09T3M-XL
45°	45°	09	C6	5.4	5.4	3	7	495-063C6-4509H	63.0	63.5	63.5	74.9	62.7	80.0	68.2	20	1.4	2.43	4700	7	495-09T3M-XL

## Cylindrical shank - Internal coolant supply



KAPR <sub>1</sub> KAPR <sub>2</sub>		CZC <sub>MS</sub>	APMX <sub>1</sub>	APMX <sub>2</sub>	CNSC	Ordering code	Dimensions, mm										CICT	MIID				
30°	60°	09	16	3.8	6.5	1	1	495-012A16-3009L	DCON <sub>MS</sub>	DC <sub>1</sub>	DC <sub>2</sub>	DCX	BD	LF <sub>1</sub>	LF <sub>2</sub>	LU	BAR	NM	KG	RPMX		
45°	45°	09	16	5.4	5.4	1	1	495-012A16-4509L	16.0	12.0	17.7	23.4	11.2	100.0	90.8	51.0	20	1.4	0.23	14400	1	495-09T3M-XL
60°	30°	09	16	6.8	3.9	1	1	495-012A16-6009L	16.0	12.0	13.5	20.1	13.5	100.0	90.3	49.0	20	1.4	0.20	14400	1	495-09T3M-XL
75°	09	16	7.7	7.7	1	1	495-012A16-7509L	16.0	12.0	16.2	13.0	13.0	100.0	90.3	49.0	20	1.4	0.20	14400	1	495-09T3M-XL	
45°	45°	09	20	5.4	5.4	1	3	495-020A20-4509M	20.0	20.5	20.9	31.9	19.7	110.0	98.2	58.0	20	1.4	0.33	9500	3	495-09T3M-XL
75°	09	25	7.7	7.7	1	3	495-025A25-7509H	25.0	25.5	29.7	25.2	25.2	100.0	90.3	49.0	20	1.4	0.50	8100	3	495-09T3M-XL	
30°	60°	09	25	3.8	6.5	1	4	495-025A25-3009H	25.0	25.5	31.8	39.5	30.7	120.0	108.7	59.0	20	1.4	0.54	8100	4	495-09T3M-XL
45°	45°	09	25	5.4	5.4	1	4	495-025A25-4509H	25.0	25.5	25.9	36.9	24.7	120.0	108.2	59.0	20	1.4	0.48	8100	4	495-09T3M-XL
60°	30°	09	25	6.8	3.9	1	4	495-025A25-6009H	25.0	25.5	19.9	33.6	18.7	120.0	108.4	59.0	20	1.4	0.42	8100	4	495-09T3M-XL

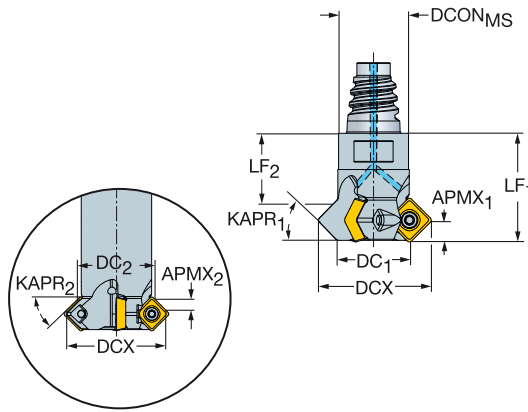
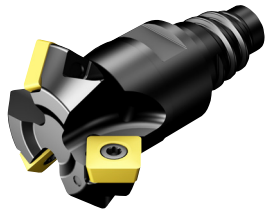
Spare parts
Insert screw
5513 020-04

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroMill® 495 chamfer milling cutter

Coromant EH - Internal coolant supply



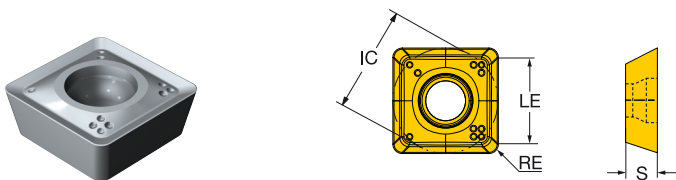
									Dimensions, mm											
KAPR <sub>1</sub>	KAPR <sub>2</sub>	CZC <sub>MS</sub>	APMX <sub>1</sub>	APMX <sub>2</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DC <sub>1</sub>	DC <sub>2</sub>	DCX	BD	LF <sub>1</sub>	LF <sub>2</sub>	BAR	NM	KG	RPMX	CICT	MIID	
45°	45°	09	E16	5.4	5.4	1	495-012EH16-4509L	15.5	12.0	17.7	23.4	11.2	30.0	20.8	20	1.4	0.09	14400	1	495-09T3M-XL
45°	45°	09	E20	5.4	5.4	1	495-020EH20-4509M	19.3	20.5	20.9	31.9	19.7	30.0	18.2	20	1.4	0.15	9500	3	495-09T3M-XL
45°	45°	09	E25	5.4	5.4	1	495-025EH25-4509H	24.2	25.5	25.5	36.9	24.7	35.0	23.2	20	1.4	0.18	8100	4	495-09T3M-XL

Spare parts
Insert screw
5513 020-04

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

# CoroMill® 495 insert for milling

KRINS 90°



						Dimensions, mm					
	RE	Ordering code	P	M	N	S	H	IC	LE	S	
Medium	MM	09 0.80	495-09T3M-MM	1130	1040	1130	1130	1130	9.0	7.4	3.51
	PM	09 0.80	495-09T3M-PM	★	☆	☆	☆	☆	9.0	7.4	3.51



L2



1154



N23



N9



N15



N3

## Milling with large engagement

ISO P	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	Max chip thickness, $h_{ex}$ mm		
							CT530	GC1010	GC1025
							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	430-390-350	-	340-310-255
P1.2.Z.AN	01.2		C = 0.25-0.55%	1600	150	0.25	385-350-315	-	305-280-230
P1.3.Z.AN	01.3		C = 0.55-0.80%	1700	170	0.25	365-330-300	-	290-260-215
P1.3.Z.AN	01.4			1800	210	0.25	315-290-260	-	250-230-185
P1.3.Z.HT	01.5			2000	300	0.25	235-210-195	-	185-170-140
			<b>Low alloyed (alloying elements ≤ 5%)</b>						
P2.1.Z.AN	02.1		Non-hardened	1700	175	0.25	300-275-245	-	280-255-210
P2.5.Z.HT	02.2		Hardened and tempered	1900	300	0.25	195-180-160	-	155-140-115
			<b>High alloyed (alloying elements &gt; 5%)</b>						
P3.0.Z.AN	03.11		Annealed	1950	200	0.25	230-205-185	180-165-135	180-165-135
P3.1.Z.AN	03.13		Hardened tool steel	2150	200	0.25	190-170-155	150-135-110	150-135-110
P3.0.Z.HT	03.21			2900	300	0.25	165-150-135	130-120-100	130-120-100
P3.0.Z.HT	03.22			3100	380	0.25	105-95-85	80-75-60	80-75-60
			<b>Castings</b>						
P1.5.C.UT	06.1		Unalloyed	1400	150	0.25	305-280-250	245-220-180	245-220-180
P2.6.C.UT	06.2		Low alloyed (alloying elements ≤ 5%)	1600	200	0.25	245-220-200	195-175-145	195-175-145
P3.0.C.UT	06.3		High alloyed (alloying elements > 5%)	1950	200	0.25	180-160-145	140-130-105	140-130-105
ISO M	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	Max chip thickness, $h_{ex}$ mm		
							CT530	M30B	GC1130
							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	285-255-230	265-210-135	255-225-180
P5.0.Z.PH	05.12		PH-hardened	2850	330	0.21	205-185-165	175-140-90	180-160-130
P5.0.Z.HT	05.13		Hardened	2350	330	0.21	215-190-170	200-160-100	185-165-135
			<b>Austenitic</b>						
M1.0.Z.AQ	05.21		Non-hardened	1950	200	0.21	265-240-215	-	250-225-180
M1.0.Z.PH	05.22		PH-hardened	2850	330	0.21	200-175-160	-	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	260-235-210	-	205-185-145
M3.2.Z.AQ	05.52		Weldable < 0.05%C	2450	260	0.21	230-205-185	-	175-155-125
			<b>Stainless steel - Cast</b>						
			<b>Ferritic/martensitic</b>						
P5.0.C.UT	15.11		Non-hardened	1700	200	0.25	255-230-205	230-185-120	225-200-160
P5.0.C.PH	15.12		PH-hardened	2450	330	0.25	180-160-145	150-120-80	155-140-115
P5.0.C.HT	15.13		Hardened	2150	330	0.25	195-175-155	180-145-90	170-155-120
M1.0.C.UT	15.21		Non hardened	1800	200	0.25	255-225-205	-	235-210-170
M1.0C.PH	15.22		PH-hardened	2450	330	0.25	180-160-145	-	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	245-220-195	-	195-175-140
M3.2.C.AQ	15.52		Weldable < 0.05%C	2250	260	0.25	215-190-170	-	160-145-115
ISO K	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	Max chip thickness, $h_{ex}$ mm		
							CB50	CC6190	GC1010
							Cutting speed $v_c$ , m/min		
			<b>Malleable cast iron</b>						
			Ferritic (short chipping)	790	130	0.28	-	1300-1050-880	225-185-150
K1.1.C.NS	07.2		Pearlitic (long chipping)	900	230	0.28	-	1100-890-730	185-155-125
			<b>Grey cast iron</b>						
K2.1.C.UT	08.1		Low tensile strength	890	180	0.28	910-780-670	1600-1300-1050	245-200-165
K2.2.C.UT	08.2		High tensile strength	1100	245	0.28	850-720-620	1200-990-810	195-160-130
			<b>Nodular cast iron</b>						
K3.1.C.UT	09.1		Ferritic	900	160	0.28	-	1000-830-680	155-125-105
K3.3.C.UT	09.2		Pearlitic	1350	250	0.28	495-420-360	840-690-570	145-120-95

**Conditions:**

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



GC1130	GC4220	GC4330	GC4340	GC2030	GC2040	GC3040				
<b>Max chip thickness, <math>h_{ex}</math> mm</b>										
0.05-0.1-0.2	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.4	0.1-0.2-0.4	0.1-0.2-0.4				
<b>Cutting speed <math>v_c</math> m/min</b>										
375-340-280 335-305-250 320-290-235 275-250-205 205-185-155	490-405-330 440-360-295 415-340-280 365-300-245 270-220-180	400-330-270 360-295-245 340-280-230 295-245-200 220-180-150	340-280-230 305-250-205 290-235-195 250-205-170 185-155-125	295-240-165 265-215-145 250-205-135 220-180-120 160-130-90	295-240-165 265-215-145 250-205-135 220-180-120 160-130-90	390-320-260 350-285-235 330-270-220 290-235-195 215-175-145				
265-240-195 170-155-130	345-285-230 225-185-150	280-230-190 185-150-125	240-195-160 155-130-105	205-170-115 135-110-75	205-170-115 135-110-75	275-225-185 180-145-120				
180-165-135 150-135-110 130-120-100 80-75-60	300-245-200 215-180-145 190-155-125 120-95-80	195-160-130 160-130-110 140-115-95 85-70-60	165-135-110 135-110-90 120-100-80 75-60-50	155-130-85 125-105-70 110-90-60 70-55-38	155-130-85 125-105-70 110-90-60 70-55-38	205-170-140 170-140-115 150-125-100 95-75-65				
245-220-180 195-175-145 140-130-105	350-290-235 280-230-190 205-170-140	260-215-175 205-170-140 150-125-100	220-180-150 175-145-120 130-105-85	210-170-115 170-140-95 120-100-70	210-170-115 170-140-95 120-100-70	280-230-190 220-180-150 160-135-110				
GC1040	S30T	S40T	GC2030	GC2040	GC4330	GC4340	GC1010	GC1025		
<b>Max chip thickness, <math>h_{ex}</math> mm</b>										
0.05-0.15-0.25	0.05-0.15-0.25	0.1-0.2-0.3	0.05-0.15-0.25	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.4	0.1-0.2-0.3	0.05-0.1-0.2		
<b>Cutting speed <math>v_c</math> m/min</b>										
185-140-105 130-100-70 135-100-75	255-190-140 180-135-100 185-140-105	250-200-160 170-135-110 180-145-115	240-190-155 170-135-110 175-140-115	240-190-155 165-130-105 175-140-110	275-220-175 190-150-120 200-160-125	210-170-110 140-110-70 160-125-80	285-255-230 205-185-165 215-190-170	255-225-180 180-160-130 185-165-135		
180-135-100 125-95-70 125-90-70	250-185-140 170-130-95 170-125-95	210-165-135 165-130-105 145-115-95	235-190-150 165-130-105 -	200-160-130 160-125-100 -	- - -	185-150-95 135-105-70 -	265-240-215 200-175-160 170-125-95	250-225-180 170-155-125 -		
150-115-85 125-95-70	205-155-115 175-130-95	175-140-110 140-115-90	195-155-125 165-130-105	170-135-105 135-110-85	- -	170-135-85 135-110-70	260-240-215 230-205-185	205-185-145 170-155-125		
165-125-90 115-85-65 125-90-70	225-165-125 155-115-85 170-125-95	220-175-140 150-120-95 165-135-105	215-170-135 150-120-95 160-130-105	210-170-135 145-115-90 160-130-100	245-195-155 165-130-105 180-145-115	185-150-95 120-100-65 145-115-75	255-230-205 180-160-145 195-175-155	225-200-160 155-140-115 170-155-120		
175-130-95 115-85-65 110-85-60	235-175-130 160-115-85 155-115-85	200-160-130 150-120-95 130-105-85	225-180-145 150-120-95 -	190-155-125 145-115-90 -	- - -	180-140-90 125-100-65 -	255-225-205 180-160-145 -	235-210-170 160-140-115 -		
145-105-80 115-85-65	195-15-110 160-120-90	165-130-105 135-105-85	185-150-120 150-120-95	160-125-100 130-100-80	- -	160-125-80 125-100-65	245-220-195 215-190-170	195-175-140 160-145-115		
GC3220	GC3330	GC3040	K20W	GC4330	GC4340	GC1020	H13A	K20D	K20M	K15W
<b>Max chip thickness, <math>h_{ex}</math> mm</b>										
0.1-0.2-0.3	0.1-0.2-0.4	0.1-0.2-0.4	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.4	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
<b>Cutting speed <math>v_c</math> m/min</b>										
265-220-180 220-180-150	260-215-145 215-175-120	240-195-135 200-165-110	225-185-150 185-150-125	215-175-145 175-145-120	195-160-130 160-130-110	205-170-140 170-140-115	120-105-75 100-85-65	265-220-180 220-180-150	255-210-170 210-170-140	- -
290-240-195 235-190-155	285-235-155 225-185-125	260-215-145 210-170-115	245-200-165 195-160-130	230-190-155 185-155-125	215-175-145 170-140-115	225-185-150 180-145-120	130-110-85 105-90-65	290-240-195 235-190-155	275-225-185 220-180-150	245-200-165 195-160-130
180-150-125 170-140-115	280-230-155 225-185-125	165-135-90 150-125-85	155-125-105 140-115-95	145-120-100 135-110-90	135-110-90 125-100-85	140-115-95 130-105-90	80-70-50 75-65-50	180-150-125 170-140-115	175-140-115 160-130-110	- -

## Milling with large engagement

ISO N	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	CD10			H10			CT530		
							Max chip thickness, $h_{ex}$ mm								
							0.1 - 0.15 - 0.2			0.1 - 0.15 - 0.2			0.1 - 0.15 - 0.2		
Cutting speed $v_c$ , m/min															
MC No.	CMC No.	Material	N/mm <sup>2</sup>	HB	mc										
N1.2.Z.UT	30.11	Aluminium alloys Wrought or wrought and coldworked, non-aging	400	60		1900-1750-1600			940-870-810			1050-960-890			
N1.2.Z.AG	30.12	Aluminium alloys Wrought or wrought and aged	650	100		1700-1550-1450			850-780-730			930-860-800			
N1.3.C.UT	30.21	Aluminium alloys Cast, non-aging	600	75	0.25	1900-1750-1600			940-870-810			1050-960-890			
N1.3.C.AG	30.22	Aluminium alloys Cast or cast and aged	700	90	0.25	1700-1550-1450			850-790-730			930-860-800			
N1.1.Z.UT	30.3	Aluminium alloys Al >99%	350	30		1900-1750-1600			950-880-810			1050-960-890			
N1.4.C.NS	30.41	Aluminium alloys Cast, 13-15% Si	700	130		760-700-650			380-350-325			415-385-355			
	30.42	Aluminium alloys Cast, 16-22% Si	700	130		570-530-485			285-265-245			310-290-270			
N3.3.U.UT	33.1	Copper and copper alloys Free cutting alloys, $\geq 1\%$ Pb	550	110	0.25	940-870-810			470-435-405			520-480-445			
N3.2.C.UT	33.2	Copper and copper alloys Brass, leaded bronzes, $\leq 1\%$ Pb	550	90		940-870-810			470-435-405			520-480-445			
N3.1.U.UT	33.3	Copper and copper alloys Bronze and non-leaded copper incl. electrolytic copper	1350	100	0.25	660-610-570			330-305-285			365-335-310			
ISO S	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	GC1025			GC1130			H13A		
Max chip thickness, $h_{ex}$ mm															
			0.05 - 0.15 - 0.2			0.1 - 0.15 - 0.2			0.1 - 0.15 - 0.2						
Cutting speed $v_c$ , m/min															
MC No.	CMC No.	Material	N/mm <sup>2</sup>	HB	mc										
S1.0.U.AN	20.11	Heat resistant super alloys Iron base Annealed or solution treated	2400	200	0.25	60-55-50			60-55-50			60-55-50			
	20.12	Heat resistant super alloys Iron base Aged or solution treated and aged	2500	280	0.25	45-40-37			45-40-37			45-40-38			
S2.0.Z.AN	20.21	Nickel base Annealed or solution treated	2650	250	0.25	60-55-50			60-55-50			55-55-50			
	20.22	Nickel base Aged or solution treated and aged	2900	350	0.25	36-33-30			36-33-30			35-33-30			
S2.0.C.NS	20.24	Nickel base Cast or cast and aged	3000	320	0.25	45-40-36			45-40-36			45-40-38			
S3.0.Z.AN	20.31	Cobalt alloys Annealed or solution treated	2700	200	0.25	25-22-20			25-22-20			23-21-18			
	20.32	Cobalt alloys Solution treated and aged	3000	300	0.25	18-16-14			18-16-14			17-15-13			
S3.0.C.NS	20.33	Cobalt alloys Cast or cast and aged	3100	320	0.25	16-14-13			16-14-13			16-14-13			
S4.1.Z.UT	23.1	Titanium alloys <sup>1)</sup> Commercial pure (99,5% Ti)	1300	Rm <sup>2)</sup> 400	0.23	125-115-105			125-115-105			125-115-110			
	23.21	Titanium alloys <sup>1)</sup> $\alpha$ , near $\alpha$ and $\alpha + \beta$ alloys, annealed	1400	950	0.23	55-50-45			55-50-45			50-45-45			
	23.22	Titanium alloys <sup>1)</sup> $\alpha + \beta$ alloys in aged cond., $\beta$ alloys, annealed or aged	1400	1050	0.23	45-40-36			45-40-36			38-36-33			
ISO H	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	CB50			CT530			GC4220		
Max chip thickness, $h_{ex}$ mm															
			0.07 - 0.12 - 0.2			0.07 - 0.12 - 0.2			0.1 - 0.15 - 0.25						
Cutting speed $v_c$ , m/min															
MC No.	CMC No.	Material	N/mm <sup>2</sup>	HB	mc										
H1.3.Z.HA	04.1	Extra hard steel Hardened and tempered	4200	59 HRC	0.25	160-140-115			80-75-55			55-45-36			
H2.0.C.UT	10.1	Chilled cast iron Cast or cast and aged	2250	400	0.28	310-270-215			155-140-110			100-90-70			

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

2) Rm = ultimate tensile strength measured in MPa.

**Conditions:**

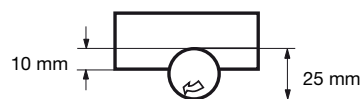
Cutter, dia. 125 mm, centered over the workpiece. Working engagement 100 mm.

GC1130	H10F	H13A	GC1025					
<b>Max chip thickness, <math>h_{ex}</math> mm</b>								
0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.1-0.15-0.2					
<b>Cutting speed <math>v_c</math> m/min</b>								
990-910-850	940-870-810	750-700-650	990-910-850					
890-820-760	850-780-730	680-630-580	890-820-760					
990-910-850	940-870-810	750-700-650	990-910-850					
990-920-850	850-790-730	680-630-580	990-920-850					
990-920-850	950-880-810	760-700-650	990-920-850					
395-370-340	380-350-325	300-280-260	395-370-340					
300-275-255	285-265-245	225-210-195	300-275-255					
495-460-425	470-435-405	375-350-325	495-460-425					
495-460-425	470-435-405	375-350-325	495-460-425					
345-320-295	330-305-285	265-245-225	345-320-295					
<b>H10F S30T S40T GC2030 GC2040 GC1010</b>								
<b>Max chip thickness, <math>h_{ex}</math> mm</b>								
0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.05 - 0.15 - 0.2	0.1 - 0.15 - 0.25	0.1-0.15-0.2			
<b>Cutting speed <math>v_c</math> m/min</b>								
55-50-45	-	-	55-50-45	60-55-45	-			
40-37-35	-	-	40-38-34	45-39-32	-			
50-50-45	-	-	55-50-45	55-50-40	-			
32-30-27	-	-	34-31-28	35-31-26	-			
40-37-34	-	-	40-37-34	40-38-31	-			
22-19-17	-	-	23-21-18	23-21-17	-			
15-14-12	-	-	17-15-13	17-15-12	-			
14-13-12	-	-	15-14-12	15-14-11	-			
115-105-100	150-135-125	125-115-110	120-105-95	120-110-100	150-135-125			
45-40-38	65-60-55	45-40-39	50-45-39	45-39-36	65-60-55			
34-31-29	50-50-45	38-36-33	40-37-34	37-33-30	55-50-45			
<b>GC3040 GC1010 GC1130 GC1025</b>								
<b>Max chip thickness, <math>h_{ex}</math> mm</b>								
0.1 - 0.2 - 0.25	0.07 - 0.12 - 0.2	0.07-0.12-0.2	0.07-0.12-0.2					
<b>Cutting speed <math>v_c</math> m/min</b>								
45-33-29	110-95-80	40-36-29	40-36-29					
85-65-55	215-185-150	75-70-55	75-70-55					

## Milling with small engagement

ISO P	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	CT530	GC1010	GC3040
							Max chip thickness, $h_{ex}$ mm		
							0.1 - 0.15 - 0.2	0.05 - 0.1 - 0.2	0.1-0.15-0.3
				N/mm <sup>2</sup>	HB		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	500-490-475	-	455-445-415
P1.2.Z.AN	01.2		C = 0.25-0.55%	1600	150	0.25	450-440-430	-	410-400-375
P1.3.Z.AN	01.3		C = 0.55-0.80%	1700	170	0.25	425-415-405	-	385-375-350
P1.3.Z.AN	01.4			1800	210	0.25	370-360-355	-	335-330-305
P1.3.Z.HT	01.5			2000	300	0.25	275-265-260	-	250-245-225
			<b>Low-alloy (alloying elements ≤5%)</b>						
P2.1.Z.AN	02.1		Non-hardened	1700	175	0.25	350-345-335	-	320-310-290
P2.5.Z.HT	02.2		Hardened and tempered	1900	300	0.25	230-225-220	-	205-205-190
			<b>High-alloy (alloying elements &gt;5%)</b>						
P3.0.Z.AN	03.11		Annealed	1950	200	0.25	265-260-255	195-190-185	240-235-220
P3.1.Z.AN	03.13		Hardened tool steel	2150	200	0.25	220-215-210	160-160-150	200-195-185
P3.0.Z.HT	03.21			2900	300	0.25	190-190-185	140-140-135	175-170-160
P3.0.Z.HT	03.22			3100	380	0.25	120-120-115	90-85-85	110-105-100
			<b>Castings</b>						
P1.5.C.UT	06.1		Unalloyed	1400	150	0.25	355-350-340	265-255-245	325-315-295
P2.6.C.UT	06.2		Low-alloy (alloying elements ≤5%)	1600	200	0.25	285-280-275	210-205-195	260-255-235
P3.0.C.UT	06.3		High-alloy (alloying elements >5%)	1950	200	0.25	210-205-200	155-150-145	190-185-175
ISO M	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	CT530	GC1130	GC1025
				N/mm <sup>2</sup>	HB		Max chip thickness, $h_{ex}$ mm		
							0.1 - 0.15 - 0.2	0.05 - 0.1 - 0.2	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	340-335-325	275-270-255	275-270-255
P5.0.Z.PH	05.12		PH-hardened	2850	330	0.21	245-240-235	195-190-180	195-190-180
P5.0.Z.HT	05.13		Hardened	2350	330	0.21	255-250-240	200-195-190	200-195-190
			<b>Austenitic</b>						
M1.0.Z.AQ	05.21		Non-hardened	1950	200	0.21	320-310-300	270-265-255	270-265-255
M1.0.Z.PH	05.22		PH-hardened	2850	330	0.21	235-230-225	190-185-175	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	310-300-295	225-220-210	225-220-210
M3.2.Z.AQ	05.52		Weldable < 0.05%C	2450	260	0.21	275-270-260	190-185-175	190-185-175
			<b>Stainless steel - Cast</b>						
			<b>Ferritic/martensitic</b>						
P5.0.C.UT	15.11		Non-hardened	1700	200	0.25	305-295-290	245-240-230	245-240-230
P5.0.C.PH	15.12		PH-hardened	2450	330	0.25	215-210-205	170-170-160	170-170-160
P5.0.C.HT	15.13		Hardened	2150	330	0.25	235-225-220	185-180-175	185-180-175
			<b>Austenitic</b>						
M1.0.C.UT	15.21		Austenitic	1800	200	0.25	300-295-285	260-250-240	260-250-240
M1.0.C.PH	15.22		PH-hardened	2450	330	0.25	215-210-205	170-170-160	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	295-285-280	215-205-195	215-205-195
M3.2.C.AQ	15.52		Weldable < 0.05%C	2250	260	0.25	255-250-245	175-170-165	175-170-165
ISO K	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$	Hardness Brinell	mc	CB50	CC6190	K20D
				N/mm <sup>2</sup>	HB		Max chip thickness, $h_{ex}$ mm		
							0.1 - 0.15 - 0.2	0.1 - 0.2 - 0.3	0.1-0.2-0.3
							Cutting speed $v_c$ , m/min		
			<b>Malleable cast iron</b>						
			Ferritic (short chipping)	790	130	0.28	-	1500-1450-1400	305-290-280
K1.1.C.NS	07.1		Pearlitic (long chipping)	900	230	0.28	-	1250-1200-1150	250-240-230
			<b>Grey cast iron</b>						
K2.1.C.UT	08.1		Low tensile strength	890	180	0.28	1150-1100-1100	1850-1750-1700	285-270-260
K2.2.C.UT	08.2		High tensile strength	1100	245	0.28	1100-1050-1000	1400-1350-1300	225-215-210
			<b>Nodular cast iron</b>						
K3.1.C.UT	09.1		Ferritic	900	160	0.28	-	1200-1150-1100	210-205-200
K3.3.C.UT	09.2		Pearlitic	1350	250	0.28	630-610-590	980-930-890	195-195-185

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

**Conditions:**

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

GC1025	GC1130	GC4220	GC4330	GC4340	GC2030	GC2040				
Max chip thickness, $h_{ex}$ mm										
0.05-0.1-0.2	0.05-0.1-0.2	0.1-0.15-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.05-0.15-0.25	0.1-0.2-0.3				
Cutting speed $v_c$ , m/min										
365-360-345 330-325-310 310-305-290 270-265-255 200-195-190	405-395-380 365-355-340 345-335-320 300-295-280 220-220-210	570-560-520 510-500-470 485-475-445 425-415-390 310-305-285	465-445-425 420-400-385 395-380-360 345-330-315 255-245-235	395-380-360 355-340-325 335-320-310 295-280-270 220-210-200	340-335-320 305-300-290 290-280-270 255-250-240 185-185-175	340-325-315 305-295-280 290-275-265 255-245-235 185-180-170				
300-295-285 170-165-160	285-280-265 185-180-175	400-390-365 260-255-240	325-315-300 215-205-195	280-265-255 180-175-165	240-235-225 155-155-145	240-230-220 155-150-145				
195-190-185 160-160-150 140-140-135 90-85-85	195-190-185 160-160-150 140-140-135 90-85-85	350-340-320 250-245-230 220-215-200 135-135-125	225-215-205 185-180-170 165-155-150 100-95-95	190-185-175 160-150-145 140-135-125 85-85-80	180-175-170 150-145-140 130-125-120 80-80-75	180-175-165 150-140-135 130-125-120 80-75-75				
265-255-245 210-205-195 155-150-145	265-255-245 210-205-195 155-150-145	410-400-375 325-320-295 240-235-220	305-290-280 240-230-220 175-170-160	255-245-235 205-195-190 150-145-140	240-235-225 195-190-185 145-140-135	240-230-220 195-185-180 145-135-130				
GC1040	S30T	S40T	GC2030	GC2040	GC4330	GC4340	M30B	GC1010		
Max chip thickness, $h_{ex}$ mm										
0.05-0.15-0.25	0.05-0.15-0.25	0.1-0.2-0.25	0.05-0.15-0.25	0.1-0.2-0.25	0.1-0.2-0.25	0.1-0.2-0.3	0.1-0.2-0.4	0.05-0.1-0.2		
Cutting speed $v_c$ , m/min										
210-195-185 145-140-130 155-145-135	285-265-250 200-185-175 210-195-180	295-280-275 205-195-275 215-205-200	260-250-235 185-175-170 195-185-175	285-270-265 195-185-180 205-195-190	325-310-305 225-215-210 235-225-220	250-240-225 165-160-150 190-180-170	275-270-255 195-190-180 200-195-190	340-335-325 245-240-235 255-250-240		
205-190-175 140-135-125 140-130-120	280-260-245 190-180-170 190-180-170	250-235-230 195-185-180 175-165-160	255-245-230 180-170-160 -	240-225-220 190-180-175 -	- - -	220-210-200 160-150-145 -	- - -	320-310-300 235-230-225 190-180-170		
170-160-150 140-130-125	230-215-200 195-180-170	205-195-190 165-160-155	215-205-195 180-170-160	200-190-185 160-155-150	- -	200-190-180 160-155-145	- -	310-300-295 275-270-260		
185-175-165 130-120-110 185-175-170	250-235-220 175-165-155 190-180-165	2-250-235 180-170-165 200-190-185	235-225-210 160-155-145 175-165-160	250-240-235 170-165-160 190-180-175	290-275-270 195-185-185 215-205-200	225-210-200 145-140-130 175-165-155	245-240-230 170-170-160 185-180-175	305-295-290 215-210-205 235-225-220		
195-180-170 130-120-110 125-120-110	265-250-235 175-165-155 175-160-150	240-225-220 180-170-165 155-145-145	245-230-220 160-155-145 -	230-215-210 170-165-160 -	- - -	210-200-190 145-140-130 -	- - -	300-295-285 215-210-205 -		
160-150-140 130-125-115	220-205-190 180-170-160	195-185-180 160-150-145	205-195-185 165-160-150	190-180-175 150-145-140	- -	190-180-170 150-140-135	- -	295-285-280 255-250-245		
GC3220	GC3330	GC3040	K20W	GC4330	GC4340	GC1020	H13A	GC1010	K20M	K15W
Max chip thickness, $h_{ex}$ mm										
0.1-0.15-0.25	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.15-0.25	0.1-0.15-0.25	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
Cutting speed $v_c$ , m/min										
310-305-290 255-250-240	305-290-280 250-240-230	280-270-255 230-220-210	260-250-240 215-205-195	250-245-235 205-200-190	225-220-210 185-185-175	240-230-220 195-190-180	135-130-125 110-110-105	250-245-235 205-200-190	295-290-275 245-240-225	- -
340-330-315 270-265-255	330-315-300 265-255-240	305-290-280 245-235-225	285-270-260 225-215-210	270-265-255 215-210-205	250-240-230 200-195-185	260-250-240 205-200-190	145-140-140 120-115-110	270-265-255 215-210-205	320-315-300 260-250-240	285-270-260 225-215-210
210-205-200 195-195-185	330-315-300 265-255-240	190-185-175 175-170-160	180-170-165 165-160-150	170-165-160 155-155-145	155-150-145 145-140-135	160-155-150 150-145-140	95-90-85 85-85-80	170-165-160 155-155-145	200-195-190 185-185-175	- -

## Milling with small engagement

ISO N	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	CD10	CT530	H10
							Max chip thickness, $h_{ex}$ mm		
							0.1 - 0.15 - 0.2	0.1 - 0.15 - 0.2	0.1-0.15-0.2
							Cutting speed $v_c$ , m/min		
N1.2.Z.UT	30.11		<b>Aluminium alloys</b> Wrought or wrought and coldworked, non-aging	400	60		2100-2100-2050	1150-1150-1100	1050-1050-1000
N1.2.Z.AG	30.12		Wrought or wrought and aged	650	100		1900-1850-1850	1050-1050-1000	950-940-920
N1.3.C.UT	30.21		<b>Aluminium alloys</b> Cast, non-aging	600	75	0.25	2100-2100-2050	1150-1150-1000	1050-1050-1000
N1.3.C.AG	30.22		Cast or cast and aged	700	90	0.25	1900-1900-1850	1050-1050-1100	950-940-920
N1.1.Z.UT	30.3		<b>Aluminium alloys</b> Al >99%	350	30		2150-2100-2050	1150-1150-1150	1050-1050-1050
N1.4.C.NS	30.41	30.42	<b>Aluminium alloys</b> Cast, 13-15% Si Cast, 16-22% Si	700 700	130 130		850-840-820 640-630-620	470-460-450 350-345-340	425-420-410 320-315-310
N3.3.U.UT	33.1		<b>Copper and copper alloys</b> Free cutting alloys, $\geq 1\%$ Pb	550	110	0.25	1050-1050-1050	580-570-560	530-520-510
N3.2.C.UT	33.2		Brass, leaded bronzes, $\leq 1\%$ Pb	550	90		1050-1050-1000	580-570-560	530-520-510
N3.1.U.UT	33.3		Bronze and non-leaded copper incl. electrolytic copper	1350	100	0.25	740-730-720	410-400-395	370-365-360
ISO S	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	GC1025	GC1130	GC1010
							Max chip thickness, $h_{ex}$ mm		
							0.05 - 0.15 - 0.2	0.05-0.15-0.2	0.1-0.15-0.2
							Cutting speed $v_c$ , m/min		
S1.0.U.AN	20.11		<b>Heat resistant super alloys</b> <b>Iron base</b> Annealed or solution treated	2400	200	0.25	70-70-70	70-70-70	-
S1.0.U.AG	20.12		Aged or solution treated and aged	2500	280	0.25	55-50-50	55-50-50	-
S2.0.Z.AN	20.21		<b>Nickel base</b> Annealed or solution treated	2650	250	0.25	70-65-65	70-65-65	-
S2.0.Z.AG	20.22		Aged or solution treated and aged	2900	350	0.25	45-40-40	45-40-40	-
S2.0.C.NS	20.24		Cast or cast and aged	3000	320	0.25	55-50-50	55-50-50	-
S3.0.Z.AN	20.31		<b>Cobalt alloys</b> Annealed or solution treated	2700	200	0.25	30-29-28	30-29-28	-
S3.0.Z.AG	20.32		Solution treated and aged	3000	300	0.25	21-20-20	21-20-20	-
S3.0.C.NS	20.33		Cast or cast and aged	3100	320	0.25	20-19-18	20-19-18	-
S4.1.Z.UT	23.1		<b>Titanium alloys<sup>1)</sup></b> Commercial pure (99,5% Ti)	1300	400	0.23	150-145-140	150-145-140	170-165-160
S4.2.Z.AN	23.21		$\alpha$ , near $\alpha$ and $\alpha + \beta$ alloys, annealed	1400	950	0.23	65-65-65	65-65-65	75-75-70
S4.3.Z.AG	23.22		$\alpha + \beta$ alloys in aged cond., $\beta$ alloys, annealed or aged	1400	1050	0.23	55-50-50	55-50-50	65-60-66
ISO H	MC No.	CMC No.	Material	Specific cutting force $k_{c1}$ N/mm <sup>2</sup>	Hardness Brinell HB	mc	CB50	CT530	GC1025
							Max chip thickness, $h_{ex}$ mm		
							0.07 - 0.12 - 0.2	0.07 - 0.1 - 0.2	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	190-180-175	95-90-85	45-45-45
H2.0.C.UT	10.1		<b>Chilled cast iron</b> Cast or cast and aged	2250	400	0.28	355-345-330	180-175-165	90-85-85

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

2) Rm = ultimate tensile strength measured in MPa.

**Conditions:**

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

GC1025	GC1130	H10F	H13A							
<b>Max chip thickness, <math>h_{ex}</math> mm</b>										
0.1-0.15-0.2	0.1-0.15-0.2	0.1-0.15-0.2	0.1-0.15-0.2							
<b>Cutting speed <math>v_c</math> m/min</b>										
1100-1100-1050	1100-1100-1050	1050-1050-1000	850-830-820							
1000-980-970	1000-980-970	950-940-920	760-750-740							
1100-1100-1050	1100-1100-1050	1050-1050-1000	850-830-820							
110-1100-1100	1100-1100-1100	950-940-920	760-750-740							
1100-1100-1100	1100-1100-1100	1050-1050-1050	850-840-825							
445-440-430	445-440-430	425-420-410	340-335-330							
335-330-325	335-330-325	320-315-310	255-250-245							
560-550-540	560-550-540	530-520-510	425-415-410							
560-550-540	560-550-540	530-520-510	425-415-410							
390-380-375	390-380-375	370-365-360	295-290-285							
<b>H13A H10F S30T S40T GC2030 GC2040</b>										
<b>Max chip thickness, <math>h_{ex}</math> mm</b>										
0.1-0.15-0.2	0.1-0.2-0.3	0.1-0.15-0.2	0.1-0.15-0.2	0.05-0.15-0.2	0.05-0.15-0.25					
<b>Cutting speed <math>v_c</math> m/min</b>										
65-65-65	60-60-60	-	-	65-65-65	70-65-65					
50-50-50	45-45-40	-	-	50-50-45	50-50-45					
65-65-60	60-55-55	-	-	65-60-60	65-65-60					
40-39-38	36-35-33	-	-	40-38-38	40-39-38					
50-50-50	45-45-40	-	-	50-45-45	50-50-45					
28-27-26	26-24-23	-	-	28-27-26	28-27-26					
20-19-19	18-17-16	-	-	20-19-19	20-19-19					
19-19-18	17-16-16	-	-	19-18-17	19-18-17					
140-140-135	130-125-120	170-165-160	145-145-140	140-135-130	145-140-135					
55-55-55	50-50-45	75-75-70	55-50-50	55-55-55	50-50-50					
45-40-40	38-37-36	65-60-66	45-45-45	50-45-45	45-40-40					
<b>GC4220 GC3040 GC1010 GC1130</b>										
<b>Max chip thickness, <math>h_{ex}</math> mm</b>										
0.1-0.12-0.25	0.1-0.2-0.25	0.07-0.12-0.2	0.07-0.12-0.2							
<b>Cutting speed <math>v_c</math> m/min</b>										
65-65-60	55-50-50	130-125-120	45-45-45							
125-125-115	100-95-95	250-240-230	90-85-85							

## Face milling tools



## CoroMill® 345

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
345L-1305M-PM	0.3	(0.16-0.4)	0.21	(0.11-0.28)
345R-1305E-KL	0.11	(0.07-0.2)	0.08	(0.05-0.14)
345R-1305E-KM	0.3	(0.16-0.4)	0.21	(0.11-0.28)
345R-1305E-PL	0.11	(0.07-0.2)	0.08	(0.05-0.14)
345R-1305M-KH	0.35	(0.3-0.49)	0.25	(0.21-0.35)
345R-1305M-KL	0.16	(0.07-0.23)	0.11	(0.05-0.16)
345R-1305M-KM	0.3	(0.16-0.4)	0.21	(0.11-0.28)
345R-1305M-PH	0.45	(0.35-0.55)	0.32	(0.25-0.39)
345R-1305M-PL	0.17	(0.07-0.21)	0.12	(0.05-0.15)
345R-1305M-PM	0.3	(0.16-0.4)	0.21	(0.11-0.28)
345R-13T5E-ML	0.11	(0.07-0.2)	0.08	(0.05-0.14)
345R-13T5E-MM	0.11	(0.07-0.2)	0.08	(0.05-0.14)
345R-13T5M-MM	0.25	(0.16-0.34)	0.18	(0.11-0.24)

## CoroMill® 245

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
R245-12T3E	0.24	(0.1-0.28)	0.1	(0.06-0.15)
R245-12T3E-AL	0.24	(0.1-0.28)	0.17	(0.07-0.2)
R245-12T3E-KL	0.14	(0.08-0.21)	0.1	(0.06-0.15)
R245-12T3E-ML	0.14	(0.08-0.21)	0.1	(0.06-0.15)
R245-12T3E-PL	0.14	(0.08-0.21)	0.1	(0.06-0.15)
R245-12T3K-MM	0.23	(0.1-0.28)	0.16	(0.07-0.2)
R245-12T3M-KH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
R245-12T3M-KL	0.17	(0.08-0.21)	0.12	(0.06-0.15)
R245-12T3M-KM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
R245-12T3M-PH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
R245-12T3M-PL	0.17	(0.08-0.21)	0.12	(0.06-0.15)
R245-12T3M-PM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
R245-18T6M-KM	0.28	(0.16-0.49)	0.2	(0.11-0.35)
R245-18T6M-MM	0.28	(0.16-0.49)	0.2	(0.11-0.35)
R245-18T6M-PM	0.28	(0.16-0.49)	0.2	(0.11-0.35)

## CoroMill® 419

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
419N-140530E-SM	0.61	(0.4-1.2)	0.2	(0.13-0.39)
419N-140530M-KH	0.98	(0.49-2)	0.32	(0.16-0.65)
419R-1405E-MM	0.71	(0.34-1.2)	0.23	(0.11-0.39)
419R-1405M-PH	0.98	(0.46-2)	0.32	(0.15-0.65)
419R-1405M-PM	0.8	(0.4-1.78)	0.26	(0.13-0.58)

## CoroMill® 210

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
R210-090412M-KM	0.98	(0.4-1.5)	0.17	(0.07-0.26)
R210-090412M-MM	1.5	(0.4-2.02)	0.26	(0.07-0.35)
R210-090412M-PM	0.98	(0.4-1.5)	0.17	(0.07-0.26)
R210-090414E-KM	1.5	(0.4-2.02)	0.26	(0.07-0.35)
R210-090414E-MM	1.5	(0.4-2.02)	0.26	(0.07-0.35)
R210-090414E-PM	1.5	(0.4-2.02)	0.26	(0.07-0.35)
R210-140512M-KM	1.5	(0.4-2.02)	0.26	(0.07-0.35)
R210-140512M-MM	2.02	(0.4-2.99)	0.35	(0.07-0.52)
R210-140512M-PM	1.5	(0.4-2.02)	0.26	(0.07-0.35)
R210-140514E-KM	1.5	(0.4-2.02)	0.26	(0.07-0.35)
R210-140514E-MM	2.02	(0.4-2.99)	0.35	(0.07-0.52)
R210-140514E-PM	1.5	(0.4-2.02)	0.26	(0.07-0.35)



# Face milling tools

## CoroMill® 415



Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
415N-050206M-M30	0.39	(0.3-0.5)	0.1	(0.08-0.13)
415N-070310M-M30	0.46	(0.35-0.55)	0.12	(0.09-0.14)
415N-070320E-M30	0.46	(0.35-0.55)	0.12	(0.09-0.14)
415N-070320M-M30	0.46	(0.35-0.55)	0.12	(0.09-0.14)
415N-050212E-M30	0.39	(0.35-0.55)	0.1	(0.08-0.13)
415N-050212M-M30	0.39	(0.35-0.55)	0.1	(0.08-0.13)

## CoroMill® 425

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
425N-1707E-KLW12	0.19	(0.02-0.28)	0.08	(0.01-0.12)

## CoroMill® 745

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
745L-2109E-M50	0.25	(0.18-0.42)	0.17	(0.12-0.28)
*	0.61	(0.44-1.02)	0.17	(0.12-0.28)
745R-2109E-H50	0.3	(0.21-0.45)	0.2	(0.11-0.3)
*	0.73	(0.51-1.09)	0.2	(0.14-0.30)
745R-2109E-M30	0.21	(0.15-0.3)	0.14	(0.4-0.2)
*	0.51	(0.36-0.73)	0.14	(0.10-0.20)
745R-2109E-M31	0.21	(0.15-0.3)	0.14	(0.1-0.2)
745R-2109E-M50	0.25	(0.18-0.42)	0.17	(0.12-0.28)
*	0.61	(0.44-0.90)	0.17	(0.12-0.28)

\* High feed cutter

# Shoulder milling tools

## CoroMill® 490

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
490L-140408M-PM	0.17	(0.12-0.25)	0.17	(0.12-0.25)
490R-08T304E-ML	0.13	(0.08-0.18)	0.13	(0.08-0.18)
490R-08T304M-KL	0.12	(0.05-0.15)	0.12	(0.05-0.15)
490R-08T304M-PL	0.08	(0.05-0.12)	0.08	(0.05-0.12)
490R-08T308E-ML	0.14	(0.08-0.18)	0.14	(0.08-0.18)
490R-08T308E-MM	0.17	(0.12-0.22)	0.17	(0.12-0.22)
490R-08T308M-KH	0.24	(0.15-0.3)	0.24	(0.15-0.3)
490R-08T308M-KL	0.12	(0.05-0.15)	0.12	(0.05-0.15)
490R-08T308M-KM	0.17	(0.1-0.2)	0.17	(0.1-0.2)
490R-08T308M-MM	0.16	(0.1-0.2)	0.16	(0.1-0.2)
490R-08T308M-PH	0.2	(0.15-0.25)	0.2	(0.15-0.25)
490R-08T308M-PL	0.1	(0.05-0.15)	0.1	(0.05-0.15)
490R-08T308M-PM	0.15	(0.1-0.2)	0.15	(0.1-0.2)
490R-08T312E-MM	0.17	(0.12-0.22)	0.17	(0.12-0.22)
490R-08T312M-KM	0.17	(0.1-0.2)	0.17	(0.1-0.2)
490R-08T312M-PM	0.14	(0.08-0.18)	0.14	(0.08-0.18)
490R-08T316E-MM	0.17	(0.12-0.22)	0.17	(0.12-0.22)
490R-08T316M-KH	0.24	(0.15-0.3)	0.24	(0.15-0.3)
490R-08T316M-KM	0.17	(0.1-0.2)	0.17	(0.1-0.2)
490R-08T316M-PH	0.21	(0.15-0.25)	0.21	(0.15-0.25)
490R-08T316M-PM	0.14	(0.08-0.18)	0.14	(0.08-0.18)
490R-140408E	0.1	(0.08-0.15)	0.1	(0.08-0.15)
490R-140408E-ML	0.14	(0.08-0.18)	0.14	(0.08-0.18)
490R-140408E-MM	0.17	(0.12-0.22)	0.17	(0.12-0.22)
490R-140408M-MM	0.16	(0.12-0.2)	0.16	(0.12-0.2)
490R-140408M-PH	0.28	(0.2-0.35)	0.28	(0.2-0.35)
490R-140408M-PL	0.1	(0.05-0.15)	0.1	(0.05-0.15)
490R-140408M-PM	0.17	(0.12-0.25)	0.17	(0.12-0.25)
490R-140412E-MM	0.17	(0.12-0.22)	0.17	(0.12-0.22)
490R-140412M-PM	0.17	(0.12-0.25)	0.17	(0.12-0.25)
490R-140416E-MM	0.17	(0.12-0.22)	0.17	(0.12-0.22)
490R-140416M-PM	0.17	(0.12-0.25)	0.17	(0.12-0.25)
490R-140420E	0.1	(0.08-0.15)	0.1	(0.08-0.15)
490R-140420E-MM	0.16	(0.12-0.2)	0.17	(0.12-0.22)
490R-140420M-MM	0.16	(0.12-0.2)	0.16	(0.12-0.2)
490R-140420M-PH	0.28	(0.2-0.35)	0.28	(0.2-0.35)
490R-140420M-PM	0.17	(0.12-0.25)	0.17	(0.12-0.25)

## Shoulder milling tools



CoroMill® 390

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
390R-070202E-ML	0.05	(0.02-0.07)	0.05	(0.02-0.07)
390R-070202E-NL	0.1	(0.02-0.2)	0.1	(0.02-0.2)
390R-070202E-PL	0.05	(0.02-0.07)	0.05	(0.02-0.07)
390R-070202M-MM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070202M-PM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070204E-KL	0.07	(0.03-0.1)	0.05	(0.02-0.07)
390R-070204E-ML	0.05	(0.02-0.07)	0.05	(0.02-0.07)
390R-070204E-MM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070204E-NL	0.05	(0.02-0.07)	0.1	(0.02-0.2)
390R-070204E-PL	0.05	(0.02-0.07)	0.05	(0.02-0.07)
390R-070204M-KM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070204M-MM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070204M-PM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070208E-KL	0.07	(0.03-0.1)	0.05	(0.02-0.07)
390R-070208E-ML	0.05	(0.02-0.07)	0.05	(0.02-0.07)
390R-070208E-MM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070208E-NL	0.05	(0.02-0.07)	0.1	(0.02-0.2)
390R-070208E-PL	0.05	(0.02-0.07)	0.05	(0.02-0.07)
390R-070208M-KM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070208M-MM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070208M-PM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070212E-ML	0.07	(0.03-0.1)	0.05	(0.02-0.07)
390R-070212E-PL	0.05	(0.02-0.07)	0.05	(0.02-0.07)
390R-070212M-MM	0.1	(0.02-0.2)	0.07	(0.03-0.1)
390R-070212M-PM	0.07	(0.03-0.1)	0.07	(0.03-0.1)
390R-070216E-ML	0.07	(0.03-0.1)	0.05	(0.02-0.07)
390R-070216E-PL	0.07	(0.03-0.1)	0.05	(0.02-0.07)
390R-070216M-KM	0.05	(0.02-0.07)	0.07	(0.03-0.1)
390R-070216M-MM	0.1	(0.02-0.2)	0.07	(0.03-0.1)
390R-070216M-PM	0.12	(0.08-0.2)	0.07	(0.03-0.1)
R390-11T302E-KM	0.1	(0.08-0.15)	0.1	(0.08-0.18)
R390-11T302E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T302E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T304E-PL	0.08	(0.05-0.15)	0.08	(0.05-0.15)
R390-11T304M-KM	0.1	(0.08-0.15)	0.1	(0.08-0.15)
R390-11T304M-PM	0.1	(0.08-0.15)	0.1	(0.08-0.15)
R390-11T308E-KL	0.08	(0.05-0.15)	0.08	(0.05-0.15)
R390-11T308E-ML	0.08	(0.04-0.15)	0.08	(0.04-0.15)
R390-11T308E-NL	0.18	(0.06-0.35)	0.15	(0.05-0.25)
R390-11T308E-PL	0.08	(0.05-0.15)	0.08	(0.05-0.15)
R390-11T308E-PLW	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T308M-KL	0.08	(0.05-0.15)	0.08	(0.05-0.15)
R390-11T308M-KM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T308M-MM	0.13	(0.08-0.2)	0.13	(0.08-0.2)
R390-11T308M-PL	0.08	(0.05-0.15)	0.08	(0.05-0.15)
R390-11T308M-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T310M-KH	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T310M-MH	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T310M-PH	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T312E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-11T312E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T312E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T316E-KM	0.15	(0.1-0.25)	0.1	(0.08-0.18)
R390-11T316E-ML	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T316E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T316E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T316M-KM	0.12	(0.08-0.2)	0.15	(0.1-0.25)
R390-11T316M-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T320E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-11T320E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T320E-NL	0.18	(0.06-0.4)	0.18	(0.06-0.35)
R390-11T320E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T324E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-11T324E-ML	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T324E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T324E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T331E-KM	0.15	(0.1-0.25)	0.1	(0.08-0.18)
R390-11T331E-ML	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T331E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T331E-NL	0.18	(0.06-0.4)	0.18	(0.06-0.4)
R390-11T331E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T331M-KM	0.12	(0.08-0.2)	0.15	(0.1-0.25)

## Shoulder milling tools



## CoroMill® 390

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{\text{ex}}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
R390-11T331M-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-11T304E-P4-NL	0.17	(0.1-0.2)	0.17	(0.1-0.2)
R390-170404E-KM	0.1	(0.08-0.15)	0.1	(0.08-0.18)
R390-170404E-MM	0.15	(0.08-0.2)	0.12	(0.08-0.2)
R390-170404E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170404M-KM	0.1	(0.08-0.15)	0.1	(0.08-0.15)
R390-170404M-PM	0.1	(0.08-0.15)	0.1	(0.08-0.15)
R390-170408E-KL	0.08	(0.05-0.15)	0.08	(0.05-0.15)
R390-170408E-ML	0.08	(0.04-0.15)	0.08	(0.04-0.15)
R390-170408E-NL	0.17	(0.1-0.2)	0.15	(0.08-0.25)
R390-170408E-PL	0.08	(0.05-0.15)	0.08	(0.05-0.15)
R390-170408M-KH	0.2	(0.15-0.35)	0.2	(0.15-0.35)
R390-170408M-KL	0.08	(0.05-0.15)	0.08	(0.05-0.15)
R390-170408M-KM	0.15	(0.1-0.25)	0.15	(0.1-0.25)
R390-170408M-MM	0.15	(0.08-0.2)	0.15	(0.08-0.2)
R390-170408M-PH	0.2	(0.15-0.35)	0.2	(0.15-0.35)
R390-170408M-PL	0.08	(0.05-0.15)	0.08	(0.05-0.15)
R390-170408M-PM	0.15	(0.1-0.25)	0.15	(0.1-0.25)
R390-170412E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-170412E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170412E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170416E-KM	0.15	(0.1-0.25)	0.1	(0.08-0.18)
R390-170416E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170416E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170416M-KM	0.12	(0.08-0.2)	0.15	(0.1-0.25)
R390-170416M-PH	0.2	(0.15-0.35)	0.2	(0.15-0.35)
R390-170416M-PM	0.15	(0.1-0.25)	0.15	(0.1-0.25)
R390-170420E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-170420E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170420E-NL	0.2	(0.12-0.32)	0.2	(0.1-0.3)
R390-170420E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170424E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-170424E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170424E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170431E-KM	0.15	(0.1-0.25)	0.1	(0.08-0.18)
R390-170431E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170431E-NL	0.2	(0.12-0.32)	0.2	(0.12-0.32)
R390-170431E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170431M-KM	0.12	(0.08-0.2)	0.15	(0.1-0.25)
R390-170431M-PM	0.15	(0.1-0.25)	0.15	(0.1-0.25)
R390-170440E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-170440E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170440E-NL	0.2	(0.12-0.4)	0.2	(0.12-0.32)
R390-170440E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170448E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-170448E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170448E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170450E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-170450E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170450E-NL	0.2	(0.12-0.4)	0.2	(0.12-0.4)
R390-170450E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170460E-KM	0.1	(0.08-0.18)	0.1	(0.08-0.18)
R390-170460E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170460E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170464E-KM	0.08	(0.04-0.15)	0.1	(0.08-0.18)
R390-170464E-MM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170464E-PM	0.12	(0.08-0.2)	0.12	(0.08-0.2)
R390-170408E-P6-NL	0.17	(0.1-0.2)	0.17	(0.1-0.2)
R390-180608H-KL	0.11	(0.05-0.22)	0.11	(0.05-0.22)
R390-180608H-ML	0.11	(0.05-0.22)	0.11	(0.05-0.22)
R390-180608H-PL	0.11	(0.05-0.22)	0.11	(0.05-0.22)
R390-180608M-KM	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180608M-MM	0.18	(0.1-0.3)	0.18	(0.1-0.3)
R390-180608M-PM	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180612H-KL	0.11	(0.05-0.22)	0.11	(0.05-0.22)
R390-180612H-ML	0.11	(0.05-0.22)	0.11	(0.05-0.22)
R390-180612H-PL	0.11	(0.05-0.22)	0.11	(0.05-0.22)
R390-180612M-KM	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180612M-KMR	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180612M-MM	0.18	(0.1-0.3)	0.18	(0.1-0.3)
R390-180612M-MMR	0.18	(0.1-0.3)	0.18	(0.1-0.3)
R390-180612M-PM	0.2	(0.08-0.3)	0.2	(0.08-0.3)

## Shoulder milling tools



## CoroMill® 390

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
R390-180612M-PMR	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180616H-ML	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180616H-PL	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180616M-KM	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180616M-MM	0.18	(0.1-0.3)	0.18	(0.1-0.3)
R390-180616M-PM	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180620H-ML	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180620H-PL	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180620M-KM	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180620M-MM	0.18	(0.1-0.3)	0.18	(0.1-0.3)
R390-180620M-PM	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180624H-ML	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180624H-PL	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180631H-KL	0.11	(0.05-0.22)	0.11	(0.05-0.22)
R390-180631H-ML	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180631H-PL	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180631M-KM	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180631M-MM	0.18	(0.1-0.3)	0.18	(0.1-0.3)
R390-180631M-PM	0.2	(0.08-0.3)	0.2	(0.08-0.3)
R390-180640H-ML	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180640H-PL	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180650H-ML	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180650H-PL	0.12	(0.05-0.22)	0.12	(0.05-0.22)
R390-180660H-ML	0.14	(0.05-0.22)	0.14	(0.05-0.22)
R390-180660H-PL	0.14	(0.05-0.22)	0.14	(0.05-0.22)
R390-180664H-ML	0.14	(0.05-0.22)	0.14	(0.05-0.22)
R390-180664H-PL	0.14	(0.05-0.22)	0.14	(0.05-0.22)

## CoroMill® 690

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
690-100508M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-100510M-P-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-100512M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-100516M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-100520M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-100531M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140608M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140610M-P-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140612M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140616M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140620M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140624M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140631M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140650M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140660M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)
690-140664M-E-SL	0.1	(0.05-0.2)	0.1	(0.05-0.2)

## CoroMill® Century

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
R590-110504H-NL	0.15	(0.05-0.3)	0.2	(0.1-0.4)
R590-110508H-KL	0.12	(0.07-0.2)	0.08	(0.05-0.15)
R590-110508H-PL	0.12	(0.01-0.15)	0.08	(0.05-0.15)
R590-110508H-PR2-KM	0.2	(0.1-0.4)	0.2	(0.1-0.3)
R590-1105H-PC2-NL	0.15	(0.05-0.3)	0.15	(0.05-0.3)
R590-1105H-PC5-NL	0.15	(0.05-0.3)	0.15	(0.05-0.3)
R590-1105H-PR2-NL	0.15	(0.05-0.3)	0.15	(0.05-0.3)
R590-1105H-PR5-NL	0.15	(0.05-0.3)	0.15	(0.05-0.3)
R590-1105H-PS2-NL	0.15	(0.05-0.3)	0.15	(0.05-0.3)
R590-1105H-PS5-NL	0.15	(0.05-0.3)	0.15	(0.05-0.3)
L590-1105H-ZC2-KL	0.08	(0.05-0.15)	0.2	(0.1-0.3)
R590-1105H-ZC2-KL	0.2	(0.1-0.3)	0.2	(0.1-0.3)

## Disc milling tools



## CoroMill® 331

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
L331.1A-115030E-L50	0.10	(0.02-0.12)	0.08	(0.02-0.10)
L331.1A-115040E-L50	0.10	(0.02-0.12)	0.08	(0.02-0.10)
L331.1A-115048E-L50	0.10	(0.02-0.12)	0.08	(0.02-0.10)
L331.1A-115063E-L50	0.10	(0.02-0.12)	0.08	(0.02-0.10)
L331.1A-115015E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
L331.1A-115023E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
L331.1A-115030E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
L331.1A-043515H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-043523H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-054515H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-054523H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-054530H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-084515H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-084523H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-084530H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-115015H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-115023H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-115030H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-115048H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-115063H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-145015H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-145023H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-145030H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-145048H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
L331.1A-145063H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-115030E-L50	0.10	(0.02-0.12)	0.08	(0.02-0.10)
R331.1A-115040E-L50	0.10	(0.02-0.12)	0.08	(0.02-0.10)
R331.1A-115048E-L50	0.10	(0.02-0.12)	0.08	(0.02-0.10)
R331.1A-115063E-L50	0.10	(0.02-0.12)	0.08	(0.02-0.10)
R331.1A-115015E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
R331.1A-115023E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
R331.1A-115030E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
R331.1A-043515H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-043523H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-054515H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-054523H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-054530H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-084515H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-084523H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-084530H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-115015H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-115023H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-115030H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-115048H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-115063H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-145015H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-145023H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-145030H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-145048H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
R331.1A-145063H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-043505E-L30	0.06	(0.01-0.08)	0.05	(0.01-0.07)
N331.1A-043505E-L50	0.10	(0.02-0.18)	0.08	(0.02-0.15)
N331.1A-043505E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
N331.1A-054508E-L30	0.06	(0.01-0.08)	0.05	(0.01-0.07)
N331.1A-054508E-L50	0.10	(0.02-0.18)	0.08	(0.02-0.15)
N331.1A-054508E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
N331.1A-084508E-L30	0.06	(0.01-0.08)	0.05	(0.01-0.07)
N331.1A-084508E-L50	0.10	(0.02-0.18)	0.08	(0.02-0.15)
N331.1A-084508E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
N331.1A-115008E-L30	0.06	(0.01-0.08)	0.05	(0.01-0.07)
N331.1A-115008E-L50	0.10	(0.02-0.18)	0.08	(0.02-0.15)
N331.1A-115008E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
N331.1A-145008E-L30	0.06	(0.01-0.08)	0.05	(0.01-0.07)
N331.1A-145008E-L50	0.10	(0.02-0.18)	0.08	(0.02-0.15)
N331.1A-145008E-M30	0.14	(0.05-0.20)	0.12	(0.04-0.17)
N331.1A-043505H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-054508H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-084508H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-115008H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-145008H-WL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-084508H-WM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-115008H-WM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-145008H-WM	0.15	(0.06-0.3)	0.13	(0.05-0.25)

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
N331.1A-043505H-ML	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-054508H-ML	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-084508H-ML	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-115008H-ML	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-145008H-ML	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-043505H-MM	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-054508H-MM	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-084508H-MM	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-115008H-MM	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-145008H-MM	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-043505H-NL	0.12	(0.01-0.18)	0.1	(0.01-0.15)
N331.1A-054508H-NL	0.12	(0.01-0.18)	0.1	(0.01-0.15)
N331.1A-084508H-NL	0.12	(0.01-0.18)	0.1	(0.01-0.15)
N331.1A-115008H-NL	0.12	(0.01-0.18)	0.1	(0.01-0.15)
N331.1A-145008H-NL	0.12	(0.01-0.18)	0.1	(0.01-0.15)
N331.1A-043505H-PL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-054508H-PL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-084508H-PL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-115008H-PL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-145008H-PL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-054508H-PM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-084508H-PM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-115008H-PM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-145008H-PM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-043505E-KL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-054508E-KL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-084508E-KL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-115008E-KL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-145008E-KL	0.12	(0.08-0.18)	0.1	(0.03-0.15)
N331.1A-054508E-KM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-084508E-KM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-115008E-KM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-145008E-KM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-043505M-KM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-054508M-KM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-084508M-KM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-115008M-KM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-145008M-KM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1D-136508E-PM	0.20	(0.08-0.24)	0.17	(0.07-0.2)
N331.1D-136508M-PM	0.20	(0.08-0.24)	0.17	(0.07-0.2)
N331.1D-136512M-PM	0.20	(0.08-0.24)	0.17	(0.07-0.2)
N331.1D-136520E-PM	0.20	(0.08-0.24)	0.17	(0.07-0.2)
N331.1D-136520M-PM	0.20	(0.08-0.24)	0.17	(0.07-0.2)

DC/AR ratio = 12% (same for all 90 degree concepts)

## Profile milling tools

## CoroMill® 300

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{bx}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
R300-0517E-PM	0.08	(0.05-0.12)	0.08	(0.05-0.12)
R300-0720E-MM	0.1	(0.05-0.15)	0.1	(0.05-0.15)
R300-0720E-PM	0.1	(0.05-0.15)	0.1	(0.05-0.15)
R300-0724E-MM	0.1	(0.05-0.15)	0.1	(0.05-0.15)
R300-0724E-PM	0.1	(0.05-0.15)	0.1	(0.05-0.15)
R300-0828E-KL	0.13	(0.05-0.2)	0.11	(0.05-0.15)
R300-0828E-KM	0.15	(0.07-0.25)	0.13	(0.05-0.2)
R300-0828E-MM	0.13	(0.07-0.2)	0.13	(0.05-0.2)
R300-0828E-PL	0.11	(0.05-0.15)	0.11	(0.05-0.15)
R300-0828E-PM	0.13	(0.05-0.2)	0.13	(0.05-0.2)
R300-0828M-KH	0.15	(0.07-0.25)	0.15	(0.07-0.25)
R300-0828M-MH	0.13	(0.05-0.2)	0.15	(0.07-0.25)
R300-0828M-MM	0.13	(0.07-0.2)	0.13	(0.07-0.2)
R300-0828M-PH	0.15	(0.07-0.25)	0.15	(0.07-0.25)
R300-0828M-PM	0.13	(0.07-0.2)	0.13	(0.07-0.2)
R300-0932E-MM	0.15	(0.07-0.23)	0.13	(0.04-0.2)
R300-0932E-PM	0.15	(0.05-0.23)	0.13	(0.04-0.2)
R300-0932M-PH	0.17	(0.07-0.29)	0.15	(0.06-0.25)
R300-0932M-PM	0.15	(0.07-0.23)	0.13	(0.06-0.2)
R300-1032E-KL	0.21	(0.05-0.29)	0.13	(0.04-0.15)
R300-1032E-MM	0.17	(0.07-0.29)	0.18	(0.04-0.25)
R300-1032E-PL	0.15	(0.05-0.17)	0.13	(0.04-0.15)
R300-1032E-PM	0.21	(0.05-0.29)	0.18	(0.04-0.25)
R300-1032M-KH	0.23	(0.07-0.35)	0.2	(0.06-0.3)
R300-1032M-MH	0.23	(0.07-0.35)	0.2	(0.06-0.3)
R300-1032M-MM	0.17	(0.07-0.29)	0.15	(0.06-0.25)
R300-1032M-PH	0.23	(0.07-0.35)	0.2	(0.06-0.3)
R300-1032M-PM	0.17	(0.07-0.29)	0.15	(0.06-0.25)
R300-1240E-KM	0.23	(0.07-0.35)	0.18	(0.04-0.25)
R300-1240E-ML	0.15	(0.05-0.23)	0.13	(0.04-0.2)
R300-1240E-MM	0.21	(0.05-0.29)	0.18	(0.04-0.25)
R300-1240E-PL	0.15	(0.05-0.23)	0.13	(0.04-0.2)
R300-1240E-PM	0.21	(0.05-0.29)	0.18	(0.04-0.25)
R300-1240M-KH	0.23	(0.07-0.35)	0.2	(0.06-0.3)
R300-1240M-MH	0.23	(0.07-0.35)	0.2	(0.06-0.3)
R300-1240M-MM	0.17	(0.07-0.29)	0.15	(0.06-0.25)
R300-1240M-PH	0.23	(0.07-0.35)	0.2	(0.06-0.3)
R300-1240M-PM	0.17	(0.07-0.29)	0.15	(0.06-0.25)
R300-1340E-ML	0.15	(0.05-0.23)	0.13	(0.04-0.2)
R300-1340E-MM	0.21	(0.05-0.29)	0.18	(0.04-0.25)
R300-1340E-PL	0.15	(0.05-0.23)	0.13	(0.04-0.2)
R300-1340E-PM	0.21	(0.05-0.29)	0.18	(0.04-0.25)
R300-1340M-KH	0.23	(0.07-0.35)	0.2	(0.06-0.3)
R300-1340M-MH	0.23	(0.07-0.35)	0.2	(0.06-0.3)
R300-1340M-MM	0.17	(0.07-0.29)	0.15	(0.06-0.25)

## Profile milling tools



## CoroMill® 300

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
R300-1340M-PH	0.23	(0.07-0.35)	0.2	(0.06-0.3)
R300-1340M-PM	0.17	(0.07-0.29)	0.15	(0.06-0.25)
R300-1648E-KM	0.29	(0.07-0.46)	0.2	(0.04-0.3)
R300-1648E-ML	0.17	(0.05-0.23)	0.15	(0.04-0.2)
R300-1648E-MM	0.21	(0.07-0.29)	0.2	(0.04-0.3)
R300-1648E-PL	0.17	(0.05-0.23)	0.15	(0.04-0.2)
R300-1648E-PM	0.23	(0.05-0.35)	0.2	(0.04-0.3)
R300-1648M-KH	0.29	(0.07-0.46)	0.25	(0.06-0.4)
R300-1648M-MH	0.29	(0.07-0.46)	0.25	(0.06-0.4)
R300-1648M-MM	0.21	(0.07-0.29)	0.18	(0.06-0.25)
R300-1648M-PH	0.29	(0.07-0.46)	0.25	(0.06-0.4)
R300-1648M-PM	0.21	(0.07-0.29)	0.18	(0.06-0.25)
R300-2060E-ML	0.28	(0.06-0.35)	0.2	(0.04-0.25)
R300-2060E-MM	0.35	(0.06-0.57)	0.25	(0.04-0.4)
R300-2060E-PL	0.28	(0.06-0.35)	0.2	(0.04-0.25)
R300-2060E-PM	0.35	(0.06-0.57)	0.25	(0.04-0.4)
R300-2060M-KH	0.49	(0.07-0.78)	0.35	(0.05-0.55)
R300-2060M-MH	0.49	(0.07-0.78)	0.35	(0.05-0.55)
R300-2060M-MM	0.28	(0.07-0.42)	0.2	(0.05-0.3)
R300-2060M-PH	0.49	(0.07-0.78)	0.35	(0.05-0.55)
R300-2060M-PM	0.28	(0.07-0.42)	0.2	(0.05-0.3)
R300-2570E-ML	0.31	(0.06-0.4)	0.22	(0.04-0.28)
R300-2570E-PL	0.31	(0.06-0.4)	0.22	(0.04-0.28)
R300-2570M-KH	0.57	(0.07-0.85)	0.4	(0.05-0.6)
R300-2570M-MM	0.31	(0.07-0.47)	0.22	(0.05-0.33)
R300-2570M-PH	0.57	(0.07-0.85)	0.4	(0.05-0.6)
R300-2570M-PM	0.31	(0.07-0.47)	0.22	(0.05-0.33)

## CoroMill® 600

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

## CoroMill® 216

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
APMT160408-M	0.35	(0.14-0.7)	0.25	(0.1-0.5)
R216-1002E-M	0.14	(0.06-0.21)	0.1	(0.04-0.15)
R216-1202E-M	0.14	(0.06-0.21)	0.1	(0.04-0.15)
R216-1202M-M	0.14	(0.08-0.21)	0.1	(0.04-0.15)
R216-1603E-M	0.14	(0.06-0.21)	0.1	(0.04-0.15)
R216-1603M-M	0.14	(0.08-0.21)	0.1	(0.06-0.15)
R216-20T3E-M	0.21	(0.06-0.25)	0.15	(0.04-0.18)
R216-20T3M-M	0.14	(0.08-0.21)	0.1	(0.06-0.15)
R216-2504E-M	0.21	(0.06-0.25)	0.15	(0.04-0.18)
R216-2504M-M	0.17	(0.08-0.21)	0.12	(0.06-0.15)
R216-3006E-M	0.24	(0.06-0.28)	0.17	(0.04-0.2)
R216-3006M-M	0.21	(0.08-0.28)	0.15	(0.06-0.2)
R216-3206E-M	0.24	(0.06-0.28)	0.17	(0.04-0.2)
R216-3206M-M	0.21	(0.08-0.28)	0.15	(0.06-0.2)
R216-4007E-M	0.28	(0.06-0.35)	0.2	(0.04-0.25)
R216-4007M-M	0.28	(0.1-0.42)	0.2	(0.07-0.3)
R216-5007E-M	0.28	(0.06-0.35)	0.2	(0.04-0.25)
R216-5007M-M	0.35	(0.1-0.7)	0.25	(0.07-0.5)



## Profile milling tools



## CoroMill® 200

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
RCHT09T300-ML	0.15	(0.08-0.2)	0.15	(0.08-0.2)
RCHT09T300-PL	0.1	(0.08-0.15)	0.1	(0.08-0.15)
RCHT10T3M0-KL	0.17	(0.1-0.2)	0.1	(0.08-0.15)
RCHT10T3M0-ML	0.15	(0.08-0.2)	0.15	(0.08-0.2)
RCHT10T3M0-PL	0.1	(0.08-0.15)	0.1	(0.08-0.15)
RCHT1204M0	0.21	(0.1-0.42)	0.1	(0.08-0.15)
RCHT1204M0-KL	0.24	(0.1-0.28)	0.1	(0.06-0.15)
RCHT1204M0-PL	0.14	(0.08-0.21)	0.1	(0.06-0.15)
RCHT130400-KL	0.24	(0.1-0.28)	0.1	(0.06-0.15)
RCHT130400-ML	0.21	(0.08-0.28)	0.15	(0.06-0.2)
RCHT130400-PL	0.14	(0.08-0.21)	0.1	(0.06-0.15)
RCHT1606M0-KL	0.24	(0.1-0.28)	0.1	(0.06-0.15)
RCHT1606M0-ML	0.21	(0.08-0.28)	0.15	(0.06-0.2)
RCHT1606M0-PL	0.14	(0.08-0.21)	0.1	(0.06-0.15)
RCHT190600-ML	0.21	(0.08-0.28)	0.15	(0.06-0.2)
RCHT190600-PL	0.14	(0.08-0.21)	0.1	(0.06-0.15)
RCHT2006M0-KL	0.24	(0.1-0.28)	0.1	(0.06-0.15)
RCHT2006M0-ML	0.21	(0.08-0.28)	0.15	(0.06-0.2)
RCHT2006M0-PL	0.14	(0.08-0.21)	0.1	(0.06-0.15)
RCHT1204M0-ML	0.21	(0.08-0.28)	0.15	(0.06-0.2)
RCKT09T300-KH	0.25	(0.1-0.3)	0.25	(0.1-0.3)
RCKT09T300-MM	0.2	(0.1-0.3)	0.2	(0.1-0.3)
RCKT09T300-PH	0.25	(0.1-0.3)	0.25	(0.1-0.3)
RCKT09T300-PM	0.17	(0.1-0.2)	0.17	(0.1-0.2)
RCKT10T3M0-KH	0.25	(0.1-0.3)	0.25	(0.1-0.3)
RCKT10T3M0-KM	0.17	(0.1-0.2)	0.17	(0.1-0.2)
RCKT10T3M0-MM	0.2	(0.1-0.3)	0.2	(0.1-0.3)
RCKT10T3M0-PH	0.25	(0.1-0.3)	0.25	(0.1-0.3)
RCKT10T3M0-PM	0.17	(0.1-0.2)	0.17	(0.1-0.2)
RCKT10T3M0-WM	0.17	(0.1-0.2)	0.17	(0.1-0.2)
RCKT1204M0-KH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT1204M0-KM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT1204M0-MM	0.28	(0.1-0.42)	0.2	(0.07-0.3)
RCKT1204M0-PH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT1204M0-PM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT1204M0-WM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT1204M0	0.35	(0.1-0.42)	0.15	(0.07-0.3)
RCKT130400-KH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT130400-KM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT130400-MM	0.28	(0.1-0.42)	0.2	(0.07-0.3)
RCKT130400-PH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT130400-PM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT130400-WM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT1606M0-KH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT1606M0-KM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT1606M0-MM	0.28	(0.1-0.42)	0.2	(0.07-0.3)
RCKT1606M0-PH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT1606M0-PM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT1606M0-WM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT1606M0	0.35	(0.1-0.42)	0.15	(0.07-0.3)
RCKT190600-KH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT190600-KM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT190600-MM	0.28	(0.1-0.42)	0.2	(0.07-0.3)
RCKT190600-PH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT190600-PM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT190600-WM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT2006M0-KH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT2006M0-KM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT2006M0-MM	0.28	(0.1-0.42)	0.2	(0.07-0.3)
RCKT2006M0-PH	0.35	(0.1-0.42)	0.25	(0.07-0.3)
RCKT2006M0-PM	0.24	(0.1-0.28)	0.17	(0.07-0.2)
RCKT2006M0-WM	0.24	(0.1-0.28)	0.17	(0.07-0.2)



## Groove milling tools



## CoroMill® 327

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
327R12-22 11045-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 13045-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 16045-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 18545-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 21545-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 26545-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 31545-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 41545-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-221304508-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-221604508-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-222654518-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-224154525-GC	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R06-10 10000-GM	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R06-10 15002-GM	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R06-10 20002-GM	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R06-10 25002-GM	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R09-18 15002-GM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 20002-GM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 25002-GM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 30002-GM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R12-22 15002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 20002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 25002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 30002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 40002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R14-28 15000-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R14-28 20002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R14-28 25002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R14-28 30002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R14-28 35002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R14-28 40002-GM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R09-18 15001-GMM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 20002-GMM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 25002-GMM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 30002-GMM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R12-28 15001-GMM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-28 20002-GMM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-28 25002-GMM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-28 30002-GMM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-28 40002-GMM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R14-35 15001-GMM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R14-35 20002-GMM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R14-35 25002-GMM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R14-35 30002-GMM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R06-12 22011-RM	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R09-18 22011-RM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R12-22 10005-RM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 20010-RM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 30015-RM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 40020-RM	0.07	(0.04-0.1)	0.07	(0.04-0.1)

## CoroMill® 328

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
328R13-13000-GM	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-16000-GM	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-18502-GM	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-18545-GC	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-21502-GM	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-21545-GC	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-26502-GM	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-26545-GC	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-2654515-GC	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-31502-GM	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-31545-GC	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-41502-GM	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-41545-GC	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-4154520-GC	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-51502-GM	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-51545-GC	0.1	(0.04-0.15)	0.07	(0.03-0.1)

## Groove milling tools



## CoroMill® QD

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
QD-NE-0200-010E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NF-0239-010E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NF-0250-010E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NG-0300-010E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NG-0318-010E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NH-0400-015E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NJ-0476-020E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NJ-0500-020E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NK-0600-025E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NK-0635-025E-NL	0.16	(0.01-0.3)	0.13	(0.01-0.25)
QD-NE-0200-020E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NF-0239-020E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NF-0250-020E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NG-0300-020E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NG-0318-020E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NH-0400-025E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NJ-0476-030E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NJ-0500-030E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NK-0600-035E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NK-0635-035E-SL	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NE-0200-020E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NF-0239-020E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NF-0250-020E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NG-0300-020E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NG-0318-020E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NH-0400-025E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NJ-0476-030E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NJ-0500-030E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NK-0600-035E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NK-0635-035E-SM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NE-0200-020E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NF-0239-020E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NF-0250-020E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NG-0300-020E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NG-0318-020E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NH-0400-025E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NJ-0476-030E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NJ-0500-030E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NK-0600-035E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NK-0635-035E-ML	0.05	(0.01-0.08)	0.04	(0.01-0.07)
QD-NE-0200-020E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NF-0239-020E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NF-0250-020E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NG-0300-020E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NG-0318-020E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NH-0400-025E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NJ-0476-030E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NJ-0500-030E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NK-0600-035E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NK-0635-035E-MM	0.09	(0.05-0.14)	0.08	(0.04-0.12)
QD-NE-0200-020E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)
QD-NF-0239-020E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)
QD-NF-0250-020E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)
QD-NG-0300-020E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)
QD-NH-0400-025E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)
QD-NG-0318-020E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)
QD-NJ-0476-030E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)
QD-NJ-0500-030E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)
QD-NK-0600-035E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)
QD-NK-0635-035E-KL	0.13	(0.02-0.18)	0.11	(0.02-0.15)

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
QD-NE-0200-035M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NF-0239-035M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NF-0250-035M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NG-0300-035M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NG-0318-035M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NH-0400-040M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NJ-0476-045M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NJ-0500-045M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NK-0600-050M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NK-0635-050M-KM	0.13	(0.05-0.18)	0.11	(0.04-0.15)
QD-NE-0200-020E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NF-0239-020E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NF-0250-020E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NG-0300-020E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NG-0318-020E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NH-0400-025E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NJ-0476-030E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NJ-0500-030E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NK-0600-035E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NK-0635-035E-PL	0.06	(0.02-0.08)	0.05	(0.02-0.08)
QD-NE-0200-020E-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NF-0239-020E-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NF-0250-020E-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NG-0300-020E-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NG-0318-020E-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NH-0400-025E-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NJ-0476-030E-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NJ-0500-030E-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NK-0600-035E-PM	0.2	(0.08-0.12)	0.1	(0.07-0.1)
QD-NK-0635-035E-PM	0.2	(0.08-0.12)	0.1	(0.07-0.1)
QD-NE-0200-020M-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NF-0239-020M-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NF-0250-020M-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NG-0300-020M-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NG-0318-020M-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NH-0400-025M-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NJ-0476-030M-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NJ-0500-030M-PM	0.13	(0.08-0.18)	0.11	(0.07-0.15)
QD-NK-0600-035M-PM	0.12	(0.08-0.12)	0.1	(0.07-0.1)
QD-NK-0635-035M-PM	0.12	(0.08-0.12)	0.1	(0.07-0.1)
QD-NE-0200-035M-PH	0.13	(0.05-0.15)	0.11	(0.04-0.13)
QD-NF-0239-035M-PH	0.13	(0.05-0.15)	0.11	(0.04-0.13)
QD-NF-0250-035M-PH	0.13	(0.05-0.15)	0.11	(0.04-0.13)
QD-NG-0300-035M-PH	0.13	(0.05-0.15)	0.11	(0.04-0.13)
QD-NG-0318-035M-PH	0.13	(0.05-0.15)	0.11	(0.04-0.13)
QD-NH-0400-040M-PH	0.13	(0.05-0.15)	0.11	(0.04-0.13)
QD-NJ-0476-045M-PH	0.13	(0.05-0.15)	0.11	(0.04-0.13)
QD-NJ-0500-045M-PH	0.13	(0.05-0.15)	0.11	(0.04-0.13)
QD-NK-0600-050M-PH	0.12	(0.05-0.12)	0.1	(0.04-0.1)
QD-NK-0635-050M-PH	0.12	(0.05-0.12)	0.1	(0.04-0.1)

Recommendation for diameter 63 mm cutters:

- PL is the 1st choice geometry in ISO P applications
- Use maximum 70% of the recommended  $h_{ex}$  value when using the PM geometry
- PH geometry is not recommended

## Thread milling tools



CoroMill® 328

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
328R13-04UN-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-06UN-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-08UN-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-10UN-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-12UN-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-14UN-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-150MM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-150VM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-16UN-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-200MM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-300MM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-350MM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-400MM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-400VM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-450MM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-500MM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-550MM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)
328R13-600MM-TH	0.1	(0.04-0.15)	0.07	(0.03-0.1)

CoroMill® 327

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min.- max.)	Starting value	(min.- max.)
327R06-12 100VM-TH	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R09-18 100VM-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R12-22 100VM-TH	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R06-12 250VM-TH	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R09-18 250VM-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R12-22 250VM-TH	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R06-12 19WH-TH	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R09-18 19WH-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R06-12 14WH-TH	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R09-18 14WH-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R06-12 11WH-TH	0.05	(0.02-0.06)	0.05	(0.02-0.06)
327R09-18 11WH-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 24UN-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 20UN-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 18UN-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 16UN-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 14UN-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 12UN-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 11UN-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 10UN-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 08UN-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 150MM-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 200MM-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 300MM-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 350MM-TH	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R12-22 150MM-TH	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 175MM-TH	0.07	(0.04-0.1)	0.06	(0.04-0.1)
327R12-22 200MM-TH	0.07	(0.04-0.1)	0.06	(0.04-0.1)
327R12-22 300MM-TH	0.07	(0.04-0.1)	0.06	(0.04-0.1)
327R12-22 350MM-TH	0.07	(0.04-0.1)	0.06	(0.04-0.1)
327R12-22 400MM-TH	0.07	(0.04-0.1)	0.06	(0.04-0.1)
327R12-22 450MM-TH	0.07	(0.04-0.1)	0.06	(0.04-0.1)
327R09-18 100VM-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R12-22 100VM-THM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R09-18 250VM-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R12-22 250VM-THM	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R09-18 24UN-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 20UN-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 18UN-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 16UN-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 14UN-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 12UN-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 11UN-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 10UN-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 08UN-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 150MM-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 200MM-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 300MM-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)
327R09-18 350MM-THM	0.06	(0.03-0.08)	0.06	(0.03-0.08)

## Chamfer milling tools



## CoroMill® 495

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min. - max.)	Starting value	(min. - max.)
495-09T3M-MM	0.17	(0.12-0.25)	0.16	(0.12-0.2)
495-09T3M-PM	0.17	(0.12-0.25)	0.17	(0.12-0.25)

## CoroMill® 327

Ordering code	Feed per tooth, $f_z$ mm/tooth		Max chip thickness, $h_{ex}$ mm	
	Starting value	(min. - max.)	Starting value	(min. - max.)
327R06-12 12045-CH	0.07	(0.04-0.1)	0.07	(0.04-0.1)
327R12-22 20045-CH	0.07	(0.04-0.1)	0.07	(0.04-0.1)

# Grades for milling

**P** Steel

## Basic grades



**GC1130 (HC)** - P30 (P15-P40)

Hard, thin coated PVD-grade with Zertivo™ technology for various applications. Suitable from light roughing to finishing in average stability for wet and dry machining. Good choice for complex tool paths and sticky materials.

Where GC1130 is not available, please use GC1030.



**GC4340 (HC)** - P40 (P35-P50)

Tough CVD-coated grade (medium thick coating) suited for tough and demanding medium to rough milling applications for wet and dry machining.



**GC4330 (HC)** - P30 (P10-P40)

Medium hard CVD-coated grade (medium thick coating) designed for medium to rough milling applications in average cutting conditions for wet and dry machining.



**GC4220 (HC)** - P20 (P10-P25)

Hard CVD-coated (thick coating) grade suitable for high cutting speeds in medium to rough milling application with good stability for dry machining.

## Complementary grades



**GC1010 (HC)** - P10 (P05-P15)

Very hard PVD-coated (thin coating) grade for finishing in very stable conditions and hardened materials for wet and dry machining.



**CT530 (HT)** - P15 (P10-P15)

Medium hard uncoated cermet grade for finishing applications at high cutting speeds for dry machining.



**GC2030 (HC)** - P30 (P20-P40)

Medium hard PVD-coated (thin coating) grade for sticky materials for wet and dry machining.



**GC2040 (HC)** - P45 (P30-P50)

Tough CVD-coated grade (medium thick coating) for roughing in tough and demanding applications for wet and dry machining and good for mixed material production.



**GC3040 (HC)** - P20 (P10-P40)

Medium hard CVD-coated (thick coating) grade which complements GC4330 in abrasive materials.



**M30B (HC)** - P35 (P30-P40)

Tough CVD-coated (thin coated) grade for turbine blade machining under tough and demanding conditions at high cutting speeds for wet and dry machining.



**GC1025 (HC)** - P30 (P15-P30)

Hard PVD-coated (thin coating) grade for light roughing to finishing in sticky materials for wet and dry machining.

### Letter symbols specifying the designation of hard cutting materials:

#### Hardmetals:

**HT** Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

**HC** Hardmetals as above, but coated

## Grades for milling

### **M** Austenitic/ferritic/martensitic stainless steel

#### Basic grades



#### **GC1040 (HC)** - M30 (M15-M35)

Tough, thin-coated PVD grade for finishing to roughing in unstable to stable wet or dry conditions. Good choice for complex tool paths and sticky materials.



#### **GC2040 (HC)** - M40 (M25-M40)

Tough, medium-thick coated CVD grade designed for tough and demanding, medium to rough milling applications with poor stability in dry conditions. High feed rates, large diameters and radial engagements.



#### **S30T (HC)** - M25 (M15-M35)

Medium hard, thin-coated PVD grade to be used as a complement to GC1040 when stability is good and for demands on high cutting speed in wet and dry conditions.



#### **GC2030 (HC)** - M25 (M15-M30)

Medium-hard, thin coated PVD grade for light roughing to finishing. Complement to GC1040 in good stability, for high cutting speeds in dry conditions.

#### Complementary grades



#### **M30B (HC)** - M35 (M30-M40)

Tough, thin-coated CVD grade for turbine blade machining under toughness-demanding conditions at high cutting speeds. Can be used in both wet and dry conditions.

#### Letter symbols specifying the designation of hard cutting materials:

##### Hardmetals:

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

#### Complementary grades



#### **S40T (HC)** - M40 (M30-M40)

Very tough, medium-thick-coated CVD grade designed for toughness-demanding medium to rough milling applications with poor stability. Can be used in both dry and wet conditions.



#### **GC1130 (HC)** - M15 (M10-M20)

Hard, thin-coated PVD grade with Zertivo™ technology for use as a complement to GC1040 with good stability and demands for high cutting speed. Can be used in both dry and wet conditions. Good choice for mixed ISO M/ISO P material production.

Where GC1130 does not exist, please use GC1030.



#### **CT530 (HT)** - M10 (M10-M15)

Medium hard uncoated cermet grade for finishing applications at high cutting speeds for dry machining.



#### **GC1010 (HC)** - M10 (M05-M10)

Very hard, thin-coated PVD grade for finishing in stable conditions for wet and dry machining.



#### **GC4330 (HC)** - M30 (M25-M35)

Medium hard, medium-thick-coated CVD grade for medium to rough milling of martensitic stainless steels at elevated cutting speeds in average and dry conditions.



#### **GC4340 (HC)** - M40 (M30-M40)

Tough, medium-thick-coated CVD grade for tough and demanding, medium to rough milling applications of martensitic stainless steels in dry conditions.

# Grades for milling

## Cast iron

### Basic grades



#### **GC3330 (HC)** - K20 (K15-K35)

Hard CVD-coated grade with thick coating, designed for medium to rough milling of all cast irons in average to stable conditions, both dry and wet. First choice in grey cast iron and mixed ISO K applications.



#### **GC1020 (HC)** - K20 (K10-K25)

Hard PVD-coated grade with thin coating for light roughing to finishing of nodular cast iron in dry and wet conditions, and grey cast iron in wet and average to stable conditions. First choice for nodular cast iron and/or small diameter cutters.



#### **GC3220 (HC)** - K15 (K10-K25)

Hard CVD-coated grade with very thick coating, designed for high cutting speeds in medium to rough grey cast milling applications with good stability in dry conditions.



#### **GC3040 (HC)** - K30 (K20-K40)

Medium-hard CVD grade with thick coating for tough and demanding medium to rough milling applications of grey cast iron in dry conditions.



#### **K20W (HC)** - K20 (K15-K30)

Hard CVD-coated grade with thin coating for finishing to light rough milling of all cast irons in stable and wet conditions. Ideal for large diameter cutters.



#### **K20D (HC)** - K15 (K10-K25)

Hard CVD-coated grade with very thick coating designed for high cutting speed in medium to rough grey cast iron milling applications with good stability in dry conditions.

#### Letter symbols specifying the designation of hard cutting materials:

##### Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HC Hardmetals as above, but coated

##### Ceramics:

CN Nitride ceramics containing primarily silicon nitride (Si<sub>3</sub>N<sub>4</sub>)

##### Boron nitride:

BN Polycrystalline boron nitride<sup>1)</sup>

<sup>1)</sup> Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

### Complementary grades



#### **CB50 (BN)** - K10 (K01-K20)

Hard CBN-tipped grade for light roughing to finishing of grey cast iron in stable, dry conditions. Use when dimensional stability and long tool life are critical.



#### **CC6190 (CN)** - K05 (K01-K15)

Hard silicon nitride ceramic grade for very high cutting speeds in light roughing to semi-finishing of grey cast iron in stable and dry conditions.



#### **GC1010 (HC)** - K05 (K01-K10)

Very hard PVD-coated grade with thin coating for finishing in very stable conditions. A harder complement to GC1020 in wet conditions.



#### **H13A (HW)** - K20 (K10-K25)

Hard uncoated carbide grade for rough to finish milling with sharp cutting edges, at low speeds and in average to stable, dry and wet conditions.



#### **GC4340 (HC)** - K40 (K30-K40)

Tough CVD-coated grade with medium-thick coating, for use as a tougher complement to GC3040 when stability is poor, in dry and wet conditions.



#### **GC4330 (HC)** - K30 (K20-K35)

Medium-hard CVD-coated grade with medium-thick coating, for toughness-demanding, medium to rough milling applications of nodular cast iron in dry and wet conditions.



#### **K20M (HC)** - K15 (K10-K25)

Hard CVD-coated grade with medium-thick coating, for medium to rough milling in various applications of all kinds of cast iron, mainly dry conditions.



#### **K15W (HC)** - K15 (K10-K25)

Hard CVD-coated grade with thin coating for finishing of cast iron and bi-metal components such as cast iron and aluminum in stable and wet conditions. Use as a complement to K20W when a sharp edge is needed.

## Grades for milling

**N**
**Non ferrous metals, plastics, wood**

### Basic grades


**H13A (HW)** - N15 (N10-N25)

Hard uncoated grade for roughing to semi-finishing with sharp edges in average to stable conditions. Excellent surface finish in wet and dry machining.


**H10 (HW)** - N10 (N05-N15)

Very hard uncoated grade, for light roughing to finishing with sharp cutting edges in stable conditions with high demands on the quality of the surface finish in wet and dry machining.


**CD10 (DP)** - N05 (N01-N10)

Polycrystalline diamond-tipped grade (PCD) with sharp edges for light roughing to finishing in stable conditions for wet or dry machining with a high demand on the quality of the surface finish and process stability. Good choice for abrasive materials.

### Complementary grades


**CT530 (HT)** - N15 (N10-N20)

Medium-hard, uncoated cermet grade for finishing in rather stable conditions and elevated cutting speeds in wet and dry conditions.


**GC1130 (HC)** - N15 (N10-N25)

Hard, thin-coated PVD Zertivo™ grade for roughing to semi-finishing in average conditions with less demands on surface finish in wet and dry conditions.

\*Where GC1130 does not exist, please use GC1030.


**H10F (HW)** - N15 (N10-N25)

Hard uncoated grade for light roughing to finishing with sharp edges in average conditions for good surface in wet and dry conditions.

#### Letter symbols specifying the designation of hard cutting materials:

##### Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

##### Diamond:

DP Polycrystalline diamond<sup>1)</sup>

<sup>1)</sup> Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.



# Grades for milling

## **S** Heat resistant alloys Titanium alloys

### Basic grades



#### **S30T (HC)** - S25 (S15-S30)

Medium-hard PVD-coated grade with thin coating, for finishing to light roughing applications in rather stable conditions. Excellent edge line durability and surface finish. Can be used in both wet and dry conditions.



#### **S40T (HC)** - S35 (S25-S45)

A very tough, medium-thick-coated CVD grade for roughing in toughness-demanding applications. Can be used in both wet and dry conditions.



#### **GC1130 (HC)** - S15 (S10-S25)

A hard PVD-coated Zertivo™ grade with thin coating, to be used as a complement to S30T for long time in cut. Can be used in both wet and dry conditions.

\*Where GC1130 does not exist, please use GC1030.



#### **GC1010 (HC)** - S10 (S05-S10)

A very hard and thin-coated PVD grade for finishing in very stable, wet or dry conditions.

### Complementary grades



#### **GC1040 (HC)** - S30 (S20-S35)

Tough thin-coated PVD grade, to be used as a tougher complement to S30T in slightly more unstable applications in both wet and dry conditions.



#### **GC2030 (HC)** - S20 (S15-S25)

Medium-hard, thin-coated PVD grade to be used as a complement to S30T for long time in cut. Can be used in both wet and dry conditions.



#### **GC2040 (HC)** - S30 (S25-S40)

Tough, medium thick coated CVD grade for roughing in toughness-demanding applications. Use as a complement to S40T for large diameters or large radial engagements in wet and dry conditions.



#### **H10F (HW)** - S25 (S20-S30)

Hard uncoated grade for light roughing to finishing in stable conditions with high demands on sharp edges and surface finish for both wet and dry conditions.



#### **H13A (HW)** - S20 (S15-S25)

Hard uncoated grade, for use as backup for H10F in more stable applications. Can be used in both wet and dry conditions.



#### **GC1025 (HC)** - S15 (S10-S20)

Hard, thin-coated PVD grade to be used as a complement to S30T for long time in cut and/or machining sticky materials. Can be used in both wet and dry conditions.

### Letter symbols specifying the designation of hard cutting materials:

#### Hardmetals:

HW Uncoated hardmetal containing primarily tungsten carbide (WC)

HC Hardmetals as above, but coated

## Grades for milling

H

### Hardened steel

#### Basic grades



#### GC1010 (HC) - H10 (H05-H15)

Hard PVD grade with a thin coating for light roughing to finishing of hardened steel with 36 HRC or higher and should be used in stable conditions for both wet and dry machining.



#### GC4220 (HC) - H25 (H15-H30)

Hard CVD grade with a thick coating for light roughing to finishing at low feeds, moderate speeds and large radial engagements in the lower ISO H hardness range for both wet and dry machining.

#### Complementary grades



#### GC1130 (HC) - H10 (H10-H20)

Hard, thin coated PVD grade with Zertivo™ technology for light roughing to finishing at low feeds, moderate speeds and small radial engagements in the lower ISO H hardness range for both wet and dry machining.

\*Where GC1130 does not exist, please use GC1030.



#### CT530 (HT) - H25(H10-H25)

Medium-hard uncoated cermet grade, for light finishing in stable and dry conditions.



#### CB50 (BN) - H05 (H01-H10)

Hard CBN-tipped grade for semi-finishing to finishing in very stable and dry conditions. Use when dimensional stability and long tool life are crucial.



#### GC3040 (HC) - H25 (H20-H30)

Medium-hard, thick coated CVD grade that can be used as a backup to GC4220 in unstable and dry conditions.



#### CC6190 (CN) - H10 (H05-H15)

Hard silicon nitride ceramic grade for light roughing to semi finishing of chilled cast iron at stable and dry conditions.

#### Letter symbols specifying the designation of hard cutting materials:

##### Hardmetals:

HT Uncoated hardmetal, also called cermet, containing primarily titanium carbides (TiC) or titanium nitrides (TiN) or both

HC Hardmetals as above, but coated

##### Ceramics:

CN Nitride ceramics containing primarily silicon nitride (Si<sub>3</sub>N<sub>4</sub>)

##### Boron nitride:

BN Polycrystalline boron nitride<sup>1)</sup>

<sup>1)</sup> Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

# Drilling

## Exchangeable tip drills

CoroDrill® 870 J4

## Indexable drills

CoroDrill® DS20 J26

CoroDrill® 880 J34

Trepanning tool J44

Coromant U insert for drilling J47

## Which drilling solution suits your needs?

When drilling small to medium holes, there are different drilling solutions to choose from:

- Exchangeable tip drills
- Indexable insert drills
- Solid carbide drills

When selecting your drill type, there are many aspects to consider. Hole tolerance, drilling depth and diameter are of primary importance. Further, the work piece material, design of the component, batch sizes and machine type needs to be considered.

Generally speaking, symmetrical drills such as solid carbide or exchangeable tip will provide closer hole tolerances and operate at higher feed rates. Indexable insert drills are very cost efficient when hole tolerance is not of primary importance and since being run at lower feeds they impose lower amounts of axial forces into the work piece.

## Select your strategy

Drilling is often carried out late in the manufacturing process, after previous operations have already enhanced the initial component's value. The drilling application, although seemingly simple, is a complex operation that can have significant consequences if the tool malfunctions or is run beyond its capacity. For this reason it is important to have a strategy on how to achieve your desired hole.

### Drilling deep holes

- The process of drilling deeper holes requires longer tools that are more sensitive to deflection
- Chips have a longer distance to evacuate
- When drilling 6-7xD holes with CoroDrill DS20, a feed reduction at entry and exit is required. Entry feed should be 75% of recommended feed rate, exit feed should be 0.05 mm/rev.

### Important factors to consider:






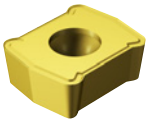






- If drilling holes deeper than 6xD with CoroDrill 870 use a piloting operation
- Ensure that coolant flow is sufficient to evacuate chips
- Adjust your cutting data to obtain satisfactory chips, a stable process and ultimately reaching the demands of your hole

### Achieving a stable process

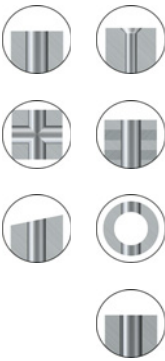
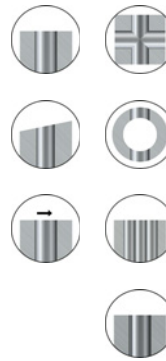
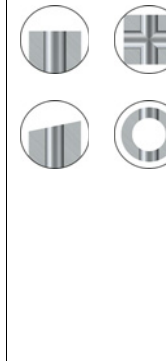
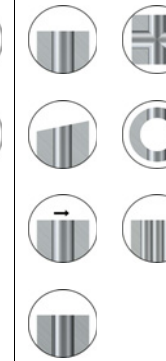

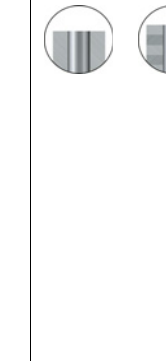
- Achieving a stable process is the ultimate goal when selecting your drilling strategy
- To achieve this multiple factors come into play (coolant, fixturing, machine capacity, etc.)
- Apart from the previously mentioned, a factor that has a large impact is cutting data

### Adjust cutting data to optimize your process either to:

- Increase penetration rates (by increasing feed)
- Prolong tool life (by reducing speed)

						
Drill type	Exchangeable tip drill	Indexable insert drill	Indexable insert drill	Large diameter indexable insert drill	Trepanning tool	Coromant U insert for drilling
DC mm	10.00-33.00	15.00-40.00	12.00-63.50	65.00-84.00	60.00-110.00	
ISO application area						
ULDR	3-10 x DC	4-7 x DC	2-3 x DC	3-4 x DC	2.5 x DC	
TCHA	H9-H10	IT13-IT14	H12-H13	IT13	IT13	
Coolant	Internal	Internal	Internal	Internal	External	
Page	<b>J4</b>	<b>J26</b>	<b>J34</b>	<b>J34</b>	<b>J44</b>	<b>J47</b>

Application

					
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# CoroDrill® 870

Secure and predictable holemaking process

ISO application area:



## Benefits and features

The interface between tip and drill is simple, accurate, and stable. Optimised drill flutes facilitate chip evacuation. The tip is changed while still in the holder saving you valuable cutting time. New cutting edge geometries and grades provide a safe cutting process with optimised chip control, high penetration rates, and a long, dependable tool life.



## Application

- Reliable and secure process
- Easy handling and secure tip changing
- Optimised chip control and evacuation
- Long, predictable tool life and high productivity
- Low cost per hole and excellent hole quality

[www.sandvik.coromant.com/corodril870](http://www.sandvik.coromant.com/corodril870)

## Drill bodies

- Drilling depths: up to 10 x drill diameter
- Couplings: Cylindrical shank with flat (ISO 9766)
- Hole tolerances: H9-H10

## Drill tips

- New grades to provide increased tool life and predictable wear
- Easy handling and secure tip changing
- Tip changing possible while tool is in the machine to reduce downtime

## Drill tip geometries

- PM optimized for ISO-P
- MM optimized for ISO-M
- KM optimized for ISO-K
- GP pilot tip for all materials

Gently press the tip down and toward the support surface while tightening the screw to the recommended torque shown on the drill body. Preferably use a torque screw driver to ensure the tip is securely seated. Untighten the screw approximately 1.5 revolutions to release the tip.



Tailor Made step and chamfer drills for producing step or chamfer holes in one operation are available.

## Hole tolerance (not applicable for GP geometry)





H9 - H10

Diameter range, mm		10.00-18.00	18.01-30.00	30.01-33.00
Hole tolerance, mm	3xDC-8xDC 10xDC	0/+0.043 0/+0.070	0/+0.052 0/+0.084	0/+0.062 0/+0.100



# CoroDrill® 870

## Geometry overview

Geometry	Geometry information
PM	 <p>-PM geometry is considered to be an all-round tip. Although primarily intended for low alloyed and carbon steels, it also shows good functionality and tool life in austenitic stainless steels as well as cast irons.</p>
MM	 <p>-MM geometry has the same micro and macro geometry as PM, but has a reinforced chisel edge improving tool life especially for Duplex stainless steels.</p>
KM	 <p>-KM shares the same micro geometry as the PM. The difference for KM is its corner chamfer allowing reduced exit breakouts in the work piece material.</p>
GP	 <p>-GP is intended for piloting applications. It is based upon the PM geometry but has a larger point angle and different tolerance class.</p>

## Grade overview

### GC4334

- New thick PVD coating (AlTiN) with improved edge security provide resistance against built-up edge and chipping.
- A tough high Cr content fine-grain substrate for high reliability and chipping resistance.
- First choice in ISO-P

### GC3334

- New multi-layer PVD coating (AlTiCrN) with improved wear resistance.
- A hard and fine-grained substrate, further increasing the wear resistance.
- First choice in ISO-K

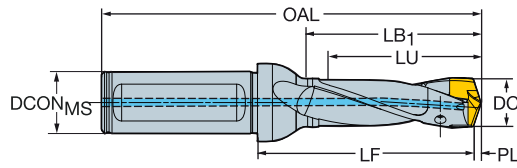
### GC2334

- New thin multi-layer PVD coating (AlTiCrN) with improved resistance against flaking and chipping on secondary edge.
- A tough high Cr content fine-grain substrate for high reliability and chipping resistance.
- First choice in ISO-M

# CoroDrill® 870 exchangeable tip drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



							Dimensions, mm								
DCN	DCX	LU	CZC <sub>MS</sub>	TCHA	Ordering code	DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	BAR	KG	RPM <sub>x</sub>	MID <sub>p</sub>	
10.00	10.49	6	33.09	16	H9	870-1000-6L16-3	16.00	46.40	96.00	35.00	1.60	10	0.141	33000	870-1040-6-PM
10.00	10.49	6	54.07	16	H9	870-1000-6L16-5	16.00	67.40	117.00	56.00	1.60	10	0.148	15000	
10.00	10.49	6	85.54	16	H9	870-1000-6L16-8	16.00	99.40	149.00	88.00	1.60	15	0.157	12000	
10.00	10.49	6	106.52	16	H10	870-1000-6L16-10	16.00	120.40	170.00	109.00	1.60	30	0.161	9000	
10.50	10.99	7	34.67	16	H9	870-1050-7L16-3	16.00	47.31	97.00	36.00	1.69	10	0.143	33000	870-1090-7-PM
10.50	10.99	7	56.65	16	H9	870-1050-7L16-5	16.00	69.31	119.00	58.00	1.69	10	0.150	15000	
10.50	10.99	7	89.62	16	H9	870-1050-7L16-8	16.00	102.31	152.00	91.00	1.69	15	0.161	12000	
10.50	10.99	7	111.60	16	H10	870-1050-7L16-10	16.00	124.31	174.00	113.00	1.69	30	0.168	9000	
11.00	11.49	8	36.23	16	H9	870-1100-8L16-3	16.00	49.25	99.00	38.00	1.75	10	0.145	33000	870-1140-8-PM
11.00	11.49	8	59.21	16	H9	870-1100-8L16-5	16.00	72.25	122.00	61.00	1.75	10	0.154	15000	
11.00	11.49	8	93.68	16	H9	870-1100-8L16-8	16.00	107.25	157.00	96.00	1.75	15	0.165	12000	
11.00	11.49	8	116.66	16	H10	870-1100-8L16-10	16.00	130.25	180.00	119.00	1.75	30	0.172	9000	
11.50	11.99	9	37.82	16	H9	870-1150-9L16-3	16.00	51.17	101.00	40.00	1.83	10	0.146	33000	870-1190-9-PM
11.50	11.99	9	61.80	16	H9	870-1150-9L16-5	16.00	75.17	125.00	64.00	1.83	10	0.157	15000	
11.50	11.99	9	97.77	16	H9	870-1150-9L16-8	16.00	111.17	161.00	100.00	1.83	15	0.170	12000	
11.50	11.99	9	121.75	16	H10	870-1150-9L16-10	16.00	135.17	185.00	124.00	1.83	30	0.178	9000	
12.00	12.49	10	39.38	16	H9	870-1200-10L16-3	16.00	53.10	103.00	42.00	1.90	10	0.151	33000	870-1240-10-PM
12.00	12.49	10	64.36	16	H9	870-1200-10L16-5	16.00	77.10	127.00	66.00	1.90	10	0.164	15000	
12.00	12.49	10	101.83	16	H9	870-1200-10L16-8	16.00	116.10	166.00	105.00	1.90	15	0.180	12000	
12.00	12.49	10	126.81	16	H10	870-1200-10L16-10	16.00	141.10	191.00	130.00	1.90	30	0.187	7000	
12.50	12.99	11	40.97	16	H9	870-1250-11L16-3	16.00	54.02	104.00	43.00	1.98	10	0.154	33000	870-1290-11-PM
12.50	12.99	11	66.95	16	H9	870-1250-11L16-5	16.00	80.02	130.00	69.00	1.98	10	0.167	15000	
12.50	12.99	11	105.92	16	H9	870-1250-11L16-8	16.00	119.02	169.00	108.00	1.98	15	0.185	10000	
12.50	12.99	11	131.90	16	H10	870-1250-11L16-10	16.00	145.02	195.00	134.00	1.98	30	0.193	7000	
13.00	13.49	12	42.54	16	H9	870-1300-12L16-3	16.00	55.94	106.00	45.00	2.06	10	0.157	33000	870-1340-12-PM
13.00	13.49	12	69.52	16	H9	870-1300-12L16-5	16.00	82.94	133.00	72.00	2.06	10	0.171	15000	
13.00	13.49	12	109.99	16	H9	870-1300-12L16-8	16.00	123.94	174.00	113.00	2.06	15	0.187	9500	
13.00	13.49	12	136.97	16	H10	870-1300-12L16-10	16.00	150.94	201.00	140.00	2.06	30	0.220	6500	
13.50	13.99	13	44.13	16	H9	870-1350-13L16-3	16.00	57.86	108.00	47.00	2.14	10	0.159	33000	870-1390-13-PM
13.50	13.99	13	72.11	16	H9	870-1350-13L16-5	16.00	84.86	135.00	74.00	2.14	10	0.175	15000	
13.50	13.99	13	114.08	16	H9	870-1350-13L16-8	16.00	127.86	178.00	117.00	2.14	15	0.200	9500	
13.50	13.99	13	142.06	16	H10	870-1350-13L16-10	16.00	155.86	206.00	145.00	2.14	30	0.228	6500	
14.00	14.99	14	47.27	20	H9	870-1400-14L20-3	20.00	63.72	116.00	50.00	2.28	10	0.227	33000	870-1490-14-PM
14.00	14.99	14	77.25	20	H9	870-1400-14L20-5	20.00	93.72	146.00	80.00	2.28	10	0.246	15000	
14.00	14.99	14	122.22	20	H9	870-1400-14L20-8	20.00	138.72	191.00	125.00	2.28	15	0.269	9500	
14.00	14.99	14	152.20	20	H10	870-1400-14L20-10	20.00	168.72	221.00	155.00	2.28	30	0.308	6500	
15.00	15.99	15	50.42	20	H9	870-1500-15L20-3	20.00	66.56	119.00	53.00	2.44	10	0.233	33000	870-1590-15-PM
15.00	15.99	15	82.40	20	H9	870-1500-15L20-5	20.00	98.56	151.00	85.00	2.44	10	0.258	15000	
15.00	15.99	15	130.37	20	H9	870-1500-15L20-8	20.00	146.56	199.00	133.00	2.44	15	0.310	8000	
15.00	15.99	15	162.35	20	H10	870-1500-15L20-10	20.00	178.56	231.00	165.00	2.44	30	0.330	5000	
16.00	16.99	16	53.56	20	H9	870-1600-16L20-3	20.00	69.42	122.00	56.00	2.58	10	0.241	33000	870-1690-16-PM
16.00	16.99	16	87.54	20	H9	870-1600-16L20-5	20.00	103.42	156.00	90.00	2.58	10	0.271	15000	
16.00	16.99	16	138.51	20	H9	870-1600-16L20-8	20.00	154.42	207.00	141.00	2.58	15	0.330	8000	
16.00	16.99	16	172.49	20	H10	870-1600-16L20-10	20.00	188.42	241.00	175.00	2.58	30	0.352	5000	
17.00	17.99	17	56.71	20	H9	870-1700-17L20-3	20.00	73.27	126.00	59.00	2.73	10	0.244	30000	870-1790-17-PM
17.00	17.99	17	92.69	20	H9	870-1700-17L20-5	20.00	109.27	162.00	95.00	2.73	10	0.280	13500	
17.00	17.99	17	146.66	20	H9	870-1700-17L20-8	20.00	163.27	216.00	149.00	2.73	15	0.338	8000	
17.00	17.99	17	182.64	20	H10	870-1700-17L20-10	20.00	199.27	252.00	185.00	2.73	30	0.368	5000	
18.00	18.99	18	59.86	20	H9	870-1800-18L20-3	20.00	76.13	129.00	62.00	2.87	10	0.259	30000	870-1890-18-PM
18.00	18.99	18	97.84	20	H9	870-1800-18L20-5	20.00	113.13	166.00	100.00	2.87	10	0.300	13500	
18.00	18.99	18	154.81	20	H9	870-1800-18L20-8	20.00	171.13	224.00	157.00	2.87	15	0.369	8000	
18.00	18.99	18	192.79	20	H10	870-1800-18L20-10	20.00	209.13	262.00	195.00	2.87	30	0.420	5000	
19.00	19.99	19	63.01	25	H9	870-1900-19L25-3	25.00	82.98	142.00	66.00	3.02	10	0.413	30000	870-1990-19-PM
19.00	19.99	19	102.99	25	H9	870-1900-19L25-5	25.00	122.98	182.00	106.00	3.02	10	0.460	13500	
19.00	19.99	19	162.96	25	H9	870-1900-19L25-8	25.00	182.98	242.00	166.00	3.02	15	0.560	7000	
19.00	19.99	19	202.94	25	H10	870-1900-19L25-10	25.00	222.98	282.00	206.00	3.02	30	0.595	4500	
20.00	20.99	20	66.16	25	H9	870-2000-20L25-3	25.00	86.83	146.00	69.00	3.17	10	0.434	21500	870-2090-20-PM
20.00	20.99	20	108.14	25	H9	870-2000-20L25-5	25.00	128.83	188.00	111.00	3.17	10	0.492	12000	
20.00	20.99	20	171.11	25	H9	870-2000-20L25-8	25.00	191.83	251.00	174.00	3.17	15	0.591	7000	
20.00	20.99	20	213.09	25	H10	870-2000-20L25-10	25.00	233.83	293.00	216.00	3.17	30	0.632	4500	



J8



L2



N23



N6



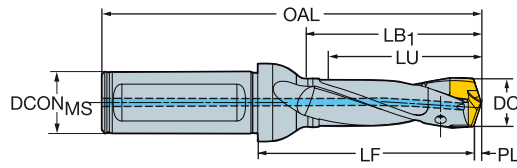
N15



# CoroDrill® 870 exchangeable tip drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



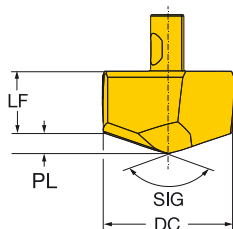
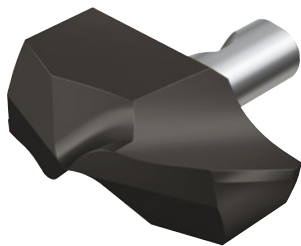
							Dimensions, mm										
DCN	DCX	LU	CZC <sub>MS</sub>	TCHA	Ordering code	DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	BAR	KG	RPMX	MID <sub>p</sub>			
21.00	21.99	21	69.30	25	H9	870-2100-21L25-3	25.00	89.68	149.00	72.00	3.32	10	0.450	21500	870-2190-21-PM		
21.00	21.99	21	113.28	25	H9	870-2100-21L25-5	25.00	133.68	193.00	116.00	3.32	10	0.508	12000			
21.00	21.99	21	179.25	25	H9	870-2100-21L25-8	25.00	199.68	259.00	182.00	3.32	15	0.627	7000			
21.00	21.99	21	223.23	25	H10	870-2100-21L25-10	25.00	243.68	303.00	226.00	3.32	30	0.679	4500			
22.00	22.99	22	72.45	25	H9	870-2200-22L25-3	25.00	93.53	153.00	76.00	3.47	10	0.470	21500	870-2290-22-PM		
22.00	22.99	22	118.43	25	H9	870-2200-22L25-5	25.00	139.53	199.00	122.00	3.47	10	0.575	12000			
22.00	22.99	22	187.40	25	H9	870-2200-22L25-8	25.00	208.53	268.00	191.00	3.47	15	0.675	7000			
22.00	22.99	22	233.38	25	H10	870-2200-22L25-10	25.00	253.53	313.00	236.00	3.47	30	0.724	4500			
23.00	23.99	23	75.59	25	H9	870-2300-23L25-3	25.00	97.39	157.00	79.00	3.61	10	0.485	21500	870-2390-23-PM		
23.00	23.99	23	123.57	25	H9	870-2300-23L25-5	25.00	145.39	205.00	127.00	3.61	10	0.600	21500			
23.00	23.99	23	195.54	25	H9	870-2300-23L25-8	25.00	217.39	277.00	199.00	3.61	15	0.706	6000			
23.00	23.99	23	243.52	25	H10	870-2300-23L25-10	25.00	265.39	325.00	247.00	3.61	30	0.776	4000			
24.00	24.99	24	78.75	32	H9	870-2400-24L32-3	32.00	104.23	168.00	82.00	3.77	10	0.728	16000	870-2490-24-PM		
24.00	24.99	24	128.73	32	H9	870-2400-24L32-5	32.00	155.23	219.00	132.00	3.77	10	0.898	10500			
24.00	24.99	24	203.70	32	H9	870-2400-24L32-8	32.00	229.23	293.00	207.00	3.77	15	1.033	6000			
24.00	24.99	24	253.68	32	H10	870-2400-24L32-10	32.00	275.23	339.00	257.00	3.77	30	1.073	4000			
25.00	25.99	25	81.90	32	H9	870-2500-25L32-3	32.00	107.09	171.00	85.00	3.91	10	0.818	16000	870-2590-25-PM		
25.00	25.99	25	133.88	32	H9	870-2500-25L32-5	32.00	159.09	223.00	137.00	3.91	10	0.930	10500			
25.00	25.99	25	211.85	32	H9	870-2500-25L32-8	32.00	237.09	301.00	215.00	3.91	15	1.085	6000			
25.00	25.99	25	263.83	32	H10	870-2500-25L32-10	32.00	289.09	353.00	267.00	3.91	30	1.121	4000			
26.00	26.99	26	85.05	32	H9	870-2600-26L32-3	32.00	111.97	176.00	89.00	4.03	10	0.838	16000	870-2665-26-PM		
26.00	26.99	26	139.03	32	H9	870-2600-26L32-5	32.00	165.97	230.00	143.00	4.03	10	0.956	10500			
26.00	26.99	26	220.00	32	H9	870-2600-26L32-8	32.00	245.97	310.00	223.00	4.03	15	1.085	6000			
26.00	26.99	26	273.98	32	H10	870-2600-26L32-10	32.00	299.97	364.00	277.00	4.03	10	1.269	3500			
27.00	27.99	27	88.21	32	H9	870-2700-27L32-3	32.00	113.86	178.00	92.00	4.14	10	0.851	16000	870-2750-27-PM		
27.00	27.99	27	144.19	32	H9	870-2700-27L32-5	32.00	170.86	235.00	148.00	4.14	10	0.997	10500			
27.00	27.99	27	228.16	32	H9	870-2700-27L32-8	32.00	253.86	318.00	232.00	4.14	10	1.163	5000			
28.00	28.99	28	91.36	32	H9	870-2800-28L32-3	32.00	116.68	181.00	95.00	4.32	10	0.906	16000	870-2858-28-PM		
28.00	28.99	28	149.34	32	H9	870-2800-28L32-5	32.00	174.68	239.00	153.00	4.32	10	1.056	10500			
28.00	28.99	28	236.31	32	H9	870-2800-28L32-8	32.00	261.68	326.00	240.00	4.32	10	1.249	5000			
29.00	29.99	29	94.50	32	H9	870-2900-29L32-3	32.00	119.52	184.00	98.00	4.48	10	0.922	16000	870-2965-29-PM		
29.00	29.99	29	154.48	32	H9	870-2900-29L32-5	32.00	180.52	245.00	158.00	4.48	10	1.098	10500			
29.00	29.99	29	244.45	32	H9	870-2900-29L32-8	32.00	269.52	334.00	248.00	4.48	10	1.314	5000			
30.00	30.99	30	97.65	32	H9	870-3000-30L32-3	32.00	123.40	188.00	102.00	4.60	10	0.961	16000	870-3050-30-PM		
30.00	30.99	30	159.63	32	H9	870-3000-30L32-5	32.00	186.40	251.00	164.00	4.60	10	1.150	9500			
30.00	30.99	30	252.60	32	H9	870-3000-30L32-8	32.00	277.40	342.00	256.00	4.60	10	1.415	4000			
31.00	33.00	31	104.09	32	H9	870-3100-31L32-3	32.00	128.92	194.00	108.00	5.08	10	1.008	16000	870-3300-31-PM		
31.00	33.00	31	170.09	32	H9	870-3100-31L32-5	32.00	194.92	260.00	174.00	5.08	10	1.233	9500			
31.00	33.00	31	269.09	32	H9	870-3100-31L32-8	32.00	293.92	359.00	273.00	5.08	10	1.555	4000			

Spare parts		Spare parts	
	Insert screw		Insert screw
6	5513 031-15	19	5513 031-13
7	5513 031-15	20	5513 031-14
8	5513 031-15	21	5513 031-14
9	5513 031-15	22	5513 031-14
10	5513 031-12	23	5513 031-14
11	5513 031-12	24	5513 031-16
12	5513 031-12	25	5513 031-16
13	5513 031-12	26	5513 031-16
14	5513 031-12	27	5513 031-16
15	5513 031-12	28	5513 031-17
16	5513 031-13	29	5513 031-17
17	5513 031-13	30	5513 031-17
18	5513 031-13	31	5513 031-17

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



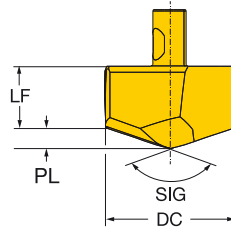
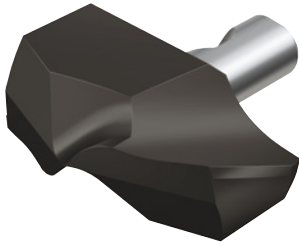
# CoroDrill® 870 drill tip



DC	Ordering code	Material					Dimensions, mm			
		P	M	K	N	S	LF	PL	SIG	TCHA
10.00	6 870-1000-6-PM	★					4.7	1.5	142°	H9
10.00	870-1000-6-MM		★				4.7	1.5	142°	H9
10.00	870-1000-6-KM	☆		★			4.4	1.8	142°	H9
10.00	870-1000-6-GP	★	★		★	☆	4.6	1.1	152°	F9
10.10	870-1010-6-PM	★					4.7	1.6	142°	H9
10.10	870-1010-6-MM		★				4.7	1.6	142°	H9
10.10	870-1010-6-KM	☆		★			4.4	1.8	142°	H9
10.10	870-1010-6-GP	★	★	★	☆	☆	4.6	1.1	152°	F9
10.20	870-1020-6-PM	★					4.6	1.6	142°	H9
10.20	870-1020-6-MM		★				4.6	1.6	142°	H9
10.20	870-1020-6-KM	☆		★			4.3	1.9	142°	H9
10.20	870-1020-6-GP	★	★	★	☆	☆	4.6	1.1	152°	F9
10.30	870-1030-6-PM	★					4.6	1.6	142°	H9
10.30	870-1030-6-MM		★				4.6	1.6	142°	H9
10.30	870-1030-6-KM	☆		★			4.3	1.9	142°	H9
10.30	870-1030-6-GP	★	★	★	☆	☆	4.6	1.1	152°	F9
10.40	870-1040-6-PM	★					4.6	1.6	142°	H9
10.40	870-1040-6-MM		★				4.6	1.6	142°	H9
10.40	870-1040-6-KM	☆		★			4.3	1.9	142°	H9
10.40	870-1040-6-GP	★	★	★	☆	☆	4.6	1.1	152°	F9
10.50	7 870-1050-7-PM	★					4.6	1.6	142°	H9
10.50	870-1050-7-MM		★				4.6	1.6	142°	H9
10.50	870-1050-7-KM	☆		★			4.3	1.9	142°	H9
10.50	870-1050-7-GP	★	★	★	☆	☆	4.6	1.2	152°	F9
10.60	870-1060-7-PM	★					4.6	1.6	142°	H9
10.60	870-1060-7-MM		★				4.6	1.6	142°	H9
10.60	870-1060-7-KM	☆		★			4.3	1.9	142°	H9
10.60	870-1060-7-GP	★	★	★	☆	☆	4.6	1.2	152°	F9
10.70	870-1070-7-PM	★					4.6	1.7	142°	H9
10.70	870-1070-7-MM		★				4.6	1.7	142°	H9
10.70	870-1070-7-KM	☆		★			4.3	1.9	142°	H9
10.70	870-1070-7-GP	★	★	★	☆	☆	4.5	1.2	152°	F9
10.80	870-1080-7-PM	★					4.5	1.7	142°	H9
10.80	870-1080-7-MM		★				4.5	1.7	142°	H9
10.80	870-1080-7-KM	☆		★			4.3	2.0	142°	H9
10.80	870-1080-7-GP	★	★	★	☆	☆	4.5	1.2	152°	F9
10.90	870-1090-7-PM	★					4.5	1.7	142°	H9
10.90	870-1090-7-MM		★				4.5	1.7	142°	H9
10.90	870-1090-7-KM	☆		★			4.2	2.0	142°	H9
10.90	870-1090-7-GP	★	★	★	☆	☆	4.5	1.2	152°	F9



# CoroDrill® 870 drill tip



DC	Ordering code	Dimensions, mm						LF	PL	SIG	TCHA
		P	M	K	N	S					
8	870-1100-8-PM	★					5.2	1.7	142°	H9	
8	870-1100-8-MM		★				5.2	1.7	142°	H9	
8	870-1100-8-KM	☆		★			4.9	2.0	142°	H9	
8	870-1100-8-GP	★	★				5.2	1.2	152°	F9	
11.0	870-1110-8-PM	★					5.2	1.7	142°	H9	
11.0	870-1110-8-MM		★				5.2	1.7	142°	H9	
11.0	870-1110-8-KM	☆		★			4.9	2.0	142°	H9	
11.0	870-1110-8-GP	★	★				5.2	1.2	152°	F9	
11.1	870-1111-8-PM	★					5.2	1.7	142°	H9	
11.1	870-1111-8-MM		★				5.2	1.7	142°	H9	
11.1	870-1111-8-KM	☆		★			4.9	2.0	142°	H9	
11.1	870-1111-8-GP	★	★				5.2	1.2	152°	F9	
11.2	870-1120-8-PM	★					5.2	1.7	142°	H9	
11.2	870-1120-8-MM		★				5.2	1.7	142°	H9	
11.2	870-1120-8-KM	☆		★			4.9	2.0	142°	H9	
11.2	870-1120-8-GP	★	★				5.2	1.2	152°	F9	
11.3	870-1130-8-PM	★					5.2	1.7	142°	H9	
11.3	870-1130-8-MM		★				5.2	1.7	142°	H9	
11.3	870-1130-8-KM	☆		★			4.9	2.0	142°	H9	
11.3	870-1130-8-GP	★	★				5.2	1.2	152°	F9	
11.4	870-1140-8-PM	★					5.2	1.8	142°	H9	
11.4	870-1140-8-MM		★				5.2	1.8	142°	H9	
11.4	870-1140-8-KM	☆		★			4.9	2.0	142°	H9	
11.4	870-1140-8-GP	★	★				5.2	1.2	152°	F9	
9	870-1150-9-PM	★					5.1	1.8	142°	H9	
9	870-1150-9-MM		★				5.1	1.8	142°	H9	
9	870-1150-9-KM	☆		★			4.8	2.1	142°	H9	
9	870-1150-9-GP	★	★				5.2	1.2	152°	F9	
11.6	870-1160-9-PM	★					5.1	1.8	142°	H9	
11.6	870-1160-9-MM		★				5.1	1.8	142°	H9	
11.6	870-1160-9-KM	☆		★			4.8	2.1	142°	H9	
11.6	870-1160-9-GP	★	★				5.2	1.3	152°	F9	
11.7	870-1170-9-PM	★					5.1	1.8	142°	H9	
11.7	870-1170-9-MM		★				5.1	1.8	142°	H9	
11.7	870-1170-9-KM	☆		★			4.8	2.2	142°	H9	
11.7	870-1170-9-GP	★	★				5.1	1.3	152°	F9	
11.8	870-1180-9-PM	★					5.1	1.8	142°	H9	
11.8	870-1180-9-MM		★				5.1	1.8	142°	H9	
11.8	870-1180-9-KM	☆		★			4.7	2.2	142°	H9	
11.8	870-1180-9-GP	★	★				5.1	1.3	152°	F9	
11.9	870-1190-9-PM	★					5.1	1.8	142°	H9	
11.9	870-1190-9-MM		★				5.1	1.8	142°	H9	
11.9	870-1190-9-KM	☆		★			4.7	2.2	142°	H9	
11.9	870-1190-9-GP	★	★				5.1	1.3	152°	F9	



J6



J50



J5



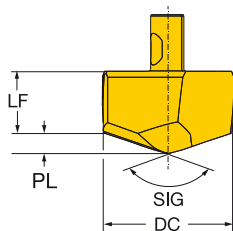
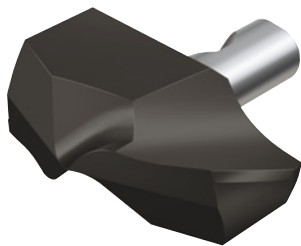
N23



N6



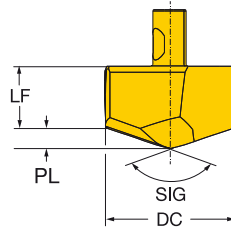
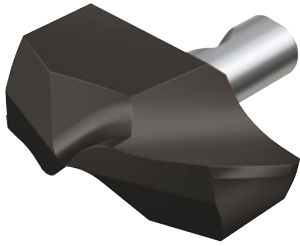
# CoroDrill® 870 drill tip



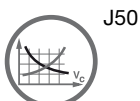
DC	Ordering code	Material					Dimensions, mm			
		P	M	K	N	S	LF	PL	SIG	TCHA
12.00	10 870-1200-10-PM	★					5.7	1.8	142°	H9
12.00	870-1200-10-MM		★				5.7	1.8	142°	H9
12.00	870-1200-10-KM	☆		★			5.3	2.2	142°	H9
12.00	870-1200-10-GP	★	★		☆	☆	5.7	1.3	152°	F9
12.10	870-1210-10-PM	★			☆	☆	5.7	1.9	142°	H9
12.10	870-1210-10-MM		★			☆	5.7	1.9	142°	H9
12.10	870-1210-10-KM	☆		★			5.3	2.2	142°	H9
12.10	870-1210-10-GP	★	★	★	☆	☆	5.7	1.3	152°	F9
12.20	870-1220-10-PM	★			☆	☆	5.6	1.9	142°	H9
12.20	870-1220-10-MM		★			☆	5.6	1.9	142°	H9
12.20	870-1220-10-KM	☆		★			5.3	2.2	142°	H9
12.20	870-1220-10-GP	★	★	★	☆	☆	5.7	1.3	152°	F9
12.30	870-1230-10-PM	★			☆	☆	5.6	1.9	142°	H9
12.30	870-1230-10-MM		★			☆	5.6	1.9	142°	H9
12.30	870-1230-10-KM	☆		★			5.3	2.2	142°	H9
12.30	870-1230-10-GP	★	★	★	☆	☆	5.7	1.3	152°	F9
12.40	870-1240-10-PM	★			☆	☆	5.6	1.9	142°	H9
12.40	870-1240-10-MM		★			☆	5.6	1.9	142°	H9
12.40	870-1240-10-KM	☆		★			5.3	2.3	142°	H9
12.40	870-1240-10-GP	★	★	★	☆	☆	5.7	1.3	152°	F9
12.50	11 870-1250-11-PM	★			☆	☆	5.6	1.9	142°	H9
12.50	870-1250-11-MM		★			☆	5.6	1.9	142°	H9
12.50	870-1250-11-KM	☆		★			5.2	2.3	142°	H9
12.50	870-1250-11-GP	★	★	★	☆	☆	5.7	1.3	152°	F9
12.60	870-1260-11-PM	★			☆	☆	5.6	1.9	142°	H9
12.60	870-1260-11-MM		★			☆	5.6	1.9	142°	H9
12.60	870-1260-11-KM	☆		★			5.2	2.3	142°	H9
12.60	870-1260-11-GP	★	★	★	☆	☆	5.6	1.4	152°	F9
12.70	870-1270-11-PM	★			☆	☆	5.6	2.0	142°	H9
12.70	870-1270-11-MM		★			☆	5.6	2.0	142°	H9
12.70	870-1270-11-KM	☆		★			5.2	2.3	142°	H9
12.70	870-1270-11-GP	★	★	★	☆	☆	5.6	1.4	152°	F9
12.80	870-1280-11-PM	★			☆	☆	5.5	2.0	142°	H9
12.80	870-1280-11-MM		★			☆	5.5	2.0	142°	H9
12.80	870-1280-11-KM	☆		★			5.2	2.3	142°	H9
12.80	870-1280-11-GP	★	★	★	☆	☆	5.6	1.4	152°	F9
12.90	870-1290-11-PM	★			☆	☆	5.5	2.0	142°	H9
12.90	870-1290-11-MM		★			☆	5.5	2.0	142°	H9
12.90	870-1290-11-KM	☆		★			5.2	2.3	142°	H9
12.90	870-1290-11-GP	★	★	★	☆	☆	5.6	1.4	152°	F9



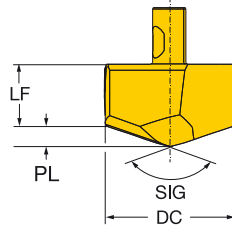
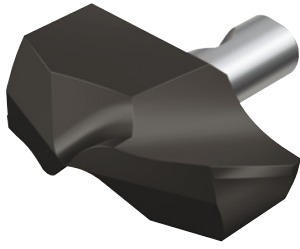
# CoroDrill® 870 drill tip



DC	Ordering code	Material						Dimensions, mm			
		P	M	K	N	S	LF	PL	SIG	TCHA	
		3334	4334	2334	4334	3334	4334	2334	4334		
13.00	12 870-1300-12-PM	★	☆	☆	☆	☆	6.0	2.0	142°	H9	
13.00	870-1300-12-PL	☆	★	★	☆	☆	5.4	2.6	142°	H9	
13.00	870-1300-12-MM	☆	★	★	☆	☆	6.0	2.0	142°	H9	
13.00	870-1300-12-KM	☆	☆	★	☆	☆	5.6	2.4	142°	H9	
13.00	870-1300-12-GP	★	★	★	☆	☆	6.1	1.4	152°	F9	
13.10	870-1310-12-PM	★	☆	☆	☆	☆	6.0	2.0	142°	H9	
13.10	870-1310-12-MM	★	★	★	☆	☆	6.0	2.0	142°	H9	
13.10	870-1310-12-KM	☆	☆	★	☆	☆	5.6	2.4	142°	H9	
13.10	870-1310-12-GP	★	★	★	☆	☆	6.1	1.4	152°	F9	
13.20	870-1320-12-PM	★	☆	☆	☆	☆	6.0	2.0	142°	H9	
13.20	870-1320-12-MM	★	★	★	☆	☆	6.0	2.0	142°	H9	
13.20	870-1320-12-KM	☆	☆	★	☆	☆	5.6	2.5	142°	H9	
13.20	870-1320-12-GP	★	★	★	☆	☆	6.1	1.4	152°	F9	
13.30	870-1330-12-PM	★	☆	☆	☆	☆	6.0	2.0	142°	H9	
13.30	870-1330-12-MM	★	★	★	☆	☆	6.0	2.0	142°	H9	
13.30	870-1330-12-KM	☆	☆	★	☆	☆	5.5	2.5	142°	H9	
13.30	870-1330-12-GP	★	★	★	☆	☆	6.1	1.4	152°	F9	
13.40	870-1340-12-PM	★	☆	☆	☆	☆	5.9	2.1	142°	H9	
13.40	870-1340-12-MM	★	★	★	☆	☆	5.9	2.1	142°	H9	
13.40	870-1340-12-KM	☆	☆	★	☆	☆	5.5	2.5	142°	H9	
13.40	870-1340-12-GP	★	★	★	☆	☆	6.1	1.4	152°	F9	
13.50	13 870-1350-13-PM	★	☆	☆	☆	☆	5.9	2.1	142°	H9	
13.50	870-1350-13-MM	★	★	★	☆	☆	5.9	2.1	142°	H9	
13.50	870-1350-13-KM	☆	☆	★	☆	☆	5.5	2.5	142°	H9	
13.50	870-1350-13-GP	★	★	★	☆	☆	6.1	1.5	152°	F9	
13.60	870-1360-13-PM	★	☆	☆	☆	☆	5.9	2.1	142°	H9	
13.60	870-1360-13-MM	★	★	★	☆	☆	5.9	2.1	142°	H9	
13.60	870-1360-13-KM	☆	☆	★	☆	☆	5.5	2.5	142°	H9	
13.60	870-1360-13-GP	★	★	★	☆	☆	6.0	1.5	152°	F9	
13.70	870-1370-13-PM	★	☆	☆	☆	☆	5.9	2.1	142°	H9	
13.70	870-1370-13-MM	★	★	★	☆	☆	5.9	2.1	142°	H9	
13.70	870-1370-13-KM	☆	☆	★	☆	☆	5.5	2.5	142°	H9	
13.70	870-1370-13-GP	★	★	★	☆	☆	6.0	1.5	152°	F9	
13.80	870-1380-13-PM	★	☆	☆	☆	☆	5.9	2.1	142°	H9	
13.80	870-1380-13-MM	★	★	★	☆	☆	5.9	2.1	142°	H9	
13.80	870-1380-13-KM	☆	☆	★	☆	☆	5.5	2.6	142°	H9	
13.80	870-1380-13-GP	★	★	★	☆	☆	6.0	1.5	152°	F9	
13.90	870-1390-13-PM	★	☆	☆	☆	☆	5.9	2.1	142°	H9	
13.90	870-1390-13-MM	★	★	★	☆	☆	5.9	2.1	142°	H9	
13.90	870-1390-13-KM	☆	☆	★	☆	☆	5.4	2.6	142°	H9	
13.90	870-1390-13-GP	★	★	★	☆	☆	6.0	1.5	152°	F9	



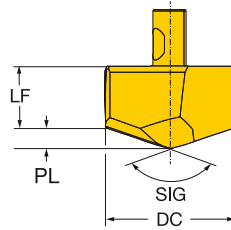
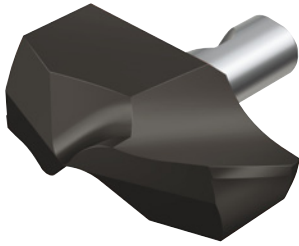
# CoroDrill® 870 drill tip



DC	Ordering code	Dimensions, mm						LF	PL	SIG	TCHA
		P	M	K	N	S					
14.00	870-1400-14-PM	★						6.6	2.1	142°	H9
14.00	870-1400-14-MM		★					6.6	2.1	142°	H9
14.00	870-1400-14-KM	☆		★				6.1	2.6	142°	H9
14.00	870-1400-14-GP	★	★		★			6.7	1.5	152°	F9
14.10	870-1410-14-PM	★						6.6	2.2	142°	H9
14.10	870-1410-14-MM		★					6.6	2.2	142°	H9
14.10	870-1410-14-KM	☆		★				6.1	2.6	142°	H9
14.10	870-1410-14-GP	★	★	★				6.7	1.5	152°	F9
14.20	870-1420-14-PM	★						6.5	2.2	142°	H9
14.20	870-1420-14-MM		★					6.5	2.2	142°	H9
14.20	870-1420-14-KM	☆		★				6.1	2.6	142°	H9
14.20	870-1420-14-GP	★	★	★				6.7	1.5	152°	F9
14.29	870-1429-14-PM	★						6.5	2.2	142°	H9
14.29	870-1429-14-MM		★					6.5	2.2	142°	H9
14.29	870-1429-14-KM	☆		★				6.1	2.6	142°	H9
14.29	870-1429-14-GP	★	★	★				6.7	1.5	152°	F9
14.30	870-1430-14-PM	★						6.5	2.2	142°	H9
14.30	870-1430-14-MM		★					6.5	2.2	142°	H9
14.30	870-1430-14-KM	☆		★				6.1	2.6	142°	H9
14.30	870-1430-14-GP	★	★	★				6.7	1.5	152°	F9
14.40	870-1440-14-PM	★						6.5	2.2	142°	H9
14.40	870-1440-14-MM		★					6.5	2.2	142°	H9
14.40	870-1440-14-KM	☆		★				6.1	2.6	142°	H9
14.40	870-1440-14-GP	★	★	★				6.7	1.5	152°	F9
14.50	870-1450-14-PM	★						6.5	2.2	142°	H9
14.50	870-1450-14-MM		★					6.5	2.2	142°	H9
14.50	870-1450-14-KM	☆		★				6.1	2.6	142°	H9
14.50	870-1450-14-GP	★	★	★				6.7	1.6	152°	F9
14.60	870-1460-14-PM	★						6.5	2.2	142°	H9
14.60	870-1460-14-MM		★					6.5	2.2	142°	H9
14.60	870-1460-14-KM	☆		★				6.0	2.7	142°	H9
14.60	870-1460-14-GP	★	★	★				6.6	1.6	152°	F9
14.70	870-1470-14-PM	★						6.5	2.3	142°	H9
14.70	870-1470-14-MM		★					6.5	2.3	142°	H9
14.70	870-1470-14-KM	☆		★				6.0	2.7	142°	H9
14.70	870-1470-14-GP	★	★	★				6.6	1.6	152°	F9
14.80	870-1480-14-PM	★						6.4	2.3	142°	H9
14.80	870-1480-14-MM		★					6.4	2.3	142°	H9
14.80	870-1480-14-KM	☆		★				6.0	2.7	142°	H9
14.80	870-1480-14-GP	★	★	★				6.6	1.6	152°	F9
14.90	870-1490-14-PM	★						6.4	2.3	142°	H9
14.90	870-1490-14-MM		★					6.4	2.3	142°	H9
14.90	870-1490-14-KM	☆		★				6.0	2.7	142°	H9
14.90	870-1490-14-GP	★	★	★				6.6	1.6	152°	F9



# CoroDrill® 870 drill tip



DC	Ordering code	Dimensions, mm						LF	PL	SIG	TCHA
		P		M		K					
		3334	4334	2334	4334	3334	4334				
15.00	870-1500-15-PM	★	☆					7.0	2.3	142°	H9
15.00	870-1500-15-MM			★				7.0	2.3	142°	H9
15.00	870-1500-15-KM	☆			★			6.5	2.8	142°	H9
15.00	870-1500-15-GP	★	★	★	☆	☆		7.2	1.6	152°	F9
15.10	870-1510-15-PM	★	☆					7.0	2.3	142°	H9
15.10	870-1510-15-MM			★				7.0	2.3	142°	H9
15.10	870-1510-15-KM	☆			★			6.5	2.8	142°	H9
15.10	870-1510-15-GP	★	★	★	☆	☆		7.2	1.6	152°	F9
15.20	870-1520-15-PM	★	☆					7.0	2.3	142°	H9
15.20	870-1520-15-MM			★				7.0	2.3	142°	H9
15.20	870-1520-15-KM	☆			★			6.5	2.8	142°	H9
15.20	870-1520-15-GP	★	★	★	☆	☆		7.2	1.6	152°	F9
15.30	870-1530-15-PM	★	☆					7.0	2.3	142°	H9
15.30	870-1530-15-MM			★				7.0	2.3	142°	H9
15.30	870-1530-15-KM	☆			★			6.5	2.8	142°	H9
15.30	870-1530-15-GP	★	★	★	☆	☆		7.2	1.6	152°	F9
15.40	870-1540-15-PM	★	☆					7.0	2.4	142°	H9
15.40	870-1540-15-MM			★				7.0	2.4	142°	H9
15.40	870-1540-15-KM	☆			★			6.5	2.9	142°	H9
15.40	870-1540-15-GP	★	★	★	☆	☆		7.2	1.6	152°	F9
15.50	870-1550-15-PM	★	☆					6.9	2.4	142°	H9
15.50	870-1550-15-MM			★				6.9	2.4	142°	H9
15.50	870-1550-15-KM	☆			★			6.4	2.9	142°	H9
15.50	870-1550-15-GP	★	★	★	☆	☆		7.2	1.7	152°	F9
15.60	870-1560-15-PM	★	☆					6.9	2.4	142°	H9
15.60	870-1560-15-MM			★				6.9	2.4	142°	H9
15.60	870-1560-15-KM	☆			★			6.4	2.9	142°	H9
15.60	870-1560-15-GP	★	★	★	☆	☆		7.1	1.7	152°	F9
15.70	870-1570-15-PM	★	☆					6.9	2.4	142°	H9
15.70	870-1570-15-MM			★				6.9	2.4	142°	H9
15.70	870-1570-15-KM	☆			★			6.4	2.9	142°	H9
15.70	870-1570-15-GP	★	★	★	☆	☆		7.1	1.7	152°	F9
15.80	870-1580-15-PM	★	☆					6.9	2.4	142°	H9
15.80	870-1580-15-MM			★				6.9	2.4	142°	H9
15.80	870-1580-15-KM	☆			★			6.4	2.9	142°	H9
15.80	870-1580-15-GP	★	★	★	☆	☆		7.1	1.7	152°	F9
15.88	870-1588-15-PM	★	☆					6.9	2.4	142°	H9
15.88	870-1588-15-PL	☆			★			6.0	3.3	142°	H9
15.88	870-1588-15-MM			★				6.9	2.4	142°	H9
15.88	870-1588-15-KM	☆			★			6.4	2.9	142°	H9
15.88	870-1588-15-GP	★	★	★	☆	☆		7.1	1.7	152°	F9
15.90	870-1590-15-PM	★	☆					6.9	2.4	142°	H9
15.90	870-1590-15-MM			★				6.9	2.4	142°	H9
15.90	870-1590-15-KM	☆			★			6.4	2.9	142°	H9
15.90	870-1590-15-GP	★	★	★	☆	☆		7.1	1.7	152°	F9



J6



J50



J5



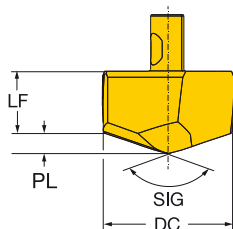
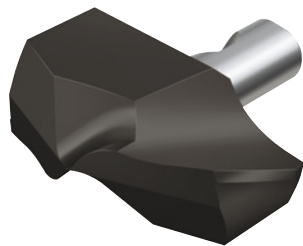
N23



N6



# CoroDrill® 870 drill tip

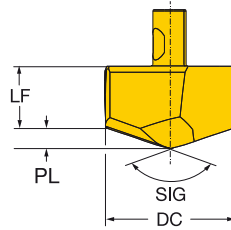
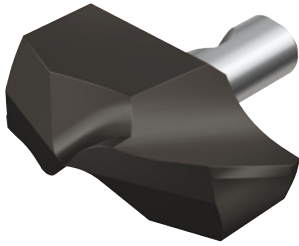


DC	Ordering code	Dimensions, mm					LF	PL	SIG	TCHA
		P	M	K	N	S				
16.00	870-1600-16-PM	★					7.6	2.4	142°	H9
16.00	870-1600-16-MM		★				7.6	2.4	142°	H9
16.00	870-1600-16-KM	☆		★			7.0	3.0	142°	H9
16.00	870-1600-16-GP	★	★		☆		7.8	1.7	152°	F9
16.10	870-1610-16-PM	★			☆		7.6	2.4	142°	H9
16.10	870-1610-16-MM		★			☆	7.6	2.4	142°	H9
16.10	870-1610-16-KM	☆		★			7.0	3.0	142°	H9
16.10	870-1610-16-GP	★	★	★	☆		7.8	1.7	152°	F9
16.13	870-1613-16-PM	★			☆		7.6	2.5	142°	H9
16.13	870-1613-16-PL	☆	★				6.7	3.3	142°	H9
16.13	870-1613-16-MM		★			☆	7.6	2.5	142°	H9
16.13	870-1613-16-KM	☆		★			7.0	3.0	142°	H9
16.13	870-1613-16-GP	★	★	★	☆		7.8	1.7	152°	F9
16.20	870-1620-16-PM	★			☆		7.5	2.5	142°	H9
16.20	870-1620-16-MM		★			☆	7.5	2.5	142°	H9
16.20	870-1620-16-KM	☆		★			7.0	3.0	142°	H9
16.20	870-1620-16-GP	★	★	★	☆		7.8	1.7	152°	F9
16.30	870-1630-16-PM	★			☆		7.5	2.5	142°	H9
16.30	870-1630-16-MM		★			☆	7.5	2.5	142°	H9
16.30	870-1630-16-KM	☆		★			7.0	3.1	142°	H9
16.30	870-1630-16-GP	★	★	★	☆		7.8	1.7	152°	F9
16.40	870-1640-16-PM	★			☆		7.5	2.5	142°	H9
16.40	870-1640-16-MM		★			☆	7.5	2.5	142°	H9
16.40	870-1640-16-KM	☆		★			6.9	3.1	142°	H9
16.40	870-1640-16-GP	★	★	★	☆		7.8	1.7	152°	F9
16.50	870-1650-16-PM	★			☆		7.5	2.5	142°	H9
16.50	870-1650-16-MM		★			☆	7.5	2.5	142°	H9
16.50	870-1650-16-KM	☆		★			6.9	3.1	142°	H9
16.50	870-1650-16-GP	★	★	★	☆		7.8	1.8	152°	F9
16.60	870-1660-16-PM	★			☆		7.5	2.5	142°	H9
16.60	870-1660-16-MM		★			☆	7.5	2.5	142°	H9
16.60	870-1660-16-KM	☆		★			6.9	3.1	142°	H9
16.60	870-1660-16-GP	★	★	★	☆		7.7	1.8	152°	F9
16.70	870-1670-16-PM	★			☆		7.5	2.5	142°	H9
16.70	870-1670-16-MM		★			☆	7.5	2.5	142°	H9
16.70	870-1670-16-KM	☆		★			6.9	3.1	142°	H9
16.70	870-1670-16-GP	★	★	★	☆		7.7	1.8	152°	F9
16.80	870-1680-16-PM	★			☆		7.4	2.6	142°	H9
16.80	870-1680-16-MM		★			☆	7.4	2.6	142°	H9
16.80	870-1680-16-KM	☆		★			6.9	3.1	142°	H9
16.80	870-1680-16-GP	★	★	★	☆		7.7	1.8	152°	F9
16.90	870-1690-16-PM	★			☆		7.4	2.6	142°	H9
16.90	870-1690-16-MM		★			☆	7.4	2.6	142°	H9
16.90	870-1690-16-KM	☆		★			6.9	3.2	142°	H9
16.90	870-1690-16-GP	★	★	★	☆		7.7	1.8	152°	F9





# CoroDrill® 870 drill tip



DC	Ordering code	Dimensions, mm						LF	PL	SIG	TCHA
		P		M		K					
		3334	4334	2334	4334	3334	4334				
17.00	870-1700-17-PM	★						8.0	2.6	142°	H9
17.00	870-1700-17-MM		★				8.0	2.6	142°	H9	
17.00	870-1700-17-KM	☆			★		7.4	3.2	142°	H9	
17.00	870-1700-17-GP		★	★		★	8.2	1.8	152°	F9	
17.10	870-1710-17-PM		★				8.0	2.6	142°	H9	
17.10	870-1710-17-MM		★				8.0	2.6	142°	H9	
17.10	870-1710-17-KM	☆			★		7.4	3.2	142°	H9	
17.10	870-1710-17-GP		★	★		★	8.2	1.8	152°	F9	
17.20	870-1720-17-PM		★				8.0	2.6	142°	H9	
17.20	870-1720-17-MM		★				8.0	2.6	142°	H9	
17.20	870-1720-17-KM	☆			★		7.3	3.3	142°	H9	
17.20	870-1720-17-GP		★	★		★	8.2	1.8	152°	F9	
17.30	870-1730-17-PM		★				8.0	2.6	142°	H9	
17.30	870-1730-17-MM		★				8.0	2.6	142°	H9	
17.30	870-1730-17-KM	☆			★		7.3	3.3	142°	H9	
17.30	870-1730-17-GP		★	★		★	8.2	1.8	152°	F9	
17.40	870-1740-17-PM		★				8.0	2.7	142°	H9	
17.40	870-1740-17-MM		★				8.0	2.7	142°	H9	
17.40	870-1740-17-KM	☆			★		7.3	3.3	142°	H9	
17.40	870-1740-17-GP		★	★		★	8.2	1.8	152°	F9	
17.46	870-1746-17-PM		★				7.9	2.7	142°	H9	
17.46	870-1746-17-MM		★				7.9	2.7	142°	H9	
17.46	870-1746-17-KM	☆			★		7.3	3.3	142°	H9	
17.46	870-1746-17-GP		★	★		★	8.2	1.8	152°	F9	
17.50	870-1750-17-PM		★				7.9	2.7	142°	H9	
17.50	870-1750-17-MM		★				7.9	2.7	142°	H9	
17.50	870-1750-17-KM	☆			★		7.3	3.3	142°	H9	
17.50	870-1750-17-GP		★	★		★	8.2	1.9	152°	F9	
17.60	870-1760-17-PM		★				7.9	2.7	142°	H9	
17.60	870-1760-17-MM		★				7.9	2.7	142°	H9	
17.60	870-1760-17-KM	☆			★		7.3	3.3	142°	H9	
17.60	870-1760-17-GP		★	★		★	8.1	1.9	152°	F9	
17.70	870-1770-17-PM		★				7.9	2.7	142°	H9	
17.70	870-1770-17-MM		★				7.9	2.7	142°	H9	
17.70	870-1770-17-KM	☆			★		7.3	3.3	142°	H9	
17.70	870-1770-17-GP		★	★		★	8.1	1.9	152°	F9	
17.80	870-1780-17-PM		★				7.9	2.7	142°	H9	
17.80	870-1780-17-MM		★				7.9	2.7	142°	H9	
17.80	870-1780-17-KM	☆			★		7.2	3.4	142°	H9	
17.80	870-1780-17-GP		★	★		★	8.1	1.9	152°	F9	
17.90	870-1790-17-PM		★				7.9	2.7	142°	H9	
17.90	870-1790-17-MM		★				7.9	2.7	142°	H9	
17.90	870-1790-17-KM	☆			★		7.2	3.4	142°	H9	
17.90	870-1790-17-GP		★	★		★	8.1	1.9	152°	F9	



J6



J50



J5



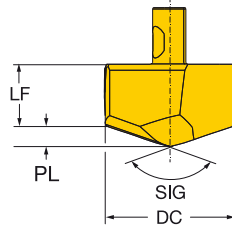
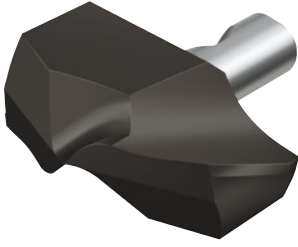
N23



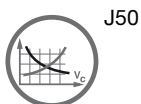
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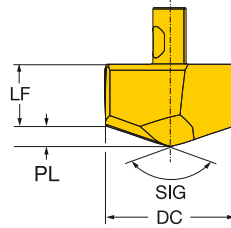
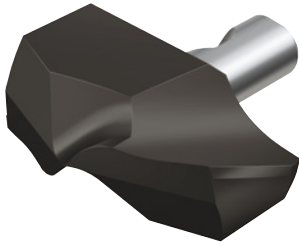
# CoroDrill® 870 drill tip



DC	Ordering code	Dimensions, mm						LF	PL	SIG	TCHA
		P	M	K	N	S					
18.00	870-1800-18-PM	★					8.6	2.7	142°	H9	
18.00	870-1800-18-MM		★				8.6	2.7	142°	H9	
18.00	870-1800-18-KM	☆		★			7.9	3.4	142°	H9	
18.00	870-1800-18-GP	★	★		★	☆	8.8	1.9	152°	F9	
18.10	870-1810-18-PM	★			☆	☆	8.6	2.7	142°	H9	
18.10	870-1810-18-MM		★			☆	8.6	2.7	142°	H9	
18.10	870-1810-18-KM	☆		★			7.9	3.4	142°	H9	
18.10	870-1810-18-GP	★	★	★	☆	☆	8.8	1.9	152°	F9	
18.20	870-1820-18-PM	★			☆	☆	8.6	2.8	142°	H9	
18.20	870-1820-18-MM		★			☆	8.6	2.8	142°	H9	
18.20	870-1820-18-KM	☆		★			7.9	3.4	142°	H9	
18.20	870-1820-18-GP	★	★	★	☆	☆	8.8	1.9	152°	F9	
18.30	870-1830-18-PM	★			☆	☆	8.5	2.8	142°	H9	
18.30	870-1830-18-MM		★			☆	8.5	2.8	142°	H9	
18.30	870-1830-18-KM	☆		★			7.9	3.4	142°	H9	
18.30	870-1830-18-GP	★	★	★	☆	☆	8.8	1.9	152°	F9	
18.40	870-1840-18-PM	★			☆	☆	8.5	2.8	142°	H9	
18.40	870-1840-18-MM		★			☆	8.5	2.8	142°	H9	
18.40	870-1840-18-KM	☆		★			7.9	3.4	142°	H9	
18.40	870-1840-18-GP	★	★	★	☆	☆	8.8	1.9	152°	F9	
18.50	870-1850-18-PM	★			☆	☆	8.5	2.8	142°	H9	
18.50	870-1850-18-MM		★			☆	8.5	2.8	142°	H9	
18.50	870-1850-18-KM	☆		★			7.9	3.5	142°	H9	
18.50	870-1850-18-GP	★	★	★	☆	☆	8.8	1.9	152°	F9	
18.60	870-1860-18-PM	★			☆	☆	8.5	2.8	142°	H9	
18.60	870-1860-18-MM		★			☆	8.5	2.8	142°	H9	
18.60	870-1860-18-KM	☆		★			7.8	3.5	142°	H9	
18.60	870-1860-18-GP	★	★	★	☆	☆	8.8	2.0	152°	F9	
18.70	870-1870-18-PM	★			☆	☆	8.5	2.8	142°	H9	
18.70	870-1870-18-MM		★			☆	8.5	2.8	142°	H9	
18.70	870-1870-18-KM	☆		★			7.8	3.5	142°	H9	
18.70	870-1870-18-GP	★	★	★	☆	☆	8.7	2.0	152°	F9	
18.80	870-1880-18-PM	★			☆	☆	8.5	2.9	142°	H9	
18.80	870-1880-18-MM		★			☆	8.5	2.9	142°	H9	
18.80	870-1880-18-KM	☆		★			7.8	3.5	142°	H9	
18.80	870-1880-18-GP	★	★	★	☆	☆	8.7	2.0	152°	F9	
18.90	870-1890-18-PM	★			☆	☆	8.4	2.9	142°	H9	
18.90	870-1890-18-MM		★			☆	8.4	2.9	142°	H9	
18.90	870-1890-18-KM	☆		★			7.8	3.5	142°	H9	
18.90	870-1890-18-GP	★	★	★	☆	☆	8.7	2.0	152°	F9	



# CoroDrill® 870 drill tip



DC	Ordering code	Dimensions, mm						LF	PL	SIG	TCHA
		P		M		K					
		3334	4334	2334	4334	3334	4334				
19.00	870-1900-19-PM	★	☆	☆	☆	☆	☆	9.0	2.9	142°	H9
19.00	870-1900-19-MM		★					9.0	2.9	142°	H9
19.00	870-1900-19-KM	☆		★				8.3	3.6	142°	H9
19.00	870-1900-19-GP	★	★	★	☆	☆	☆	9.2	2.0	152°	F9
19.05	870-1905-19-PM	★	☆	☆	☆	☆	☆	9.0	2.9	142°	H9
19.05	870-1905-19-PL	☆	★					8.0	3.8	142°	H9
19.05	870-1905-19-MM		★					9.0	2.9	142°	H9
19.05	870-1905-19-KM	☆		★				8.3	3.6	142°	H9
19.05	870-1905-19-GP	★	★	★	☆	☆	☆	9.2	2.0	152°	F9
19.10	870-1910-19-PM	★	☆	☆	☆	☆	☆	9.0	2.9	142°	H9
19.10	870-1910-19-MM		★					9.0	2.9	142°	H9
19.10	870-1910-19-KM	☆		★				8.3	3.6	142°	H9
19.10	870-1910-19-GP	★	★	★	☆	☆	☆	9.2	2.0	152°	F9
19.20	870-1920-19-PM	★	☆	☆	☆	☆	☆	9.0	2.9	142°	H9
19.20	870-1920-19-PL	☆	★					8.0	3.9	142°	H9
19.20	870-1920-19-MM		★					9.0	2.9	142°	H9
19.20	870-1920-19-KM	☆		★				8.3	3.6	142°	H9
19.20	870-1920-19-GP	★	★	★	☆	☆	☆	9.2	2.0	152°	F9
19.25	870-1925-19-PM	★	☆	☆	☆	☆	☆	9.0	2.9	142°	H9
19.25	870-1925-19-PL	☆	★					8.0	3.9	142°	H9
19.25	870-1925-19-MM		★					9.0	2.9	142°	H9
19.25	870-1925-19-KM	☆		★				8.3	3.6	142°	H9
19.25	870-1925-19-GP	★	★	★	☆	☆	☆	9.2	2.0	152°	F9
19.30	870-1930-19-PM	★	☆	☆	☆	☆	☆	9.0	2.9	142°	H9
19.30	870-1930-19-PL	☆	★					8.0	4.0	142°	H9
19.30	870-1930-19-MM		★					9.0	2.9	142°	H9
19.30	870-1930-19-KM	☆		★				8.3	3.6	142°	H9
19.30	870-1930-19-GP	★	★	★	☆	☆	☆	9.2	2.0	152°	F9
19.40	870-1940-19-PM	★	☆	☆	☆	☆	☆	9.0	2.9	142°	H9
19.40	870-1940-19-MM		★					9.0	2.9	142°	H9
19.40	870-1940-19-KM	☆		★				8.2	3.7	142°	H9
19.40	870-1940-19-GP	★	★	★	☆	☆	☆	9.2	2.0	152°	F9
19.50	870-1950-19-PM	★	☆	☆	☆	☆	☆	8.9	3.0	142°	H9
19.50	870-1950-19-MM		★					8.9	3.0	142°	H9
19.50	870-1950-19-KM	☆		★				8.2	3.7	142°	H9
19.50	870-1950-19-GP	★	★	★	☆	☆	☆	9.2	2.1	152°	F9
19.60	870-1960-19-PM	★	☆	☆	☆	☆	☆	8.9	3.0	142°	H9
19.60	870-1960-19-MM		★					8.9	3.0	142°	H9
19.60	870-1960-19-KM	☆		★				8.2	3.7	142°	H9
19.60	870-1960-19-GP	★	★	★	☆	☆	☆	9.1	2.1	152°	F9
19.70	870-1970-19-PM	★	☆	☆	☆	☆	☆	8.9	3.0	142°	H9
19.70	870-1970-19-MM		★					8.9	3.0	142°	H9
19.70	870-1970-19-KM	☆		★				8.2	3.7	142°	H9
19.70	870-1970-19-GP	★	★	★	☆	☆	☆	9.1	2.1	152°	F9
19.80	870-1980-19-PM	★	☆	☆	☆	☆	☆	8.9	3.0	142°	H9
19.80	870-1980-19-MM		★					8.9	3.0	142°	H9
19.80	870-1980-19-KM	☆		★				8.2	3.7	142°	H9
19.80	870-1980-19-GP	★	★	★	☆	☆	☆	9.1	2.1	152°	F9
19.90	870-1990-19-PM	★	☆	☆	☆	☆	☆	8.9	3.0	142°	H9
19.90	870-1990-19-MM		★					8.9	3.0	142°	H9
19.90	870-1990-19-KM	☆		★				8.2	3.7	142°	H9
19.90	870-1990-19-GP	★	★	★	☆	☆	☆	9.1	2.1	152°	F9



J6



J50



J5



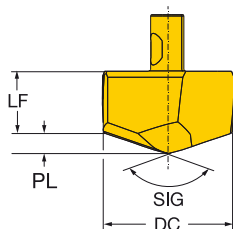
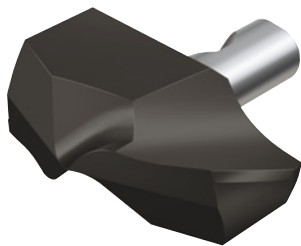
N23



N6



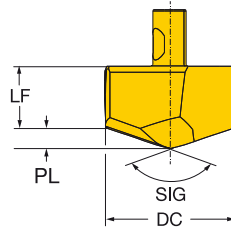
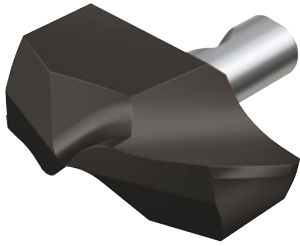
# CoroDrill® 870 drill tip



DC	Ordering code	Material					Dimensions, mm			
		P	M	K	N	S	LF	PL	SIG	TCHA
20.00	870-2000-20-PM	★					9.5	3.0	142°	H9
20.00	870-2000-20-MM		★				9.5	3.0	142°	H9
20.00	870-2000-20-KM	☆		★			8.7	3.8	142°	H9
20.00	870-2000-20-GP	★	★		☆	☆	9.7	2.1	152°	F9
20.10	870-2010-20-PM	★			☆	☆	9.5	3.0	142°	H9
20.10	870-2010-20-MM		★			☆	9.5	3.0	142°	H9
20.10	870-2010-20-KM	☆		★			8.7	3.8	142°	H9
20.10	870-2010-20-GP	★	★	★	☆	☆	9.7	2.1	152°	F9
20.20	870-2020-20-PM	★			☆	☆	9.4	3.1	142°	H9
20.20	870-2020-20-MM		★			☆	9.4	3.1	142°	H9
20.20	870-2020-20-KM	☆		★			8.7	3.9	142°	H9
20.20	870-2020-20-GP	★	★	★	☆	☆	9.7	2.1	152°	F9
20.30	870-2030-20-PM	★			☆	☆	9.4	3.1	142°	H9
20.30	870-2030-20-MM		★			☆	9.4	3.1	142°	H9
20.30	870-2030-20-KM	☆		★			8.6	3.9	142°	H9
20.30	870-2030-20-GP	★	★	★	☆	☆	9.7	2.1	152°	F9
20.40	870-2040-20-PM	★			☆	☆	9.4	3.1	142°	H9
20.40	870-2040-20-MM		★			☆	9.4	3.1	142°	H9
20.40	870-2040-20-KM	☆		★			8.6	3.9	142°	H9
20.40	870-2040-20-GP	★	★	★	☆	☆	9.7	2.1	152°	F9
20.50	870-2050-20-PM	★			☆	☆	9.4	3.1	142°	H9
20.50	870-2050-20-MM		★			☆	9.4	3.1	142°	H9
20.50	870-2050-20-KM	☆		★			8.6	3.9	142°	H9
20.50	870-2050-20-GP	★	★	★	☆	☆	9.7	2.2	152°	F9
20.60	870-2060-20-PM	★			☆	☆	9.4	3.1	142°	H9
20.60	870-2060-20-MM		★			☆	9.4	3.1	142°	H9
20.60	870-2060-20-KM	☆		★			8.6	3.9	142°	H9
20.60	870-2060-20-GP	★	★	★	☆	☆	9.7	2.2	152°	F9
20.64	870-2064-20-PM	★			☆	☆	9.4	3.1	142°	H9
20.64	870-2064-20-MM		★			☆	9.4	3.1	142°	H9
20.64	870-2064-20-KM	☆		★			8.6	3.9	142°	H9
20.64	870-2064-20-GP	★	★	★	☆	☆	9.6	2.2	152°	F9
20.70	870-2070-20-PM	★			☆	☆	9.4	3.1	142°	H9
20.70	870-2070-20-MM		★			☆	9.4	3.1	142°	H9
20.70	870-2070-20-KM	☆		★			8.6	3.9	142°	H9
20.70	870-2070-20-GP	★	★	★	☆	☆	9.6	2.2	152°	F9
20.80	870-2080-20-PM	★			☆	☆	9.3	3.2	142°	H9
20.80	870-2080-20-MM		★			☆	9.3	3.2	142°	H9
20.80	870-2080-20-KM	☆		★			8.6	4.0	142°	H9
20.80	870-2080-20-GP	★	★	★	☆	☆	9.6	2.2	152°	F9
20.90	870-2090-20-PM	★			☆	☆	9.3	3.2	142°	H9
20.90	870-2090-20-MM		★			☆	9.3	3.2	142°	H9
20.90	870-2090-20-KM	☆		★			8.5	4.0	142°	H9
20.90	870-2090-20-GP	★	★	★	☆	☆	9.6	2.2	152°	F9



# CoroDrill® 870 drill tip



DC	Ordering code	Material					Dimensions, mm			
		P	M	K	N	S	LF	PL	SIG	TCHA
21.00	870-2100-21-PM	★					10.0	3.2	142°	H9
21.00	870-2100-21-MM		★				10.0	3.2	142°	H9
21.00	870-2100-21-KM	☆		★			9.2	4.0	142°	H9
21.00	870-2100-21-GP	★	★				10.3	2.2	152°	F9
21.10	870-2110-21-PM	★					10.0	3.2	142°	H9
21.10	870-2110-21-MM		★				10.0	3.2	142°	H9
21.10	870-2110-21-KM	☆		★			9.2	4.0	142°	H9
21.10	870-2110-21-GP	★	★	★			10.3	2.2	152°	F9
21.20	870-2120-21-PM	★					10.0	3.2	142°	H9
21.20	870-2120-21-MM		★				10.0	3.2	142°	H9
21.20	870-2120-21-KM	☆		★			9.2	4.0	142°	H9
21.20	870-2120-21-GP	★	★	★			10.3	2.2	152°	F9
21.30	870-2130-21-PM	★					10.0	3.2	142°	H9
21.30	870-2130-21-MM		★				10.0	3.2	142°	H9
21.30	870-2130-21-KM	☆		★			9.2	4.0	142°	H9
21.30	870-2130-21-GP	★	★	★			10.3	2.2	152°	F9
21.40	870-2140-21-PM	★					10.0	3.2	142°	H9
21.40	870-2140-21-MM		★				10.0	3.2	142°	H9
21.40	870-2140-21-KM	☆		★			9.2	4.0	142°	H9
21.40	870-2140-21-GP	★	★	★			10.3	2.2	152°	F9
21.50	870-2150-21-PM	★					10.0	3.3	142°	H9
21.50	870-2150-21-MM		★				10.0	3.3	142°	H9
21.50	870-2150-21-KM	☆		★			9.2	4.0	142°	H9
21.50	870-2150-21-GP	★	★	★			10.3	2.2	152°	F9
21.60	870-2160-21-PM	★					9.9	3.3	142°	H9
21.60	870-2160-21-MM		★				9.9	3.3	142°	H9
21.60	870-2160-21-KM	☆		★			9.1	4.1	142°	H9
21.60	870-2160-21-GP	★	★	★			10.3	2.3	152°	F9
21.70	870-2170-21-PM	★					9.9	3.3	142°	H9
21.70	870-2170-21-MM		★				9.9	3.3	142°	H9
21.70	870-2170-21-KM	☆		★			9.1	4.1	142°	H9
21.70	870-2170-21-GP	★	★	★			10.2	2.3	152°	F9
21.80	870-2180-21-PM	★					9.9	3.3	142°	H9
21.80	870-2180-21-MM		★				9.9	3.3	142°	H9
21.80	870-2180-21-KM	☆		★			9.1	4.1	142°	H9
21.80	870-2180-21-GP	★	★	★			10.2	2.3	152°	F9
21.90	870-2190-21-PM	★					9.9	3.3	142°	H9
21.90	870-2190-21-MM		★				9.9	3.3	142°	H9
21.90	870-2190-21-KM	☆		★			9.1	4.1	142°	H9
21.90	870-2190-21-GP	★	★	★			10.2	2.3	152°	F9



J6



J50



J5



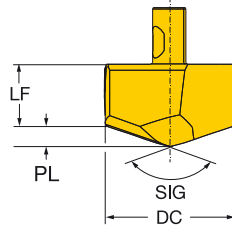
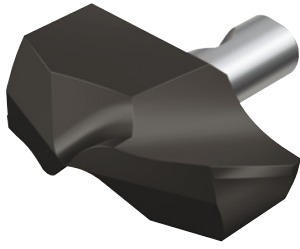
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N6



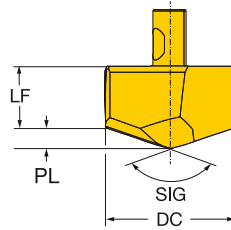
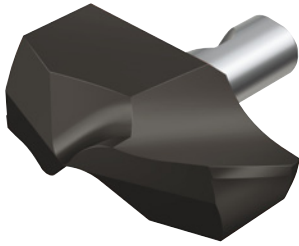
# CoroDrill® 870 drill tip



DC	Ordering code	Material					Dimensions, mm			
		P	M	K	N	S	LF	PL	SIG	TCHA
22.00	870-2200-22-PM	★					10.5	3.3	142°	H9
22.00	870-2200-22-MM		★				10.5	3.3	142°	H9
22.00	870-2200-22-KM	☆		★			9.6	4.2	142°	H9
22.00	870-2200-22-GP	★	★		☆	☆	10.8	2.3	152°	F9
22.10	870-2210-22-PM	★			☆	☆	10.5	3.3	142°	H9
22.10	870-2210-22-MM		★			☆	10.5	3.3	142°	H9
22.10	870-2210-22-KM	☆		★			9.6	4.2	142°	H9
22.10	870-2210-22-GP	★	★	★	☆	☆	10.8	2.3	152°	F9
22.20	870-2220-22-PM	★			☆	☆	10.5	3.4	142°	H9
22.20	870-2220-22-PL	☆	★				9.3	4.5	142°	H9
22.20	870-2220-22-MM		★			☆	10.5	3.4	142°	H9
22.20	870-2220-22-KM	☆		★			9.6	4.2	142°	H9
22.20	870-2220-22-GP	★	★	★	☆	☆	10.8	2.3	152°	F9
22.23	870-2223-22-PM	★			☆	☆	10.5	3.4	142°	H9
22.23	870-2223-22-MM		★			☆	10.5	3.4	142°	H9
22.23	870-2223-22-KM	☆		★			9.6	4.2	142°	H9
22.23	870-2223-22-GP	★	★	★	☆	☆	10.8	2.3	152°	F9
22.30	870-2230-22-PM	★			☆	☆	10.4	3.4	142°	H9
22.30	870-2230-22-MM		★			☆	10.4	3.4	142°	H9
22.30	870-2230-22-KM	☆		★			9.6	4.2	142°	H9
22.30	870-2230-22-GP	★	★	★	☆	☆	10.8	2.3	152°	F9
22.40	870-2240-22-PM	★			☆	☆	10.4	3.4	142°	H9
22.40	870-2240-22-MM		★			☆	10.4	3.4	142°	H9
22.40	870-2240-22-KM	☆		★			9.6	4.2	142°	H9
22.40	870-2240-22-GP	★	★	★	☆	☆	10.8	2.3	152°	F9
22.50	870-2250-22-PM	★			☆	☆	10.4	3.4	142°	H9
22.50	870-2250-22-MM		★			☆	10.4	3.4	142°	H9
22.50	870-2250-22-KM	☆		★			9.5	4.3	142°	H9
22.50	870-2250-22-GP	★	★	★	☆	☆	10.8	2.4	152°	F9
22.60	870-2260-22-PM	★			☆	☆	10.4	3.4	142°	H9
22.60	870-2260-22-MM		★			☆	10.4	3.4	142°	H9
22.60	870-2260-22-KM	☆		★			9.5	4.3	142°	H9
22.60	870-2260-22-GP	★	★	★	☆	☆	10.7	2.4	152°	F9
22.70	870-2270-22-PM	★			☆	☆	10.4	3.4	142°	H9
22.70	870-2270-22-MM		★			☆	10.4	3.4	142°	H9
22.70	870-2270-22-KM	☆		★			9.5	4.3	142°	H9
22.70	870-2270-22-GP	★	★	★	☆	☆	10.7	2.4	152°	F9
22.80	870-2280-22-PM	★			☆	☆	10.4	3.5	142°	H9
22.80	870-2280-22-MM		★			☆	10.4	3.5	142°	H9
22.80	870-2280-22-KM	☆		★			9.5	4.3	142°	H9
22.80	870-2280-22-GP	★	★	★	☆	☆	10.7	2.4	152°	F9
22.90	870-2290-22-PM	★			☆	☆	10.3	3.5	142°	H9
22.90	870-2290-22-MM		★			☆	10.3	3.5	142°	H9
22.90	870-2290-22-KM	☆		★			9.5	4.3	142°	H9
22.90	870-2290-22-GP	★	★	★	☆	☆	10.7	2.4	152°	F9



# CoroDrill® 870 drill tip



DC	Ordering code	Material						Dimensions, mm					
		P		M		K		N	S	LF	PL	SIG	TCHA
		3334	4334	2334	4334	3334	4334	2334	4334				
23.00	23 870-2300-23-PM	★								11.0	3.5	142°	H9
23.00	870-2300-23-MM		★							11.0	3.5	142°	H9
23.00	870-2300-23-KM	☆		★						10.1	4.4	142°	H9
23.00	870-2300-23-GP	★		★						11.4	2.4	152°	F9
23.10	870-2310-23-PM	★								11.0	3.5	142°	H9
23.10	870-2310-23-MM		★							11.0	3.5	142°	H9
23.10	870-2310-23-KM	☆		★						10.1	4.4	142°	H9
23.10	870-2310-23-GP	★		★						11.4	2.4	152°	F9
23.20	870-2320-23-PM	★								11.0	3.5	142°	H9
23.20	870-2320-23-MM		★							11.0	3.5	142°	H9
23.20	870-2320-23-KM	☆		★						10.1	4.4	142°	H9
23.20	870-2320-23-GP	★		★						11.4	2.4	152°	F9
23.30	870-2330-23-PM	★								11.0	3.5	142°	H9
23.30	870-2330-23-MM		★							11.0	3.5	142°	H9
23.30	870-2330-23-KM	☆		★						10.1	4.5	142°	H9
23.30	870-2330-23-GP	★		★						11.4	2.4	152°	F9
23.40	870-2340-23-PM	★								11.0	3.5	142°	H9
23.40	870-2340-23-MM		★							11.0	3.5	142°	H9
23.40	870-2340-23-KM	☆		★						10.0	4.5	142°	H9
23.40	870-2340-23-GP	★		★						11.4	2.4	152°	F9
23.50	870-2350-23-PM	★								11.0	3.5	142°	H9
23.50	870-2350-23-MM		★							11.0	3.5	142°	H9
23.50	870-2350-23-KM	☆		★						10.0	4.5	142°	H9
23.50	870-2350-23-GP	★		★						11.4	2.4	152°	F9
23.60	870-2360-23-PM	★								10.9	3.6	142°	H9
23.60	870-2360-23-MM		★							10.9	3.6	142°	H9
23.60	870-2360-23-KM	☆		★						10.0	4.5	142°	H9
23.60	870-2360-23-GP	★		★						11.4	2.4	152°	F9
23.70	870-2370-23-PM	★								10.9	3.6	142°	H9
23.70	870-2370-23-MM		★							10.9	3.6	142°	H9
23.70	870-2370-23-KM	☆		★						10.0	4.5	142°	H9
23.70	870-2370-23-GP	★		★						11.4	2.5	152°	F9
23.80	870-2380-23-PM	★								10.9	3.6	142°	H9
23.80	870-2380-23-PL	☆		★						9.7	4.8	142°	H9
23.80	870-2380-23-MM		★							10.9	3.6	142°	H9
23.80	870-2380-23-KM	☆		★						10.0	4.5	142°	H9
23.80	870-2380-23-GP	★		★						11.3	2.5	152°	F9
23.81	870-2381-23-PM	★								10.9	3.6	142°	H9
23.81	870-2381-23-MM		★							10.9	3.6	142°	H9
23.81	870-2381-23-KM	☆		★						10.0	4.5	142°	H9
23.81	870-2381-23-GP	★		★						11.3	2.5	152°	F9
23.90	870-2390-23-PM	★								10.9	3.6	142°	H9
23.90	870-2390-23-MM		★							10.9	3.6	142°	H9
23.90	870-2390-23-KM	☆		★						10.0	4.6	142°	H9
23.90	870-2390-23-GP	★		★						11.3	2.5	152°	F9



J6



J50



J5



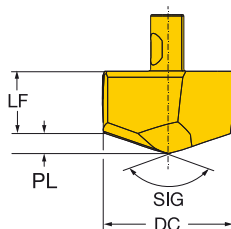
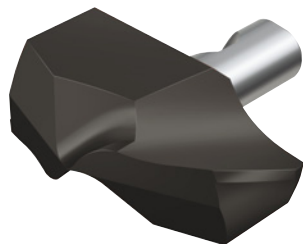
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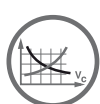
# CoroDrill® 870 drill tip



DC	Ordering code	Material					Dimensions, mm			
		P	M	K	N	S	LF	PL	SIG	TCHA
24.00	870-2400-24-PM	★					11.4	3.6	142°	H9
24.00	870-2400-24-MM		★				11.4	3.6	142°	H9
24.00	870-2400-24-KM	☆		★			10.4	4.6	142°	H9
24.00	870-2400-24-GP	★	★		★	☆	11.8	2.5	152°	F9
24.10	870-2410-24-PM	★			☆	☆	11.4	3.6	142°	H9
24.10	870-2410-24-MM		★			☆	11.4	3.6	142°	H9
24.10	870-2410-24-KM	☆		★			10.4	4.7	142°	H9
24.10	870-2410-24-GP	★	★	★	☆	☆	11.8	2.5	152°	F9
24.20	870-2420-24-PM	★			☆	☆	11.4	3.7	142°	H9
24.20	870-2420-24-MM		★			☆	11.4	3.7	142°	H9
24.20	870-2420-24-KM	☆		★			10.3	4.7	142°	H9
24.20	870-2420-24-GP	★	★	★	☆	☆	11.8	2.5	152°	F9
24.30	870-2430-24-PM	★			☆	☆	11.3	3.7	142°	H9
24.30	870-2430-24-MM		★			☆	11.3	3.7	142°	H9
24.30	870-2430-24-KM	☆		★			10.3	4.7	142°	H9
24.30	870-2430-24-GP	★	★	★	☆	☆	11.8	2.5	152°	F9
24.40	870-2440-24-PM	★			☆	☆	11.3	3.7	142°	H9
24.40	870-2440-24-MM		★			☆	11.3	3.7	142°	H9
24.40	870-2440-24-KM	☆		★			10.3	4.7	142°	H9
24.40	870-2440-24-GP	★	★	★	☆	☆	11.8	2.6	152°	F9
24.50	870-2450-24-PM	★			☆	☆	11.3	3.7	142°	H9
24.50	870-2450-24-MM		★			☆	11.3	3.7	142°	H9
24.50	870-2450-24-KM	☆		★			10.3	4.7	142°	H9
24.50	870-2450-24-GP	★	★	★	☆	☆	11.7	2.6	152°	F9
24.60	870-2460-24-PM	★			☆	☆	11.3	3.7	142°	H9
24.60	870-2460-24-MM		★			☆	11.3	3.7	142°	H9
24.60	870-2460-24-KM	☆		★			10.3	4.7	142°	H9
24.60	870-2460-24-GP	★	★	★	☆	☆	11.7	2.6	152°	F9
24.70	870-2470-24-PM	★			☆	☆	11.3	3.7	142°	H9
24.70	870-2470-24-MM		★			☆	11.3	3.7	142°	H9
24.70	870-2470-24-KM	☆		★			10.3	4.8	142°	H9
24.70	870-2470-24-GP	★	★	★	☆	☆	11.7	2.6	152°	F9
24.80	870-2480-24-PM	★			☆	☆	11.3	3.8	142°	H9
24.80	870-2480-24-MM		★			☆	11.3	3.8	142°	H9
24.80	870-2480-24-KM	☆		★			10.2	4.8	142°	H9
24.80	870-2480-24-GP	★	★	★	☆	☆	11.7	2.6	152°	F9
24.90	870-2490-24-PM	★			☆	☆	11.2	3.8	142°	H9
24.90	870-2490-24-MM		★			☆	11.2	3.8	142°	H9
24.90	870-2490-24-KM	☆		★			10.2	4.8	142°	H9
24.90	870-2490-24-GP	★	★	★	☆	☆	11.7	2.6	152°	F9



J6



J50



J5



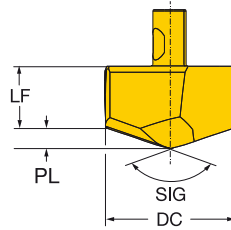
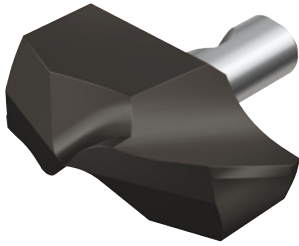
N23



N6



# CoroDrill® 870 drill tip



DC	Ordering code	Dimensions, mm						LF	PL	SIG	TCHA
		P		M		K					
		3334	4334	2334	4334	3334	4334				
25.00	25 870-2500-25-PM	★	★	☆	☆	☆	☆	11.9	3.8	142°	H9
25.00	870-2500-25-MM		★				☆	11.9	3.8	142°	H9
25.00	870-2500-25-KM	☆		★				10.9	4.8	142°	H9
25.00	870-2500-25-GP	★	★	★	☆	☆	☆	12.3	2.6	152°	F9
25.10	870-2510-25-PM	★	★	☆	☆	☆	☆	11.9	3.8	142°	H9
25.10	870-2510-25-MM		★				☆	11.9	3.8	142°	H9
25.10	870-2510-25-KM	☆		★				10.9	4.8	142°	H9
25.10	870-2510-25-GP	★	★	★	☆	☆	☆	12.3	2.7	152°	F9
25.20	870-2520-25-PM	★	★	☆	☆	☆	☆	11.9	3.8	142°	H9
25.20	870-2520-25-MM		★				☆	11.9	3.8	142°	H9
25.20	870-2520-25-KM	☆		★				10.9	4.8	142°	H9
25.20	870-2520-25-GP	★	★	★	☆	☆	☆	12.2	2.7	152°	F9
25.30	870-2530-25-PM	★	★	☆	☆	☆	☆	11.9	3.8	142°	H9
25.30	870-2530-25-MM		★				☆	11.9	3.8	142°	H9
25.30	870-2530-25-KM	☆		★				10.9	4.8	142°	H9
25.30	870-2530-25-GP	★	★	★	☆	☆	☆	12.2	2.7	152°	F9
25.40	870-2540-25-PM	★	★	☆	☆	☆	☆	11.9	3.8	142°	H9
25.40	870-2540-25-MM		★				☆	11.9	3.8	142°	H9
25.40	870-2540-25-KM	☆		★				10.9	4.8	142°	H9
25.40	870-2540-25-GP	★	★	★	☆	☆	☆	12.2	2.7	152°	F9
25.50	870-2550-25-PM	★	★	☆	☆	☆	☆	11.9	3.8	142°	H9
25.50	870-2550-25-MM		★				☆	11.9	3.8	142°	H9
25.50	870-2550-25-KM	☆		★				10.9	4.9	142°	H9
25.50	870-2550-25-GP	★	★	★	☆	☆	☆	12.2	2.7	152°	F9
25.60	870-2560-25-PM	★	★	☆	☆	☆	☆	11.8	3.9	142°	H9
25.60	870-2560-25-MM		★				☆	11.8	3.9	142°	H9
25.60	870-2560-25-KM	☆		★				10.8	4.9	142°	H9
25.60	870-2560-25-GP	★	★	★	☆	☆	☆	12.2	2.7	152°	F9
25.65	870-2565-25-PL	☆	★					10.5	5.2	142°	H9
25.70	870-2570-25-PM	★	★	☆	☆	☆	☆	11.8	3.9	142°	H9
25.70	870-2570-25-MM		★				☆	11.8	3.9	142°	H9
25.70	870-2570-25-KM	☆		★				10.8	4.9	142°	H9
25.70	870-2570-25-GP	★	★	★	☆	☆	☆	12.2	2.7	152°	F9
25.80	870-2580-25-PM	★	★	☆	☆	☆	☆	11.8	3.9	142°	H9
25.80	870-2580-25-MM		★				☆	11.8	3.9	142°	H9
25.80	870-2580-25-KM	☆		★				10.8	4.9	142°	H9
25.80	870-2580-25-GP	★	★	★	☆	☆	☆	12.1	2.8	152°	F9
25.90	870-2590-25-PM	★	★	☆	☆	☆	☆	11.8	3.9	142°	H9
25.90	870-2590-25-MM		★				☆	11.8	3.9	142°	H9
25.90	870-2590-25-KM	☆		★				10.8	4.9	142°	H9
25.90	870-2590-25-GP	★	★	★	☆	☆	☆	12.1	2.8	152°	F9
26.00	26 870-2600-26-PM	★	★	☆	☆	☆	☆	12.5	3.9	142°	H9
26.00	870-2600-26-MM		★				☆	12.5	3.9	142°	H9
26.00	870-2600-26-KM	☆		★				11.4	5.0	142°	H9
26.00	870-2600-26-GP	★	★	★	☆	☆	☆	12.9	2.7	152°	F9
26.50	870-2650-26-PM	★	★	☆	☆	☆	☆	12.4	4.0	142°	H9
26.50	870-2650-26-MM		★				☆	12.4	4.0	142°	H9
26.50	870-2650-26-KM	☆		★				11.3	5.1	142°	H9
26.50	870-2650-26-GP	★	★	★	☆	☆	☆	12.8	2.8	152°	F9
26.65	870-2665-26-PM	★	★	☆	☆	☆	☆	12.4	4.0	142°	H9
26.65	870-2665-26-MM		★				☆	12.4	4.0	142°	H9
26.65	870-2665-26-KM	☆		★				11.3	5.1	142°	H9
26.65	870-2665-26-GP	★	★	★	☆	☆	☆	12.8	2.8	152°	F9



J6



J50



J5



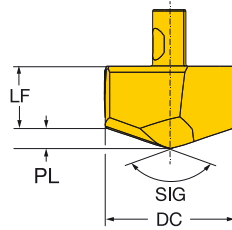
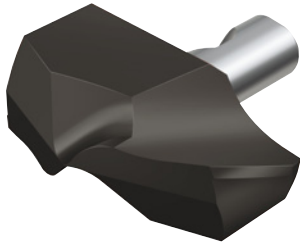
N23



N6



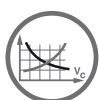
# CoroDrill® 870 drill tip



DC	Ordering code	Dimensions, mm						LF	PL	SIG	TCHA	
		P	M	K	N	S						
27.00	27 870-2700-27-PM	3334	4334	2334	3334	4334	2334	4334	13.0	4.1	142°	H9
27.00	870-2700-27-MM	☆	★	☆	☆	☆	☆	☆	13.0	4.1	142°	H9
27.00	870-2700-27-KM	☆	☆	★	☆	☆	☆	☆	11.8	5.2	142°	H9
27.00	870-2700-27-GP	☆	★	★	★	☆	☆	☆	13.3	2.8	152°	F9
27.50	870-2750-27-PM	☆	★	☆	☆	☆	☆	☆	12.9	4.1	142°	H9
27.50	870-2750-27-MM	☆	★	☆	☆	☆	☆	☆	12.9	4.1	142°	H9
27.50	870-2750-27-KM	☆	☆	★	☆	☆	☆	☆	11.7	5.3	142°	H9
27.50	870-2750-27-GP	☆	★	★	★	☆	☆	☆	13.2	2.9	152°	F9
28.00	28 870-2800-28-PM	☆	★	☆	☆	☆	☆	☆	13.4	4.2	142°	H9
28.00	870-2800-28-MM	☆	★	☆	☆	☆	☆	☆	13.4	4.2	142°	H9
28.00	870-2800-28-KM	☆	☆	★	☆	☆	☆	☆	12.2	5.4	142°	H9
28.00	870-2800-28-GP	☆	★	★	★	☆	☆	☆	13.8	2.9	152°	F9
28.50	870-2850-28-PM	☆	★	☆	☆	☆	☆	☆	13.3	4.3	142°	H9
28.50	870-2850-28-MM	☆	★	☆	☆	☆	☆	☆	13.3	4.3	142°	H9
28.50	870-2850-28-KM	☆	☆	★	☆	☆	☆	☆	12.1	5.5	142°	H9
28.50	870-2850-28-GP	☆	★	★	★	☆	☆	☆	13.7	3.0	152°	F9
28.58	870-2858-28-PM	☆	★	☆	☆	☆	☆	☆	13.3	4.3	142°	H9
28.58	870-2858-28-MM	☆	★	☆	☆	☆	☆	☆	13.3	4.3	142°	H9
28.58	870-2858-28-KM	☆	☆	★	☆	☆	☆	☆	12.1	5.5	142°	H9
28.58	870-2858-28-GP	☆	★	★	★	☆	☆	☆	13.7	3.0	152°	F9
29.00	29 870-2900-29-PM	☆	★	☆	☆	☆	☆	☆	13.9	4.4	142°	H9
29.00	870-2900-29-MM	☆	★	☆	☆	☆	☆	☆	13.9	4.4	142°	H9
29.00	870-2900-29-KM	☆	☆	★	☆	☆	☆	☆	12.7	5.6	142°	H9
29.00	870-2900-29-GP	☆	★	★	★	☆	☆	☆	14.3	3.0	152°	F9
29.50	870-2950-29-PM	☆	★	☆	☆	☆	☆	☆	13.9	4.5	142°	H9
29.50	870-2950-29-MM	☆	★	☆	☆	☆	☆	☆	13.9	4.5	142°	H9
29.50	870-2950-29-KM	☆	☆	★	☆	☆	☆	☆	12.6	5.7	142°	H9
29.50	870-2950-29-GP	☆	★	★	★	☆	☆	☆	14.2	3.1	152°	F9
29.65	870-2965-29-PM	☆	★	☆	☆	☆	☆	☆	13.8	4.5	142°	H9
29.65	870-2965-29-MM	☆	★	☆	☆	☆	☆	☆	13.8	4.5	142°	H9
29.65	870-2965-29-KM	☆	☆	★	☆	☆	☆	☆	12.6	5.7	142°	H9
29.65	870-2965-29-GP	☆	★	★	★	☆	☆	☆	14.2	3.1	152°	F9
30.00	30 870-3000-30-PM	☆	★	☆	☆	☆	☆	☆	14.4	4.5	142°	H9
30.00	870-3000-30-MM	☆	★	☆	☆	☆	☆	☆	14.4	4.5	142°	H9
30.00	870-3000-30-KM	☆	☆	★	☆	☆	☆	☆	13.1	5.8	142°	H9
30.00	870-3000-30-GP	☆	★	★	★	☆	☆	☆	14.7	3.2	152°	F9
30.50	870-3050-30-PM	☆	★	☆	☆	☆	☆	☆	14.3	4.6	142°	H9
30.50	870-3050-30-MM	☆	★	☆	☆	☆	☆	☆	14.3	4.6	142°	H9
30.50	870-3050-30-KM	☆	☆	★	☆	☆	☆	☆	13.0	5.9	142°	H9
30.50	870-3050-30-GP	☆	★	★	★	☆	☆	☆	14.6	3.2	152°	F9



J6



J50



J5

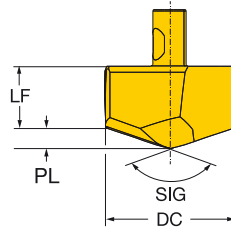
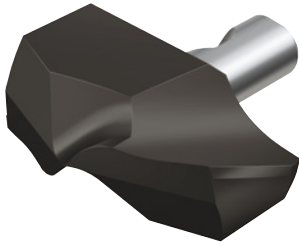


N23



N6

# CoroDrill® 870 drill tip



DC	Ordering code	Material						Dimensions, mm			
		P	M	K	N	S	LF	PL	SIG	TCHA	
31.00	870-3100-31-PM	★					14.8	4.8	142°	H9	
31.00	870-3100-31-MM		★				14.8	4.8	142°	H9	
31.00	870-3100-31-KM	☆		★			13.4	6.1	142°	H9	
31.00	870-3100-31-GP	★	★	★	☆	☆	15.1	3.3	152°	F9	
31.50	870-3150-31-PM	★					14.7	4.8	142°	H9	
31.50	870-3150-31-MM		★				14.7	4.8	142°	H9	
31.50	870-3150-31-KM	☆		★			13.3	6.2	142°	H9	
31.50	870-3150-31-GP	★	★	★	☆	☆	15.0	3.4	152°	F9	
31.75	870-3175-31-PM	★					14.6	4.9	142°	H9	
31.75	870-3175-31-MM		★				14.6	4.9	142°	H9	
31.75	870-3175-31-KM	☆		★			13.3	6.2	142°	H9	
31.75	870-3175-31-GP	★	★	★	☆	☆	15.0	3.4	152°	F9	
32.00	870-3200-31-PM	★					14.6	4.9	142°	H9	
32.00	870-3200-31-MM		★				14.6	4.9	142°	H9	
32.00	870-3200-31-KM	☆		★			13.2	6.3	142°	H9	
32.00	870-3200-31-GP	★	★	★	☆	☆	15.0	3.4	152°	F9	
32.15	870-3215-31-PM	★					14.6	5.0	142°	H9	
32.15	870-3215-31-MM		★				14.6	5.0	142°	H9	
32.15	870-3215-31-KM	☆		★			13.2	6.3	142°	H9	
32.15	870-3215-31-GP	★	★	★	☆	☆	14.9	3.5	152°	F9	
32.50	870-3250-31-PM	★					14.5	5.0	142°	H9	
32.50	870-3250-31-MM		★				14.5	5.0	142°	H9	
32.50	870-3250-31-KM	☆		★			13.1	6.4	142°	H9	
32.50	870-3250-31-GP	★	★	★	☆	☆	14.9	3.5	152°	F9	
33.00	870-3300-31-PM	★					14.4	5.1	142°	H9	
33.00	870-3300-31-MM		★				14.4	5.1	142°	H9	
33.00	870-3300-31-KM	☆		★			13.0	6.5	142°	H9	
33.00	870-3300-31-GP	★	★	★	☆	☆	14.8	3.6	152°	F9	



J6



J50



J5



N23



N6



# CoroDrill® DS20

## Indexable insert drills

### ISO application area



### Benefits and features

- Secure and reliable cutting process with high productivity
- Versatile drill with good chip formation in a broad cutting data range
- Optimized chip control and chip evacuation
- Light cutting and extremely low cutting forces
- Only indexable insert drills that can drill holes up to 7 x DC

### Modular Drilling Interface

The MDI adaptors are available in Coromant Capto® and HSK and provide high precision, excellent centring capabilities and can reduce tool inventory. See page L2



[www.sandvik.coromant.com/corodrills20](http://www.sandvik.coromant.com/corodrills20)

### Drill bodies

- Cylindrical shank with flat according to ISO 9766
- Modular Drilling Interface (MDI)

### Inserts

- Inserts with optimized geometries for all materials

$D_c$ min mm	$D_c$ max mm	Achievable lower tolerance (TCHAL)				Achievable upper tolerance (TCHAU)			
		4xD	5xD	6xD	7xD	4xD	5xD	6xD	7xD
15.00	18.00	0	0	-0.1	-0.1	0.27	0.27	0.4	0.4
18.01	30.00	0	0	-0.1	-0.1	0.33	0.33	0.4	0.4
30.01	40.00	0	0	-0.1	-0.1	0.39	0.39	0.4	0.4



J28











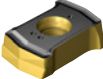
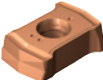


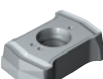


J33



N6

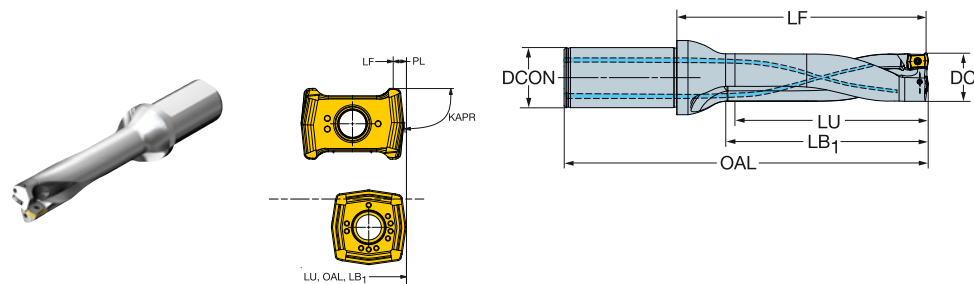
## Insert overview

Central insert		Geometry information	
L5		<b>P M N S H</b>	<ul style="list-style-type: none"> <li>- Long-chipping materials</li> <li>- Hardened steel</li> <li>- Low to medium feed</li> <li>- Light cutting</li> </ul>
M7		<b>P K</b>	<ul style="list-style-type: none"> <li>- Short-chipping material</li> <li>- Low to high feed</li> <li>- Strong reinforced edge</li> </ul>
Peripheral insert		Geometry information	
M7W		<b>P K H</b>	<ul style="list-style-type: none"> <li>- First choice in short chipping materials</li> <li>- Low to high feed</li> <li>- Strong reinforced edge</li> </ul>
L5W		<b>P M N S</b>	<ul style="list-style-type: none"> <li>- Long-chipping materials</li> <li>- Low to medium feed</li> <li>- Light cutting</li> </ul>
H5W		<b>P M</b>	<ul style="list-style-type: none"> <li>- Complementary for long-chipping materials</li> <li>- Low to medium feed</li> <li>- Negative T-land</li> <li>- High cutting forces</li> </ul>
S5W		<b>M N S</b>	<ul style="list-style-type: none"> <li>- Sharp and extremely light cutting</li> <li>- Low feed</li> </ul>
L6W		<b>P M K N S H</b>	<ul style="list-style-type: none"> <li>- All-round geometry for mixed production</li> <li>- First choice in Inconel and hardened steel</li> <li>- Low to medium feed</li> <li>- Light cutting</li> </ul>
Central insert		Grade information	
	<b>P K S H</b>	<b>GC1344</b>	<ul style="list-style-type: none"> <li>- PVD-coated with Zertivo® technology</li> <li>- Excellent wear resistance and toughness</li> </ul>
	<b>M S</b>	<b>GC1144</b>	<ul style="list-style-type: none"> <li>- PVD-coated grade for all types of ISO M and titanium materials</li> </ul>
	<b>N S</b>	<b>H13A</b>	<ul style="list-style-type: none"> <li>- Universal, tough and uncoated grade best for low to moderate cutting speeds</li> <li>- Complementary grade for ISO S</li> </ul>
Peripheral insert		Grade information	
	<b>P M K H</b>	<b>GC4334</b>	<ul style="list-style-type: none"> <li>- Good to average conditions</li> <li>- CVD coating with Inveio® technology provides a high level of wear resistance</li> </ul>
	<b>M S</b>	<b>GC2044</b>	<ul style="list-style-type: none"> <li>- PVD-oxide coating for excellent wear resistance</li> </ul>
	<b>P M K N S H</b>	<b>GC4344</b>	<ul style="list-style-type: none"> <li>- PVD-coating with Zertivo® technology</li> <li>- Tough and demanding operations</li> <li>- Provides good edge-line properties and reliable tool life</li> </ul>
	<b>P K</b>	<b>GC4324</b>	<ul style="list-style-type: none"> <li>- MT-CVD coating with Inveio® technology</li> <li>- Productive choice in stable conditions</li> </ul>
	<b>N S</b>	<b>H13A</b>	<ul style="list-style-type: none"> <li>- Universal, tough and uncoated grade best for low to moderate cutting speeds</li> <li>- Complementary grade for ISO S</li> </ul>

# CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



DC		LU	CZC <sub>MS</sub>	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm							RPMX	
DC	01C	01P	20	1.00	0.00	0.27	DS20-D1500L20-04	DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	KAPR	BAR	KG	RPMX
15.00	01C	01P	60.00	20	1.00	0.00	DS20-D1500L20-04	20.00	80.69	131.00	63.00	0.46	81°	10	0.190	24000
			75.00	20	1.00	0.00	DS20-D1500L20-05	20.00	95.69	146.00	78.00	0.46	81°	10	0.200	15000
			90.00	20	1.00	-0.10	DS20-D1500L20-06	20.00	110.69	161.00	93.00	0.46	81°	10	0.210	11000
			105.00	20	1.00	-0.10	DS20-D1500L20-07	20.00	125.69	176.00	108.00	0.46	81°	10	0.219	8000
16.00	01C	01P	64.00	20	0.75	0.00	DS20-D1600L20-04	20.00	84.69	135.00	67.00	0.46	81°	10	0.220	22000
			80.00	20	0.75	0.00	DS20-D1600L20-05	20.00	100.69	151.00	83.00	0.46	81°	10	0.212	14000
			96.00	20	0.75	-0.10	DS20-D1600L20-06	20.00	116.69	167.00	99.00	0.46	81°	10	0.224	10000
			112.00	20	0.75	-0.10	DS20-D1600L20-07	20.00	132.69	183.00	115.00	0.46	81°	10	0.236	7000
17.00	01C	01P	68.00	20	0.50	0.00	DS20-D1700L20-04	20.00	88.69	139.00	71.00	0.46	81°	10	0.211	21000
			85.00	20	0.50	0.00	DS20-D1700L20-05	20.00	105.69	156.00	88.00	0.46	81°	10	0.226	13000
			102.00	20	0.50	-0.10	DS20-D1700L20-06	20.00	122.69	173.00	105.00	0.46	81°	10	0.240	9000
			119.00	20	0.50	-0.10	DS20-D1700L20-07	20.00	139.69	190.00	122.00	0.46	81°	10	0.255	7000
18.00	01C	01P	72.00	25	0.25	0.00	DS20-D1800L25-04	25.00	96.69	153.00	75.00	0.46	81°	10	0.348	20000
			90.00	25	0.25	0.00	DS20-D1800L25-05	25.00	114.69	171.00	93.00	0.46	81°	10	0.366	13000
			108.00	25	0.25	-0.10	DS20-D1800L25-06	25.00	132.69	189.00	111.00	0.46	81°	10	0.383	9000
			126.00	25	0.25	-0.10	DS20-D1800L25-07	25.00	150.69	207.00	129.00	0.46	81°	10	0.400	6000
19.00	02C	02P	76.00	25	1.06	0.00	DS20-D1900L25-04	25.00	100.62	157.00	79.00	0.55	81°	10	0.348	19000
			95.00	25	1.06	0.00	DS20-D1900L25-05	25.00	119.62	176.00	98.00	0.55	81°	10	0.367	12000
			114.00	25	1.06	-0.10	DS20-D1900L25-06	25.00	138.62	195.00	117.00	0.55	81°	10	0.387	8000
			133.00	25	1.06	-0.10	DS20-D1900L25-07	25.00	157.62	214.00	136.00	0.55	81°	10	0.405	6000
20.00	02C	02P	80.00	25	0.82	0.00	DS20-D2000L25-04	25.00	104.62	161.00	83.00	0.55	81°	10	0.364	18000
			100.00	25	0.82	0.00	DS20-D2000L25-05	25.00	124.62	181.00	103.00	0.55	81°	10	0.386	11000
			120.00	25	0.82	-0.10	DS20-D2000L25-06	25.00	144.62	201.00	123.00	0.55	81°	10	0.409	8000
			140.00	25	0.82	-0.10	DS20-D2000L25-07	25.00	164.62	221.00	143.00	0.55	81°	10	0.431	6000
21.00	02C	02P	84.00	25	0.58	0.00	DS20-D2100L25-04	25.00	108.62	165.00	87.00	0.55	81°	10	0.381	17000
			105.00	25	0.58	0.00	DS20-D2100L25-05	25.00	129.62	186.00	108.00	0.55	81°	10	0.407	11000
			126.00	25	0.58	-0.10	DS20-D2100L25-06	25.00	150.62	207.00	129.00	0.55	81°	10	0.434	8000
			147.00	25	0.58	-0.10	DS20-D2100L25-07	25.00	171.62	228.00	150.00	0.55	81°	10	0.460	5000
22.00	02C	02P	88.00	25	0.34	0.00	DS20-D2200L25-04	25.00	112.62	169.00	91.00	0.55	81°	10	0.401	16000
			110.00	25	0.34	0.00	DS20-D2200L25-05	25.00	134.62	191.00	113.00	0.55	81°	10	0.431	10000
			132.00	25	0.34	-0.10	DS20-D2200L25-06	25.00	156.62	213.00	135.00	0.55	81°	10	0.463	7000
			154.00	25	0.34	-0.10	DS20-D2200L25-07	25.00	178.62	235.00	157.00	0.55	81°	10	0.494	5000
23.00	03C	03P	92.00	25	1.30	0.00	DS20-D2300L25-04	25.00	117.53	174.00	96.00	0.66	81°	10	0.420	15000
			115.00	25	1.30	0.00	DS20-D2300L25-05	25.00	140.53	197.00	119.00	0.66	81°	10	0.452	10000
			138.00	25	1.30	-0.10	DS20-D2300L25-06	25.00	163.53	220.00	142.00	0.66	81°	10	0.488	7000
			161.00	25	1.30	-0.10	DS20-D2300L25-07	25.00	186.53	243.00	165.00	0.66	81°	10	0.524	5000
24.00	03C	03P	96.00	25	1.10	0.00	DS20-D2400L25-04	25.00	121.53	178.00	100.00	0.66	81°	10	0.439	15000
			120.00	25	1.10	0.00	DS20-D2400L25-05	25.00	145.53	202.00	124.00	0.66	81°	10	0.550	9000
			144.00	25	1.10	-0.10	DS20-D2400L25-06	25.00	169.53	226.00	148.00	0.66	81°	10	0.520	6000
			168.00	25	1.10	-0.10	DS20-D2400L25-07	25.00	193.53	250.00	172.00	0.66	81°	10	0.561	5000
25.00	03C	03P	100.00	25	0.90	0.00	DS20-D2500L25-04	25.00	125.53	182.00	104.00	0.66	81°	10	0.463	14000
			125.00	25	0.90	0.00	DS20-D2500L25-05	25.00	150.53	207.00	129.00	0.66	81°	10	0.510	9000
			150.00	25	0.90	-0.10	DS20-D2500L25-06	25.00	175.53	232.00	154.00	0.66	81°	10	0.557	6000
			175.00	25	0.90	-0.10	DS20-D2500L25-07	25.00	200.53	257.00	179.00	0.66	81°	10	0.603	4000

DC	Spare parts
	Insert screw
15.00-18.00	5513 020-27
18.01-22.00	5513 020-88
22.01-27.00	5513 020-58
27.01-33.00	5513 020-57
33.01-40.00	416.1-833
40.01-65.00	416.1-834

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



J33



N23

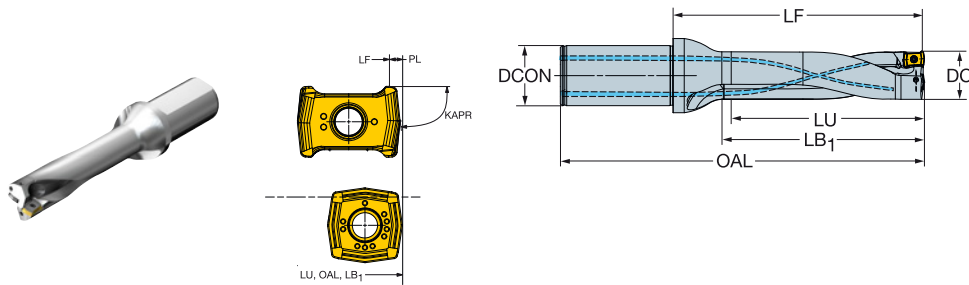


N15

# CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



DC		LU	CZC <sub>MIS</sub>	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm							RPMX	
DC	03C	03P	104.00	32	0.70	0.00	DS20-D2600L32-04	DCON <sub>MIS</sub>	LF	OAL	LB <sub>1</sub>	PL	KAPR	BAR	KG	RPMX
			130.00	32	0.70	0.00	DS20-D2600L32-05	32.00	159.53	220.00	134.00	0.66	81°	10	0.758	9000
			156.00	32	0.70	-0.10	DS20-D2600L32-06	32.00	185.53	246.00	160.00	0.66	81°	10	0.812	6000
			182.00	32	0.70	-0.10	DS20-D2600L32-07	32.00	211.53	272.00	186.00	0.66	81°	10	0.865	4000
27.00	03C	03P	108.00	32	0.50	0.00	DS20-D2700L32-04	32.00	136.53	197.00	112.00	0.66	81°	10	0.734	13000
			135.00	32	0.50	0.00	DS20-D2700L32-05	32.00	163.53	224.00	139.00	0.66	81°	10	0.794	8000
			162.00	32	0.50	-0.10	DS20-D2700L32-06	32.00	190.53	251.00	166.00	0.66	81°	10	0.854	6000
			189.00	32	0.50	-0.10	DS20-D2700L32-07	32.00	217.53	278.00	193.00	0.66	81°	10	0.912	4000
28.00	04C	04P	112.00	32	2.12	0.00	DS20-D2800L32-04	32.00	140.16	201.00	116.00	0.83	81°	10	0.743	13000
			140.00	32	2.12	0.00	DS20-D2800L32-05	32.00	168.16	229.00	144.00	0.83	81°	10	0.809	8000
			168.00	32	2.12	-0.10	DS20-D2800L32-06	32.00	196.16	257.00	172.00	0.83	81°	10	0.874	6000
			196.00	32	2.12	-0.10	DS20-D2800L32-07	32.00	224.16	285.00	200.00	0.83	81°	10	0.939	4000
29.00	04C	04P	116.00	32	1.84	0.00	DS20-D2900L32-04	32.00	144.16	205.00	120.00	0.83	81°	10	0.773	12000
			145.00	32	1.84	0.00	DS20-D2900L32-05	32.00	173.16	234.00	149.00	0.83	81°	10	0.846	8000
			174.00	32	1.84	-0.10	DS20-D2900L32-06	32.00	202.16	263.00	178.00	0.83	81°	10	0.918	5000
			203.00	32	1.84	-0.10	DS20-D2900L32-07	32.00	231.16	292.00	207.00	0.83	81°	10	0.991	4000
30.00	04C	04P	120.00	32	1.56	0.00	DS20-D3000L32-04	32.00	148.16	209.00	124.00	0.83	81°	10	0.805	12000
			150.00	32	1.56	0.00	DS20-D3000L32-05	32.00	178.16	239.00	154.00	0.83	81°	10	0.885	8000
			180.00	32	1.56	-0.10	DS20-D3000L32-06	32.00	208.16	269.00	184.00	0.83	81°	10	0.966	5000
			210.00	32	1.56	-0.10	DS20-D3000L32-07	32.00	238.16	299.00	214.00	0.83	81°	10	1.046	4000
31.00	04C	04P	124.00	40	1.28	0.00	DS20-D3100L40-04	40.00	158.16	229.00	128.00	0.83	81°	10	1.250	12000
			155.00	40	1.28	0.00	DS20-D3100L40-05	40.00	189.16	260.00	159.00	0.83	81°	10	1.339	7000
			186.00	40	1.28	-0.10	DS20-D3100L40-06	40.00	220.16	291.00	190.00	0.83	81°	10	1.428	5000
			217.00	40	1.28	-0.10	DS20-D3100L40-07	40.00	251.16	322.00	221.00	0.83	81°	10	1.516	4000
32.00	04C	04P	128.00	40	1.00	0.00	DS20-D3200L40-04	40.00	162.16	233.00	132.00	0.83	81°	10	1.286	11000
			160.00	40	1.00	0.00	DS20-D3200L40-05	40.00	194.16	265.00	164.00	0.83	81°	10	1.384	7000
			192.00	40	1.00	-0.10	DS20-D3200L40-06	40.00	226.16	297.00	196.00	0.83	81°	10	1.481	5000
			224.00	40	1.00	-0.10	DS20-D3200L40-07	40.00	258.16	329.00	228.00	0.83	81°	10	1.579	3000
33.00	04C	04P	132.00	40	0.72	0.00	DS20-D3300L40-04	40.00	165.16	236.00	136.00	0.83	81°	10	1.313	11000
			165.00	40	0.72	0.00	DS20-D3300L40-05	40.00	198.16	269.00	169.00	0.83	81°	10	1.420	7000
			198.00	40	0.72	-0.10	DS20-D3300L40-06	40.00	231.16	302.00	202.00	0.83	81°	10	1.527	5000
			231.00	40	0.72	-0.10	DS20-D3300L40-07	40.00	264.16	335.00	235.00	0.83	81°	10	1.634	3000
34.00	05C	05P	136.00	40	2.16	0.00	DS20-D3400L40-04	40.00	169.28	240.00	140.00	1.00	81°	10	1.354	11000
			170.00	40	2.16	0.00	DS20-D3400L40-05	40.00	203.28	274.00	174.00	1.00	81°	10	1.471	7000
			204.00	40	2.16	-0.10	DS20-D3400L40-06	40.00	237.28	308.00	208.00	1.00	81°	10	1.531	4000
			238.00	40	2.16	-0.10	DS20-D3400L40-07	40.00	271.28	342.00	242.00	1.00	81°	10	1.705	3000
35.00	05C	05P	140.00	40	1.92	0.00	DS20-D3500L40-04	40.00	173.28	244.00	144.00	1.00	81°	10	1.398	10000
			175.00	40	1.92	0.00	DS20-D3500L40-05	40.00	208.28	279.00	179.00	1.00	81°	10	1.525	6000
			210.00	40	1.92	-0.10	DS20-D3500L40-06	40.00	243.28	314.00	214.00	1.00	81°	10	1.653	4000
			245.00	40	1.92	-0.10	DS20-D3500L40-07	40.00	278.28	349.00	249.00	1.00	81°	10	1.781	3000
36.00	05C	05P	144.00	40	1.68	0.00	DS20-D3600L40-04	40.00	177.28	248.00	148.00	1.00	81°	10	1.443	10000
			180.00	40	1.68	0.00	DS20-D3600L40-05	40.00	213.28	284.00	184.00	1.00	81°	10	1.582	6000
			216.00	40	1.68	-0.10	DS20-D3600L40-06	40.00	249.28	320.00	220.00	1.00	81°	10	1.721	4000
			252.00	40	1.68	-0.10	DS20-D3600L40-07	40.00	285.28	356.00	256.00	1.00	81°	10	1.860	3000

Spare parts	
DC	Insert screw
15.00-18.00	5513 020-27
18.01-22.00	5513 020-88
22.01-27.00	5513 020-58
27.01-33.00	5513 020-57
33.01-40.00	416.1-833
40.01-65.00	416.1-834

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



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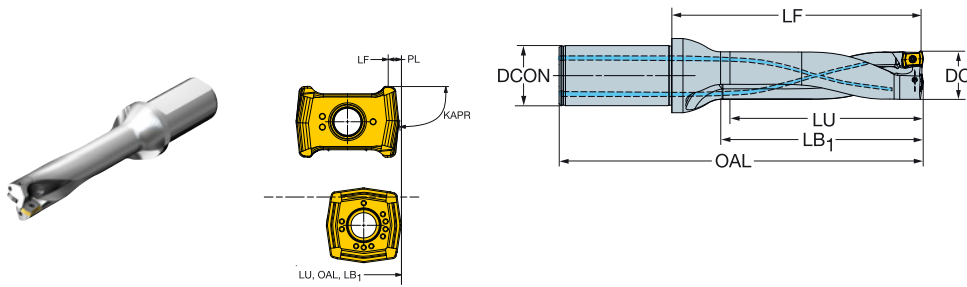
N15



# CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



							Dimensions, mm										
DC	05C	05P	LU	CZC <sub>MS</sub>	ADJLX	TCHAL	TCHAU	Ordering code	DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	KAPR	BAR	KG	RPMX
37.00	05C	05P	148.00	40	1.44	0.00	0.35	DS20-D3700L40-04	40.00	181.28	252.00	152.00	1.00	81°	10	1.492	10000
			185.00	40	1.44	0.00	0.35	DS20-D3700L40-05	40.00	218.28	289.00	189.00	1.00	81°	10	1.643	6000
			222.00	40	1.44	-0.10	0.40	DS20-D3700L40-06	40.00	255.28	326.00	226.00	1.00	81°	10	1.794	4000
			259.00	40	1.44	-0.10	0.40	DS20-D3700L40-07	40.00	292.28	363.00	263.00	1.00	81°	10	1.945	3000
38.00	05C	05P	152.00	40	1.20	0.00	0.35	DS20-D3800L40-04	40.00	185.28	256.00	156.00	1.00	81°	10	1.543	9000
			190.00	40	1.20	0.00	0.35	DS20-D3800L40-05	40.00	223.28	294.00	194.00	1.00	81°	10	1.707	6000
			228.00	40	1.20	-0.10	0.40	DS20-D3800L40-06	40.00	261.28	332.00	232.00	1.00	81°	10	1.870	4000
			266.00	40	1.20	-0.10	0.40	DS20-D3800L40-07	40.00	299.28	370.00	270.00	1.00	81°	10	2.390	3000
39.00	05C	05P	156.00	40	0.96	0.00	0.35	DS20-D3900L40-04	40.00	189.28	260.00	160.00	1.00	81°	10	1.597	9000
			195.00	40	0.96	0.00	0.35	DS20-D3900L40-05	40.00	228.28	299.00	199.00	1.00	81°	10	1.774	6000
			234.00	40	0.96	-0.10	0.40	DS20-D3900L40-06	40.00	267.28	338.00	238.00	1.00	81°	10	1.950	4000
			273.00	40	0.96	-0.10	0.40	DS20-D3900L40-07	40.00	306.28	377.00	277.00	1.00	81°	10	2.127	3000
40.00	05C	05P	160.00	40	0.72	0.00	0.35	DS20-D4000L40-04	40.00	193.28	264.00	164.00	1.00	81°	10	1.654	9000
			200.00	40	0.72	0.00	0.35	DS20-D4000L40-05	40.00	233.28	304.00	204.00	1.00	81°	10	1.844	6000
			240.00	40	0.72	-0.10	0.40	DS20-D4000L40-06	40.00	273.28	344.00	244.00	1.00	81°	10	2.035	4000
			280.00	40	0.72	-0.10	0.40	DS20-D4000L40-07	40.00	313.28	384.00	284.00	1.00	81°	10	2.226	3000

Spare parts	
DC	Insert screw
15.00-18.00	5513 020-27
18.01-22.00	5513 020-88
22.01-27.00	5513 020-58
27.01-33.00	5513 020-57
33.01-40.00	416.1-833
40.01-65.00	416.1-834

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

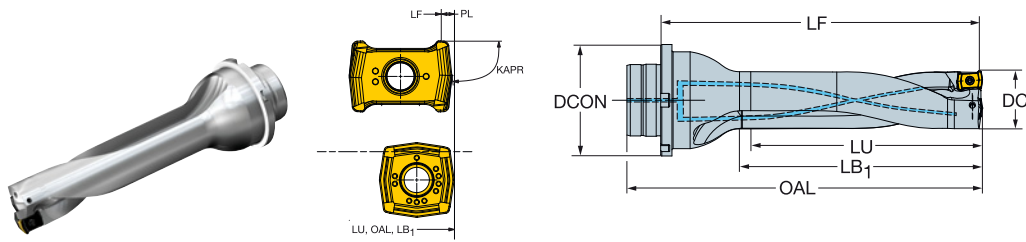




# CoroDrill® DS20 indexable insert drill

Modular drill interface

Internal coolant supply



										Dimensions, mm									
DC			LU	CZC <sub>MS</sub>	ADJLX	TCHAL	TCHAU	Ordering code		DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	KAPR	BAR	KG	RPMX	
15.00	01C	01P	60.00	MDI-20	1.00	0.00	0.27	DS20-D1500DM20-04	20.00	88.69	104.00	63.00	0.46	81°	10	0.191	24000		
			105.00	MDI-20	1.00	-0.10	0.40	DS20-D1500DM20-07	20.00	133.69	149.00	108.00	0.46	81°	10	0.204	8000		
16.00	01C	01P	64.00	MDI-20	0.75	0.00	0.27	DS20-D1600DM20-04	20.00	92.69	108.00	67.00	0.46	81°	10	0.199	22000		
			112.00	MDI-20	0.75	-0.10	0.40	DS20-D1600DM20-07	20.00	140.69	156.00	115.00	0.46	81°	10	0.219	7000		
17.00	01C	01P	68.00	MDI-20	0.50	0.00	0.27	DS20-D1700DM20-04	20.00	96.69	112.00	71.00	0.46	81°	10	0.211	21000		
			119.00	MDI-20	0.50	-0.10	0.40	DS20-D1700DM20-07	20.00	147.69	163.00	122.00	0.46	81°	10	0.236	7000		
18.00	01C	01P	72.00	MDI-25	0.25	0.00	0.27	DS20-D1800DM25-04	25.00	104.69	120.00	75.00	0.46	81°	10	0.317	20000		
			126.00	MDI-25	0.25	-0.10	0.40	DS20-D1800DM25-07	25.00	158.69	174.00	129.00	0.46	81°	10	0.353	6000		
19.00	02C	02P	76.00	MDI-25	1.06	0.00	0.33	DS20-D1900DM25-04	25.00	108.62	124.00	79.00	0.55	81°	10	0.313	19000		
			133.00	MDI-25	1.06	-0.10	0.40	DS20-D1900DM25-07	25.00	165.62	181.00	136.00	0.55	81°	10	0.389	6000		
20.00	02C	02P	80.00	MDI-25	0.82	0.00	0.33	DS20-D2000DM25-04	25.00	112.62	128.00	83.00	0.55	81°	10	0.340	18000		
			140.00	MDI-25	0.82	-0.10	0.40	DS20-D2000DM25-07	25.00	172.62	188.00	143.00	0.55	81°	10	0.400	6000		
21.00	02C	02P	84.00	MDI-25	0.58	0.00	0.33	DS20-D2100DM25-04	25.00	116.62	132.00	87.00	0.55	81°	10	0.342	17000		
			147.00	MDI-25	0.58	-0.10	0.40	DS20-D2100DM25-07	25.00	179.62	195.00	150.00	0.55	81°	10	0.425	5000		
22.00	02C	02P	88.00	MDI-25	0.34	0.00	0.33	DS20-D2200DM25-04	25.00	120.62	136.00	91.00	0.55	81°	10	0.381	16000		
			154.00	MDI-25	0.34	-0.10	0.40	DS20-D2200DM25-07	25.00	186.62	202.00	157.00	0.55	81°	10	0.500	5000		
23.00	03C	03P	92.00	MDI-25	1.30	0.00	0.33	DS20-D2300DM25-04	25.00	125.53	141.00	96.00	0.66	81°	10	0.379	15000		
			161.00	MDI-25	1.30	-0.10	0.40	DS20-D2300DM25-07	25.00	194.53	210.00	165.00	0.66	81°	10	0.488	5000		
24.00	03C	03P	96.00	MDI-25	1.10	0.00	0.33	DS20-D2400DM25-04	25.00	129.53	145.00	100.00	0.66	81°	10	0.400	15000		
			168.00	MDI-25	1.10	-0.10	0.40	DS20-D2400DM25-07	25.00	201.53	217.00	172.00	0.66	81°	10	0.600	5000		
25.00	03C	03P	100.00	MDI-25	0.90	0.00	0.33	DS20-D2500DM25-04	25.00	133.53	149.00	104.00	0.66	81°	10	0.446	14000		
			175.00	MDI-25	0.90	-0.10	0.40	DS20-D2500DM25-07	25.00	208.53	224.00	179.00	0.66	81°	10	0.600	4000		
26.00	03C	03P	104.00	MDI-32	0.70	0.00	0.33	DS20-D2600DM32-04	32.00	142.53	158.00	108.00	0.66	81°	10	0.700	14000		
			182.00	MDI-32	0.70	-0.10	0.40	DS20-D2600DM32-07	32.00	220.53	236.00	186.00	0.66	81°	10	0.808	4000		
27.00	03C	03P	108.00	MDI-32	0.50	0.00	0.33	DS20-D2700DM32-04	32.00	146.53	162.00	112.00	0.66	81°	10	0.700	13000		
			189.00	MDI-32	0.50	-0.10	0.40	DS20-D2700DM32-07	32.00	227.53	243.00	193.00	0.66	81°	10	0.853	4000		
28.00	04C	04P	112.00	MDI-32	2.12	0.00	0.33	DS20-D2800DM32-04	32.00	150.16	166.00	116.00	0.83	81°	10	0.705	13000		
			196.00	MDI-32	2.12	-0.10	0.40	DS20-D2800DM32-07	32.00	234.16	250.00	200.00	0.83	81°	10	0.901	4000		
29.00	04C	04P	116.00	MDI-32	1.84	0.00	0.33	DS20-D2900DM32-04	32.00	154.16	170.00	120.00	0.83	81°	10	0.734	12000		
			203.00	MDI-32	1.84	-0.10	0.40	DS20-D2900DM32-07	32.00	241.16	257.00	207.00	0.83	81°	10	0.952	4000		
30.00	04C	04P	120.00	MDI-32	1.56	0.00	0.33	DS20-D3000DM32-04	32.00	158.16	174.00	124.00	0.83	81°	10	0.766	12000		
			210.00	MDI-32	1.56	-0.10	0.40	DS20-D3000DM32-07	32.00	248.16	264.00	214.00	0.83	81°	10	1.008	4000		
31.00	04C	04P	124.00	MDI-32	1.28	0.00	0.35	DS20-D3100DM32-04	32.00	164.16	180.00	128.00	0.83	81°	10	0.818	12000		
			217.00	MDI-32	1.28	-0.10	0.40	DS20-D3100DM32-07	32.00	256.16	272.00	221.00	0.83	81°	10	1.075	4000		
32.00	04C	04P	128.00	MDI-40	1.00	0.00	0.35	DS20-D3200DM40-04	40.00	175.16	191.00	132.00	0.83	81°	10	1.260	11000		
			224.00	MDI-40	1.00	-0.10	0.40	DS20-D3200DM40-07	40.00	271.16	287.00	228.00	0.83	81°	10	1.553	3000		
33.00	04C	04P	132.00	MDI-40	0.72	0.00	0.35	DS20-D3300DM40-04	40.00	179.16	195.00	136.00	0.83	81°	10	1.299	11000		
			231.00	MDI-40	0.72	-0.10	0.40	DS20-D3300DM40-07	40.00	278.16	294.00	235.00	0.83	81°	10	1.620	3000		

Spare parts	
DC	Insert screw
15.00-18.00	5513 020-27
18.01-22.00	5513 020-88
22.01-27.00	5513 020-58
27.01-33.00	5513 020-57
33.01-40.00	416.1-833
40.01-59.00	416.1-834

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



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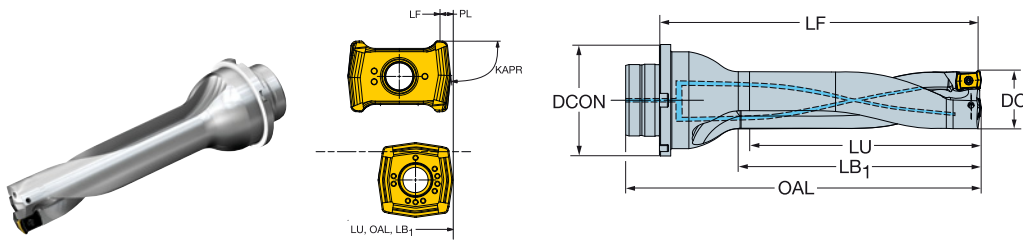


N15



# CoroDrill® DS20 indexable insert drill

Modular drill interface  
Internal coolant supply



DC		LU	CZC <sub>MS</sub>	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm							BAR	KG	RPMX
DC	PL	LU						DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	KAPR				
34.00	05P	05P	136.00	MDI-40	2.16	0.00	0.35	DS20-D3400DM40-04	40.00	183.28	199.00	140.00	1.00	81°	10	1.340	11000
			238.00	MDI-40	2.16	-0.10	0.40	DS20-D3400DM40-07	40.00	285.28	301.00	242.00	1.00	81°	10	1.691	3000
35.00	05C	05C	140.00	MDI-40	1.92	0.00	0.35	DS20-D3500DM40-04	40.00	187.28	203.00	144.00	1.00	81°	10	1.383	10000
			245.00	MDI-40	1.92	-0.10	0.40	DS20-D3500DM40-07	40.00	292.28	308.00	249.00	1.00	81°	10	1.766	3000
36.00	05C	05C	144.00	MDI-40	1.68	0.00	0.35	DS20-D3600DM40-04	40.00	191.28	207.00	148.00	1.00	81°	10	1.429	10000
			252.00	MDI-40	1.68	-0.10	0.40	DS20-D3600DM40-07	40.00	299.28	315.00	256.00	1.00	81°	10	1.846	3000
37.00	05P	05P	148.00	MDI-40	1.44	0.00	0.35	DS20-D3700DM40-04	40.00	195.28	211.00	152.00	1.00	81°	10	1.477	10000
			259.00	MDI-40	1.44	-0.10	0.40	DS20-D3700DM40-07	40.00	306.28	322.00	263.00	1.00	81°	10	1.930	3000
38.00	05P	05P	152.00	MDI-40	1.20	0.00	0.35	DS20-D3800DM40-04	40.00	199.28	215.00	156.00	1.00	81°	10	1.529	9000
			266.00	MDI-40	1.20	-0.10	0.40	DS20-D3800DM40-07	40.00	313.28	329.00	270.00	1.00	81°	10	2.019	3000
39.00	05C	05C	156.00	MDI-40	0.96	0.00	0.35	DS20-D3900DM40-04	40.00	203.28	219.00	160.00	1.00	81°	10	1.582	9000
			273.00	MDI-40	0.96	-0.10	0.40	DS20-D3900DM40-07	40.00	320.28	336.00	277.00	1.00	81°	10	2.113	3000
40.00	05C	05P	160.00	MDI-40	0.72	0.00	0.35	DS20-D4000DM40-04	40.00	206.28	222.00	164.00	1.00	81°	10	1.624	9000
			280.00	MDI-40	0.72	-0.10	0.40	DS20-D4000DM40-07	40.00	326.28	342.00	284.00	1.00	81°	10	2.196	3000

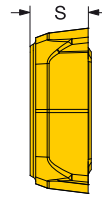
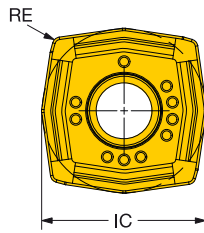
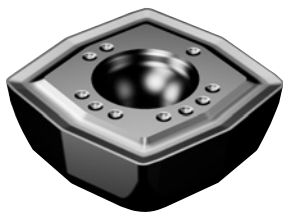
Spare parts	
DC	Insert screw
15.00-18.00	5513 020-27
18.01-22.00	5513 020-88
22.01-27.00	5513 020-58
27.01-33.00	5513 020-57
33.01-40.00	416.1-833
40.01-59.00	416.1-834

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



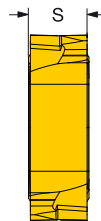
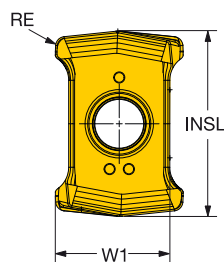
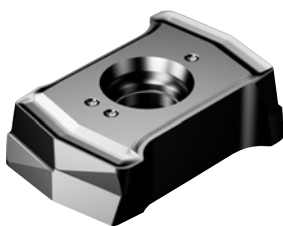
# CoroDrill® DS20 insert for drilling

## Central insert



INSUC	Ordering code	P	M	K	N	S	H	Dimensions, mm			
		1344	1144	1344	HT3A	1344	HT3A	1344	S	RE	IC
01C	C	DS20-0104-C-L5	★	★	★	☆	★	★	2.30	0.35	6.0
01C	C	DS20-0104-C-M7	★	★	★	☆	★	★	2.30	0.35	6.0
02C	C	DS20-0205-C-L5	★	★	★	☆	★	★	2.60	0.35	7.3
02C	C	DS20-0205-C-M7	★	★	★	☆	★	★	2.60	0.35	7.3
03C	C	DS20-0306-C-L5	★	★	★	☆	★	★	3.00	0.35	8.9
03C	C	DS20-0306-C-M7	★	★	★	☆	★	★	3.00	0.35	8.9
04C	C	DS20-0407-C-L5	★	★	★	☆	★	★	3.20	0.35	11.1
04C	C	DS20-0407-C-M7	★	★	★	☆	★	★	3.20	0.35	11.1
05C	C	DS20-0508-C-L5	★	★	★	☆	★	★	3.50	0.35	13.4
05C	C	DS20-0508-C-M7	★	★	★	☆	★	★	3.50	0.35	13.4

## Peripheral insert



INSUC	Ordering code	P	M	K	N	S	H	Dimensions, mm								
		4324	4334	4334	2044	4334	4344	HT3A	2044	4344	HT3A	4334	4344	S	RE	W1
01P	P	DS20-0104-P-H5W	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.73	0.40	5.0
01P	P	DS20-0104-P-L5W	☆	★	★	☆	☆	☆	☆	☆	☆	☆	☆	2.73	0.40	5.0
01P	P	DS20-0104-P-L6W	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	2.73	0.40	5.0
01P	P	DS20-0104-P-M7W	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	2.73	0.40	5.0
01P	P	DS20-0104-P-S5W	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	2.73	0.40	5.0
02P	P	DS20-0205-P-H5W	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.10	0.50	6.1
02P	P	DS20-0205-P-L5W	☆	★	★	☆	☆	☆	☆	☆	☆	☆	☆	3.10	0.50	6.1
02P	P	DS20-0205-P-L6W	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	3.10	0.50	6.1
02P	P	DS20-0205-P-M7W	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.10	0.50	6.1
02P	P	DS20-0205-P-S5W	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	3.10	0.50	6.1
03P	P	DS20-0306-P-H5W	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.53	0.60	7.3
03P	P	DS20-0306-P-L5W	☆	★	★	☆	☆	☆	☆	☆	☆	☆	☆	3.53	0.60	7.3
03P	P	DS20-0306-P-L6W	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	3.53	0.60	7.3
03P	P	DS20-0306-P-M7W	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.53	0.60	7.3
03P	P	DS20-0306-P-S5W	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	3.53	0.60	7.3
04P	P	DS20-0407-P-H5W	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.25	0.70	9.2
04P	P	DS20-0407-P-L5W	☆	★	★	☆	☆	☆	☆	☆	☆	☆	☆	4.25	0.70	9.2
04P	P	DS20-0407-P-L6W	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	4.25	0.70	9.2
04P	P	DS20-0407-P-M7W	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.25	0.70	9.2
04P	P	DS20-0407-P-S5W	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	4.25	0.70	9.2
05P	P	DS20-0508-P-H5W	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.75	0.80	11.2
05P	P	DS20-0508-P-L5W	☆	★	★	☆	☆	☆	☆	☆	☆	☆	☆	4.75	0.80	11.2
05P	P	DS20-0508-P-L6W	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	4.75	0.80	11.2
05P	P	DS20-0508-P-M7W	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	4.75	0.80	11.2
05P	P	DS20-0508-P-S5W	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	4.75	0.80	11.2



J28



J54



N23

# CoroDrill® 880

## Indexable insert drills

### J ISO application area



#### Benefits and features for hole diameters 12.00–63.50 mm

- Up to 100% higher productivity
- Close hole tolerance and improved surface finish
- Four true cutting edges with Wiper technology
- Strong drill body with central and peripheral inserts features unique Step Technology™ for a perfect cutting force balance
- Excellent chip evacuation



#### Benefits and features for hole diameters 65.00–84.00 mm

- Secure and reliable drilling due to a robust drill body with a rigid cartridge interface
- Excellent chip control and evacuation
- Excellent flexibility – one drill body covers five diameter dimensions due to replaceable fixed cartridge system
- User-friendly economical solution with exchangeable cartridges and indexable inserts



[www.sandvik.coromant.com/corodril880](http://www.sandvik.coromant.com/corodril880)

### M Drill bodies

- Couplings:
- Coromant Capto®
  - Cylindrical shank
  - VL coupling

### Inserts

- Inserts with optimized geometries for all materials

### 2 – 3 x DC

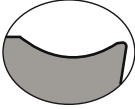

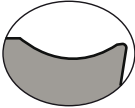
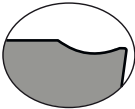
Diameter range, mm	12.00-43.99	44.00-52.99	53.00-63.50
Hole tolerance, mm	0/+0.25	0/+0.28	0/+0.30

### N



# CoroDrill® 880

## Geometry overview

Geometry	Geometry information
LM	 <ul style="list-style-type: none"> <li>- First choice in low carbon steel</li> <li>- A versatile geometry with an all-around chip breaker</li> <li>- Operates best at low to medium feeds</li> <li>- Provides low cutting forces</li> </ul>
GR	 <ul style="list-style-type: none"> <li>- First choice in alloyed steel and cast irons</li> <li>- Operates best at medium to high feeds</li> </ul>
MS	 <ul style="list-style-type: none"> <li>- First choice in stainless and non-ferrous materials</li> <li>- Sharp edge allowing low cutting forces</li> </ul>
GM	 <ul style="list-style-type: none"> <li>- Low cutting forces</li> <li>- Low to medium feed</li> </ul>

## Grade overview

### 4334

- First choice in normal conditions in ISO P and K
- Complementary choice in stable ISO M applications

### 4324

- Wear-resistant choice for ISO P and K

### 4344

- Secure grade that works in all types of materials

### 2044

- First choice in ISO M
- Complementary choice in ISO S

### N124

- Diamond-coating
- First choice in ISO N

### H13A

- Uncoated grade

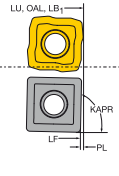
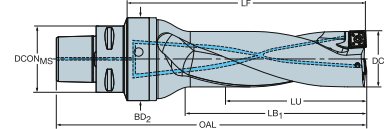
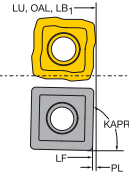
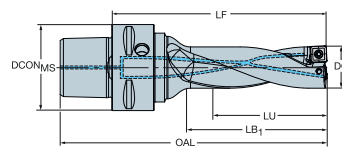
# CoroDrill® 880 indexable insert drill

Coromant Capto®

DSGN

1

2



										Dimensions, mm									
DC			LU	CZC <sub>MS</sub>	ADJLX	TCHAL	TCHAU	DSGN	Ordering code	DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	BD <sub>2</sub>	PL	KAPR	BAR	KG	RPMX
12.00	01C	01P	36.00	C4	0.25	0.00	0.25	1	880-D1200C4-03	40.00	70.61	95.00	39.00		0.38	79°	10	0.343	33000
12.50	01C	01P	38.00	C4	0.25	0.00	0.25	1	880-D1250C4-03	40.00	72.61	97.00	40.00		0.38	79°	10	0.320	33000
12.70	01C	01P	38.00	C4	0.25	0.00	0.25	1	880-D1270C4-03	40.00	73.61	98.00	41.00		0.38	79°	10	0.352	33000
			38.00	C5	0.25	0.00	0.25	1	880-D1270C5-03	50.00	73.61	104.00	41.00		0.38	79°	10	0.570	33000
			38.00	C6	0.25	0.00	0.25	1	880-D1270C6-03	63.00	75.61	114.00	41.00		0.38	79°	10	0.900	33000
13.00	01C	01P	39.00	C4	0.25	0.00	0.25	1	880-D1300C4-03	40.00	74.61	99.00	42.00		0.38	79°	10	0.345	33000
			39.00	C5	0.25	0.00	0.25	1	880-D1300C5-03	50.00	74.61	105.00	42.00		0.38	79°	10	0.570	33000
13.50	01C	01P	41.00	C4	0.25	0.00	0.25	1	880-D1350C4-03	40.00	76.61	101.00	44.00		0.38	79°	10	0.355	33000
			41.00	C6	0.25	0.00	0.25	1	880-D1350C6-03	63.00	78.61	117.00	44.00		0.38	79°	10	0.900	33000
14.00	02C	02P	42.00	C4	0.50	0.00	0.25	1	880-D1400C4-03	40.00	77.67	102.00	45.00		0.32	88°	10	0.351	33000
			42.00	C5	0.50	0.00	0.25	1	880-D1400C5-03	50.00	77.67	108.00	45.00		0.32	88°	10	0.572	33000
			42.00	C6	0.50	0.00	0.25	1	880-D1400C6-03	63.00	79.67	118.00	45.00		0.32	88°	10	0.900	33000
14.50	02C	02P	44.00	C4	0.45	0.00	0.25	1	880-D1450C4-03	40.00	79.67	104.00	46.00		0.32	88°	10	0.356	33000
15.00	02C	02P	45.00	C4	0.40	0.00	0.25	1	880-D1500C4-03	40.00	81.67	106.00	48.00		0.32	88°	10	0.358	33000
			45.00	C5	0.40	0.00	0.25	1	880-D1500C5-03	50.00	81.67	112.00	48.00		0.32	88°	10	0.579	33000
			45.00	C6	0.40	0.00	0.25	1	880-D1500C6-03	63.00	83.67	122.00	48.00		0.32	88°	10	0.900	33000
15.50	02C	02P	47.00	C4	0.30	0.00	0.25	1	880-D1550C4-03	40.00	83.66	108.00	50.00		0.33	88°	10	0.363	33000
			47.00	C5	0.30	0.00	0.25	1	880-D1550C5-03	50.00	83.66	114.00	50.00		0.33	88°	10	0.584	33000
			47.00	C6	0.30	0.00	0.25	1	880-D1550C6-03	63.00	85.66	124.00	50.00		0.33	88°	10	0.900	33000
16.00	02C	02P	48.00	C4	0.30	0.00	0.25	1	880-D1600C4-03	40.00	85.66	110.00	51.00		0.33	88°	10	0.369	33000
			48.00	C5	0.30	0.00	0.25	1	880-D1600C5-03	50.00	85.66	116.00	51.00		0.33	88°	10	0.590	33000
			48.00	C6	0.30	0.00	0.25	1	880-D1600C6-03	63.00	87.66	126.00	51.00		0.33	88°	10	0.909	33000
16.50	03C	03P	50.00	C4	0.60	0.00	0.25	1	880-D1650C4-03	40.00	87.63	112.00	53.00		0.36	88°	10	0.377	30000
			50.00	C5	0.60	0.00	0.25	1	880-D1650C5-03	50.00	87.63	118.00	53.00		0.36	88°	10	0.596	30000
17.00	03C	03P	51.00	C4	0.60	0.00	0.25	1	880-D1700C4-03	40.00	88.63	113.00	54.00		0.36	88°	10	0.379	30000
			51.00	C5	0.60	0.00	0.25	1	880-D1700C5-03	50.00	88.63	119.00	54.00		0.36	88°	10	0.601	30000
			51.00	C6	0.60	0.00	0.25	1	880-D1700C6-03	63.00	90.63	129.00	54.00		0.36	88°	10	0.919	30000
17.50	03C	03P	53.00	C4	0.50	0.00	0.25	1	880-D1750C4-03	40.00	91.62	116.00	56.00		0.37	88°	10	0.411	30000
			53.00	C5	0.50	0.00	0.25	1	880-D1750C5-03	50.00	91.62	122.00	56.00		0.37	88°	10	0.638	30000
			53.00	C6	0.50	0.00	0.25	1	880-D1750C6-03	63.00	93.62	132.00	56.00		0.37	88°	10	0.976	30000
18.00	03C	03P	54.00	C4	0.40	0.00	0.25	1	880-D1800C4-03	40.00	92.62	117.00	57.00		0.37	88°	10	0.416	30000
			54.00	C5	0.40	0.00	0.25	1	880-D1800C5-03	50.00	92.62	123.00	57.00		0.37	88°	10	0.642	30000
			54.00	C6	0.40	0.00	0.25	1	880-D1800C6-03	63.00	94.62	133.00	57.00		0.37	88°	10	1.000	30000
18.50	03C	03P	56.00	C4	0.40	0.00	0.25	1	880-D1850C4-03	40.00	94.62	119.00	59.00		0.37	88°	10	0.419	30000
			56.00	C5	0.40	0.00	0.25	1	880-D1850C5-03	50.00	94.62	125.00	59.00		0.37	88°	10	0.646	30000
19.00	03C	03P	57.00	C4	0.30	0.00	0.25	1	880-D1900C4-03	40.00	95.61	120.00	60.00		0.38	88°	10	0.424	30000
			57.00	C5	0.30	0.00	0.25	1	880-D1900C5-03	50.00	95.61	126.00	60.00		0.38	88°	10	0.651	30000
			57.00	C6	0.30	0.00	0.25	1	880-D1900C6-03	63.00	97.61	136.00	60.00		0.38	88°	10	1.000	30000
19.50	03C	03P	59.00	C4	0.30	0.00	0.25	1	880-D1950C4-03	40.00	98.61	123.00	62.00		0.38	88°	10	0.436	30000
			59.00	C5	0.30	0.00	0.25	1	880-D1950C5-03	50.00	98.61	129.00	62.00		0.38	88°	10	0.658	30000
			60.00	C6	0.90	0.00	0.25	1	880-D2000C6-03	63.00	102.56	141.00	64.00		0.43	88°	10	1.000	21500
20.00	04C	04P	60.00	C4	0.90	0.00	0.25	1	880-D2000C4-03	40.00	100.56	125.00	64.00		0.43	88°	10	0.437	21500
			60.00	C5	0.90	0.00	0.25	1	880-D2000C5-03	50.00	100.56	131.00	64.00		0.43	88°	10	0.662	21500
			60.00	C6	0.90	0.00	0.25	1	880-D2000C6-03	63.00	102.56	141.00	64.00		0.43	88°	10	1.000	21500
21.00	04C	04P	63.00	C4	0.80	0.00	0.25	1	880-D2100C4-03	40.00	103.56	128.00	66.00		0.43	88°	10	0.400	21500
			63.00	C5	0.80	0.00	0.25	1	880-D2100C5-03	50.00	103.56	134.00	66.00		0.43	88°	10	0.673	21500
			63.00	C6	0.80	0.00	0.25	1	880-D2100C6-03	63.00	105.56	144.00	66.00		0.43	88°	10	1.012	21500
22.00	04C	04P	66.00	C4	0.60	0.00	0.25	1	880-D2200C4-03	40.00	106.55	131.00	69.00		0.44	88°	10	0.438	21500
			66.00	C5	0.60	0.00	0.25	1	880-D2200C5-03	50.00	106.55	137.00	69.00		0.44	88°	10	0.688	21500
			66.00	C6	0.60	0.00	0.25	1	880-D2200C6-03	63.00	108.55	147.00	69.00		0.44	88°	10	1.029	21500
23.00	04C	04P	69.00	C4	0.50	0.00	0.25	1	880-D2300C4-03	40.00	110.54	135.00	72.00		0.45	88°	10	0.480	21500
			69.00	C5	0.50	0.00	0.25	1	880-D2300C5-03	50.00	110.54	141.00	72.00		0.45	88°	10	0.711	21500
			69.00	C6	0.50	0.00	0.25	1	880-D2300C6-03	63.00	112.54	151.00	72.00		0.45	88°	10	1.048	21500
24.00	05C	05P	72.00	C4	1.10	0.00	0.25	1	880-D2400C4-03	40.00	114.49	139.00	76.00		0.50	88°	10	0.505	16000
			72.00	C5	1.10	0.00	0.25	1	880-D2400C5-03	50.00	114.49	145.00	76.00		0.50	88°	10	0.730	16000
			72.00	C6	1.10	0.00	0.25	1	880-D2400C6-03	63.00	116.49	155.00	76.00		0.50	88°	10	1.070	16000



J42



L2



J62



J35



N23



N6



N15

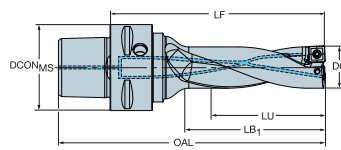
# CoroDrill® 880 indexable insert drill

Coromant Capto®

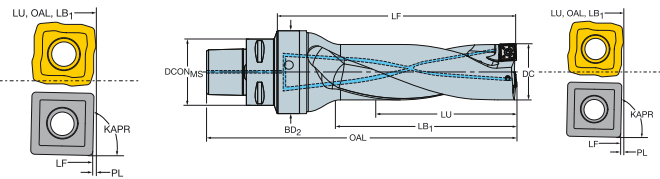


DSGN

1



2



DC	C	P	LU	CZC <sub>MS</sub>	ADJLX	TCHAL	TCHAU	DSGN	Ordering code	Dimensions, mm									
										DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	BD <sub>2</sub>	PL	KAPR	BAR	KG	RPMX
25.00	05C	05P	75.00	C4	1.00	0.00	0.25	1	880-D2500C4-03	40.00	118.48	143.00	79.00	0.51	88°	10	0.526	16000	
			75.00	C5	1.00	0.00	0.25	1	880-D2500C5-03	50.00	118.48	149.00	79.00	0.51	88°	10	0.760	16000	
			75.00	C6	1.00	0.00	0.25	1	880-D2500C6-03	63.00	120.48	159.00	79.00	0.51	88°	10	1.099	16000	
26.00	05C	05P	78.00	C4	0.90	0.00	0.25	1	880-D2600C4-03	40.00	121.47	146.00	81.00	0.52	88°	10	0.596	16000	
			78.00	C5	0.90	0.00	0.25	1	880-D2600C5-03	50.00	121.47	152.00	81.00	0.52	88°	10	0.822	16000	
			78.00	C6	0.90	0.00	0.25	1	880-D2600C6-03	63.00	123.47	162.00	81.00	0.52	88°	10	1.165	16000	
27.00	05C	05P	81.00	C4	0.70	0.00	0.25	1	880-D2700C4-03	40.00	124.46	149.00	84.00	0.53	88°	10	0.623	16000	
			81.00	C5	0.70	0.00	0.25	1	880-D2700C5-03	50.00	124.46	155.00	84.00	0.53	88°	10	0.851	16000	
			81.00	C6	0.70	0.00	0.25	1	880-D2700C6-03	63.00	126.46	165.00	84.00	0.53	88°	10	1.188	16000	
28.00	05C	05P	84.00	C4	0.60	0.00	0.25	1	880-D2800C4-03	40.00	128.46	153.00	87.00	0.53	88°	10	0.665	16000	
			84.00	C5	0.60	0.00	0.25	1	880-D2800C5-03	50.00	128.46	159.00	87.00	0.53	88°	10	0.897	16000	
			84.00	C6	0.60	0.00	0.25	1	880-D2800C6-03	63.00	130.46	169.00	87.00	0.53	88°	10	1.229	16000	
29.00	05C	05P	87.00	C4	0.50	0.00	0.25	1	880-D2900C4-03	40.00	131.45	156.00	90.00	0.54	88°	10	0.696	16000	
			87.00	C5	0.50	0.00	0.25	1	880-D2900C5-03	50.00	131.45	162.00	90.00	0.54	88°	10	0.930	16000	
			87.00	C6	0.50	0.00	0.25	1	880-D2900C6-03	63.00	133.45	172.00	90.00	0.54	88°	10	1.264	16000	
30.00	06C	06P	90.00	C4	1.12	0.00	0.25	1	880-D3000C4-03	40.00	136.41	161.00	94.00	0.58	88°	10	0.679	16000	
			90.00	C5	1.12	0.00	0.25	1	880-D3000C5-03	50.00	136.41	167.00	94.00	0.58	88°	10	0.920	16000	
			90.00	C6	1.12	0.00	0.25	1	880-D3000C6-03	63.00	138.41	177.00	94.00	0.58	88°	10	1.220	16000	
31.00	06C	06P	93.00	C5	0.99	0.00	0.25	1	880-D3100C5-03	50.00	140.40	171.00	97.00	0.59	88°	10	0.998	16000	
			93.00	C6	0.99	0.00	0.25	1	880-D3100C6-03	63.00	142.40	181.00	97.00	0.59	88°	10	1.350	16000	
			96.00	C6	0.87	0.00	0.25	1	880-D3200C6-03	63.00	145.39	184.00	100.00	0.60	88°	10	1.360	16000	
33.00	06C	06P	99.00	C5	0.75	0.00	0.25	1	880-D3300C5-03	50.00	147.38	178.00	103.00	0.61	88°	10	1.040	16000	
			99.00	C6	0.75	0.00	0.25	1	880-D3300C6-03	63.00	149.38	188.00	103.00	0.61	88°	10	1.429	16000	
			102.00	C6	0.62	0.00	0.25	1	880-D3400C6-03	63.00	152.37	191.00	106.00	0.62	88°	10	1.465	16000	
34.00	06C	06P	102.00	C5	0.62	0.00	0.25	1	880-D3400C5-03	50.00	150.37	181.00	106.00	0.62	88°	10	1.060	16000	
			102.00	C6	0.62	0.00	0.25	1	880-D3400C6-03	63.00	152.37	191.00	106.00	0.62	88°	10	1.465	16000	
			105.00	C6	0.50	0.00	0.25	1	880-D3500C6-03	63.00	156.37	195.00	109.00	0.62	88°	10	1.519	16000	
36.00	07C	07P	108.00	C5	1.38	0.00	0.25	1	880-D3600C5-03	50.00	158.32	189.00	112.00	0.67	88°	10	1.175	16000	
			108.00	C6	1.38	0.00	0.25	1	880-D3600C6-03	63.00	160.32	199.00	112.00	0.67	88°	10	1.516	16000	
			111.00	C6	1.25	0.00	0.25	1	880-D3700C6-03	63.00	163.31	202.00	115.00	0.68	88°	10	1.560	16000	
37.00	07C	07P	111.00	C5	1.25	0.00	0.25	1	880-D3700C5-03	50.00	161.31	192.00	115.00	0.68	88°	10	1.213	16000	
			111.00	C6	1.25	0.00	0.25	1	880-D3700C6-03	63.00	163.31	202.00	115.00	0.68	88°	10	1.560	16000	
			114.00	C5	1.13	0.00	0.25	1	880-D3800C5-03	50.00	165.31	196.00	118.00	0.68	88°	10	1.240	16000	
38.00	07C	07P	114.00	C6	1.13	0.00	0.25	1	880-D3800C6-03	63.00	167.31	206.00	118.00	0.68	88°	10	1.630	16000	
			117.00	C5	1.00	0.00	0.25	1	880-D3900C5-03	50.00	168.30	199.00	121.00	0.69	88°	10	1.305	16000	
			117.00	C6	1.00	0.00	0.25	1	880-D3900C6-03	63.00	170.30	209.00	121.00	0.69	88°	10	1.643	16000	
40.00	07C	07P	120.00	C5	0.88	0.00	0.25	1	880-D4000C5-03	50.00	172.29	203.00	124.00	0.70	88°	10	1.370	16000	
			120.00	C6	0.88	0.00	0.25	1	880-D4000C6-03	63.00	174.29	213.00	124.00	0.70	88°	10	1.716	16000	
			123.00	C5	0.75	0.00	0.25	1	880-D4100C5-03	50.00	176.28	207.00	127.00	0.71	88°	10	1.448	16000	
41.00	07C	07P	123.00	C6	0.75	0.00	0.25	1	880-D4100C6-03	63.00	178.28	217.00	127.00	0.71	88°	10	1.800	16000	
			126.00	C5	0.63	0.00	0.25	2	880-D4200C5-03M1	50.00	199.27	230.00	130.00	62.50	0.72	88°	10	2.110	16000
			126.00	C6	0.63	0.00	0.25	1	880-D4200C6-03M1	63.00	199.27	238.00	130.00	0.72	88°	10	2.418	16000	
43.00	07C	07P	129.00	C5	0.50	0.00	0.25	2	880-D4300C5-03M1	50.00	203.30	234.00	133.00	62.50	0.69	88°	10	2.139	16000
			129.00	C6	0.50	0.00	0.25	1	880-D4300C6-03M1	63.00	203.30	242.00	133.00	0.69	88°	10	2.458	16000	

Spare parts	
DC	Insert screw
12.70-16.00	01-02 5513 020-28
16.50-19.50	03 5513 020-33
20.00-23.00	04 5513 020-58
24.00-29.00	05 5513 020-57
30.00-42.00	06-07 416.1-833

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

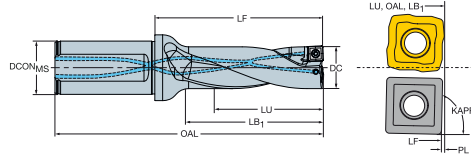




# CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



									Dimensions, mm								
DC			LU	CZC <sub>MS</sub>	ADJLX	TCHAL	TCHAU	Ordering code	DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	KAPR	BAR	KG	RPMX
12.00	01C	01P	24.00	20	0.25	0.00	0.25	880-D1200L20-02	20.00	38.61	89.00	27.00	0.38	79°	10	0.189	33000
			36.00	20	0.25	0.00	0.25	880-D1200L20-03	20.00	50.61	101.00	39.00	0.38	79°	10	0.200	33000
12.50	01C	01P	25.00	20	0.25	0.00	0.25	880-D1250L20-02	20.00	40.61	91.00	28.00	0.38	79°	10	0.200	33000
			38.00	20	0.25	0.00	0.25	880-D1250L20-03	20.00	52.61	103.00	40.00	0.38	79°	10	0.198	33000
12.70	01C	01P	25.00	20	0.25	0.00	0.25	880-D1270L20-02	20.00	40.61	91.00	28.00	0.38	79°	10	0.200	33000
			38.00	20	0.25	0.00	0.25	880-D1270L20-03	20.00	53.61	104.00	41.00	0.38	79°	10	0.200	33000
13.00	01C	01P	26.00	20	0.25	0.00	0.25	880-D1300L20-02	20.00	41.61	92.00	29.00	0.38	79°	10	0.194	33000
			39.00	20	0.25	0.00	0.25	880-D1300L20-03	20.00	54.61	105.00	42.00	0.38	79°	10	0.202	33000
13.50	01C	01P	27.00	20	0.25	0.00	0.25	880-D1350L20-02	20.00	42.61	93.00	30.00	0.38	79°	10	0.200	33000
			41.00	20	0.25	0.00	0.25	880-D1350L20-03	20.00	55.61	106.00	43.00	0.38	79°	10	0.204	33000
14.00	02C	02P	28.00	20	0.50	0.00	0.25	880-D1400L20-02	20.00	43.67	94.00	31.00	0.32	88°	10	0.200	33000
			42.00	20	0.50	0.00	0.25	880-D1400L20-03	20.00	57.67	108.00	45.00	0.32	88°	10	0.211	33000
14.50	02C	02P	29.00	20	0.45	0.00	0.25	880-D1450L20-02	20.00	45.67	96.00	32.00	0.32	88°	10	0.210	33000
			44.00	20	0.45	0.00	0.25	880-D1450L20-03	20.00	59.67	110.00	46.00	0.32	88°	10	0.217	33000
15.00	02C	02P	30.00	20	0.40	0.00	0.25	880-D1500L20-02	20.00	46.67	97.00	33.00	0.32	88°	10	0.212	33000
			45.00	20	0.40	0.00	0.25	880-D1500L20-03	20.00	61.67	112.00	48.00	0.32	88°	10	0.210	33000
15.50	02C	02P	31.00	20	0.30	0.00	0.25	880-D1550L20-02	20.00	48.66	99.00	35.00	0.33	88°	10	0.208	33000
			47.00	20	0.30	0.00	0.25	880-D1550L20-03	20.00	63.66	114.00	50.00	0.33	88°	10	0.225	33000
16.00	02C	02P	32.00	20	0.30	0.00	0.25	880-D1600L20-02	20.00	50.66	101.00	36.00	0.33	88°	10	0.215	33000
			48.00	20	0.30	0.00	0.25	880-D1600L20-03	20.00	65.66	116.00	51.00	0.33	88°	10	0.229	33000
16.50	03C	03P	33.00	20	0.60	0.00	0.25	880-D1650L20-02	20.00	51.63	102.00	37.00	0.36	88°	10	0.224	33000
			50.00	20	0.60	0.00	0.25	880-D1650L20-03	20.00	67.63	118.00	53.00	0.36	88°	10	0.235	30000
17.00	03C	03P	34.00	20	0.60	0.00	0.25	880-D1700L20-02	20.00	52.63	103.00	38.00	0.36	88°	10	0.225	33000
			51.00	20	0.60	0.00	0.25	880-D1700L20-03	20.00	68.63	119.00	54.00	0.36	88°	10	0.232	30000
17.50	03C	03P	35.00	25	0.50	0.00	0.25	880-D1750L25-02	25.00	54.62	111.00	39.00	0.37	88°	10	0.347	33000
			53.00	25	0.50	0.00	0.25	880-D1750L25-03	25.00	71.62	128.00	56.00	0.37	88°	10	0.362	30000
18.00	03C	03P	36.00	25	0.40	0.00	0.25	880-D1800L25-02	25.00	55.62	112.00	40.00	0.37	88°	10	0.352	33000
			54.00	25	0.40	0.00	0.25	880-D1800L25-03	25.00	72.62	129.00	57.00	0.37	88°	10	0.363	30000
18.50	03C	03P	37.00	25	0.40	0.00	0.25	880-D1850L25-02	25.00	56.62	113.00	41.00	0.37	88°	10	0.354	33000
			56.00	25	0.40	0.00	0.25	880-D1850L25-03	25.00	74.62	131.00	59.00	0.37	88°	10	0.369	30000
19.00	03C	03P	38.00	25	0.30	0.00	0.25	880-D1900L25-02	25.00	57.61	114.00	42.00	0.38	88°	10	0.359	33000
			57.00	25	0.30	0.00	0.25	880-D1900L25-03	25.00	75.61	132.00	60.00	0.38	88°	10	0.375	30000
19.50	03C	03P	39.00	25	0.30	0.00	0.25	880-D1950L25-02	25.00	59.61	116.00	43.00	0.38	88°	10	0.371	33000
			59.00	25	0.30	0.00	0.25	880-D1950L25-03	25.00	78.61	135.00	62.00	0.38	88°	10	0.387	30000
20.00	04C	04P	40.00	25	0.90	0.00	0.25	880-D2000L25-02	25.00	60.56	117.00	44.00	0.43	88°	10	0.367	21500
			60.00	25	0.90	0.00	0.25	880-D2000L25-03	25.00	80.56	137.00	64.00	0.43	88°	10	0.340	21500
20.50	04C	04P	62.00	25	0.80	0.00	0.25	880-D2050L25-03	25.00	81.56	138.00	65.00	0.43	88°	10	0.392	21500
			63.00	25	0.80	0.00	0.25	880-D2090L25-03	25.00	83.56	140.00	66.00	0.43	88°	10	0.412	21500
21.00	04C	04P	42.00	25	0.80	0.00	0.25	880-D2100L25-02	25.00	63.56	120.00	46.00	0.43	88°	10	0.382	21500
			63.00	25	0.80	0.00	0.25	880-D2100L25-03	25.00	83.56	140.00	66.00	0.43	88°	10	0.396	21500
21.50	04C	04P	65.00	25	0.70	0.00	0.25	880-D2150L25-03	25.00	85.55	142.00	68.00	0.44	88°	10	0.404	21500
			44.00	25	0.60	0.00	0.25	880-D2200L25-02	25.00	65.55	122.00	48.00	0.44	88°	10	0.367	21500
22.00	04C	04P	66.00	25	0.60	0.00	0.25	880-D2200L25-03	25.00	86.55	143.00	69.00	0.44	88°	10	0.423	21500
			68.00	25	0.50	0.00	0.25	880-D2250L25-03	25.00	89.54	146.00	71.00	0.45	88°	10	0.432	21500
22.50	04C	04P	46.00	25	0.50	0.00	0.25	880-D2300L25-02	25.00	68.54	125.00	50.00	0.45	88°	10	0.403	21500
			69.00	25	0.50	0.00	0.25	880-D2300L25-03	25.00	90.54	147.00	72.00	0.45	88°	10	0.448	21500
23.50	04C	04P	71.00	25	0.40	0.00	0.25	880-D2350L25-03	25.00	92.54	149.00	74.00	0.45	88°	10	0.443	21500
			72.00	25	0.30	0.00	0.25	880-D2390L25-03	25.00	94.53	151.00	76.00	0.46	88°	10	0.465	21500
23.90	04C	04P	48.00	25	1.10	0.00	0.25	880-D2400L25-02	25.00	70.49	127.00	52.00	0.50	88°	10	0.340	16000
			72.00	25	1.10	0.00	0.25	880-D2400L25-03	25.00	94.49	151.00	76.00	0.50	88°	10	0.400	16000
24.50	05C	05P	74.00	25	1.00	0.00	0.25	880-D2450L25-03	25.00	96.49	153.00	77.00	0.50	88°	10	0.480	16000
			75.00	25	1.00	0.00	0.25	880-D2500L25-03	25.00	98.48	155.00	79.00	0.51	88°	10	0.460	16000



J42



L2



J62



J35



N23



N6



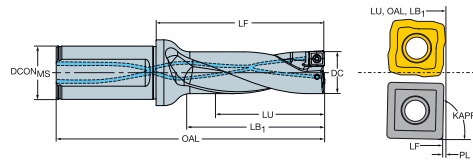
N15



# CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



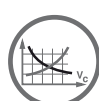
								Dimensions, mm									
DC			LU	CZC <sub>MS</sub>	ADJLX	TCHAL	TCHAU	Ordering code	DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	KAPR	BAR	KG	RPMX
25.50	05C	05P	77.00	25	0.90	0.00	0.25	880-D2550L25-03	25.00	99.48	156.00	80.00	0.51	88°	10	0.501	16000
26.00	05C	05P	52.00	32	0.90	0.00	0.25	880-D2600L32-02	32.00	76.47	137.00	56.00	0.52	88°	10	0.650	16000
			78.00	32	0.90	0.00	0.25	880-D2600L32-03	32.00	101.47	162.00	81.00	0.52	88°	10	0.700	16000
26.40	05C	05P	79.00	32	0.80	0.00	0.25	880-D2640L32-03	32.00	103.47	164.00	83.00	0.52	88°	10	0.707	16000
26.50	05C	05P	80.00	32	0.80	0.00	0.25	880-D2650L32-03	32.00	103.47	164.00	83.00	0.52	88°	10	0.717	16000
27.00	05C	05P	54.00	32	0.70	0.00	0.25	880-D2700L32-02	32.00	78.46	139.00	58.00	0.53	88°	10	0.669	16000
			81.00	32	0.70	0.00	0.25	880-D2700L32-03	32.00	104.46	165.00	84.00	0.53	88°	10	0.724	16000
27.50	05C	05P	83.00	32	0.60	0.00	0.25	880-D2750L32-03	32.00	107.46	168.00	86.00	0.53	88°	10	0.761	16000
28.00	05C	05P	56.00	32	0.60	0.00	0.25	880-D2800L32-02	32.00	81.46	142.00	60.00	0.53	88°	10	0.693	16000
			84.00	32	0.60	0.00	0.25	880-D2800L32-03	32.00	108.46	169.00	87.00	0.53	88°	10	0.755	16000
28.50	05C	05P	86.00	32	0.50	0.00	0.25	880-D2850L32-03	32.00	110.45	171.00	89.00	0.54	88°	10	0.770	16000
29.00	05C	05P	58.00	32	0.50	0.00	0.25	880-D2900L32-02	32.00	83.45	144.00	62.00	0.54	88°	10	0.710	16000
			87.00	32	0.50	0.00	0.25	880-D2900L32-03	32.00	111.45	172.00	90.00	0.54	88°	10	0.784	16000
29.40	05C	05P	88.00	32	0.40	0.00	0.25	880-D2940L32-03	32.00	114.44	175.00	92.00	0.55	88°	10	0.845	16000
29.50	05C	05P	89.00	32	0.40	0.00	0.25	880-D2950L32-03	32.00	114.44	175.00	92.00	0.55	88°	10	0.809	16000
30.00	06C	06P	60.00	32	1.12	0.00	0.25	880-D3000L32-02	32.00	86.41	147.00	64.00	0.58	88°	10	0.699	16000
			90.00	32	1.12	0.00	0.25	880-D3000L32-03	32.00	116.41	177.00	94.00	0.58	88°	10	0.790	16000
30.50	06C	06P	92.00	32	1.05	0.00	0.25	880-D3050L32-03	32.00	117.40	178.00	95.00	0.59	88°	10	0.800	16000
31.00	06C	06P	62.00	40	0.99	0.00	0.25	880-D3100L40-02	40.00	89.40	160.00	66.00	0.59	88°	10	1.136	16000
			93.00	40	0.99	0.00	0.25	880-D3100L40-03	40.00	120.40	191.00	97.00	0.59	88°	10	1.210	16000
31.50	06C	06P	95.00	40	0.93	0.00	0.25	880-D3150L40-03	40.00	121.39	192.00	98.00	0.60	88°	10	1.230	16000
32.00	06C	06P	64.00	40	0.87	0.00	0.25	880-D3200L40-02	40.00	91.39	162.00	68.00	0.60	88°	10	1.156	16000
			96.00	40	0.87	0.00	0.25	880-D3200L40-03	40.00	123.39	194.00	100.00	0.60	88°	10	1.252	16000
32.50	06C	06P	98.00	40	0.81	0.00	0.25	880-D3250L40-03	40.00	125.39	196.00	101.00	0.60	88°	10	1.278	16000
33.00	06C	06P	66.00	40	0.75	0.00	0.25	880-D3300L40-02	40.00	94.38	165.00	70.00	0.61	88°	10	1.200	16000
			99.00	40	0.75	0.00	0.25	880-D3300L40-03	40.00	127.38	198.00	103.00	0.61	88°	10	1.303	16000
33.50	06C	06P	101.00	40	0.68	0.00	0.25	880-D3350L40-03	40.00	129.38	200.00	105.00	0.61	88°	10	1.317	16000
34.00	06C	06P	68.00	40	0.62	0.00	0.25	880-D3400L40-02	40.00	97.37	168.00	73.00	0.62	88°	10	1.227	16000
			102.00	40	0.62	0.00	0.25	880-D3400L40-03	40.00	130.37	201.00	106.00	0.62	88°	10	1.340	16000
34.50	06C	06P	104.00	40	0.56	0.00	0.25	880-D3450L40-03	40.00	133.37	204.00	108.00	0.62	88°	10	1.380	16000
35.00	06C	06P	70.00	40	0.50	0.00	0.25	880-D3500L40-02	40.00	100.37	171.00	75.00	0.62	88°	10	1.270	16000
			105.00	40	0.50	0.00	0.25	880-D3500L40-03	40.00	134.37	205.00	109.00	0.62	88°	10	1.400	16000
35.50	06C	06P	107.00	40	0.44	0.00	0.25	880-D3550L40-03	40.00	136.36	207.00	111.00	0.63	88°	10	1.415	16000
36.00	07C	07P	72.00	40	1.38	0.00	0.25	880-D3600L40-02	40.00	103.32	174.00	77.00	0.67	88°	10	1.280	16000
			108.00	40	1.38	0.00	0.25	880-D3600L40-03	40.00	138.32	209.00	112.00	0.67	88°	10	1.397	16000
37.00	07C	07P	74.00	40	1.25	0.00	0.25	880-D3700L40-02	40.00	104.31	175.00	78.00	0.68	88°	10	1.300	16000
			111.00	40	1.25	0.00	0.25	880-D3700L40-03	40.00	141.31	212.00	115.00	0.68	88°	10	1.446	16000
38.00	07C	07P	76.00	40	1.13	0.00	0.25	880-D3800L40-02	40.00	107.31	178.00	80.00	0.68	88°	10	1.349	16000
			114.00	40	1.13	0.00	0.25	880-D3800L40-03	40.00	145.31	216.00	118.00	0.68	88°	10	1.480	16000
39.00	07C	07P	78.00	40	1.00	0.00	0.25	880-D3900L40-02	40.00	109.30	180.00	82.00	0.69	88°	10	1.366	16000
			117.00	40	1.00	0.00	0.25	880-D3900L40-03	40.00	148.30	219.00	121.00	0.69	88°	10	1.535	16000
40.00	07C	07P	80.00	40	0.88	0.00	0.25	880-D4000L40-02	40.00	112.29	183.00	84.00	0.70	88°	10	1.413	16000
			120.00	40	0.88	0.00	0.25	880-D4000L40-03	40.00	152.29	223.00	124.00	0.70	88°	10	1.603	16000
41.00	07C	07P	82.00	40	0.75	0.00	0.25	880-D4100L40-02	40.00	116.28	187.00	87.00	0.71	88°	10	1.480	16000
			123.00	40	0.75	0.00	0.25	880-D4100L40-03	40.00	156.28	227.00	127.00	0.71	88°	10	1.690	16000
42.00	07C	07P	84.00	40	0.63	0.00	0.25	880-D4200L40-02	40.00	118.27	189.00	89.00	0.72	88°	10	1.505	16000
			126.00	40	0.63	0.00	0.25	880-D4200L40-03	40.00	159.27	230.00	130.00	0.72	88°	10	1.740	16000
43.00	07C	07P	86.00	40	0.50	0.00	0.25	880-D4300L40-02	40.00	121.26	192.00	91.00	0.73	88°	10	1.510	16000
			129.00	40	0.50	0.00	0.25	880-D4300L40-03	40.00	163.26	234.00	133.00	0.73	88°	10	1.730	16000
44.00	08C	08P	88.00	40	1.50	0.00	0.28	880-D4400L40-02	40.00	123.23	194.00	93.00	0.76	88°	10	1.510	15000
			132.00	40	1.50	0.00	0.28	880-D4400L40-03	40.00	166.23	237.00	136.00	0.76	88°	10	1.720	15000
45.00	08C	08P	90.00	40	1.40	0.00	0.28	880-D4500L40-02	40.00	126.22	197.00	95.00	0.77	88°	10	1.560	15000
			135.00	40	1.40	0.00	0.28	880-D4500L40-03	40.00	171.22	242.00	140.00	0.77	88°	10	1.800	15000



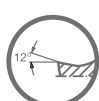
J42



L2



J62



J35



N23



N6



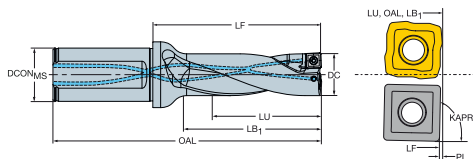
N15



# CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



Dimensions, mm

DC			LU	CZC <sub>MS</sub>	ADJLX	TCHAL	TCHAU	Ordering code	DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	KAPR	BAR	KG	RPMX
46.00	08C	08P	92.00	40	1.30	0.00	0.28	880-D4600L40-02	40.00	129.22	200.00	97.00	0.78	88°	10	1.610	15000
			138.00	40	1.30	0.00	0.28	880-D4600L40-03	40.00	175.22	246.00	143.00	0.78	88°	10	1.881	15000
47.00	08C	08P	94.00	40	1.10	0.00	0.28	880-D4700L40-02	40.00	131.21	202.00	99.00	0.78	88°	10	1.800	15000
			141.00	40	1.10	0.00	0.28	880-D4700L40-03	40.00	178.21	249.00	146.00	0.78	88°	10	2.140	15000
48.00	08C	08P	96.00	40	1.00	0.00	0.28	880-D4800L40-02	40.00	134.20	205.00	101.00	0.79	88°	10	1.925	15000
			144.00	40	1.00	0.00	0.28	880-D4800L40-03	40.00	182.20	253.00	149.00	0.79	88°	10	2.235	15000
49.00	08C	08P	98.00	40	0.90	0.00	0.28	880-D4900L40-02	40.00	136.19	207.00	103.00	0.80	88°	10	1.970	15000
			147.00	40	0.90	0.00	0.28	880-D4900L40-03	40.00	185.19	256.00	152.00	0.80	88°	10	2.275	15000
50.00	08C	08P	100.00	40	0.80	0.00	0.28	880-D5000L40-02	40.00	139.18	210.00	105.00	0.81	88°	10	2.031	15000
			150.00	40	0.80	0.00	0.28	880-D5000L40-03	40.00	189.18	260.00	155.00	0.81	88°	10	2.430	15000
51.00	08C	08P	102.00	40	0.60	0.00	0.28	880-D5100L40-02	40.00	143.18	214.00	108.00	0.82	88°	10	2.110	15000
			153.00	40	0.60	0.00	0.28	880-D5100L40-03	40.00	193.18	264.00	158.00	0.82	88°	10	2.480	15000
52.00	08C	08P	104.00	40	0.50	0.00	0.28	880-D5200L40-02	40.00	145.17	216.00	110.00	0.82	88°	10	2.180	15000
			156.00	40	0.50	0.00	0.28	880-D5200L40-03	40.00	196.17	267.00	161.00	0.82	88°	10	2.595	15000
53.00	09C	09P	106.00	40	2.00	0.00	0.30	880-D5300L40-02	40.00	148.12	219.00	112.00	0.87	88°	10	2.307	5000
			159.00	40	2.00	0.00	0.30	880-D5300L40-03	40.00	200.12	271.00	164.00	0.87	88°	10	2.600	5000
54.00	09C	09P	108.00	40	1.90	0.00	0.30	880-D5400L40-02	40.00	150.11	221.00	114.00	0.88	88°	10	2.380	5000
			162.00	40	1.90	0.00	0.30	880-D5400L40-03	40.00	203.11	274.00	167.00	0.88	88°	10	2.714	5000
55.00	09C	09P	110.00	40	1.70	0.00	0.30	880-D5500L40-02	40.00	153.10	224.00	116.00	0.89	88°	10	2.349	5000
			165.00	40	1.70	0.00	0.30	880-D5500L40-03	40.00	208.10	279.00	171.00	0.89	88°	10	2.850	5000
56.00	09C	09P	112.00	40	1.60	0.00	0.30	880-D5600L40-02	40.00	156.10	227.00	118.00	0.89	88°	10	2.451	5000
			168.00	40	1.60	0.00	0.30	880-D5600L40-03	40.00	212.10	283.00	174.00	0.89	88°	10	2.977	5000
57.00	09C	09P	114.00	40	1.50	0.00	0.30	880-D5700L40-02	40.00	158.09	229.00	120.00	0.90	88°	10	2.530	5000
			171.00	40	1.50	0.00	0.30	880-D5700L40-03	40.00	215.09	286.00	177.00	0.90	88°	10	3.120	5000
58.00	09C	09P	116.00	40	1.40	0.00	0.30	880-D5800L40-02	40.00	161.08	232.00	122.00	0.91	88°	10	2.650	5000
			174.00	40	1.40	0.00	0.30	880-D5800L40-03	40.00	219.08	290.00	180.00	0.91	88°	10	3.593	5000
59.00	09C	09P	118.00	40	1.20	0.00	0.30	880-D5900L40-02	40.00	163.07	234.00	124.00	0.92	88°	10	2.703	5000
			177.00	40	1.20	0.00	0.30	880-D5900L40-03	40.00	222.07	293.00	183.00	0.92	88°	10	3.346	5000
60.00	09C	09P	120.00	40	1.10	0.00	0.30	880-D6000L40-02	40.00	166.06	237.00	126.00	0.93	88°	10	2.820	5000
			180.00	40	1.10	0.00	0.30	880-D6000L40-03	40.00	226.06	297.00	186.00	0.93	88°	10	3.570	5000
61.00	09C	09P	122.00	40	1.00	0.00	0.30	880-D6100L40-02	40.00	170.06	241.00	129.00	0.93	88°	10	3.032	5000
			183.00	40	1.00	0.00	0.30	880-D6100L40-03	40.00	231.06	302.00	190.00	0.93	88°	10	4.039	5000
62.00	09C	09P	124.00	40	0.80	0.00	0.30	880-D6200L40-02	40.00	172.05	243.00	131.00	0.94	88°	10	3.020	5000
			186.00	40	0.80	0.00	0.30	880-D6200L40-03	40.00	234.05	305.00	193.00	0.94	88°	10	4.115	5000
63.00	09C	09P	126.00	40	0.70	0.00	0.30	880-D6300L40-02	40.00	175.04	246.00	133.00	0.95	88°	10	3.173	5000
			189.00	40	0.70	0.00	0.30	880-D6300L40-03	40.00	238.04	309.00	196.00	0.95	88°	10	4.300	5000

Spare parts		
DC	Insert screw	
12.00-16.00	01-02	5513 020-28
16.50-19.50	03	5513 020-33
20.00-23.90	04	5513 020-58
24.00-28.50	05	5513 020-57
30.00-41.00	06-07	416.1-833
44.00-63.00	08-09	416.1-834

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



J42



L2



J62



J35



N23



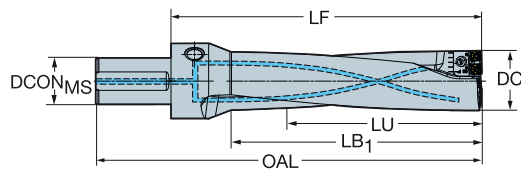
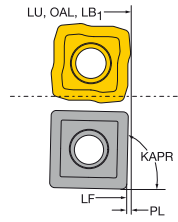
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N15

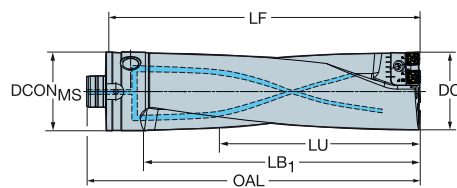
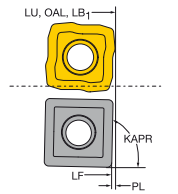
# CoroDrill® 880 indexable insert drill

Internal coolant supply



## Cylindrical shank with flat according to ISO 9766

										Dimensions, mm								
DC	C I I P				LU	CZC <sub>MS</sub>	TCHAL	TCHAU	Ordering code	DCON <sub>MS</sub>	LF	OAL	LB <sub>1</sub>	PL	KAPR	BAR	KG	RPMX
65.00	06C	06P	06P	06P	207.00	50	-0.30	0.30	880-D0650L50-03	50.00	275.70	357.00	212.77	1.30	88°	10	8.495	5000
					276.00	50	-0.30	0.30	880-D0650L50-04	50.00	344.70	426.00	281.77	1.30	88°	10	10.125	5000
66.00	06C	06P	06P	06P	207.00	50	-0.30	0.30	880-D0660L50-03	50.00	275.70	357.00	212.77	1.30	88°	10	8.470	5000
					276.00	50	-0.30	0.30	880-D0660L50-04	50.00	344.70	426.00	281.77	1.30	88°	10	7.900	5000
67.00	06C	06P	06P	06P	207.00	50	-0.30	0.30	880-D0670L50-03	50.00	275.70	357.00	212.77	1.30	88°	10	7.105	5000
					276.00	50	-0.30	0.30	880-D0670L50-04	50.00	344.70	426.00	281.77	1.30	88°	10	7.900	5000
68.00	06C	06P	06P	06P	207.00	50	-0.30	0.30	880-D0680L50-03	50.00	275.70	357.00	212.77	1.30	88°	10	8.460	5000
					276.00	50	-0.30	0.30	880-D0680L50-04	50.00	344.70	426.00	281.77	1.30	88°	10	7.900	5000
69.00	06C	06P	06P	06P	207.00	50	-0.30	0.30	880-D0690L50-03	50.00	275.70	357.00	212.77	1.30	88°	10	8.460	5000
					276.00	50	-0.30	0.30	880-D0690L50-04	50.00	344.70	426.00	281.77	1.30	88°	10	7.900	5000
70.00	06C	06P	06P	06P	222.00	50	-0.30	0.30	880-D0700L50-03	50.00	300.60	382.00	249.63	1.40	88°	10	9.485	5000
					296.00	50	-0.30	0.30	880-D0700L50-04	50.00	374.60	456.00	323.63	1.40	88°	10	10.980	5000
71.00	06C	06P	06P	06P	222.00	50	-0.30	0.30	880-D0710L50-03	50.00	300.60	382.00	249.63	1.40	88°	10	9.450	5000
					296.00	50	-0.30	0.30	880-D0710L50-04	50.00	374.60	456.00	323.63	1.40	88°	10	11.217	5000
72.00	06C	06P	06P	06P	222.00	50	-0.30	0.30	880-D0720L50-03	50.00	300.60	382.00	249.63	1.40	88°	10	9.515	5000
					296.00	50	-0.30	0.30	880-D0720L50-04	50.00	374.60	456.00	323.63	1.40	88°	10	11.320	5000
73.00	06C	06P	06P	06P	222.00	50	-0.30	0.30	880-D0730L50-03	50.00	300.60	382.00	249.63	1.40	88°	10	9.400	5000
					296.00	50	-0.30	0.30	880-D0730L50-04	50.00	374.60	456.00	323.63	1.40	88°	10	11.370	5000
74.00	06C	06P	07P	07P	222.00	50	-0.30	0.30	880-D0740L50-03	50.00	300.60	382.00	249.63	1.40	88°	10	9.350	5000
					296.00	50	-0.30	0.30	880-D0740L50-04	50.00	374.60	456.00	323.63	1.40	88°	10	11.275	5000
75.00	07C	07P	07P	07P	237.00	50	-0.30	0.30	880-D0750L50-03	50.00	305.60	387.00	255.15	1.40	88°	10	10.250	5000
					316.00	50	-0.30	0.30	880-D0750L50-04	50.00	384.60	466.00	334.15	1.40	88°	10	12.325	5000
76.00	07C	07P	07P	07P	237.00	50	-0.30	0.30	880-D0760L50-03	50.00	305.60	387.00	255.15	1.40	88°	10	10.700	5000
					316.00	50	-0.30	0.30	880-D0760L50-04	50.00	384.60	466.00	334.15	1.40	88°	10	12.250	5000
77.00	07C	07P	07P	07P	237.00	50	-0.30	0.30	880-D0770L50-03	50.00	305.60	387.00	255.15	1.40	88°	10	10.700	5000
					316.00	50	-0.30	0.30	880-D0770L50-04	50.00	384.60	466.00	334.15	1.40	88°	10	12.268	5000
78.00	07C	07P	07P	07P	237.00	50	-0.30	0.30	880-D0780L50-03	50.00	305.60	387.00	255.15	1.40	88°	10	10.700	5000
					316.00	50	-0.30	0.30	880-D0780L50-04	50.00	384.60	466.00	334.15	1.40	88°	10	12.385	5000
79.00	07C	07P	07P	07P	237.00	50	-0.30	0.30	880-D0790L50-03	50.00	305.60	387.00	255.15	1.40	88°	10	10.700	5000
					316.00	50	-0.30	0.30	880-D0790L50-04	50.00	384.60	466.00	334.15	1.40	88°	10	12.230	5000



## VL coupling

										Dimensions, mm								
DC	C I I P				LU	CZC <sub>MS</sub>	TCHAL	TCHAU	Ordering code	DCON	LF	OAL	LB <sub>1</sub>	PL	KAPR	BAR	KG	RPMX
80.00	07C	07P	07P	07P	252.00	80	-0.30	0.30	880-D0800V80-03	80.00	330.50	350.00	287.61	1.50	88°	10	10.500	5000
					336.00	80	-0.30	0.30	880-D0800V80-04	80.00	414.50	434.00	371.61	1.50	88°	10	13.300	5000
81.00	07C	07P	07P	07P	252.00	80	-0.30	0.30	880-D0810V80-03	80.00	330.50	350.00	287.61	1.50	88°	10	12.700	5000
					336.00	80	-0.30	0.30	880-D0810V80-04	80.00	414.50	434.00	371.61	1.50	88°	10	13.125	5000
82.00	07C	07P	07P	07P	252.00	80	-0.30	0.30	880-D0820V80-03	80.00	330.50	350.00	287.61	1.50	88°	10	12.700	5000
					336.00	80	-0.30	0.30	880-D0820V80-04	80.00	414.50	434.00	371.61	1.50	88°	10	13.205	5000
83.00	07C	07P	07P	07P	252.00	80	-0.30	0.30	880-D0830V80-03	80.00	330.50	350.00	287.61	1.50	88°	10	12.700	5000
					336.00	80	-0.30	0.30	880-D0830V80-04	80.00	414.50	434.00	371.61	1.50	88°	10	15.100	5000
84.00	07C	07P	07P	07P	252.00	80	-0.30	0.30	880-D0840V80-03	80.00	330.50	350.00	287.61	1.50	88°	10	12.700	5000
					336.00	80	-0.30	0.30	880-D0840V80-04	80.00	414.50	434.00	371.61	1.50	88°	10	13.300	5000

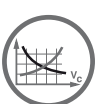
Cartridges are included, inserts are sold separately



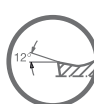
J42



L2



J62



J35



N23



N6



N15

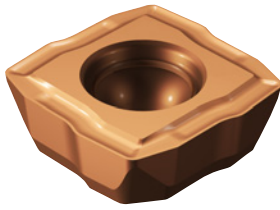


J48

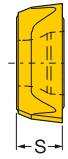
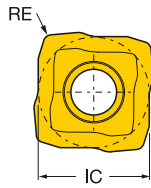


# CoroDrill® 880 insert for drilling

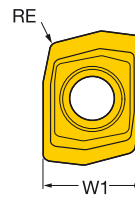
Central insert



880..C



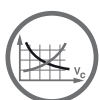
880-01..C



	INSUC	Ordering code	P M K N S H									Dimensions, mm												
			P			M			K			N			S			H			S	RE	IC	W1
			1044	1044	1144	1044	1044	1144	1044	H13A	N134	1044	1144	H13A	1044	1044	1044							
Medium feed	01C	C	880-01 02 03H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	2.20	0.30	4.8		
	02C	C	880-02 02 04H-C-GM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	2.40	0.40	4.9		
		C	880-02 02 04H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	2.40	0.40	4.9		
	03C	C	880-03 03 05H-C-GM	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	2.60	0.50	5.7		
		C	880-03 03 05H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	2.60	0.50	5.7		
	04C	C	880-04 03 05H-C-GM	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	2.80	0.50	6.8		
		C	880-04 03 05H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	2.80	0.50	6.8		
	05C	C	880-05 03 05H-C-GM	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	3.00	0.50	8.4		
		C	880-05 03 05H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	3.00	0.50	8.4		
	06C	C	880-06 04 06H-C-GM	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	3.50	0.60	10.2		
		C	880-06 04 06H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	3.50	0.60	10.2		
	07C	C	880-07 04 06H-C-GM	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	4.00	0.60	12.4		
		C	880-07 04 06H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	4.00	0.60	12.4		
	08C	C	880-08 05 08H-C-GM	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	4.50	0.80	14.9		
		C	880-08 05 08H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	4.50	0.80	14.9		
	09C	C	880-09 06 08H-C-GM	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	5.50	0.80	17.9		
		C	880-09 06 08H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	★	★	☆	☆	★	★	5.50	0.80	17.9		
	High feed	01C	C	880-01 02 03H-C-GR	★			★	☆			☆			★			★	★	2.20	0.30	4.8		
02C		C	880-02 02 04H-C-GR	★	☆		★	☆			☆			★			★	★	2.40	0.40	4.9			
03C		C	880-03 03 05H-C-GR	★	☆		★	☆			☆			★			★	★	2.60	0.50	5.7			
04C		C	880-04 03 05H-C-GR	★	☆		★	☆			☆			★			★	★	2.80	0.50	6.8			
05C		C	880-05 03 05H-C-GR	★	☆		★	☆			☆			★			★	★	3.00	0.50	8.4			
06C		C	880-06 04 06H-C-GR	★	☆		★	☆			☆			★			★	★	3.50	0.60	10.2			
07C		C	880-07 04 06H-C-GR	★	☆		★	☆			☆			★			★	★	4.00	0.60	12.4			
08C		C	880-08 05 08H-C-GR	★	☆		★	☆			☆			★			★	★	4.50	0.80	14.9			
09C		C	880-09 06 08H-C-GR	★	☆		★	☆			☆			★			★	★	5.50	0.80	17.9			



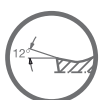
J36



J62



J35



J35



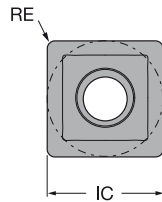
N23

# CoroDrill® 880 insert for drilling

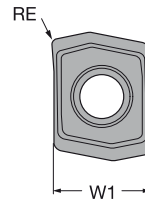
Peripheral insert



880..P



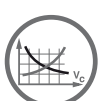
880-01..P



INSUC	Ordering code	Material										Dimensions, mm									
		P			M			K		N		S		H		S	RE	IC	W1		
		4324	4334	4344	2044	4334	4344	4324	4334	4344	4344	H13A	N124	2044	4344					H13A	4334
Medium feed	01P	P	880-01 02 W04H-P-LM	☆	★	☆													2.20	0.40	4.8
		P	880-01 02 W04H-P-MS	☆	★	☆	★						★	★					2.20	0.40	4.8
	02P	P	880-02 02 W04H-P-GM	☆	☆	☆	☆	☆	☆	☆	☆				☆	☆	☆	☆	2.40	0.40	5.1
		P	880-02 02 W05H-P-LM	☆	★	☆										★	★	★	2.40	0.50	5.1
		P	880-02 02 W05H-P-MS	☆	★	☆	★							★	★				2.40	0.50	5.1
	03P	P	880-03 03 W05H-P-GM	☆	☆	☆	☆	☆	☆	☆	☆				☆	☆	☆	☆	2.60	0.50	6.0
		P	880-03 03 W06H-P-LM	☆	★	☆	☆	☆	☆	☆	☆	☆				★	★	★	2.60	0.60	6.0
		P	880-03 03 W06H-P-MS	☆	★	☆	★							★	★				2.60	0.60	6.0
	04P	P	880-04 03 W05H-P-GM	☆	☆	☆	☆	☆	☆	☆	☆							★	2.80	0.50	7.4
		P	880-04 03 W07H-P-LM	☆	★	☆	☆	☆	☆	☆	☆	☆				★	★	★	2.80	0.70	7.4
		P	880-04 03 W07H-P-MS	☆	★	☆	★							★	★				2.80	0.70	7.4
	05P	P	880-05 03 W05H-P-GM	☆	☆	☆	☆	☆	☆	☆	☆							★	3.00	0.50	8.9
		P	880-05 03 W08H-P-LM	☆	★	☆	☆	☆	☆	☆	☆	☆				★	★	★	3.00	0.80	8.9
		P	880-05 03 W08H-P-MS	☆	★	☆	★							★	★				3.00	0.80	8.9
	06P	P	880-06 04 W06H-P-GM	☆	☆	☆	☆	☆	☆	☆	☆							★	3.50	0.60	10.7
		P	880-06 04 W08H-P-LM	☆	★	☆	☆	☆	☆	☆	☆	☆				★	★	★	3.50	0.80	10.7
		P	880-06 04 W08H-P-MS	☆	★	☆	★								★	★			3.50	0.80	10.7
	07P	P	880-07 04 W06H-P-GM	☆	☆	☆	☆	☆	☆	☆	☆							★	4.00	0.60	12.7
	P	880-07 04 W10H-P-LM	☆	★	☆	☆	☆	☆	☆	☆	☆				★	★	★	4.00	1.00	12.7	
	P	880-07 04 W10H-P-MS	☆	★	☆	★								★	★			4.00	1.00	12.7	
08P	P	880-08 05 W08H-P-GM	☆	☆	☆	☆	☆	☆	☆	☆							★	4.50	0.80	15.5	
	P	880-08 05 W10H-P-LM	☆	★	☆	☆	☆	☆	☆	☆	☆				★	★	★	4.50	1.00	15.5	
	P	880-08 05 W10H-P-MS	☆	★	☆	★								★	★			4.50	1.00	15.5	
09P	P	880-09 06 W08H-P-GM	☆	☆	☆	☆	☆	☆	☆	☆							★	5.50	0.80	18.6	
	P	880-09 06 W10H-P-LM	☆	★	☆	☆	☆	☆	☆	☆	☆				★	★	★	5.50	1.00	18.6	
	P	880-09 06 W10H-P-MS	☆	★	☆	★								★	★			5.50	1.00	18.6	
High feed	01P	P	880-01 02 W04H-P-GR	☆	★	☆	☆	☆	☆	☆	☆				☆	☆	★	2.20	0.40	4.8	
	02P	P	880-02 02 W05H-P-GR	☆	★	☆	☆	☆	☆	☆	☆				☆	☆	☆	2.40	0.50	5.1	
		P	880-02 02 W05H-P-GT	☆	☆	☆	☆	☆	☆	☆	☆				☆	☆	☆	2.40	0.50	5.1	
	03P	P	880-03 03 W06H-P-GR	☆	★	☆	☆	☆	☆	☆	☆							☆	2.60	0.60	6.0
		P	880-03 03 W06H-P-GT	☆	☆	☆	☆	☆	☆	☆	☆							☆	2.60	0.60	6.0
	04P	P	880-04 03 W07H-P-GR	☆	★	☆	☆	☆	☆	☆	☆							☆	2.80	0.70	7.4
		P	880-04 03 W07H-P-GT	☆	☆	☆	☆	☆	☆	☆	☆							☆	2.80	0.70	7.4
	05P	P	880-05 03 W08H-P-GR	☆	★	☆	☆	☆	☆	☆	☆							☆	3.00	0.80	8.9
		P	880-05 03 W08H-P-GT	☆	☆	☆	☆	☆	☆	☆	☆							☆	3.00	0.80	8.9
	06P	P	880-06 04 W10H-P-GR	☆	★	☆	☆	☆	☆	☆	☆							☆	3.50	1.00	10.7
		P	880-06 04 W10H-P-GT	☆	☆	☆	☆	☆	☆	☆	☆							☆	3.50	1.00	10.7
	07P	P	880-07 04 W12H-P-GR	☆	★	☆	☆	☆	☆	☆	☆							☆	4.00	1.20	12.7
		P	880-07 04 W12H-P-GT	☆	☆	☆	☆	☆	☆	☆	☆							☆	4.00	1.20	12.7
	08P	P	880-08 05 W12H-P-GR	☆	★	☆	☆	☆	☆	☆	☆							☆	4.50	1.20	15.5
		P	880-08 05 W12H-P-GT	☆	☆	☆	☆	☆	☆	☆	☆							☆	4.50	1.20	15.5
	09P	P	880-09 06 W12H-P-GR	☆	★	☆	☆	☆	☆	☆	☆							☆	5.50	1.20	18.6
		P	880-09 06 W12H-P-GT	☆	☆	☆	☆	☆	☆	☆	☆							☆	5.50	1.20	18.6



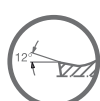
J36



J62



J35



J35



N23

# Trepanning tool

Proven concept for core drilling

## Applications

- Trepanning
- Through-hole applications
- Stack drilling

ISO application area:



## Benefits and features

- Excellent reliability in unstable applications and lathe applications
- Internal coolant supply
- Stack drilling cartridges available

## Drill bodies

- VL coupling

## Inserts

- Geometries and grades for most materials

## Vertical setup

The core will fall down when drill breaks through, which does not normally cause a problem.

## Horizontal setup

Long and heavy cores may require a core support to prevent the core from falling down and chipping the inner insert.



J45

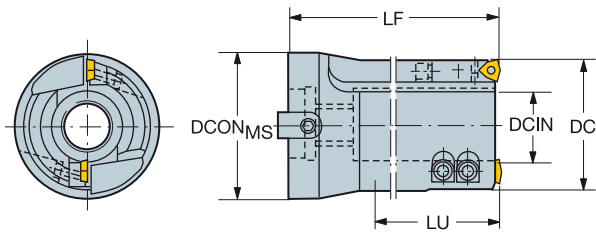


J46

# Trepanning tool

VL coupling

Internal coolant supply



							Dimensions, mm					
DC	DCIN	LU	CZC <sub>MS</sub>	TCHAL	TCHAU	Ordering code	DCON <sub>MS</sub>	LF	KAPR	BAR	KG	
60.00	24.00	06	150.00	80	-0.20	0.20	R416.7-0600-25-01	80.00	195.00	85°	20	3.160
65.00	29.00	06	165.00	80	-0.20	0.20	R416.7-0650-25-01	80.00	210.00	85°	20	3.853
70.00	34.00	06	175.00	80	-0.20	0.20	R416.7-0700-25-01	80.00	220.00	85°	20	4.080
75.00	39.00	06	190.00	80	-0.20	0.20	R416.7-0750-25-01	80.00	235.00	85°	20	4.757
80.00	44.00	06	200.00	80	-0.20	0.20	R416.7-0800-25-01	80.00	245.00	85°	20	5.524
85.00	49.00	06	215.00	80	-0.20	0.20	R416.7-0850-25-01	80.00	260.00	85°	20	6.040
90.00	54.00	06	225.00	80	-0.20	0.20	R416.7-0900-25-01	80.00	270.00	85°	20	6.700
95.00	59.00	06	240.00	80	-0.20	0.20	R416.7-0950-25-01	80.00	285.00	85°	20	7.700
100.00	64.00	06	250.00	80	-0.20	0.20	R416.7-1000-25-01	80.00	295.00	85°	20	8.634
110.00	74.00	06	275.00	80	-0.20	0.20	R416.7-1100-25-01	80.00	320.00	85°	20	10.080

For mounting information see page M28

## Spare parts

Driving key	Screw	Screw
5631 010-03	3212 010-360	430.21-825

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

## Accessories

### Cartridge for trepanning tool

Inner	Insert	Peripheral	Insert
L430.23-1117-06	WCMX 06	R430.26-1114-06	WCMX 06

### Cartridge for stack drilling with trepanning tool

Inner	Insert	Peripheral	Insert
L430.23-1117-06SD	WCMX 06	R430.26-1114-06SD	WCMX 06

Accessories, must be ordered separately



J46



L2

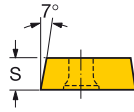
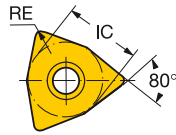
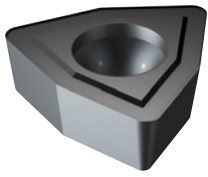


N23



N15

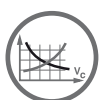
# Trepanning inserts



Medium feed	INSUC	Ordering code	Dimensions, mm																	
			P			M			K			N		S						
			1020	235	3040	4235	1020	235	3040	4235	1020	1125	3040	4235	1020	HT3A	1020	HT3A	S	RE
06	P	WCMX 06 T3 08 R-51	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.97	0.80	9.5
	P	WCMX 06 T3 08 R-53	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.97	0.80	9.5
	P	WCMX 06 T3 08-56	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.97	0.80	9.5
	P	WCMX 06 T3 08-58	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.97	0.80	9.5
	P	WCMX 06 T3 08-GM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	3.97	0.80	9.5



J45



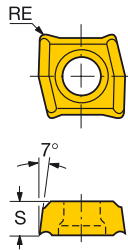
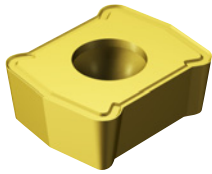
J67



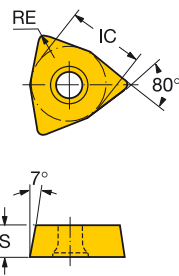
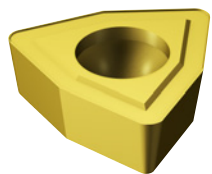
N23



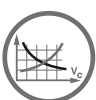
# Coromant U insert for drilling



Medium feed	INSUC	Ordering code	P												M			K			N			S			H			Dimensions, mm	
			1020	1120	235	3040	1020	1120	235	3040	1020	1120	3040	1020	1120	HT3A	1020	1120	HT3A	1020	1120	3040	S	RE							
			★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★						
02	C	LCMX 02 02 04C-53	★				★					★											2.38	0.40							
	P	LCMX 02 02 04P-53		☆		★					★			★			★						2.38	0.40							
	C	LCMX 02 02 04TC-53	☆								☆										☆		2.38	0.40							
	P	LCMX 03 03 04-58			☆				☆		☆												3.18	0.40							
	P	LCMX 03 03 04R-WM			☆				☆		☆												3.18	0.45							
	P+C	LCMX 03 03 08-53	★		☆	★		☆	★		★			★		★		☆			★		3.18	0.80							
03	P+C	LCMX 03 03 08T-53	★		☆			☆		☆											☆		3.18	0.80							
	P	LCMX 04 03 04-58			☆			☆		☆													3.18	0.40							
	P	LCMX 04 03 04R-WM			☆			☆		☆													3.18	0.40							
	P+C	LCMX 04 03 08-53	★		☆	★		☆	★		★			★		★		☆			★		3.18	0.80							
	P+C	LCMX 04 03 08T-53	★		☆			☆		☆											☆		3.18	0.80							
	P	LCMX 04 03 04-58			☆			☆		☆													3.18	0.40							
04	P	LCMX 04 03 04R-WM			☆			☆		☆													3.18	0.40							
	P+C	LCMX 04 03 08-53	★		☆	★		☆	★		★			★		★		☆			★		3.18	0.80							
	P+C	LCMX 04 03 08T-53	★		☆			☆		☆											☆		3.18	0.80							
	P	LCMX 04 03 04-58			☆			☆		☆													3.18	0.40							
	P	LCMX 04 03 04R-WM			☆			☆		☆													3.18	0.40							
	P+C	LCMX 04 03 08-53	★		☆	★		☆	★		★			★		★		☆			★		3.18	0.80							
05	P+C	LCMX 04 03 08T-53	★		☆			☆		☆											☆		3.18	0.80							



Medium feed	INSUC	Ordering code	P												M			K				N			S		H		Dimensions, mm		
			1020	1125	235	3040	4235	1020	1125	235	3040	4235	1020	1125	235	3040	4235	1020	HT3A	1020	HT3A	1020	3040	S	RE	IC					
			☆		☆		☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★			
05	P	WCMX 05 03 04R-WM	☆																					3.18	0.40	7.9					
	P	WCMX 05 03 08 R-51			☆																			3.18	0.80	7.9					
	P+C	WCMX 05 03 08 R-53	★		☆	★		★	☆	★		★		★		★		☆	★	☆	★	☆	★	3.18	0.80	7.9					
	P+C	WCMX 05 03 08 T-53	☆																					3.18	0.80	7.9					
	P	WCMX 05 03 08-56			☆				☆															3.18	0.80	7.9					
	P	WCMX 05 03 08-58			☆				☆		☆													3.18	0.80	7.9					
	C	WCMX 05 03 S R-54			☆									☆										3.18	0.40	7.9					
	06	P	WCMX 06 T3 04R-WM	☆																				3.97	0.40	9.5					
		P	WCMX 06 T3 08 R-51			☆																		3.97	0.80	9.5					
		P+C	WCMX 06 T3 08 R-53	★		☆	★		★	☆	★		★		★		★		☆	★	☆	★	☆	3.97	0.80	9.5					
		P+C	WCMX 06 T3 08 T-53	☆																				3.97	0.80	9.5					
		P	WCMX 06 T3 08-56			☆				☆														3.97	0.80	9.5					
P		WCMX 06 T3 08-58			☆				☆		☆												3.97	0.80	9.5						
P+C		WCMX 06 T3 08-GM		☆			☆				☆				☆								3.97	0.80	9.5						
C		WCMX 06 T3 S R-56			☆																		3.97	0.80	9.5						
08	P	WCMX 08 04 12 R-51			☆																		4.76	1.20	12.7						
	P+C	WCMX 08 04 12 R-53	★		☆	★		★	☆	★		★		★		★		☆	★	☆	★	☆	4.76	1.20	12.7						
	P+C	WCMX 08 04 12 T-53	☆																				4.76	1.20	12.7						
	P	WCMX 08 04 12-56			☆				☆														4.76	1.20	12.7						
	P	WCMX 08 04 12-58			☆				☆		☆												4.76	1.20	12.7						
	P+C	WCMX 08 04 12-GM		☆			☆				☆				☆								4.76	1.20	12.7						
	C	WCMX 08 04 S R-56			☆																		4.76	0.40	12.7						



J68



N23



## CoroDrill® 880 large diameter drill

## Insert to cartridge correlation

Diameter range, mm	Central cartridge		Peripheral cartridge	
	Insert	Qty	Insert	Qty
65-69	880-06...C	1	880-06...P	2
	880-06...P	1		
70-73	880-06...C	1	880-06...P	2
	880-06...P	1		
74	880-06...C	1	880-07...P	2
	880-06...P	1		
75-79	880-07...C	1	880-07...P	2
	880-07...P	1		
80-84	880-07...C	1	880-07...P	2
	880-07...P	1		

DC Ordering code		Included parts			
		Drill body		Cartridge	
		3xD	4xD	Central	Peripheral
65	880-D0650xxx-xx				
66	880-D0660xxx-xx	880-D065-069L50-3	880-D065-069L50-4	880-D0650-C	880-D0650-P
67	880-D0670xxx-xx	880-D065-069LX50-3	880-D065-069LX50-4		880-D0670-P
68	880-D0680xxx-xx	880-D065-069V80-3	880-D065-069V80-4		880-D0680-P
69	880-D0690xxx-xx				880-D0690-P
70	880-D0700xxx-xx				880-D0700-P
71	880-D0710xxx-xx	880-D070-074L50-3	880-D070-074L50-4	880-D0700-C	880-D0710-P
72	880-D0720xxx-xx	880-D070-074LX50-3	880-D070-074LX50-4		880-D0720-P
73	880-D0730xxx-xx	880-D070-074V80-3	880-D070-074V80-4		880-D0730-P
74	880-D0740xxx-xx				880-D0740-P
75	880-D0750xxx-xx				880-D0750-P
76	880-D0760xxx-xx	880-D075-079L50-3	880-D075-079L50-4	880-D0750-C	880-D0760-P
77	880-D0770xxx-xx	880-D075-079LX50-3	880-D075-079LX50-4		880-D0770-P
78	880-D0780xxx-xx	880-D075-079V80-3	880-D075-079V80-4		880-D0780-P
79	880-D0790xxx-xx				880-D0790-P
80	880-D0800xxx-xx				880-D0800-P
81	880-D0810xxx-xx				880-D0810-P
82	880-D0820xxx-xx	880-D080-084LX63-3	880-D080-084LX63-4	880-D0800-C	880-D0820-P
83	880-D0830xxx-xx	880-D080-084V80-3	880-D080-084V80-4		880-D0830-P
84	880-D0840xxx-xx				880-D0840-P

## Selecting your cutting data

Chip formation and chip evacuation are critical issues in drilling and depend on the workpiece material, choice of drill/insert geometry, coolant pressure/volume and cutting data. Chip jamming can cause radial movement of the drill and consequently affect hole quality, drill life and reliability or drill/insert breakages.

Chip formation is acceptable when the chips can be evacuated from the drill without disturbance. The best way to identify this is to listen during drilling. A consistent sound means that chip evacuation is good, but an interrupted sound indicates chip jamming. Check the feed force or power monitor. If there are irregularities, chip jamming could be the reason. Look at the chips: if they are long and bent, instead of curled, chip jamming has occurred. Look at the hole: if chip jamming has occurred, an uneven surface will be visible

### Effects of cutting speed – $v_c$

#### Cutting speed that is too high:

Rapid flank wear  
Plastic deformation  
Poor hole quality and bad hole tolerance

#### Cutting speed that is too low:

Built-up edge  
Bad chip evacuation  
Longer time in cut

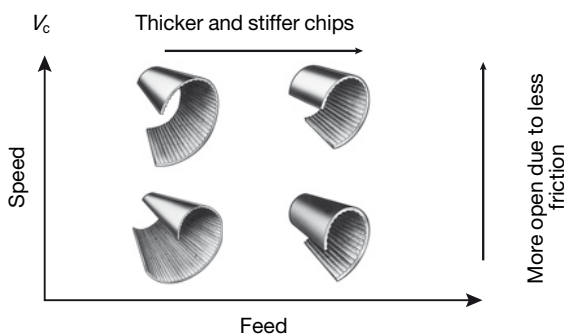
### Effects of feed – $f_n$

#### High feed rate:

Harder chip breaking  
Less time in cut  
Less tool wear but increased risk for drill breakages  
Reduced hole quality

#### Low feed rate:

Preferable for long-chipping materials  
Quality improvement  
Accelerated tool wear  
Longer time in cut



## Achieving good hole quality

### Chip evacuation

Make sure chip evacuation is satisfactory. Chip jamming affects hole quality and reliability/tool life. Drill/insert geometry and cutting data are crucial.

### Stability, tool set-up

Use the shortest possible drill. Use a rigid and accurate tool holder with minimum run-out. Make sure the machine spindle is in good condition and is well-aligned. Ensure that the component is fixed and stable. Establish correct feed rates for irregular, angular surfaces and cross holes.

### Tool life

Check insert wear and establish a predetermined tool life program. The most effective way to supervise drilling is by using a feed force monitor.

### Maintenance

Change the insert-clamping screw regularly. Clean the tip seat before changing the insert, and make sure to use a torque wrench. Don't exceed maximum wear before regrinding solid carbide drills.

### Drilling deep holes with CoroDrill® DS20

If best possible hole quality is needed when drilling 6-7xD holes with CoroDrill DS20, it is important to utilize a reduced feed rate at the entry (first 1-2 mm) and exit (last 5 mm).

# CoroDrill® 870

< 6 x DC

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V <sub>c</sub> ) m/min correlating with drill diameter						
					10.00-20.99 mm			21.00-33.00 mm			
					Min.	Rec.	Max.	Min.	Rec.	Max.	
P			<b>Unalloyed steel</b>		<b>Grade 4334</b>						
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	80	120	160	80	120	160	
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	80	120	160	80	120	160	
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	70	100	130	70	100	130	
	P1.5.C.UT	06.1	Cast - untreated	150	80	110	140	80	110	140	
			<b>Low alloy steel</b>		<b>Grade 4334 and 3334</b>						
	P2.1.Z.AN	02.1	Annealed	175	80	110	140	80	110	140	
	P2.2.Z.AN	02.1	Annealed	240	80	110	140	80	110	140	
	P2.4.Z.AN	02.1	Annealed	225	80	110	140	80	110	140	
	P2.5.Z.HT	02.2	Hardened and tempered	330	70	100	130	50	75	100	
P2.6.C.UT	06.2	Cast - untreated	200	70	100	130	70	100	130		
		<b>High alloy steel</b>									
P3.0.Z.AN	03.11	Annealed	200	60	80	100	60	80	100		
P3.0.Z.HT	03.21	Hardened and tempered	380	40	60	80	40	60	80		
M			<b>Ferritic/martensitic stainless steel</b>		<b>Grade 4334 and 2334</b>						
	P5.0.Z.AN	05.11	Annealed	200	30	40	50	30	40	50	
	P5.0.Z.HT	05.13	Hardened and tempered	330	70	90	110	60	75	90	
			<b>Austenitic stainless steel</b>		<b>Grade 2334 and 4334</b>						
	M1.0.Z.AQ	05.21	Annealed/quenched	200	40	50	60	40	50	60	
	M1.0.C.UT	15.21	Cast-untreated	200	50	60	70	50	60	70	
	M1.1.Z.AQ	05.21	Machinability improved	200	60	75	90	60	75	90	
			<b>Super-austenitic (Ni≥20%) stainless steel</b>								
	M2.0.Z.AQ	05.23	Annealed/quenched	200	20	40	60	20	40	60	
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	20	40	60	20	40	60	
		<b>Duplex (austenitic/ferritic) stainless steel</b>									
M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	40	55	70	40	55	70		
M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	20	40	60	20	40	60		
K			<b>Malleable cast iron</b>		<b>Grade 3334 and 4334</b>						
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	100	145	190	100	145	190	
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	90	125	160	90	125	160	
			<b>Grey cast iron</b>								
	K2.1.C.UT	08.1	Low tensile strength	180	100	150	200	100	150	200	
	K2.2.C.UT	08.2	High tensile strength	245	90	130	170	90	130	170	
		<b>Nodular cast iron</b>									
K3.1.C.UT	09.1	Ferritic	155	100	145	190	100	145	190		
K3.3.C.UT	09.2	Pearlitic	265	90	125	160	90	125	160		
N			<b>Aluminium based alloys</b>		<b>Grade 4334</b>						
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	150	200	250	150	200	250	
N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	150	200	250	150	200	250		
S			<b>Heat resistant super alloys</b>		<b>Grade 2334 and 4334</b>						
	S2.0.Z.AG	20.22	Ni based	350	18	20	30	18	20	30	
S4.3.Z.AN	23.21	Titanium based	330	25	40	60	25	40	60		

## CoroDrill® 870

&lt; 6 x DC

Feed ( $f_n$ ) mm/r correlating with drill diameter																	
10.00-11.99 mm			12.00-13.99 mm			14.00-15.99 mm			16.00-20.99 mm			21.00-25.99 mm			26.00-33.00 mm		
Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.
<b>Geometry -PM and -GP</b>																	
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
0.12	0.18	0.28	0.14	0.20	0.35	0.16	0.25	0.41	0.20	0.32	0.45	0.20	0.34	0.45	0.20	0.34	0.45
<b>Geometry -PM, -KM and -GP</b>																	
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.12	0.18	0.30	0.14	0.20	0.37	0.16	0.25	0.45	0.20	0.32	0.48	0.20	0.36	0.50	0.20	0.40	0.52
0.10	0.16	0.24	0.12	0.19	0.33	0.14	0.22	0.38	0.18	0.25	0.40	0.18	0.30	0.45	0.18	0.30	0.45
0.10	0.16	0.24	0.12	0.19	0.33	0.14	0.22	0.38	0.18	0.25	0.40	0.18	0.30	0.45	0.18	0.30	0.45
<b>Geometry -PM, -MM and -GP</b>																	
0.12	0.14	0.19	0.14	0.16	0.22	0.14	0.18	0.24	0.18	0.24	0.30	0.22	0.28	0.34	0.22	0.28	0.34
0.10	0.12	0.16	0.10	0.12	0.16	0.12	0.14	0.18	0.14	0.18	0.22	0.16	0.22	0.26	0.16	0.22	0.26
<b>Geometry -MM, PM and -GP</b>																	
0.10	0.12	0.14	0.10	0.12	0.14	0.12	0.14	0.16	0.12	0.16	0.2	0.14	0.18	0.22	0.14	0.18	0.22
0.10	0.12	0.14	0.10	0.12	0.14	0.12	0.14	0.16	0.12	0.16	0.2	0.14	0.18	0.22	0.14	0.18	0.22
0.10	0.12	0.16	0.10	0.12	0.16	0.12	0.14	0.18	0.14	0.16	0.22	0.14	0.18	0.24	0.14	0.18	0.24
0.10	0.12	0.14	0.10	0.12	0.16	0.10	0.12	0.16	0.10	0.14	0.16	0.12	0.14	0.18	0.12	0.14	0.18
0.10	0.12	0.14	0.10	0.12	0.16	0.10	0.12	0.16	0.10	0.14	0.16	0.12	0.14	0.18	0.12	0.14	0.18
<b>Geometry -MM and -GP</b>																	
0.10	0.12	0.16	0.10	0.12	0.16	0.12	0.14	0.18	0.14	0.16	0.22	0.14	0.16	0.22	0.14	0.16	0.22
0.10	0.12	0.14	0.10	0.12	0.14	0.12	0.14	0.16	0.12	0.16	0.2	0.12	0.16	0.2	0.12	0.16	0.2
<b>Geometry -KM, PM and -GP</b>																	
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
0.16	0.25	0.36	0.18	0.30	0.42	0.21	0.37	0.48	0.25	0.44	0.55	0.30	0.48	0.60	0.30	0.50	0.60
<b>Geometry -PM and -GP</b>																	
0.20	0.25	0.30	0.22	0.32	0.40	0.26	0.34	0.42	0.30	0.36	0.44	0.32	0.38	0.50	0.32	0.38	0.50
0.20	0.25	0.30	0.22	0.32	0.40	0.26	0.34	0.42	0.30	0.36	0.44	0.32	0.38	0.50	0.32	0.38	0.50
<b>Geometry -MM, -PM and -GP</b>																	
0.08	0.10	0.14	0.08	0.11	0.14	0.10	0.12	0.14	0.11	0.13	0.16	0.12	0.15	0.20	0.12	0.15	0.20
0.09	0.12	0.15	0.10	0.14	0.16	0.12	0.16	0.20	0.14	0.18	0.22	0.16	0.20	0.25	0.18	0.22	0.27

# CoroDrill® 870

≥ 6 x DC

ISO	MC No.	CMC No.	Material	Hardness Brinell (HB)	Cutting speed (V <sub>c</sub> ) m/min correlating with drill diameter						
					10.00-20.99mm			21.00-33.00mm			
					Min.	Rec.	Max.	Min.	Rec.	Max.	
P			<b>Unalloyed steel</b>		<b>Grade 4334</b>						
	P1.1.Z.AN	01.1	C=0.10-0.25%	125	80	120	160	80	120	160	
	P1.2.Z.AN	01.2	C=0.25-0.55%	190	80	120	160	80	120	160	
	P1.3.Z.AN	01.3	C=0.55-0.80%	190	70	100	130	70	100	130	
	P1.5.C.UT	06.1	Cast - untreated	150	80	110	140	80	110	140	
			<b>Low alloy steel</b>		<b>Grade 4334 and 3334</b>						
	P2.1.Z.AN	02.1	Annealed	175	80	110	140	80	110	140	
	P2.2.Z.AN	02.1	Annealed	240	80	110	140	80	110	140	
	P2.4.Z.AN	02.1	Annealed	225	80	110	140	80	110	140	
	P2.5.Z.HT	02.2	Hardened and tempered	330	70	100	130	50	75	100	
P2.6.C.UT	06.2	Cast - untreated	200	70	100	130	70	100	130		
		<b>High alloy steel</b>									
P3.0.Z.AN	03.11	Annealed	200	60	80	100	60	80	100		
P3.0.Z.HT	03.21	Hardened and tempered	380	40	60	80	40	60	80		
M			<b>Ferritic/martensitic stainless steel</b>		<b>Grade 4334 and 2334</b>						
	P5.0.Z.AN	05.11	Annealed	200	30	40	50	30	40	50	
	P5.0.Z.HT	05.13	Hardened and tempered	330	70	90	110	60	75	90	
			<b>Austenitic stainless steel</b>		<b>Grade 2334 and 4334</b>						
	M1.0.Z.AQ	05.21	Annealed/quenched	200	40	50	60	40	50	60	
	M1.0.C.UT	15.21	Cast-untreated	200	50	60	70	50	60	70	
	M1.1.Z.AQ	05.21	Machinability improved	200	60	75	90	60	75	90	
			<b>Super-austenitic (Ni≥20%) stainless steel</b>								
	M2.0.Z.AQ	05.23	Annealed/quenched	200	20	40	60	20	40	60	
	M2.0.C.AQ	15.23	Cast+annealed/quenched	200	20	40	60	20	40	60	
		<b>Duplex (austenitic/ferritic) stainless steel</b>		<b>Grade 2334</b>							
M3.1.Z.AQ	05.51	>60% ferrite (N<0.10%)	230	40	55	70	40	55	70		
M3.2.Z.AQ	05.52	<60% ferrite (N≥0.10%)	260	20	40	60	20	40	60		
K			<b>Malleable cast iron</b>		<b>Grade 3334 and 4334</b>						
	K1.1.C.NS	07.1	Ferritic (short chipping)	130	100	130	170	100	130	170	
	K1.1.C.NS	07.2	Pearlitic (long chipping)	200	90	115	145	90	115	145	
			<b>Grey cast iron</b>								
	K2.1.C.UT	08.1	Low tensile strength	180	100	135	180	100	135	180	
	K2.2.C.UT	08.2	High tensile strength	245	90	120	155	90	120	155	
		<b>Nodular cast iron</b>									
K3.1.C.UT	09.1	Ferritic	155	100	130	170	100	130	170		
K3.3.C.UT	09.2	Pearlitic	265	90	115	145	90	115	145		
N			<b>Aluminium based alloys</b>		<b>Grade 4334</b>						
	N1.2.Z.AG	30.12	AlSi alloys, Si ≤ 1%	100	150	200	250	150	200	250	
N1.3.C.AG	30.22	AlSi cast alloys, Si > 1% and < 13%	80	150	200	250	150	200	250		
S			<b>Heat resistant super alloys</b>		<b>Grade 2334 and 4334</b>						
	S2.0.Z.AG	20.22	Ni based	350	18	20	30	18	20	30	
S4.3.Z.AN	23.21	Titanium based	330	25	40	60	25	40	60		

## CoroDrill® 870

≥ 6 x DC

Feed ( $f_n$ ) mm/r correlating with drill diameter																	
10.00-11.99 mm			12.00-13.99 mm			14.00-15.99 mm			16.00-20.99 mm			21.00-25.99 mm			26.00-33.00 mm		
Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.	Min.	Rec.	Max.
<b>Geometry -PM</b>																	
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
0.12	0.14	0.22	0.14	0.16	0.28	0.16	0.20	0.33	0.20	0.26	0.36	0.20	0.27	0.36	0.20	0.27	0.36
<b>Geometry -PM and -KM</b>																	
0.12	0.14	0.24	0.14	0.16	0.30	0.16	0.20	0.36	0.20	0.26	0.38	0.20	0.29	0.40	0.20	0.32	0.42
0.12	0.14	0.24	0.14	0.16	0.30	0.16	0.20	0.36	0.20	0.26	0.38	0.20	0.29	0.40	0.20	0.32	0.42
0.12	0.14	0.24	0.14	0.16	0.30	0.16	0.20	0.36	0.20	0.26	0.38	0.20	0.29	0.40	0.20	0.32	0.42
0.12	0.13	0.21	0.14	0.15	0.26	0.16	0.18	0.32	0.20	0.22	0.34	0.20	0.25	0.35	0.20	0.28	0.36
0.12	0.14	0.24	0.14	0.16	0.30	0.16	0.20	0.36	0.20	0.26	0.38	0.20	0.29	0.40	0.20	0.32	0.42
0.10	0.13	0.19	0.12	0.15	0.26	0.14	0.18	0.30	0.18	0.20	0.32	0.18	0.24	0.36	0.18	0.24	0.36
0.10	0.11	0.17	0.12	0.13	0.23	0.14	0.15	0.27	0.18	0.19	0.28	0.18	0.21	0.32	0.18	0.21	0.32
<b>Geometry -PM and -MM</b>																	
0.12	0.13	0.15	0.14	0.15	0.18	0.14	0.15	0.19	0.18	0.19	0.24	0.22	0.23	0.27	0.22	0.23	0.27
0.10	0.11	0.12	0.10	0.11	0.12	0.12	0.13	0.14	0.14	0.15	0.16	0.16	0.17	0.18	0.16	0.17	0.18
<b>Geometry -MM and -PM</b>																	
0.10	0.11	0.12	0.10	0.11	0.12	0.12	0.13	0.14	0.12	0.13	0.16	0.14	0.15	0.18	0.14	0.15	0.18
0.10	0.11	0.12	0.10	0.11	0.12	0.12	0.13	0.14	0.12	0.13	0.16	0.14	0.15	0.18	0.14	0.15	0.18
0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.14	0.15	0.18	0.14	0.15	0.19	0.14	0.15	0.19
0.10	0.11	0.12	0.10	0.11	0.13	0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.12	0.13	0.14
0.10	0.11	0.12	0.10	0.11	0.13	0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.12	0.13	0.14
<b>Geometry -MM</b>																	
0.10	0.11	0.13	0.10	0.11	0.13	0.12	0.13	0.14	0.14	0.15	0.18	0.14	0.15	0.18	0.14	0.15	0.18
0.10	0.11	0.12	0.10	0.11	0.13	0.12	0.13	0.14	0.12	0.13	0.16	0.12	0.13	0.16	0.12	0.13	0.16
<b>Geometry -KM and -PM</b>																	
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
0.16	0.20	0.29	0.18	0.24	0.34	0.21	0.30	0.38	0.25	0.35	0.44	0.30	0.38	0.48	0.30	0.40	0.48
<b>Geometry -PM</b>																	
0.20	0.22	0.28	0.22	0.24	0.35	0.26	0.28	0.38	0.30	0.32	0.40	0.32	0.34	0.45	0.32	0.34	0.45
0.20	0.22	0.28	0.22	0.24	0.35	0.26	0.28	0.38	0.30	0.32	0.40	0.32	0.34	0.45	0.32	0.34	0.45
<b>Geometry -MM and -PM</b>																	
0.08	0.10	0.14	0.08	0.11	0.14	0.10	0.12	0.14	0.11	0.13	0.16	0.12	0.15	0.20	0.12	0.15	0.20
0.09	0.11	0.14	0.10	0.12	0.15	0.12	0.14	0.18	0.14	0.16	0.20	0.16	0.18	0.22	0.18	0.20	0.25

# CoroDrill® DS20

4 – 5 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 4xD					Drill length 5xD				
					Min.	Rec.	Max.		-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
								$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev
P	P1.0.ZAN	Unalloyed steel C=0.05-0.10%	110	4324	230	340	400	15.00-18.00	0.04-0.08	<b>0.04-0.08</b>	0.04-0.08	-	0.04-0.1	0.04-0.07	<b>0.04-0.07</b>	0.04-0.07	-	0.04-0.09
				4334	210	285	325	18.01-22.00	0.04-0.09	<b>0.04-0.09</b>	0.04-0.09	-	0.04-0.11	0.04-0.08	<b>0.04-0.08</b>	0.04-0.08	-	0.04-0.1
				4344	190	225	245	22.01-27.00	0.04-0.1	<b>0.04-0.1</b>	0.04-0.1	-	0.04-0.12	0.04-0.09	<b>0.04-0.09</b>	0.04-0.09	-	0.04-0.11
								27.01-33.00	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.13	0.05-0.1	<b>0.05-0.1</b>	0.05-0.1	-	0.05-0.12
								33.01-40.00	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.16	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.14
								40.01-52.00	0.06-0.12	<b>0.06-0.12</b>	0.06-0.12	-	0.06-0.16	0.06-0.11	<b>0.06-0.11</b>	0.06-0.11	-	0.06-0.14
	P1.1.ZAN	Unalloyed steel C=0.05-0.25%	125	4324	230	320	370	15.00-18.00	0.04-0.1	<b>0.04-0.1</b>	0.04-0.1	-	0.04-0.1	0.04-0.09	<b>0.04-0.09</b>	0.04-0.09	-	0.04-0.09
				4334	200	270	305	18.01-22.00	0.04-0.11	<b>0.04-0.11</b>	0.04-0.11	-	0.04-0.11	0.04-0.1	<b>0.04-0.1</b>	0.04-0.1	-	0.04-0.1
				4344	170	210	235	22.01-27.00	0.04-0.12	<b>0.04-0.12</b>	0.04-0.12	-	0.04-0.12	0.04-0.11	<b>0.04-0.11</b>	0.04-0.11	-	0.04-0.11
								27.01-33.00	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.13	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.12
								33.01-40.00	0.05-0.14	<b>0.05-0.14</b>	0.05-0.14	-	0.05-0.16	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.14
								40.01-52.00	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14	-	0.06-0.16	0.06-0.13	<b>0.06-0.13</b>	0.06-0.13	-	0.06-0.14
	P1.2.ZAN	Unalloyed steel C=0.25-0.55%	190	4324	190	265	305	15.00-18.00	-	0.05-0.12	0.06-0.14	<b>0.06-0.16</b>	-	-	0.05-0.1	0.06-0.12	<b>0.06-0.14</b>	-
				4334	155	215	250	18.01-22.00	-	0.05-0.14	0.06-0.16	<b>0.06-0.18</b>	-	-	0.05-0.12	0.06-0.14	<b>0.06-0.15</b>	-
				4344	120	165	190	22.01-27.00	-	0.05-0.18	0.06-0.2	<b>0.06-0.22</b>	-	-	0.05-0.15	0.06-0.17	<b>0.06-0.19</b>	-
								27.01-33.00	-	0.07-0.22	0.08-0.24	<b>0.08-0.26</b>	-	-	0.07-0.19	0.08-0.2	<b>0.08-0.22</b>	-
								33.01-40.00	-	0.07-0.24	0.08-0.26	<b>0.08-0.28</b>	-	-	0.07-0.2	0.08-0.22	<b>0.08-0.24</b>	-
								40.01-52.00	-	0.09-0.24	0.1-0.26	<b>0.1-0.28</b>	-	-	0.09-0.2	0.1-0.22	<b>0.1-0.24</b>	-
	P1.3.ZAN	Unalloyed steel C=0.55-0.80%	190	4324	170	250	290	15.00-18.00	-	0.05-0.12	0.06-0.14	<b>0.06-0.16</b>	-	-	0.05-0.1	0.06-0.12	<b>0.06-0.14</b>	-
				4334	140	205	240	18.01-22.00	-	0.05-0.14	0.06-0.16	<b>0.06-0.18</b>	-	-	0.05-0.12	0.06-0.14	<b>0.06-0.15</b>	-
				4344	105	155	185	22.01-27.00	-	0.05-0.18	0.06-0.2	<b>0.06-0.22</b>	-	-	0.05-0.15	0.06-0.17	<b>0.06-0.19</b>	-
								27.01-33.00	-	0.07-0.22	0.08-0.24	<b>0.08-0.26</b>	-	-	0.07-0.19	0.08-0.2	<b>0.08-0.22</b>	-
								33.01-40.00	-	0.07-0.24	0.08-0.26	<b>0.08-0.28</b>	-	-	0.07-0.2	0.08-0.22	<b>0.08-0.24</b>	-
								40.01-52.00	-	0.09-0.24	0.1-0.26	<b>0.1-0.28</b>	-	-	0.09-0.2	0.1-0.22	<b>0.1-0.24</b>	-
P1.5.CUT	Unalloyed steel Cast - untreated	150	4324	140	260	325	15.00-18.00	-	0.04-0.12	0.04-0.12	<b>0.04-0.12</b>	-	-	0.04-0.1	0.04-0.1	<b>0.04-0.1</b>	-	
			4334	135	220	265	18.01-22.00	-	0.04-0.13	0.04-0.13	<b>0.04-0.13</b>	-	-	0.04-0.11	0.04-0.11	<b>0.04-0.11</b>	-	
			4344	125	175	200	22.01-27.00	-	0.04-0.14	0.04-0.14	<b>0.04-0.14</b>	-	-	0.04-0.12	0.04-0.12	<b>0.04-0.12</b>	-	
							27.01-33.00	-	0.05-0.15	0.05-0.15	<b>0.05-0.15</b>	-	-	0.05-0.13	0.05-0.13	<b>0.05-0.13</b>	-	
							33.01-40.00	-	0.05-0.16	0.05-0.16	<b>0.05-0.16</b>	-	-	0.05-0.14	0.05-0.14	<b>0.05-0.14</b>	-	
							40.01-52.00	-	0.06-0.16	0.06-0.16	<b>0.06-0.16</b>	-	-	0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	-	
P2.1.ZAN	Low alloy steel Annealed	175	4324	180	260	305	15.00-18.00	-	-	0.06-0.14	<b>0.06-0.16</b>	-	-	-	0.06-0.12	<b>0.06-0.14</b>	-	
			4334	150	215	250	18.01-22.00	-	-	0.06-0.16	<b>0.06-0.18</b>	-	-	-	0.06-0.14	<b>0.06-0.15</b>	-	
			4344	115	165	190	22.01-27.00	-	-	0.06-0.2	<b>0.06-0.22</b>	-	-	-	0.06-0.17	<b>0.06-0.19</b>	-	
							27.01-33.00	-	-	0.08-0.24	<b>0.08-0.26</b>	-	-	-	0.08-0.2	<b>0.08-0.22</b>	-	
							33.01-40.00	-	-	0.08-0.26	<b>0.08-0.28</b>	-	-	-	0.08-0.22	<b>0.08-0.24</b>	-	
							40.01-52.00	-	-	0.1-0.26	<b>0.1-0.28</b>	-	-	-	0.1-0.22	<b>0.1-0.24</b>	-	
P2.2.ZAN	Low alloy steel Annealed	240	4324	180	250	290	15.00-18.00	-	-	0.06-0.14	<b>0.06-0.16</b>	-	-	-	0.06-0.12	<b>0.06-0.14</b>	-	
			4334	150	200	225	18.01-22.00	-	-	0.06-0.16	<b>0.06-0.18</b>	-	-	-	0.06-0.14	<b>0.06-0.15</b>	-	
			4344	115	175	205	22.01-27.00	-	-	0.06-0.2	<b>0.06-0.22</b>	-	-	-	0.06-0.17	<b>0.06-0.19</b>	-	
							27.01-33.00	-	-	0.08-0.24	<b>0.08-0.26</b>	-	-	-	0.08-0.2	<b>0.08-0.22</b>	-	
							33.01-40.00	-	-	0.08-0.26	<b>0.08-0.28</b>	-	-	-	0.08-0.22	<b>0.08-0.24</b>	-	
							40.01-52.00	-	-	0.1-0.26	<b>0.1-0.28</b>	-	-	-	0.1-0.22	<b>0.1-0.24</b>	-	
P2.5.ZHT	Low alloy steel Hardened and tempered	330	4324	90	190	245	15.00-18.00	-	-	0.06-0.14	<b>0.06-0.16</b>	-	-	-	0.06-0.12	<b>0.06-0.14</b>	-	
			4334	85	155	195	18.01-22.00	-	-	0.06-0.16	<b>0.06-0.18</b>	-	-	-	0.06-0.14	<b>0.06-0.15</b>	-	
			4344	75	125	150	22.01-27.00	-	-	0.06-0.2	<b>0.06-0.22</b>	-	-	-	0.06-0.17	<b>0.06-0.19</b>	-	
							27.01-33.00	-	-	0.08-0.24	<b>0.08-0.26</b>	-	-	-	0.08-0.2	<b>0.08-0.22</b>	-	
							33.01-40.00	-	-	0.08-0.26	<b>0.08-0.28</b>	-	-	-	0.08-0.22	<b>0.08-0.24</b>	-	
							40.01-52.00	-	-	0.1-0.26	<b>0.1-0.28</b>	-	-	-	0.1-0.22	<b>0.1-0.24</b>	-	
P2.6.CUT	Low alloy steel Cast - untreated	200	4324	110	210	265	15.00-18.00	-	-	0.06-0.16	<b>0.06-0.18</b>	-	-	-	0.06-0.14	<b>0.06-0.15</b>	-	
			4334	105	175	210	18.01-22.00	-	-	0.06-0.18	<b>0.06-0.2</b>	-	-	-	0.06-0.15	<b>0.06-0.17</b>	-	
			4344	100	140	160	22.01-27.00	-	-	0.06-0.22	<b>0.06-0.24</b>	-	-	-	0.06-0.19	<b>0.06-0.2</b>	-	
							27.01-33.00	-	-	0.08-0.26	<b>0.08-0.28</b>	-	-	-	0.08-0.22	<b>0.08-0.24</b>	-	
							33.01-40.00	-	-	0.08-0.28	<b>0.08-0.3</b>	-	-	-	0.08-0.24	<b>0.08-0.26</b>	-	
							40.01-52.00	-	-	0.1-0.28	<b>0.1-0.3</b>	-	-	-	0.1-0.24	<b>0.1-0.26</b>	-	
P3.0.ZAN	High alloy steel Annealed	200	4324	160	245	290	15.00-18.00	-	-	0.06-0.14	<b>0.06-0.16</b>	-	-	-	0.06-0.12	<b>0.06-0.14</b>	-	
			4334	130	200	240	18.01-22.00	-	-	0.06-0.16	<b>0.06-0.18</b>	-	-	-	0.06-0.14	<b>0.06-0.15</b>	-	
			4344	100	150	180	22.01-27.00	-	-	0.06-0.2	<b>0.06-0.22</b>	-	-	-	0.06-0.17	<b>0.06-0.19</b>	-	
							27.01-33.00	-	-	0.08-0.24	<b>0.08-0.26</b>	-	-	-	0.08-0.2	<b>0.08-0.22</b>	-	
							33.01-40.00	-	-	0.08-0.26	<b>0.08-0.28</b>	-	-	-	0.08-0.22	<b>0.08-0.24</b>	-	
							40.01-52.00	-	-	0.1-0.26	<b>0.1-0.28</b>	-	-	-	0.1-0.22	<b>0.1-0.24</b>	-	



## CoroDrill® DS20

4 – 5 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 4xD					Drill length 5xD				
					4-5xD	-S5W	-L5W		-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W		
P	P3.0.Z.HT	High alloy steel Hardened and tempered	380	4324	80	165	210	15.00-18.00	-	-	0.06-0.14	<b>0.06-0.16</b>	-	-	-	0.06-0.12	<b>0.06-0.14</b>	-
				4334	75	140	175	18.01-22.00	-	-	0.06-0.16	<b>0.06-0.18</b>	-	-	-	0.06-0.14	<b>0.06-0.15</b>	-
				4344	70	110	130	22.01-27.00	-	-	0.06-0.2	<b>0.06-0.22</b>	-	-	-	0.06-0.17	<b>0.06-0.19</b>	-
								27.01-33.00	-	-	0.08-0.24	<b>0.08-0.26</b>	-	-	-	0.08-0.2	<b>0.08-0.22</b>	-
								33.01-40.00	-	-	0.08-0.26	<b>0.08-0.28</b>	-	-	-	0.08-0.22	<b>0.08-0.24</b>	-
								40.01-52.00	-	-	0.1-0.26	<b>0.1-0.28</b>	-	-	-	0.1-0.22	<b>0.1-0.24</b>	-
					52.01-65.00	-	-	0.1-0.26	<b>0.1-0.28</b>	-	-	-	0.1-0.22	<b>0.1-0.24</b>	-			
	P5.0.Z.AN	Ferritic/martensitic stainless steel Annealed	200	4334	115	185	225	15.00-18.00	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.1
				4344	115	155	175	18.01-22.00	0.05-0.14	<b>0.05-0.14</b>	0.05-0.14	-	0.05-0.13	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11
				2044	115	150	165	22.01-27.00	0.05-0.15	<b>0.05-0.15</b>	0.05-0.15	-	0.05-0.14	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.16	<b>0.07-0.16</b>	0.07-0.16	-	0.07-0.15	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.18	<b>0.07-0.18</b>	0.07-0.18	-	0.07-0.16	0.07-0.15	<b>0.07-0.15</b>	0.07-0.15	-	0.07-0.14
							40.01-52.00	0.09-0.18	<b>0.09-0.18</b>	0.09-0.18	-	0.09-0.16	0.09-0.15	<b>0.09-0.15</b>	0.09-0.15	-	0.09-0.14	
				52.01-65.00	0.09-0.18	<b>0.09-0.18</b>	0.09-0.18	-	0.09-0.16	0.09-0.15	<b>0.09-0.15</b>	0.09-0.15	-	0.09-0.14				
P5.0.Z.HT	Ferritic/martensitic stainless steel Hardened and tempered	330	4334	75	135	170	15.00-18.00	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.1	
			4344	70	115	140	18.01-22.00	0.05-0.14	<b>0.05-0.14</b>	0.05-0.14	-	0.05-0.13	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11	
			2044	70	115	140	22.01-27.00	0.05-0.15	<b>0.05-0.15</b>	0.05-0.15	-	0.05-0.14	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	
							27.01-33.00	0.07-0.16	<b>0.07-0.16</b>	0.07-0.16	-	0.07-0.15	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.13	
							33.01-40.00	0.07-0.18	<b>0.07-0.18</b>	0.07-0.18	-	0.07-0.16	0.07-0.15	<b>0.07-0.15</b>	0.07-0.15	-	0.07-0.14	
							40.01-52.00	0.09-0.18	<b>0.09-0.18</b>	0.09-0.18	-	0.09-0.16	0.09-0.15	<b>0.09-0.15</b>	0.09-0.15	-	0.09-0.14	
				52.01-65.00	0.09-0.18	<b>0.09-0.18</b>	0.09-0.18	-	0.09-0.16	0.09-0.15	<b>0.09-0.15</b>	0.09-0.15	-	0.09-0.14				
M	M1.0.Z.AQ	Austenitic Stainless steel Annealed/quenched	200	4334	115	185	225	15.00-18.00	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.1
				4344	115	165	190	18.01-22.00	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11
				2044	115	155	180	22.01-27.00	0.05-0.14	<b>0.05-0.14</b>	0.05-0.14	-	0.05-0.13	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	<b>0.07-0.15</b>	0.07-0.15	-	0.07-0.14	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	<b>0.07-0.16</b>	0.07-0.16	-	0.07-0.15	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14
					52.01-65.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14			
	M1.1.Z.AQ	Austenitic Stainless steel Machinability improved	200	4334	115	195	240	15.00-18.00	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.1
				4344	115	175	210	18.01-22.00	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11
				2044	115	170	200	22.01-27.00	0.05-0.14	<b>0.05-0.14</b>	0.05-0.14	-	0.05-0.13	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	<b>0.07-0.15</b>	0.07-0.15	-	0.07-0.14	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	<b>0.07-0.16</b>	0.07-0.16	-	0.07-0.15	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.14
							40.01-52.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14	
				52.01-65.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14				
M2.0.Z.AQ	Super Austenitic (N>20%) Stainless steel Annealed/quenched	200	4334	80	125	150	15.00-18.00	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.1	
			4344	80	110	125	18.01-22.00	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11	
			2044	80	110	125	22.01-27.00	0.05-0.14	<b>0.05-0.14</b>	0.05-0.14	-	0.05-0.13	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	
							27.01-33.00	0.07-0.15	<b>0.07-0.15</b>	0.07-0.15	-	0.07-0.14	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.13	
							33.01-40.00	0.07-0.16	<b>0.07-0.16</b>	0.07-0.16	-	0.07-0.15	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.14	
							40.01-52.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14	
				52.01-65.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14				
M3.1.Z.AQ	Duplex stainless steel >60% ferrite (N<0.10%)	230	4334	85	125	145	15.00-18.00	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.1	
			4344	85	115	130	18.01-22.00	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11	
			2044	85	110	125	22.01-27.00	0.05-0.14	<b>0.05-0.14</b>	0.05-0.14	-	0.05-0.13	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	
							27.01-33.00	0.07-0.15	<b>0.07-0.15</b>	0.07-0.15	-	0.07-0.14	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.13	
							33.01-40.00	0.07-0.16	<b>0.07-0.16</b>	0.07-0.16	-	0.07-0.15	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.14	
							40.01-52.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14	
				52.01-65.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14				
M3.2.Z.AQ	Duplex stainless steel <60% ferrite (N>0.10%)	260	4334	75	105	120	15.00-18.00	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.1	
			4344	75	100	115	18.01-22.00	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	0.05-0.11	
			2044	75	100	115	22.01-27.00	0.05-0.14	<b>0.05-0.14</b>	0.05-0.14	-	0.05-0.13	0.05-0.13	<b>0.05-0.13</b>	0.05-0.13	-	0.05-0.12	
							27.01-33.00	0.07-0.15	<b>0.07-0.15</b>	0.07-0.15	-	0.07-0.14	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.13	
							33.01-40.00	0.07-0.16	<b>0.07-0.16</b>	0.07-0.16	-	0.07-0.15	0.07-0.14	<b>0.07-0.14</b>	0.07-0.14	-	0.07-0.14	
							40.01-52.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14	
				52.01-65.00	0.09-0.16	<b>0.09-0.16</b>	0.09-0.16	-	0.09-0.15	0.09-0.14	<b>0.09-0.14</b>	0.09-0.14	-	0.09-0.14				
S	S2.0.Z.AN S2.0.Z.AG S2.0.Z.NS	Heat resistant super alloys Ni based	350	4334	20	40	50	15.00-18.00	0.04-0.08	<b>0.04-0.08</b>	0.04-0.08	-	-	0.04-0.07	<b>0.04-0.07</b>	0.04-0.07	-	
				4344	20	40	50	18.01-22.00	0.04-0.09	<b>0.04-0.09</b>	0.04-0.09	-	-	0.04-0.08	<b>0.04-0.08</b>	0.04-0.08	-	
				2044	20	40	50	22.01-27.00	0.04-0.1	<b>0.04-0.1</b>	0.04-0.1	-	-	0.04-0.09	<b>0.04-0.09</b>	0.04-0.09	-	
								27.01-33.00	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	-	0.05-0.1	<b>0.05-0.1</b>	0.05-0.1	-	
								33.01-40.00	0.05-0.12	<b>0.05-0.12</b>	0.05-0.12	-	-	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	
								40.01-52.00	0.06-0.12	<b>0.06-0.12</b>	0.06-0.12	-	-	0.06-0.11	<b>0.06-0.11</b>	0.06-0.11	-	
					52.01-65.00													

# CoroDrill® DS20

4 – 5 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 4xD					Drill length 5xD				
					-S5W	-L5W	-L6W		-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W			
K	K1.1.C.NS	Malleable cast iron Low tensile strength	200	4324	140	210	245	15.00-18.00	-	0.08-0.15	0.08-0.15	<b>0.08-0.2</b>	-	-	0.08-0.13	0.08-0.13	<b>0.08-0.17</b>	-
				4334	110	170	200	18.01-22.00	-	0.08-0.18	0.08-0.18	<b>0.08-0.23</b>	-	-	0.08-0.15	0.08-0.15	<b>0.08-0.2</b>	-
				4344	180	165	155	22.01-27.00	-	0.08-0.21	0.08-0.21	<b>0.08-0.26</b>	-	-	0.08-0.18	0.08-0.18	<b>0.08-0.22</b>	-
								27.01-33.00	-	0.1-0.24	0.1-0.24	<b>0.1-0.29</b>	-	-	0.1-0.2	0.1-0.2	<b>0.1-0.25</b>	-
								33.01-40.00	-	0.1-0.27	0.1-0.27	<b>0.1-0.32</b>	-	-	0.1-0.23	0.1-0.23	<b>0.1-0.27</b>	-
								40.01-52.00	-	0.12-0.27	0.12-0.27	<b>0.12-0.32</b>	-	-	0.12-0.23	0.12-0.23	<b>0.12-0.27</b>	-
					52.01-65.00	-	0.12-0.27	0.12-0.27	<b>0.12-0.32</b>	-	-	0.12-0.23	0.12-0.23	<b>0.12-0.27</b>	-			
	K2.1.C.UT	Grey cast iron Low tensile strength	180	4324	210	285	325	15.00-18.00	-	0.08-0.15	0.08-0.15	<b>0.08-0.2</b>	-	-	0.08-0.13	0.08-0.13	<b>0.08-0.17</b>	-
				4334	170	235	270	18.01-22.00	-	0.08-0.18	0.08-0.18	<b>0.08-0.23</b>	-	-	0.08-0.15	0.08-0.15	<b>0.08-0.2</b>	-
				4344	130	180	205	22.01-27.00	-	0.08-0.21	0.08-0.21	<b>0.08-0.26</b>	-	-	0.08-0.18	0.08-0.18	<b>0.08-0.22</b>	-
								27.01-33.00	-	0.1-0.24	0.1-0.24	<b>0.1-0.29</b>	-	-	0.1-0.2	0.1-0.2	<b>0.1-0.25</b>	-
								33.01-40.00	-	0.1-0.27	0.1-0.27	<b>0.1-0.32</b>	-	-	0.1-0.23	0.1-0.23	<b>0.1-0.27</b>	-
								40.01-52.00	-	0.12-0.27	0.12-0.27	<b>0.12-0.32</b>	-	-	0.12-0.23	0.12-0.23	<b>0.12-0.27</b>	-
					52.01-65.00	-	0.12-0.27	0.12-0.27	<b>0.12-0.32</b>	-	-	0.12-0.23	0.12-0.23	<b>0.12-0.27</b>	-			
	K2.2.C.UT	Grey cast iron High tensile strength	245	4324	125	205	245	15.00-18.00	-	0.08-0.13	0.08-0.13	<b>0.08-0.18</b>	-	-	0.08-0.11	0.08-0.11	<b>0.08-0.15</b>	-
				4334	100	160	195	18.01-22.00	-	0.08-0.16	0.08-0.16	<b>0.08-0.21</b>	-	-	0.08-0.14	0.08-0.14	<b>0.08-0.18</b>	-
				4344	75	125	150	22.01-27.00	-	0.08-0.19	0.08-0.19	<b>0.08-0.24</b>	-	-	0.08-0.16	0.08-0.16	<b>0.08-0.2</b>	-
								27.01-33.00	-	0.1-0.22	0.1-0.22	<b>0.1-0.27</b>	-	-	0.1-0.19	0.1-0.19	<b>0.1-0.23</b>	-
								33.01-40.00	-	0.1-0.25	0.1-0.25	<b>0.1-0.3</b>	-	-	0.1-0.21	0.1-0.21	<b>0.1-0.26</b>	-
								40.01-52.00	-	0.12-0.25	0.12-0.25	<b>0.12-0.3</b>	-	-	0.12-0.21	0.12-0.21	<b>0.12-0.26</b>	-
					52.01-65.00	-	0.12-0.25	0.12-0.25	<b>0.12-0.3</b>	-	-	0.12-0.21	0.12-0.21	<b>0.12-0.26</b>	-			
	K3.1.C.UT	Nodular cast iron Ferritic	155	4324	125	190	225	15.00-18.00	-	0.08-0.13	0.08-0.13	<b>0.08-0.18</b>	-	-	0.08-0.11	0.08-0.11	<b>0.08-0.15</b>	-
				4334	100	155	185	18.01-22.00	-	0.08-0.16	0.08-0.16	<b>0.08-0.21</b>	-	-	0.08-0.14	0.08-0.14	<b>0.08-0.18</b>	-
				4344	80	120	145	22.01-27.00	-	0.08-0.19	0.08-0.19	<b>0.08-0.24</b>	-	-	0.08-0.16	0.08-0.16	<b>0.08-0.2</b>	-
							27.01-33.00	-	0.1-0.22	0.1-0.22	<b>0.1-0.27</b>	-	-	0.1-0.19	0.1-0.19	<b>0.1-0.23</b>	-	
							33.01-40.00	-	0.1-0.25	0.1-0.25	<b>0.1-0.3</b>	-	-	0.1-0.21	0.1-0.21	<b>0.1-0.26</b>	-	
							40.01-52.00	-	0.12-0.25	0.12-0.25	<b>0.12-0.3</b>	-	-	0.12-0.21	0.12-0.21	<b>0.12-0.26</b>	-	
				52.01-65.00	-	0.12-0.25	0.12-0.25	<b>0.12-0.3</b>	-	-	0.12-0.21	0.12-0.21	<b>0.12-0.26</b>	-				
K3.3.C.UT	Nodular cast iron Pearlitic	265	4324	110	175	210	15.00-18.00	-	0.08-0.13	0.08-0.13	<b>0.08-0.18</b>	-	-	0.08-0.11	0.08-0.11	<b>0.08-0.15</b>	-	
			4334	90	145	175	18.01-22.00	-	0.08-0.16	0.08-0.16	<b>0.08-0.21</b>	-	-	0.08-0.14	0.08-0.14	<b>0.08-0.18</b>	-	
			4344	70	110	130	22.01-27.00	-	0.08-0.19	0.08-0.19	<b>0.08-0.24</b>	-	-	0.08-0.16	0.08-0.16	<b>0.08-0.2</b>	-	
							27.01-33.00	-	0.1-0.22	0.1-0.22	<b>0.1-0.27</b>	-	-	0.1-0.19	0.1-0.19	<b>0.1-0.23</b>	-	
							33.01-40.00	-	0.1-0.25	0.1-0.25	<b>0.1-0.3</b>	-	-	0.1-0.21	0.1-0.21	<b>0.1-0.26</b>	-	
							40.01-52.00	-	0.12-0.25	0.12-0.25	<b>0.12-0.3</b>	-	-	0.12-0.21	0.12-0.21	<b>0.12-0.26</b>	-	
				52.01-65.00	-	0.12-0.25	0.12-0.25	<b>0.12-0.3</b>	-	-	0.12-0.21	0.12-0.21	<b>0.12-0.26</b>	-				
K4.2.C.UT	Compacted graphite iron High tensile strength (Pearlite>90%)	230	4324	130	210	250	15.00-18.00	-	0.08-0.13	0.08-0.13	<b>0.08-0.18</b>	-	-	0.08-0.11	0.08-0.11	<b>0.08-0.15</b>	-	
			4334	110	170	200	18.01-22.00	-	0.08-0.16	0.08-0.16	<b>0.08-0.21</b>	-	-	0.08-0.14	0.08-0.14	<b>0.08-0.18</b>	-	
			4344	85	125	150	22.01-27.00	-	0.08-0.19	0.08-0.19	<b>0.08-0.24</b>	-	-	0.08-0.16	0.08-0.16	<b>0.08-0.2</b>	-	
							27.01-33.00	-	0.1-0.22	0.1-0.22	<b>0.1-0.27</b>	-	-	0.1-0.19	0.1-0.19	<b>0.1-0.23</b>	-	
							33.01-40.00	-	0.1-0.25	0.1-0.25	<b>0.1-0.3</b>	-	-	0.1-0.21	0.1-0.21	<b>0.1-0.26</b>	-	
							40.01-52.00	-	0.12-0.25	0.12-0.25	<b>0.12-0.3</b>	-	-	0.12-0.21	0.12-0.21	<b>0.12-0.26</b>	-	
				52.01-65.00	-	0.12-0.25	0.12-0.25	<b>0.12-0.3</b>	-	-	0.12-0.21	0.12-0.21	<b>0.12-0.26</b>	-				
H	H1.3.Z.HA	Extra hard steels Hardened & tempered	60 (HRC)	4324	30	65	85	15.00-18.00	-	0.06-0.13	<b>0.06-0.13</b>	0.06-0.13	-	-	0.06-0.11	<b>0.06-0.11</b>	0.06-0.11	-
			4334	30	65	85	18.01-22.00	-	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14	-	-	0.06-0.12	<b>0.06-0.12</b>	0.06-0.12	-	
			4344	30	65	85	22.01-27.00	-	0.06-0.15	<b>0.06-0.15</b>	0.06-0.15	-	-	0.06-0.13	<b>0.06-0.13</b>	0.06-0.13	-	
							27.01-33.00	-	0.08-0.16	<b>0.08-0.16</b>	0.08-0.16	-	-	0.08-0.14	<b>0.08-0.14</b>	0.08-0.14	-	
							33.01-40.00	-	0.08-0.18	<b>0.08-0.18</b>	0.08-0.18	-	-	0.08-0.15	<b>0.08-0.15</b>	0.08-0.15	-	
							40.01-52.00	-	0.1-0.18	<b>0.1-0.18</b>	0.1-0.18	-	-	0.1-0.15	<b>0.1-0.15</b>	0.1-0.15	-	
				52.01-65.00	-	0.1-0.18	<b>0.1-0.18</b>	0.1-0.18	-	-	0.1-0.15	<b>0.1-0.15</b>	0.1-0.15	-				

## CoroDrill® DS20

4 – 5 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 4xD					Drill length 5xD				
									-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
N	N1.2.Z.AG	Aluminum based alloys	100	H13A	300	365	400	15.00-18.00	Recommended start value at middle of feed range									
									4-5xD									
		AlSi alloys (Si<1%)	4344	300	365	400	18.01-22.00	<b>0.06-0.16</b>	0.06-0.16	0.06-0.16	-	-	<b>0.06-0.14</b>	0.06-0.14	0.06-0.14	-	-	
				18.01-22.00	<b>0.06-0.18</b>	0.06-0.18	0.06-0.18	-	-	<b>0.06-0.15</b>	0.06-0.15	0.06-0.15	-	-				
			22.01-27.00	<b>0.06-0.2</b>	0.06-0.2	0.06-0.2	-	-	<b>0.06-0.17</b>	0.06-0.17	0.06-0.17	-	-					
			27.01-33.00	<b>0.08-0.22</b>	0.08-0.22	0.08-0.22	-	-	<b>0.08-0.19</b>	0.08-0.19	0.08-0.19	-	-					
	33.01-40.00	<b>0.08-0.25</b>	0.08-0.25	0.08-0.25	-	-	<b>0.08-0.21</b>	0.08-0.21	0.08-0.21	-	-							
	40.01-52.00	<b>0.1-0.25</b>	0.1-0.25	0.1-0.25	-	-	<b>0.1-0.21</b>	0.1-0.21	0.1-0.21	-	-							
	52.01-65.00	<b>0.1-0.25</b>	0.1-0.25	0.1-0.25	-	-	<b>0.1-0.21</b>	0.1-0.21	0.1-0.21	-	-							
	N1.3.C.UT	Aluminum based alloys	75	H13A	250	350	400	15.00-18.00	Recommended start value at middle of feed range									
									4-5xD									
		AlSi cast alloys (1%<Si<13%)	4344	250	350	400	18.01-22.00	<b>0.06-0.14</b>	0.06-0.14	0.06-0.14	-	-	<b>0.06-0.12</b>	0.06-0.12	0.06-0.12	-	-	
				18.01-22.00	<b>0.06-0.16</b>	0.06-0.16	0.06-0.16	-	-	<b>0.06-0.14</b>	0.06-0.14	0.06-0.14	-	-				
			22.01-27.00	<b>0.06-0.18</b>	0.06-0.18	0.06-0.18	-	-	<b>0.06-0.15</b>	0.06-0.15	0.06-0.15	-	-					
			27.01-33.00	<b>0.08-0.2</b>	0.08-0.2	0.08-0.2	-	-	<b>0.08-0.17</b>	0.08-0.17	0.08-0.17	-	-					
	33.01-40.00	<b>0.08-0.22</b>	0.08-0.22	0.08-0.22	-	-	<b>0.08-0.19</b>	0.08-0.19	0.08-0.19	-	-							
	40.01-52.00	<b>0.1-0.22</b>	0.1-0.22	0.1-0.22	-	-	<b>0.1-0.19</b>	0.1-0.19	0.1-0.19	-	-							
	52.01-65.00	<b>0.1-0.22</b>	0.1-0.22	0.1-0.22	-	-	<b>0.1-0.19</b>	0.1-0.19	0.1-0.19	-	-							
	N1.3.C.AG	Aluminum based alloys	90	H13A	250	315	350	15.00-18.00	Recommended start value at middle of feed range									
									4-5xD									
		AlSi cast and aged alloys (1%<Si<13%)	4344	250	315	350	18.01-22.00	<b>0.06-0.14</b>	0.06-0.14	0.06-0.14	-	-	<b>0.06-0.12</b>	0.06-0.12	0.06-0.12	-	-	
				18.01-22.00	<b>0.06-0.16</b>	0.06-0.16	0.06-0.16	-	-	<b>0.06-0.14</b>	0.06-0.14	0.06-0.14	-	-				
			22.01-27.00	<b>0.06-0.18</b>	0.06-0.18	0.06-0.18	-	-	<b>0.06-0.15</b>	0.06-0.15	0.06-0.15	-	-					
			27.01-33.00	<b>0.08-0.2</b>	0.08-0.2	0.08-0.2	-	-	<b>0.08-0.17</b>	0.08-0.17	0.08-0.17	-	-					
33.01-40.00	<b>0.08-0.22</b>	0.08-0.22	0.08-0.22	-	-	<b>0.08-0.19</b>	0.08-0.19	0.08-0.19	-	-								
40.01-52.00	<b>0.1-0.22</b>	0.1-0.22	0.1-0.22	-	-	<b>0.1-0.19</b>	0.1-0.19	0.1-0.19	-	-								
52.01-65.00	<b>0.1-0.22</b>	0.1-0.22	0.1-0.22	-	-	<b>0.1-0.19</b>	0.1-0.19	0.1-0.19	-	-								
N3.3.U.UT	Copper based alloys	110	H13A	250	350	400	15.00-18.00	Recommended start value at middle of feed range										
								4-5xD										
	Free cutting copper based alloys	4344	250	350	400	18.01-22.00	<b>0.06-0.16</b>	0.06-0.16	0.06-0.16	-	-	<b>0.06-0.14</b>	0.06-0.14	0.06-0.14	-	-		
			18.01-22.00	<b>0.06-0.18</b>	0.06-0.18	0.06-0.18	-	-	<b>0.06-0.15</b>	0.06-0.15	0.06-0.15	-	-					
		22.01-27.00	<b>0.06-0.2</b>	0.06-0.2	0.06-0.2	-	-	<b>0.06-0.17</b>	0.06-0.17	0.06-0.17	-	-						
		27.01-33.00	<b>0.08-0.22</b>	0.08-0.22	0.08-0.22	-	-	<b>0.08-0.19</b>	0.08-0.19	0.08-0.19	-	-						
33.01-40.00	<b>0.08-0.25</b>	0.08-0.25	0.08-0.25	-	-	<b>0.08-0.21</b>	0.08-0.21	0.08-0.21	-	-								
40.01-52.00	<b>0.1-0.25</b>	0.1-0.25	0.1-0.25	-	-	<b>0.1-0.21</b>	0.1-0.21	0.1-0.21	-	-								
52.01-65.00	<b>0.1-0.25</b>	0.1-0.25	0.1-0.25	-	-	<b>0.1-0.21</b>	0.1-0.21	0.1-0.21	-	-								
N3.2.C.UT	Copper based alloys	90	H13A	180	220	240	15.00-18.00	Recommended start value at middle of feed range										
								4-5xD										
	Leaded brass and bronzes (Pb<1%)	4344	180	220	240	18.01-22.00	<b>0.06-0.16</b>	0.06-0.16	0.06-0.16	-	-	<b>0.06-0.14</b>	0.06-0.14	0.06-0.14	-	-		
			18.01-22.00	<b>0.06-0.18</b>	0.06-0.18	0.06-0.18	-	-	<b>0.06-0.15</b>	0.06-0.15	0.06-0.15	-	-					
		22.01-27.00	<b>0.06-0.2</b>	0.06-0.2	0.06-0.2	-	-	<b>0.06-0.17</b>	0.06-0.17	0.06-0.17	-	-						
		27.01-33.00	<b>0.08-0.22</b>	0.08-0.22	0.08-0.22	-	-	<b>0.08-0.19</b>	0.08-0.19	0.08-0.19	-	-						
33.01-40.00	<b>0.08-0.25</b>	0.08-0.25	0.08-0.25	-	-	<b>0.08-0.21</b>	0.08-0.21	0.08-0.21	-	-								
40.01-52.00	<b>0.1-0.25</b>	0.1-0.25	0.1-0.25	-	-	<b>0.1-0.21</b>	0.1-0.21	0.1-0.21	-	-								
52.01-65.00	<b>0.1-0.25</b>	0.1-0.25	0.1-0.25	-	-	<b>0.1-0.21</b>	0.1-0.21	0.1-0.21	-	-								

# CoroDrill® DS20

6 – 7 × DC

ENG

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 6xD					Drill length 7xD					
					Min.	Rec.	Max.		-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W	
																			Recommended start value at middle of feed range
								$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	$f_s$ mm/rev	
P	P1.0.ZAN	Unalloyed steel C=0.05-0.10%	110	4324	230	305	360	15.00-18.00	0.04-0.06	<b>0.04-0.06</b>	0.04-0.06	-	0.04-0.08	0.04-0.05	<b>0.04-0.05</b>	0.04-0.05	-	0.04-0.07	
				4334	210	255	295	18.01-22.00	0.04-0.07	<b>0.04-0.07</b>	0.04-0.07	-	0.04-0.09	0.04-0.06	<b>0.04-0.06</b>	0.04-0.06	-	0.04-0.07	
				4344	190	205	220	22.01-27.00	0.04-0.08	<b>0.04-0.08</b>	0.04-0.08	-	0.04-0.1	0.04-0.07	<b>0.04-0.07</b>	0.04-0.07	-	0.04-0.08	
								27.01-33.00	0.05-0.09	<b>0.05-0.09</b>	0.05-0.09	-	0.05-0.1	0.05-0.07	<b>0.05-0.07</b>	0.05-0.07	-	0.05-0.08	
								33.01-40.00	0.05-0.1	<b>0.05-0.1</b>	0.05-0.1	-	0.05-0.13	0.05-0.08	<b>0.05-0.08</b>	0.05-0.08	-	0.05-0.1	
								40.01-52.00	0.06-0.1	<b>0.06-0.1</b>	0.06-0.1	-	0.06-0.13	0.06-0.08	<b>0.06-0.08</b>	0.06-0.08	-	0.06-0.1	
					52.01-65.00	0.06-0.1	<b>0.06-0.1</b>	0.06-0.1	-	0.06-0.13	0.06-0.08	<b>0.06-0.08</b>	0.06-0.08	-	0.06-0.1				
		P1.1.ZAN	Unalloyed steel C=0.05-0.25%	125	4324	230	290	335	15.00-18.00	0.04-0.08	<b>0.04-0.08</b>	0.04-0.08	-	0.04-0.08	0.04-0.07	<b>0.04-0.07</b>	0.04-0.07	-	0.04-0.07
	4334				200	245	275	18.01-22.00	0.04-0.09	<b>0.04-0.09</b>	0.04-0.09	-	0.04-0.09	0.04-0.07	<b>0.04-0.07</b>	0.04-0.07	-	0.04-0.07	
	4344				170	190	210	22.01-27.00	0.04-0.1	<b>0.04-0.1</b>	0.04-0.1	-	0.04-0.1	0.04-0.08	<b>0.04-0.08</b>	0.04-0.08	-	0.04-0.08	
								27.01-33.00	0.05-0.1	<b>0.05-0.1</b>	0.05-0.1	-	0.05-0.1	0.05-0.08	<b>0.05-0.08</b>	0.05-0.08	-	0.05-0.08	
								33.01-40.00	0.05-0.11	<b>0.05-0.11</b>	0.05-0.11	-	0.05-0.13	0.05-0.09	<b>0.05-0.09</b>	0.05-0.09	-	0.05-0.1	
							40.01-52.00	0.06-0.11	<b>0.06-0.11</b>	0.06-0.11	-	0.06-0.13	0.06-0.09	<b>0.06-0.09</b>	0.06-0.09	-	0.06-0.1		
				52.01-65.00	0.06-0.11	<b>0.06-0.11</b>	0.06-0.11	-	0.06-0.13	0.06-0.09	<b>0.06-0.09</b>	0.06-0.09	-	0.06-0.1					
	P1.2.ZAN	Unalloyed steel C=0.25-0.55%	190	4324	190	240	275	15.00-18.00	-	0.05-0.08	0.06-0.09	<b>0.06-0.1</b>	-	-	0.05-0.07	0.06-0.08	<b>0.06-0.09</b>	-	
4334				155	195	225	18.01-22.00	-	0.05-0.09	0.06-0.1	<b>0.06-0.12</b>	-	-	0.05-0.08	0.06-0.09	<b>0.06-0.1</b>	-		
4344				120	150	170	22.01-27.00	-	0.05-0.12	0.06-0.13	<b>0.06-0.14</b>	-	-	0.05-0.1	0.06-0.11	<b>0.06-0.12</b>	-		
							27.01-33.00	-	0.07-0.14	0.08-0.16	<b>0.08-0.17</b>	-	-	0.07-0.12	0.08-0.13	<b>0.08-0.14</b>	-		
							33.01-40.00	-	0.07-0.16	0.08-0.17	<b>0.08-0.18</b>	-	-	0.07-0.13	0.08-0.14	<b>0.08-0.15</b>	-		
							40.01-52.00	-	0.09-0.16	0.1-0.17	<b>0.1-0.18</b>	-	-	0.09-0.13	0.1-0.14	<b>0.1-0.15</b>	-		
				52.01-65.00	-	0.09-0.16	0.1-0.17	<b>0.1-0.18</b>	-	-	0.09-0.13	0.1-0.14	<b>0.1-0.15</b>	-					
	P1.3.ZAN	Unalloyed steel C=0.55-0.80%	190	4324	170	225	260	15.00-18.00	-	0.05-0.08	0.06-0.09	<b>0.06-0.1</b>	-	-	0.05-0.07	0.06-0.08	<b>0.06-0.09</b>	-	
4334				140	185	215	18.01-22.00	-	0.05-0.09	0.06-0.1	<b>0.06-0.12</b>	-	-	0.05-0.08	0.06-0.09	<b>0.06-0.1</b>	-		
4344				105	140	165	22.01-27.00	-	0.05-0.12	0.06-0.13	<b>0.06-0.14</b>	-	-	0.05-0.1	0.06-0.11	<b>0.06-0.12</b>	-		
							27.01-33.00	-	0.07-0.14	0.08-0.16	<b>0.08-0.17</b>	-	-	0.07-0.12	0.08-0.13	<b>0.08-0.14</b>	-		
							33.01-40.00	-	0.07-0.16	0.08-0.17	<b>0.08-0.18</b>	-	-	0.07-0.13	0.08-0.14	<b>0.08-0.15</b>	-		
							40.01-52.00	-	0.09-0.16	0.1-0.17	<b>0.1-0.18</b>	-	-	0.09-0.13	0.1-0.14	<b>0.1-0.15</b>	-		
				52.01-65.00	-	0.09-0.16	0.1-0.17	<b>0.1-0.18</b>	-	-	0.09-0.13	0.1-0.14	<b>0.1-0.15</b>	-					
	P1.5.CUT	Unalloyed steel Cast - untreated	150	4324	140	235	295	15.00-18.00	-	0.04-0.08	0.04-0.08	<b>0.04-0.08</b>	-	-	0.04-0.07	0.04-0.07	<b>0.04-0.07</b>	-	
4334				135	200	240	18.01-22.00	-	0.04-0.08	0.04-0.08	<b>0.04-0.08</b>	-	-	0.04-0.07	0.04-0.07	<b>0.04-0.07</b>	-		
4344				125	160	180	22.01-27.00	-	0.04-0.09	0.04-0.09	<b>0.04-0.09</b>	-	-	0.04-0.08	0.04-0.08	<b>0.04-0.08</b>	-		
							27.01-33.00	-	0.05-0.1	0.05-0.1	<b>0.05-0.1</b>	-	-	0.05-0.08	0.05-0.08	<b>0.05-0.08</b>	-		
							33.01-40.00	-	0.05-0.1	0.05-0.1	<b>0.05-0.1</b>	-	-	0.05-0.09	0.05-0.09	<b>0.05-0.09</b>	-		
							40.01-52.00	-	0.06-0.1	0.06-0.1	<b>0.06-0.1</b>	-	-	0.06-0.09	0.06-0.09	<b>0.06-0.09</b>	-		
				52.01-65.00	-	0.06-0.1	0.06-0.1	<b>0.06-0.1</b>	-	-	0.06-0.09	0.06-0.09	<b>0.06-0.09</b>	-					
	P2.1.ZAN	Low alloy steel Annealed	175	4324	180	235	275	15.00-18.00	-	-	0.06-0.09	<b>0.06-0.1</b>	-	-	-	0.06-0.08	<b>0.06-0.09</b>	-	
4334				150	195	225	18.01-22.00	-	-	0.06-0.1	<b>0.06-0.12</b>	-	-	-	0.06-0.09	<b>0.06-0.1</b>	-		
4344				115	150	170	22.01-27.00	-	-	0.06-0.13	<b>0.06-0.14</b>	-	-	-	0.06-0.11	<b>0.06-0.12</b>	-		
							27.01-33.00	-	-	0.08-0.16	<b>0.08-0.17</b>	-	-	-	0.08-0.13	<b>0.08-0.14</b>	-		
							33.01-40.00	-	-	0.08-0.17	<b>0.08-0.18</b>	-	-	-	0.08-0.14	<b>0.08-0.15</b>	-		
							40.01-52.00	-	-	0.1-0.17	<b>0.1-0.18</b>	-	-	-	0.1-0.14	<b>0.1-0.15</b>	-		
				52.01-65.00	-	-	0.1-0.17	<b>0.1-0.18</b>	-	-	-	0.1-0.14	<b>0.1-0.15</b>	-					
	P2.2.ZAN	Low alloy steel Annealed	240	4324	180	225	260	15.00-18.00	-	-	0.06-0.09	<b>0.06-0.1</b>	-	-	-	0.06-0.08	<b>0.06-0.09</b>	-	
4334				150	180	205	18.01-22.00	-	-	0.06-0.1	<b>0.06-0.12</b>	-	-	-	0.06-0.09	<b>0.06-0.1</b>	-		
4344				115	160	185	22.01-27.00	-	-	0.06-0.13	<b>0.06-0.14</b>	-	-	-	0.06-0.11	<b>0.06-0.12</b>	-		
							27.01-33.00	-	-	0.08-0.16	<b>0.08-0.17</b>	-	-	-	0.08-0.13	<b>0.08-0.14</b>	-		
							33.01-40.00	-	-	0.08-0.17	<b>0.08-0.18</b>	-	-	-	0.08-0.14	<b>0.08-0.15</b>	-		
							40.01-52.00	-	-	0.1-0.17	<b>0.1-0.18</b>	-	-	-	0.1-0.14	<b>0.1-0.15</b>	-		
				52.01-65.00	-	-	0.1-0.17	<b>0.1-0.18</b>	-	-	-	0.1-0.14	<b>0.1-0.15</b>	-					
	P2.5.ZHT	Low alloy steel Hardened and tempered	330	4324	90	170	220	15.00-18.00	-	-	0.06-0.09	<b>0.06-0.1</b>	-	-	-	0.06-0.08	<b>0.06-0.09</b>	-	
4334				85	140	175	18.01-22.00	-	-	0.06-0.1	<b>0.06-0.12</b>	-	-	-	0.06-0.09	<b>0.06-0.1</b>	-		
4344				75	115	135	22.01-27.00	-	-	0.06-0.13	<b>0.06-0.14</b>	-	-	-	0.06-0.11	<b>0.06-0.12</b>	-		
							27.01-33.00	-	-	0.08-0.16	<b>0.08-0.17</b>	-	-	-	0.08-0.13	<b>0.08-0.14</b>	-		
							33.01-40.00	-	-	0.08-0.17	<b>0.08-0.18</b>	-	-	-	0.08-0.14	<b>0.08-0.15</b>	-		
							40.01-52.00	-	-	0.1-0.17	<b>0.1-0.18</b>	-	-	-	0.1-0.14	<b>0.1-0.15</b>	-		
				52.01-65.00	-	-	0.1-0.17	<b>0.1-0.18</b>	-	-	-	0.1-0.14	<b>0.1-0.15</b>	-					
	P2.6.CUT	Low alloy steel Cast - untreated	200	4324	110	190	240	15.00-18.00	-	-	0.06-0.1	<b>0.06-0.12</b>	-	-	-	0.06-0.09	<b>0.06-0.1</b>	-	
4334				105	160	190	18.01-22.00	-	-	0.06-0.12	<b>0.06-0.13</b>	-	-	-	0.06-0.1	<b>0.06-0.11</b>	-		
4344				100	125	145	22.01-27.00	-	-	0.06-0.14	<b>0.06-0.16</b>	-	-	-	0.06-0.12	<b>0.06-0.13</b>	-		
							27.01-33.00	-	-	0.08-0.17	<b>0.08-0.18</b>	-	-	-	0.08-0.14	<b>0.08-0.15</b>	-		
							33.01-40.00	-	-	0.08-0.18	<b>0.08-0.2</b>	-	-	-	0.08-0.15	<b>0.08-0.17</b>	-		
							40.01-52.00	-	-	0.1-0.18	<b>0.1-0.2</b>	-	-	-	0.1-0.15	<b>0.1-0.17</b>	-		
				52.01-65.00	-	-	0.1-0.18	<b>0.1-0.2</b>	-	-	-	0.1-0.15	<b>0.1-0.17</b>	-					
	P3.0.ZAN	High alloy steel Annealed	200	4324	160	220	260	15.00-18.00	-	-	0.06-0.09	<b>0.06-0.1</b>	-	-	-	0.06-0.08	<b>0.06-0.09</b>	-	
4334				130	180	215	18.01-22.00	-	-	0.06-0.1	<b>0.06-0.12</b>	-	-	-	0.06-0.09	<b>0.06-0.1</b>	-		
4344				100	135	160	22.01-27.00	-	-	0.06-0.13	<b>0.06-0.14</b>	-	-	-	0.06-0.11	<b>0.06-0.12</b>	-		
							27.01-33.00	-	-	0.08-0.16	<b>0.08-0.17</b>	-	-	-	0.				



# CoroDrill® DS20

6 – 7 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 6xD					Drill length 7xD				
					6-7xD	-S5W	-L5W		-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W		
K	K1.1.C.NS	Malleable cast iron Low tensile strength	200	4324	140	190	220	15.00-18.00	-	0.08-0.1	0.08-0.1	<b>0.08-0.13</b>	-	-	0.08-0.08	0.08-0.08	<b>0.08-0.11</b>	-
				4334	110	155	180	18.01-22.00	-	0.08-0.12	0.08-0.12	<b>0.08-0.15</b>	-	-	0.08-0.1	0.08-0.1	<b>0.08-0.13</b>	-
				4344	180	150	140	22.01-27.00	-	0.08-0.14	0.08-0.14	<b>0.08-0.17</b>	-	-	0.08-0.12	0.08-0.12	<b>0.08-0.14</b>	-
								27.01-33.00	-	0.1-0.16	0.1-0.16	<b>0.1-0.19</b>	-	-	0.1-0.13	0.1-0.13	<b>0.1-0.16</b>	-
								33.01-40.00	-	0.1-0.18	0.1-0.18	<b>0.1-0.21</b>	-	-	0.1-0.15	0.1-0.15	<b>0.1-0.18</b>	-
								40.01-52.00	-	0.12-0.18	0.12-0.18	<b>0.12-0.21</b>	-	-	0.12-0.15	0.12-0.15	<b>0.12-0.18</b>	-
	K2.1.C.UT	Grey cast iron Low tensile strength	180	4324	210	255	295	15.00-18.00	-	0.08-0.1	0.08-0.1	<b>0.08-0.13</b>	-	-	0.08-0.08	0.08-0.08	<b>0.08-0.11</b>	-
				4334	170	210	245	18.01-22.00	-	0.08-0.12	0.08-0.12	<b>0.08-0.15</b>	-	-	0.08-0.1	0.08-0.1	<b>0.08-0.13</b>	-
				4344	130	160	185	22.01-27.00	-	0.08-0.14	0.08-0.14	<b>0.08-0.17</b>	-	-	0.08-0.12	0.08-0.12	<b>0.08-0.14</b>	-
								27.01-33.00	-	0.1-0.16	0.1-0.16	<b>0.1-0.19</b>	-	-	0.1-0.13	0.1-0.13	<b>0.1-0.16</b>	-
								33.01-40.00	-	0.1-0.18	0.1-0.18	<b>0.1-0.21</b>	-	-	0.1-0.15	0.1-0.15	<b>0.1-0.18</b>	-
								40.01-52.00	-	0.12-0.18	0.12-0.18	<b>0.12-0.21</b>	-	-	0.12-0.15	0.12-0.15	<b>0.12-0.18</b>	-
	K2.2.C.UT	Grey cast iron High tensile strength	245	4324	125	185	220	15.00-18.00	-	0.08-0.08	0.08-0.08	<b>0.08-0.12</b>	-	-	0.08-0.07	0.08-0.07	<b>0.08-0.1</b>	-
				4334	100	145	175	18.01-22.00	-	0.08-0.1	0.08-0.1	<b>0.08-0.14</b>	-	-	0.08-0.09	0.08-0.09	<b>0.08-0.12</b>	-
				4344	75	115	135	22.01-27.00	-	0.08-0.12	0.08-0.12	<b>0.08-0.16</b>	-	-	0.08-0.1	0.08-0.1	<b>0.08-0.13</b>	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	<b>0.1-0.18</b>	-	-	0.1-0.12	0.1-0.12	<b>0.1-0.15</b>	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	<b>0.1-0.2</b>	-	-	0.1-0.14	0.1-0.14	<b>0.1-0.17</b>	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	<b>0.12-0.2</b>	-	-	0.12-0.14	0.12-0.14	<b>0.12-0.17</b>	-
K3.1.C.UT	Nodular cast iron Ferritic	155	4324	125	170	205	15.00-18.00	-	0.08-0.08	0.08-0.08	<b>0.08-0.12</b>	-	-	0.08-0.07	0.08-0.07	<b>0.08-0.1</b>	-	
			4334	100	140	165	18.01-22.00	-	0.08-0.1	0.08-0.1	<b>0.08-0.14</b>	-	-	0.08-0.09	0.08-0.09	<b>0.08-0.12</b>	-	
			4344	80	110	130	22.01-27.00	-	0.08-0.12	0.08-0.12	<b>0.08-0.16</b>	-	-	0.08-0.1	0.08-0.1	<b>0.08-0.13</b>	-	
							27.01-33.00	-	0.1-0.14	0.1-0.14	<b>0.1-0.18</b>	-	-	0.1-0.12	0.1-0.12	<b>0.1-0.15</b>	-	
							33.01-40.00	-	0.1-0.16	0.1-0.16	<b>0.1-0.2</b>	-	-	0.1-0.14	0.1-0.14	<b>0.1-0.17</b>	-	
							40.01-52.00	-	0.12-0.16	0.12-0.16	<b>0.12-0.2</b>	-	-	0.12-0.14	0.12-0.14	<b>0.12-0.17</b>	-	
K3.3.C.UT	Nodular cast iron Pearlitic	265	4324	110	160	190	15.00-18.00	-	0.08-0.08	0.08-0.08	<b>0.08-0.12</b>	-	-	0.08-0.07	0.08-0.07	<b>0.08-0.1</b>	-	
			4334	90	130	160	18.01-22.00	-	0.08-0.1	0.08-0.1	<b>0.08-0.14</b>	-	-	0.08-0.09	0.08-0.09	<b>0.08-0.12</b>	-	
			4344	70	100	115	22.01-27.00	-	0.08-0.12	0.08-0.12	<b>0.08-0.16</b>	-	-	0.08-0.1	0.08-0.1	<b>0.08-0.13</b>	-	
							27.01-33.00	-	0.1-0.14	0.1-0.14	<b>0.1-0.18</b>	-	-	0.1-0.12	0.1-0.12	<b>0.1-0.15</b>	-	
							33.01-40.00	-	0.1-0.16	0.1-0.16	<b>0.1-0.2</b>	-	-	0.1-0.14	0.1-0.14	<b>0.1-0.17</b>	-	
							40.01-52.00	-	0.12-0.16	0.12-0.16	<b>0.12-0.2</b>	-	-	0.12-0.14	0.12-0.14	<b>0.12-0.17</b>	-	
K4.2.C.UT	Compacted graphite iron High tensile strength (Pearlite>90%)	230	4324	130	190	225	15.00-18.00	-	0.08-0.08	0.08-0.08	<b>0.08-0.12</b>	-	-	0.08-0.07	0.08-0.07	<b>0.08-0.1</b>	-	
			4334	110	155	180	18.01-22.00	-	0.08-0.1	0.08-0.1	<b>0.08-0.14</b>	-	-	0.08-0.09	0.08-0.09	<b>0.08-0.12</b>	-	
			4344	85	115	135	22.01-27.00	-	0.08-0.12	0.08-0.12	<b>0.08-0.16</b>	-	-	0.08-0.1	0.08-0.1	<b>0.08-0.13</b>	-	
							27.01-33.00	-	0.1-0.14	0.1-0.14	<b>0.1-0.18</b>	-	-	0.1-0.12	0.1-0.12	<b>0.1-0.15</b>	-	
							33.01-40.00	-	0.1-0.16	0.1-0.16	<b>0.1-0.2</b>	-	-	0.1-0.14	0.1-0.14	<b>0.1-0.17</b>	-	
							40.01-52.00	-	0.12-0.16	0.12-0.16	<b>0.12-0.2</b>	-	-	0.12-0.14	0.12-0.14	<b>0.12-0.17</b>	-	
H	H1.3.Z.HA Extra hard steels Hardened & tempered	60 (HRC)	4324	30	60	75	15.00-18.00	-	0.06-0.08	0.06-0.08	<b>0.06-0.08</b>	-	-	0.06-0.07	0.06-0.07	<b>0.06-0.07</b>	-	
			4334	30	60	75	18.01-22.00	-	0.06-0.09	0.06-0.09	<b>0.06-0.09</b>	-	-	0.06-0.08	0.06-0.08	<b>0.06-0.08</b>	-	
			4344	30	60	75	22.01-27.00	-	0.06-0.1	0.06-0.1	<b>0.06-0.1</b>	-	-	0.06-0.08	0.06-0.08	<b>0.06-0.08</b>	-	
							27.01-33.00	-	0.08-0.1	0.08-0.1	<b>0.08-0.1</b>	-	-	0.08-0.09	0.08-0.09	<b>0.08-0.09</b>	-	
							33.01-40.00	-	0.08-0.12	0.08-0.12	<b>0.08-0.12</b>	-	-	0.08-0.1	0.08-0.1	<b>0.08-0.1</b>	-	
							40.01-52.00	-	0.1-0.12	0.1-0.12	<b>0.1-0.12</b>	-	-	0.1-0.1	0.1-0.1	<b>0.1-0.1</b>	-	
				52.01-65.00	-	0.1-0.12	0.1-0.12	<b>0.1-0.12</b>	-	-	0.1-0.1	0.1-0.1	<b>0.1-0.1</b>	-				

## CoroDrill® DS20

6 – 7 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations			Drill diameter	Drill length 6xD					Drill length 7xD				
					-S5W	-L5W	-L6W		-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W			
N	N1.2.Z.AG	Aluminum based alloys AlSi alloys (Si<1%)	100	H13A 4344	6-7xD			15.00-18.00 18.01-22.00 22.01-27.00 27.01-33.00 33.01-40.00 40.01-52.00 52.01-65.00	-S5W	-L5W	-L6W	-M7W	-H5W	-S5W	-L5W	-L6W	-M7W	-H5W
					Recommended start value at middle of feed range													
					300	330	360		0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-
					300	330	360		0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-
									0.06-0.13	0.06-0.13	0.06-0.13	-	-	0.06-0.11	0.06-0.11	0.06-0.11	-	-
									0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-
				0.08-0.16	0.08-0.16	0.08-0.16	-	-	0.08-0.14	0.08-0.14	0.08-0.14	-	-					
				0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-					
				0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-					
				0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-					
				0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-	-					
				0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-					
				0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-					
				0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-					
				0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-					
				0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-					
				0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-					
				0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-					
				0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-	-					
				0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-					
				0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-					
				0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-					
				0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-					
				0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-					
			0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-						
			0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-						
			0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.08	0.06-0.08	0.06-0.08	-	-						
			0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-						
			0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-						
			0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-						
			0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-						
			0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-						
			0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-						
			0.1-0.14	0.1-0.14	0.1-0.14	-	-	0.1-0.12	0.1-0.12	0.1-0.12	-	-						
			0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-						
			0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-						
			0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-						
			0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-						
			0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-						
			0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-						
			0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-						
			0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-						
			0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-						
			0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-						
			0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-						
			0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-						
			0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-						
			0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-						
			0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-						
			0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-						
			0.06-0.09	0.06-0.09	0.06-0.09	-	-	0.06-0.09	0.06-0.09	0.06-0.09	-	-						
			0.06-0.1	0.06-0.1	0.06-0.1	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-						
			0.06-0.12	0.06-0.12	0.06-0.12	-	-	0.06-0.1	0.06-0.1	0.06-0.1	-	-						
			0.08-0.13	0.08-0.13	0.08-0.13	-	-	0.08-0.11	0.08-0.11	0.08-0.11	-	-						
			0.08-0.14	0.08-0.14	0.08-0.14	-	-	0.08-0.12	0.08-0.12	0.08-0.12	-	-						
			0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-						
			0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-						
			0.1-0.16	0.1-0.16	0.1-0.16	-	-	0.1-0.14	0.1-0.14	0.1-0.14	-	-						

Feed at hole entry should be 75% of recommended feed rate. Feed at hole exit, use 0.05 mm/rev.

# CoroDrill® 880

2 – 3 x DC

ISO	MC No.	Material	Hardness Brinell  HB	Grade	Cutting speed  (m/min)	Drill diameter  DC mm	Geometry / Feed			
							Drill length 2-3xD			
							-LM <i>f<sub>n</sub></i> mm/rev	-GM <i>f<sub>n</sub></i> mm/rev	-GR <i>f<sub>n</sub></i> mm/rev	-GT <i>f<sub>n</sub></i> mm/rev
P	P1.0.Z.AN (01.0)	Unalloyed steel  Non hardened  0.05-0.10% C	90-200	4324 4334 4344	230-400 210-325 190-245	12.00-13.99	<b>0.04-0.08</b>			
						14.00-16.49	<b>0.04-0.08</b>	0.04-0.06	0.04-0.06	0.04-0.06
						16.50-19.99	<b>0.04-0.10</b>	0.04-0.06	0.04-0.06	0.04-0.06
						20.00-23.99	<b>0.04-0.12</b>	0.04-0.08	0.04-0.08	0.04-0.08
						24.00-29.99	<b>0.04-0.12</b>	0.04-0.08	0.04-0.08	0.04-0.08
						30.00-35.99	<b>0.06-0.14</b>	0.06-0.10	0.06-0.10	0.06-0.10
						36.00-43.99	<b>0.06-0.16</b>	0.06-0.10	0.06-0.10	0.06-0.10
						44.00-52.99	<b>0.08-0.16</b>	0.08-0.12	0.08-0.12	0.08-0.12
	53.00-63.50	<b>0.08-0.16</b>	0.08-0.12	0.08-0.12	0.08-0.12					
	P1.1.Z.AN (01.1)	Non hardened  0.05-0.25% C	90-200	4324 4334 4344	230-370 200-305 170-235	12.00-13.99	<b>0.04-0.10</b>			
						14.00-16.49	<b>0.04-0.10</b>	0.04-0.06	0.04-0.06	0.04-0.06
						16.50-19.99	<b>0.04-0.12</b>	0.04-0.06	0.04-0.06	0.04-0.06
						20.00-23.99	<b>0.04-0.14</b>	0.04-0.10	0.04-0.10	0.04-0.10
						24.00-29.99	<b>0.04-0.14</b>	0.04-0.10	0.04-0.10	0.04-0.10
						30.00-35.99	<b>0.06-0.16</b>	0.06-0.12	0.06-0.12	0.06-0.12
						36.00-43.99	<b>0.06-0.16</b>	0.06-0.12	0.06-0.12	0.06-0.12
						44.00-52.99	<b>0.08-0.16</b>	0.08-0.12	0.08-0.12	0.08-0.12
	53.00-63.50	<b>0.08-0.16</b>	0.08-0.12	0.08-0.12	0.08-0.12					
	P1.2.Z.AN (01.2)	Non hardened  0.25-0.55% C	125-225	4324 4334 4344	190-305 155-250 120-190	12.00-13.99	0.04-0.10			
						14.00-16.49	0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10
						16.50-19.99	0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	<b>0.06-0.18</b>	0.06-0.18
						24.00-29.99	0.06-0.18	0.06-0.18	<b>0.06-0.18</b>	0.06-0.18
						30.00-35.99	0.06-0.22	0.06-0.22	<b>0.06-0.22</b>	0.06-0.22
						36.00-43.99	0.06-0.24	0.06-0.24	<b>0.06-0.24</b>	0.06-0.24
						44.00-52.99	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24
	53.00-63.50	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24					
	P1.3.Z.AN (01.3)	Non hardened  0.55-0.80% C	150-250	4324 4334 4344	170-290 140-240 105-185	12.00-13.99	0.04-0.10			
14.00-16.49						0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10	
16.50-19.99						0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14	
20.00-23.99						0.06-0.18	0.06-0.18	<b>0.06-0.18</b>	0.06-0.18	
24.00-29.99						0.06-0.18	0.08-0.18	<b>0.08-0.18</b>	0.08-0.18	
30.00-35.99						0.06-0.24	0.08-0.24	<b>0.08-0.24</b>	0.08-0.24	
36.00-43.99						0.06-0.24	0.08-0.24	<b>0.08-0.24</b>	0.08-0.24	
44.00-52.99						0.06-0.24	0.08-0.24	<b>0.08-0.24</b>	0.08-0.24	
53.00-63.50	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24						
P1.3.Z.AN (01.4)	High carbon & carbon tool steel	180-275	4324 4334 4344	200-290 155-240 105-180	12.00-13.99	0.04-0.10				
					14.00-16.49	0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10	
					16.50-19.99	0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14	
					20.00-23.99	0.06-0.18	0.06-0.18	<b>0.06-0.18</b>	0.06-0.18	
					24.00-29.99	0.06-0.18	0.08-0.18	<b>0.08-0.18</b>	0.08-0.18	
					30.00-35.99	0.06-0.24	0.08-0.24	<b>0.08-0.24</b>	0.08-0.24	
					36.00-43.99	0.06-0.24	0.08-0.24	<b>0.08-0.24</b>	0.08-0.24	
					44.00-52.99	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24	
53.00-63.50	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24						
P2.1.Z.AN (02.1)	Low alloy steel (Non-hardened)	150-260	4324 4334 4344	180-305 150-250 115-190	12.00-13.99	0.04-0.10				
					14.00-16.49	0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10	
					16.50-19.99	0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14	
					20.00-23.99	0.06-0.18	0.06-0.18	<b>0.06-0.18</b>	0.06-0.18	
					24.00-29.99	0.06-0.18	0.08-0.18	<b>0.08-0.18</b>	0.08-0.18	
					30.00-35.99	0.06-0.24	0.06-0.24	<b>0.06-0.24</b>	0.06-0.24	
					36.00-43.99	0.06-0.24	0.06-0.24	<b>0.06-0.24</b>	0.06-0.24	
					44.00-52.99	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24	
53.00-63.50	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24						
P2.5.Z.HT (02.2)	Hardened steel	220-450	4324 4334 4344	90-245 85-195 75-150	12.00-13.99	0.04-0.10				
					14.00-16.49	0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10	
					16.50-19.99	0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14	
					20.00-23.99	0.06-0.18	0.06-0.18	<b>0.06-0.18</b>	0.06-0.18	
					24.00-29.99	0.06-0.18	0.08-0.18	<b>0.08-0.18</b>	0.08-0.18	
					30.00-35.99	0.06-0.24	0.06-0.24	<b>0.06-0.24</b>	0.06-0.24	
					36.00-43.99	0.06-0.24	0.06-0.24	<b>0.06-0.24</b>	0.06-0.24	
					44.00-52.99	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24	
53.00-63.50	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24						

Note: Bold text is recommended geometry  
Central insert grade is always 1044.



## CoroDrill® 880

2 – 3 x DC

ISO	MC No.	Material	Hardness Brinell HB	Grade	Cutting speed (m/min)	Drill diameter DC mm	Geometry / Feed Drill length 2-3xD			
							-LM $f_n$ mm/rev	-GM $f_n$ mm/rev	-GR $f_n$ mm/rev	-GT $f_n$ mm/rev
P	P3.0.Z.AN (03.11)	High alloy steel (Annealed)	150-250	4324	160-280	12.00-13.99	0.04-0.10			
						14.00-16.49	0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10
						16.50-19.99	0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	<b>0.06-0.18</b>	0.06-0.18
						24.00-29.99	0.06-0.18	0.08-0.18	<b>0.08-0.18</b>	0.08-0.18
						30.00-35.99	0.06-0.24	0.06-0.24	<b>0.06-0.24</b>	0.06-0.24
						36.00-43.99	0.06-0.24	0.06-0.24	<b>0.06-0.24</b>	0.06-0.24
						44.00-52.99	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24
						53.00-63.50	0.10-0.24	0.10-0.24	<b>0.10-0.24</b>	0.10-0.24
						P3.0.Z.HT (03.21)	Hardened steel	250-350	4324	80-210
	14.00-16.49	0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10					
	16.50-19.99	0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14					
	20.00-23.99	0.06-0.18	0.06-0.18	<b>0.06-0.18</b>	0.06-0.18					
	24.00-29.99	0.06-0.18	0.08-0.18	<b>0.08-0.18</b>	0.08-0.18					
	30.00-35.99	0.06-0.20	0.06-0.20	<b>0.06-0.20</b>	0.06-0.20					
	36.00-43.99	0.06-0.22	0.06-0.22	<b>0.06-0.22</b>	0.06-0.22					
	44.00-52.99	0.10-0.22	0.10-0.22	<b>0.10-0.22</b>	0.10-0.22					
	53.00-63.50	0.10-0.22	0.10-0.22	<b>0.10-0.22</b>	0.10-0.22					
	06.1	Steel castings (Unalloyed)	90-225	4324	140-365					
						14.00-16.49	0.04-0.08	0.04-0.08	<b>0.04-0.08</b>	0.04-0.08
						16.50-19.99	0.04-0.08	0.04-0.08	<b>0.04-0.08</b>	0.04-0.08
						20.00-23.99	0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10
						24.00-29.99	0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10
						30.00-35.99	0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14
						36.00-43.99	0.06-0.14	0.06-0.14	<b>0.06-0.14</b>	0.06-0.14
						44.00-52.99	0.08-0.14	0.08-0.14	<b>0.08-0.14</b>	0.08-0.14
						53.00-63.50	0.08-0.14	0.08-0.14	<b>0.08-0.14</b>	0.08-0.14
						P1.5.C.UT (06.2)	Low alloyed (alloying elements less than 5%)	150-250	4324	110-265
14.00-16.49	0.04-0.10	0.04-0.10	<b>0.04-0.10</b>	0.04-0.10						
16.50-19.99	0.04-0.14	0.04-0.14	<b>0.04-0.14</b>	0.04-0.14						
20.00-23.99	0.06-0.18	0.06-0.18	<b>0.06-0.18</b>	0.06-0.18						
24.00-29.99	0.06-0.18	0.08-0.18	<b>0.08-0.18</b>	0.08-0.18						
30.00-35.99	0.06-0.20	0.06-0.20	<b>0.06-0.20</b>	0.06-0.20						
36.00-43.99	0.06-0.22	0.06-0.22	<b>0.06-0.22</b>	0.06-0.22						
44.00-52.99	0.10-0.22	0.10-0.22	<b>0.10-0.22</b>	0.10-0.22						
53.00-63.50	0.10-0.22	0.10-0.22	<b>0.10-0.22</b>	0.10-0.22						

Note: Bold text is recommended geometry  
Central insert grade is always 1044.

# CoroDrill® 880

2 – 3 x DC

ISO	MC No.	Material	Hardness Brinell	Grade	Cutting speed (m/min)	Drill diameter DC mm	Geometry/ feed (f <sub>r</sub> , mm/rev.)						
							Drill length 2-3xD						
							-LM	-MS <sup>1)</sup>	-GM	-GR	-GT		
M	P5.0.Z.AN (05.11)	Stainless steel Ferritic/ Martensitic 13-25% Cr	150-270	4324	120-280	12.00-13.99	0.04-0.12	<b>0.04-0.12</b>	0.04-0.08	0.04-0.08	0.04-0.14		
						14.00-16.49	0.04-0.14	<b>0.04-0.14</b>	0.04-0.08	0.04-0.08	0.06-0.16		
						16.50-19.99	0.06-0.16	<b>0.06-0.16</b>	0.04-0.08	0.04-0.08	0.06-0.16		
						20.00-23.99	0.06-0.18	<b>0.06-0.18</b>	0.06-0.14	0.06-0.14	0.06-0.18		
						4334	115-225	24.00-29.99	0.06-0.18	<b>0.06-0.18</b>	0.06-0.14	0.06-0.14	0.06-0.18
						4344	115-175	30.00-35.99	0.06-0.20	<b>0.06-0.20</b>	0.06-0.16	0.06-0.16	0.06-0.20
	M1.0.Z.AQ (05.21)	Austenitic Ni > 8%, 13-25% Cr	150-275	4324	120-265	12.00-13.99	0.04-0.12	<b>0.04-0.12</b>	0.04-0.08	0.04-0.08	0.04-0.14		
						14.00-16.49	0.04-0.14	<b>0.04-0.14</b>	0.04-0.08	0.04-0.08	0.06-0.14		
						16.50-19.99	0.06-0.14	<b>0.06-0.14</b>	0.04-0.08	0.04-0.08	0.06-0.14		
						20.00-23.99	0.06-0.16	<b>0.06-0.16</b>	0.06-0.12	0.06-0.12	0.06-0.16		
						4334	115-225	24.00-29.99	0.06-0.16	<b>0.06-0.16</b>	0.06-0.12	0.06-0.12	0.06-0.16
						4344	115-190	30.00-35.99	0.06-0.18	<b>0.06-0.18</b>	0.06-0.16	0.06-0.16	0.06-0.20
	M3.1.Z.AQ (05.51) M3.2.Z.AQ (05.52)	Austenitic/Ferritic (Duplex)	200-320	4324	90-155	12.00-13.99	0.04-0.12	<b>0.04-0.12</b>	0.04-0.08	0.04-0.08	0.04-0.14		
						14.00-16.49	0.04-0.14	<b>0.04-0.14</b>	0.04-0.08	0.04-0.08	0.06-0.14		
						16.50-19.99	0.06-0.14	<b>0.06-0.14</b>	0.04-0.08	0.04-0.08	0.06-0.14		
20.00-23.99						0.06-0.16	<b>0.06-0.16</b>	0.06-0.12	0.06-0.12	0.06-0.16			
4334						85-145	24.00-29.99	0.06-0.16	<b>0.06-0.16</b>	0.06-0.12	0.06-0.12	0.06-0.16	
4344						85-130	30.00-35.99	0.06-0.18	<b>0.06-0.18</b>	0.06-0.16	0.06-0.16	0.06-0.18	
M1.0.C.UT (15.21)	Austenitic castings	150-250	4324	150-210	12.00-13.99	0.04-0.12	<b>0.04-0.12</b>	0.04-0.08	0.04-0.08	0.04-0.12			
					14.00-16.49	0.04-0.12	<b>0.04-0.12</b>	0.04-0.08	0.04-0.08	0.06-0.14			
					16.50-19.99	0.06-0.14	<b>0.06-0.14</b>	0.04-0.08	0.04-0.08	0.06-0.14			
					20.00-23.99	0.06-0.16	<b>0.06-0.16</b>	0.06-0.12	0.06-0.12	0.06-0.16			
					4334	115-185	24.00-29.99	0.06-0.16	<b>0.06-0.16</b>	0.06-0.12	0.06-0.12	0.06-0.16	
					4344	80-165	30.00-35.99	0.06-0.18	<b>0.06-0.18</b>	0.06-0.16	0.06-0.16	0.06-0.18	
S	S2.0.Z.AN (20.21) S2.0.Z.AG (20.22) S2.0.C.NS (20.24)	Heat resistant alloys. Ni Based	140-425	4344	20-95	12.00-13.99	<b>0.04-0.08</b>	0.04-0.08	0.04-0.08	0.04-0.08	0.04-0.08		
						14.00-16.49	<b>0.04-0.08</b>	0.04-0.08	0.04-0.10	0.04-0.08	0.05-0.08		
						16.50-19.99	<b>0.05-0.08</b>	0.05-0.08	0.05-0.10	0.05-0.08	0.05-0.08		
						20.00-23.99	<b>0.05-0.08</b>	0.05-0.08	0.05-0.10	0.05-0.08	0.05-0.08		
						2044	20-90	24.00-29.99	<b>0.06-0.10</b>	0.06-0.10	0.06-0.12	0.06-0.08	0.05-0.08
						30.00-35.99	<b>0.06-0.12</b>	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12		
	S4.2.Z.AN (23.21) S4.3.Z.AG (23.22)	Titanium: Alfa- , near Alfa- and Alfa + Beta alloys in annealed condition	Rm (Mpa) 600-1500	4344	40-145	12.00-13.99	<b>0.04-0.14</b>	0.04-0.14	0.04-0.10	0.04-0.10	0.06-0.10		
						14.00-16.49	<b>0.06-0.14</b>	0.06-0.14	0.06-0.12	0.06-0.10	0.06-0.10		
						16.50-19.99	<b>0.08-0.16</b>	0.08-0.16	0.08-0.14	0.08-0.12	0.08-0.12		
		H13A				40-135	20.00-23.99	<b>0.08-0.16</b>	0.08-0.16	0.08-0.14	0.08-0.12	0.08-0.12	
		2044				40-135	24.00-29.99	<b>0.12-0.18</b>	0.12-0.18	0.10-0.16	0.10-0.14	0.10-0.14	
		30.00-35.99				<b>0.12-0.18</b>	0.12-0.18	0.10-0.18	0.10-0.16	0.12-0.18			
S	Titanium: Alfa + Beta alloys in aged condition, Beta alloys in annealed or aged condition	Rm (Mpa) 600-1500	2044	40-135	36.00-43.99	<b>0.12-0.18</b>	0.12-0.18	0.10-0.18	0.10-0.16	0.12-0.18			
					44.00-52.99	<b>0.12-0.18</b>	0.12-0.18	0.10-0.18	0.10-0.16	0.12-0.18			
					53.00-63.50	<b>0.14-0.20</b>	0.14-0.20	0.14-0.20	0.12-0.16	0.14-0.20			

Note: Bold text is recommended geometry  
 1) -MS geometry is only available in GC2044  
 GC1044 is the universal central insert grade for all materials  
 GC1144 is the optimized central insert grade for ISO M materials

## CoroDrill® 880

2 – 3 x DC

ISO	MC No.	Material	Hardness Brinell  HB	Grade	Cutting speed  (m/min)	Drill diameter  DC mm	Geometry / Feed Drill length 2-3xD			
							-LM $f_n$ mm/rev.	-GM $f_n$ mm/rev.	-GR $f_n$ mm/rev.	-GT $f_n$ mm/rev.
K	K1.1.C.NS (07.1)	Malleable cast iron Ferritic (Short chipping)	110-145	4324	140-245	12.00-13.99				
						14.00-16.49	0.06-0.10	0.06-0.12	<b>0.06-0.20</b>	
						16.50-19.99	0.06-0.12	0.08-0.14	<b>0.08-0.22</b>	0.08 - 0.22
						20.00-23.99	0.08-0.14	0.10-0.18	<b>0.14-0.28</b>	0.10 - 0.26
						24.00-29.99	0.08-0.14	0.10-0.20	<b>0.16-0.32</b>	
						30.00-35.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>	
						36.00-43.99	0.10-0.16	0.10-0.20	<b>0.10-0.34</b>	
	44.00-52.99	0.12-0.18	0.12-0.22	<b>0.12-0.34</b>						
	53.00-63.50									
	K1.1.C.NS (07.2)	Pearlitic (long chipping)	150-270	4324	105-180	12.00-13.99				
						14.00-16.49	0.06-0.10	0.06-0.12	<b>0.06-0.16</b>	
						16.50-19.99	0.06-0.12	0.08-0.14	<b>0.08-0.18</b>	0.08 - 0.18
						20.00-23.99	0.08-0.14	0.10-0.16	<b>0.10-0.24</b>	0.10 - 0.24
						24.00-29.99	0.08-0.14	0.10-0.18	<b>0.10-0.28</b>	
						30.00-35.99	0.10-0.16	0.10-0.20	<b>0.10-0.30</b>	
						36.00-43.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>	
	44.00-52.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>						
	53.00-63.50									
	K2.1.C.UT (08.1)	Grey cast iron: Low tensile strength	150-220	4324	210-325	12.00-13.99				
						14.00-16.49	0.06-0.10	0.06-0.12	<b>0.06-0.20</b>	
						16.50-19.99	0.06-0.12	0.08-0.14	<b>0.08-0.22</b>	0.08 - 0.22
						20.00-23.99	0.08-0.14	0.10-0.18	<b>0.10-0.28</b>	0.10 - 0.28
						24.00-29.99	0.08-0.14	0.10-0.20	<b>0.10-0.32</b>	
						30.00-35.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>	
36.00-43.99						0.10-0.16	0.10-0.20	<b>0.10-0.34</b>		
44.00-52.99	0.12-0.18	0.12-0.22	<b>0.12-0.34</b>							
53.00-63.50										
K2.2.C.UT (08.2)	High tensile strength	200-330	4324	125-245	12.00-13.99					
					14.00-16.49	0.06-0.10	0.06-0.12	<b>0.06-0.16</b>		
					16.50-19.99	0.06-0.12	0.08-0.14	<b>0.08-0.18</b>	0.08 - 0.18	
					20.00-23.99	0.08-0.14	0.10-0.16	<b>0.10-0.24</b>	0.10 - 0.24	
					24.00-29.99	0.08-0.14	0.10-0.18	<b>0.10-0.28</b>		
					30.00-35.99	0.10-0.16	0.10-0.20	<b>0.10-0.30</b>		
					36.00-43.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>		
44.00-52.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>							
53.00-63.50										
K3.1.C.UT (09.1)	Nodular cast iron (Ferritic)	150-230	4324	125-225	12.00-13.99					
					14.00-16.49	0.06-0.10	0.06-0.12	<b>0.08-0.16</b>		
					16.50-19.99	0.06-0.12	0.08-0.14	<b>0.10-0.18</b>	0.08 - 0.18	
					20.00-23.99	0.08-0.14	0.10-0.16	<b>0.12-0.24</b>	0.10 - 0.24	
					24.00-29.99	0.08-0.14	0.10-0.18	<b>0.14-0.28</b>		
					30.00-35.99	0.10-0.16	0.10-0.20	<b>0.10-0.30</b>		
					36.00-43.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>		
44.00-52.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>							
53.00-63.50										
K3.3.C.UT (09.2)	Pearlitic	200-330	4324	110-210	12.00-13.99					
					14.00-16.49	0.06-0.10	0.06-0.12	<b>0.08-0.16</b>		
					16.50-19.99	0.06-0.12	0.08-0.14	<b>0.10-0.18</b>	0.08 - 0.18	
					20.00-23.99	0.08-0.14	0.10-0.16	<b>0.12-0.24</b>	0.10 - 0.24	
					24.00-29.99	0.08-0.14	0.10-0.18	<b>0.14-0.28</b>		
					30.00-35.99	0.10-0.16	0.10-0.20	<b>0.10-0.30</b>		
					36.00-43.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>		
44.00-52.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>							
53.00-63.50										

Note: Bold text is recommended geometry  
Central insert grade is always 1044.

# CoroDrill® 880

2 – 3 x DC

ISO	MC No.	Material	Hardness Brinell  HB	Grade	Cutting speed  (m/min)	Drill diameter  DC mm	Geometry / Feed			
							Drill length 2-3xD			
							-LM <i>f<sub>n</sub></i> mm/rev.	-GM <i>f<sub>n</sub></i> mm/rev.	-GR <i>f<sub>n</sub></i> mm/rev.	-GT <i>f<sub>n</sub></i> mm/rev.
H	H1.3.Z.HA (04.1)	Hardened and tempered	47-65 (HRC)	4324 4334 4344	30-85 30-85 30-85	12.00-13.99	0.10-0.16	0.10-0.20	<b>0.10-0.32</b>	
						14.00-16.49	0.04-0.08	<b>0.04-0.12</b>	0.04-0.08	0.04 - 0.08
						16.50-19.99	0.05-0.12	<b>0.06-0.14</b>	0.05-0.12	0.05 - 0.12
						20.00-23.99	0.05-0.14	<b>0.06-0.18</b>	0.05-0.14	0.05 - 0.14
						24.00-29.99	0.05-0.14	<b>0.06-0.18</b>	0.05-0.14	0.05 - 0.14
						30.00-35.99	0.06-0.16	<b>0.06-0.20</b>	0.06-0.16	
						36.00-43.99	0.06-0.16	<b>0.06-0.20</b>	0.06-0.16	
						44.00-52.99	0.10-0.16	<b>0.10-0.20</b>	0.10-0.16	
						53.00-63.50				
						N	N1.2.Z.AG (30.12)	Al. alloys Wrought or wrought and aged	30-150	4344 H13A
14.00-16.49	<b>0.04-0.14</b>	0.04-0.12	0.04-0.12	0.04-0.12						
16.50-19.99	<b>0.04-0.16</b>	0.04-0.14	0.04-0.14	0.04 - 0.14						
20.00-23.99	<b>0.06-0.18</b>	0.06-0.16	0.06-0.16	0.06 - 0.16						
24.00-29.99	<b>0.10-0.20</b>	0.10-0.18	0.10-0.18	0.10-0.18						
30.00-35.99	<b>0.10-0.25</b>	0.10-0.20	0.10-0.20							
36.00-43.99	<b>0.10-0.25</b>	0.10-0.20	0.10-0.20							
44.00-52.99	<b>0.12-0.28</b>	0.12-0.22	0.12-0.22							
53.00-63.50	0.12-0.28	0.12-0.22	0.12-0.22							
	N1.3.C.UT (30.21)	Cast. non aging	40-100	4344 H13A	300-405 300-400					
						14.00-16.49	<b>0.04-0.12</b>	0.04-0.14	0.04-0.12	0.04-0.12
						16.50-19.99	<b>0.04-0.14</b>	0.04-0.16	0.04-0.14	0.04 - 0.14
						20.00-23.99	<b>0.06-0.16</b>	0.06-0.18	0.06-0.16	0.06 - 0.16
						24.00-29.99	<b>0.10-0.18</b>	0.10-0.20	0.10-0.18	0.10-0.18
						30.00-35.99	<b>0.10-0.20</b>	0.10-0.22	0.10-0.20	
						36.00-43.99	<b>0.10-0.20</b>	0.10-0.24	0.10-0.20	
						44.00-52.99	<b>0.12-0.22</b>	0.12-0.26	0.12-0.22	
						53.00-63.50	0.12-0.22	0.12-0.26	0.12-0.22	
							N1.3.C.AG (30.22)	Cast or cast and aged	70-140	4344 H13A
14.00-16.49	<b>0.04-0.12</b>	0.04-0.14	0.04-0.12	0.04-0.12						
16.50-19.99	<b>0.04-0.14</b>	0.04-0.16	0.04-0.14	0.04 - 0.14						
20.00-23.99	<b>0.06-0.16</b>	0.06-0.18	0.06-0.16	0.06 - 0.16						
24.00-29.99	<b>0.10-0.18</b>	0.10-0.20	0.10-0.18	0.10-0.18						
30.00-35.99	<b>0.10-0.20</b>	0.10-0.22	0.10-0.20							
36.00-43.99	<b>0.10-0.20</b>	0.10-0.24	0.10-0.20							
44.00-52.99	<b>0.12-0.22</b>	0.12-0.26	0.12-0.22							
53.00-63.50	0.12-0.22	0.12-0.26	0.12-0.22							
	N3.3.U.UT (33.1)	Copper and copper alloys	70-160	4344 H13A	250-400 250-400					
						14.00-16.49	<b>0.04-0.14</b>	0.04-0.12	0.04-0.12	0.04-0.12
						16.50-19.99	<b>0.04-0.16</b>	0.04-0.14	0.04-0.14	0.04 - 0.14
						20.00-23.99	<b>0.06-0.18</b>	0.06-0.16	0.06-0.16	0.06 - 0.16
						24.00-29.99	<b>0.10-0.20</b>	0.10-0.18	0.10-0.18	0.10-0.18
						30.00-35.99	<b>0.10-0.25</b>	0.10-0.20	0.10-0.20	
						36.00-43.99	<b>0.10-0.25</b>	0.10-0.20	0.10-0.20	
						44.00-52.99	<b>0.12-0.28</b>	0.12-0.22	0.12-0.22	
						53.00-63.50	0.12-0.28	0.12-0.22	0.12-0.22	
							N3.2.C.UT (33.2)	Brass and leaded alloys (Pb < 1%)	50-200	4344 H13A
14.00-16.49	<b>0.04-0.14</b>	0.04-0.12	0.04-0.12	0.04-0.12						
16.50-19.99	<b>0.04-0.16</b>	0.04-0.14	0.04-0.14	0.04 - 0.14						
20.00-23.99	<b>0.06-0.18</b>	0.06-0.16	0.06-0.16	0.06 - 0.16						
24.00-29.99	<b>0.10-0.20</b>	0.10-0.18	0.10-0.18	0.10-0.18						
30.00-35.99	<b>0.10-0.25</b>	0.10-0.20	0.10-0.20							
36.00-43.99	<b>0.10-0.25</b>	0.10-0.20	0.10-0.20							
44.00-52.99	<b>0.12-0.28</b>	0.12-0.22	0.12-0.22							
53.00-63.50	0.12-0.28	0.12-0.22	0.12-0.22							

Note: Bold text is recommended geometry  
Central insert grade is always 1044.

## Trepanning tool

ISO	CMC No.	Material	Hardness Brinell HB	Drill dia. DC mm	Feed $f_n$ mm/r	Speed $v_c$ m/min	Geometry / Grade
P	<b>Unalloyed steel</b>						
	01.0	Non hardened 0,05–0,10% C	80–170		0.07–0.10	250–345	-58/3040
	01.1	Non hardened 0,05–0,25% C	90–200		0.07–0.12	225–315	-58/3040
	01.2	Non hardened 0,25–0,55% C	125–225				
	01.3	Non hardened 0,55–0,80% C	150–250	60–110	0.10–0.20	130–210	-53/3040
	01.4	High carbon & carbon tool steel	180–275				
	<b>Low alloy steel</b>						
	02.1	Non-hardened	150–260	60–110	0.11–0.18	145–210	-53/3040
	02.2	Hardened	220–400		0.10–0.20	100–165	
	<b>High alloy steel</b>						
	03.11	Annealed	50–250		0.10–0.20	125–200	
	03.13	Annealed HSS		60–110			-53/3040
	03.21	Hardened tool steel	250–450		0.11–0.18	90–145	
	03.22	Hardened steel					
<b>Steel castings</b>							
06.1	Unalloyed	90–225	60–110	0.06–0.12	195–280	-58/3040	
06.2	Low alloyed (alloying elements ≤ 5%)	150–250		0.11–0.18	120–175	-53/3040	
M	<b>Stainless steel</b>						
	05.1	Ferritic, Martensitic 13–25% Cr	150–270	60–110	0.10–0.20	170–240	-58/3040
05.2	Austenitic Ni > 8% 13–25% Cr	150–270	60–110	0.10–0.16	100–140	-58/235	
K	<b>Malleable</b>						
	07.1	Ferritic (short chipping)	110–145	60–110	0.16–0.26	140–210	-53/3040
	07.2	Pearlitic (long chipping)	150–270		0.14–0.20	105–155	
	<b>Grey cast iron</b>						
	08.1	Low tensile	150–220	60–110	0.16–0.26	210–280	-53/3040
	08.2	High tensile	200–300		0.14–0.20	125–210	
	<b>Nodular cast iron</b>						
09.1	Ferritic	125–230		0.14–0.20	125–195		
09.2	Ferritic	200–300	60–110	0.14–0.20	100–180	-53/3040	
N	<b>Aluminium alloys</b>						
	30.12	Wrought or wrought and aged	75–150				
	30.21	Forged	40–100	60–110	0.12–0.22	250–400	-53/H13A
	30.22	Cast, solution treated & aged	70–125				
	<b>Copper and copper alloys</b>						
33.1	Free cutting alloys (Pb ≥ 1%)	50–160	60–110	0.12–0.22	180–350	-53/H13A	
33.2	Brass and leaded bronzes (Pb ≤ 1%)						

# Coromant U indexable insert plunge drill

ISO	CMC No.	Material	Hardness Brinell HB	Drill dia DC mm	Feed f <sub>n</sub> mm/r	Speed v <sub>c</sub> m/min	Geometry / Grade			
							FIRST CHOICE Highest productivity		Complementary	
							P	C	P	C
P	01.0	Unalloyed steel Non hardened 0,05–0,10% C	80–170	12.7–17.0	0.04–0.08	290 (230–380)	-53/3040	-53/1020	-53/1120	-53/1020
				17.5–25.4	0.04–0.08		-53/3040	-53/1020	-53/1020	T-53/1020
				26.0–30.0	0.05–0.08		-53/3040	-53/1020	-53/1020	
				31.0–41.3	0.07–0.10		-53/3040	-53/1020	-53/1020	
				42.0–80.0	0.08–0.12		-53/3040	-53/1020	-53/1020	
	01.1	Non hardened 0,05–0,25% C	90–200	12.7–17.0	0.04–0.08	270 (225–345)	-53/3040	-53/1020	-53/1120	-53/1020
				17.5–25.4	0.04–0.08		-53/3040	-53/1020	-53/1020	T-53/1020
				26.0–30.0	0.05–0.10		-53/3040	-53/1020	-53/1020	
				31.0–41.3	0.07–0.12		-53/3040	-53/1020	-53/1020	
				42.0–80.0	0.08–0.14		-53/3040	-53/1020	-53/1020	
	01.2	Non hardened 0,25–0,55% C	125–225	12.7–17.0	0.04–0.10	230 (190–290)	-53/3040	-53/1020	-53/1120	-53/1020
				17.5–25.4	0.04–0.14		-53/3040	-53/1020	-53/1020	T-53/1020
				26.0–30.0	0.08–0.18		-53/3040	-53/1020	-53/1020	
				31.0–41.3	0.10–0.20		-53/3040	-53/1020	-53/1020	
				42.0–80.0	0.12–0.24		-53/3040	-53/1020	-53/1020	
	01.3	Non hardened 0,55–0,80% C	150–225	12.7–17.0	0.04–0.10	210 (170–275)	-53/3040	-53/1020	-53/1120	-53/1020
				17.5–25.4	0.06–0.14		-53/3040	-53/1020	-53/1020	T-53/1020
				26.0–30.0	0.08–0.18		-53/3040	-53/1020	-53/1020	
31.0–41.3				0.10–0.20	-53/3040		-53/1020	-53/1020		
42.0–80.0				0.12–0.24	-53/3040		-53/1020	-53/1020		
01.4	High carbon & carbon tool steel	180–275	12.7–17.0	0.04–0.10	210 (200–275)	-53/3040	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.06–0.14		-53/3040	-53/1020	-53/1020	T-53/1020	
			26.0–30.0	0.08–0.18		-53/3040	-53/1020	-53/1020		
			31.0–41.3	0.10–0.20		-53/3040	-53/1020	-53/1020		
			42.0–80.0	0.12–0.24		-53/3040	-53/1020	-53/1020		
02.1	Low alloy steel Non-hardened	150–260	12.7–17.0	0.04–0.10	220 (180–290)	-53/3040	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.06–0.12		-53/3040	-53/1020	-53/1020	T-53/1020	
			26.0–30.0	0.10–0.16		-53/3040	-53/1020	-53/1020		
			31.0–41.3	0.11–0.18		-53/3040	-53/1020	-53/1020		
			42.0–80.0	0.12–0.22		-53/3040	-53/1020	-53/1020		
02.2	Hardened	220–450	12.7–17.0	0.04–0.10	170 (90–230)	-53/3040	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.06–0.14		-53/3040	-53/1020	-53/1020	T-53/1020	
			26.0–30.0	0.10–0.18		-53/3040	-53/1020	-53/1020		
			31.0–41.3	0.10–0.20		-53/3040	-53/1020	-53/1020		
			42.0–80.0	0.12–0.24		-53/3040	-53/1020	-53/1020		
03.11	High alloy steel Annealed	50–250	12.7–17.0	0.04–0.08	180 (160–275)	-53/3040	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.04–0.14		-53/3040	-53/1020	-53/1020	T-53/1020	
			26.0–30.0	0.08–0.18		-53/3040	-53/1020	-53/1020		
			31.0–41.3	0.10–0.20		-53/3040	-53/1020	-53/1020		
			42.0–80.0	0.12–0.24		-53/3040	-53/1020	-53/1020		
03.21	Hardened steel	250–450	12.7–17.0	0.04–0.10	130 (80–200)	-53/3040	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.06–0.12		-53/3040	-53/1020	-53/1020	T-53/1020	
			26.0–30.0	0.10–0.16		-53/3040	-53/1020	-53/1020		
			31.0–41.3	0.11–0.18		-53/3040	-53/1020	-53/1020		
			42.0–80.0	0.12–0.22		-53/3040	-53/1020	-53/1020		
06.1	Steel castings Unalloyed	90–225	12.7–17.0	0.04–0.08	200 (140–310)	-53/3040	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.04–0.08		-53/3040	-53/1020	-53/1020	T-53/1020	
			26.0–30.0	0.05–0.10		-53/3040	-53/1020	-53/1020		
			31.0–41.3	0.06–0.12		-53/3040	-53/1020	-53/1020		
			42.0–80.0	0.07–0.14		-53/3040	-53/1020	-53/1020		
06.2	Low alloyed (alloying elements ≤ 5%)	150–250	12.7–17.0	0.04–0.10	160 (110–250)	-53/3040	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.06–0.12		-53/3040	-53/1020	-53/1020	T-53/1020	
			26.0–30.0	0.10–0.16		-53/3040	-53/1020	-53/1020		
			31.0–41.3	0.11–0.18		-53/3040	-53/1020	-53/1020		
			42.0–80.0	0.12–0.22		-53/3040	-53/1020	-53/1020		
M	05.11	Stainless steel Ferritic, Martensitic 13–25% Cr	150–270	12.7–17.0	0.04–0.10	170 (120–265)	53/3040	53/1020	53/1120	53/1020
				17.5–25.4	0.04–0.14		53/3040	53/1020	53/1020	
				26.0–30.0	0.08–0.18		53/3040	53/1020	53/1020	
				31.0–41.3	0.10–0.20		53/3040	53/1020	53/1020	
				42.0–80.0	0.12–0.24		53/3040	53/1020	53/1020	
	05.21	Austenitic Ni > 8% 13–25% Cr	150–275	12.7–17.0	0.04–0.10	150 (120–250)	53/3040	53/1020	53/1120	53/1020
				17.5–25.4	0.04–0.12		53/3040	53/1020	53/1020	
				26.0–30.0	0.08–0.14		53/3040	53/1020	53/1020	
				31.0–41.3	0.10–0.16		53/3040	53/1020	53/1020	
				42.0–80.0	0.11–0.18		53/3040	53/1020	53/1020	
05.51 05.52	Austenitic Ferritic (duplex)	180–320	12.7–17.0	0.04–0.10	110 (90–145)	53/3040	53/1020	53/1120	53/1020	
			17.5–25.4	0.04–0.12		53/3040	53/1020	53/1020		
			26.0–30.0	0.08–0.14		53/3040	53/1020	53/1020		
			31.0–41.3	0.10–0.16		53/3040	53/1020	53/1020		
			42.0–80.0	0.11–0.18		53/3040	53/1020	53/1020		

Insert positioning: C = Central  
P = Peripheral

**Wiper** -WM geometry for machining steel and cast iron with hardness < 200 HB in stable conditions, increase feed (f<sub>n</sub>) with 50%. For easy to machine stainless steels in stable conditions, increase feed (f<sub>n</sub>) with 25%.



## Coromant U indexable insert plunge drill

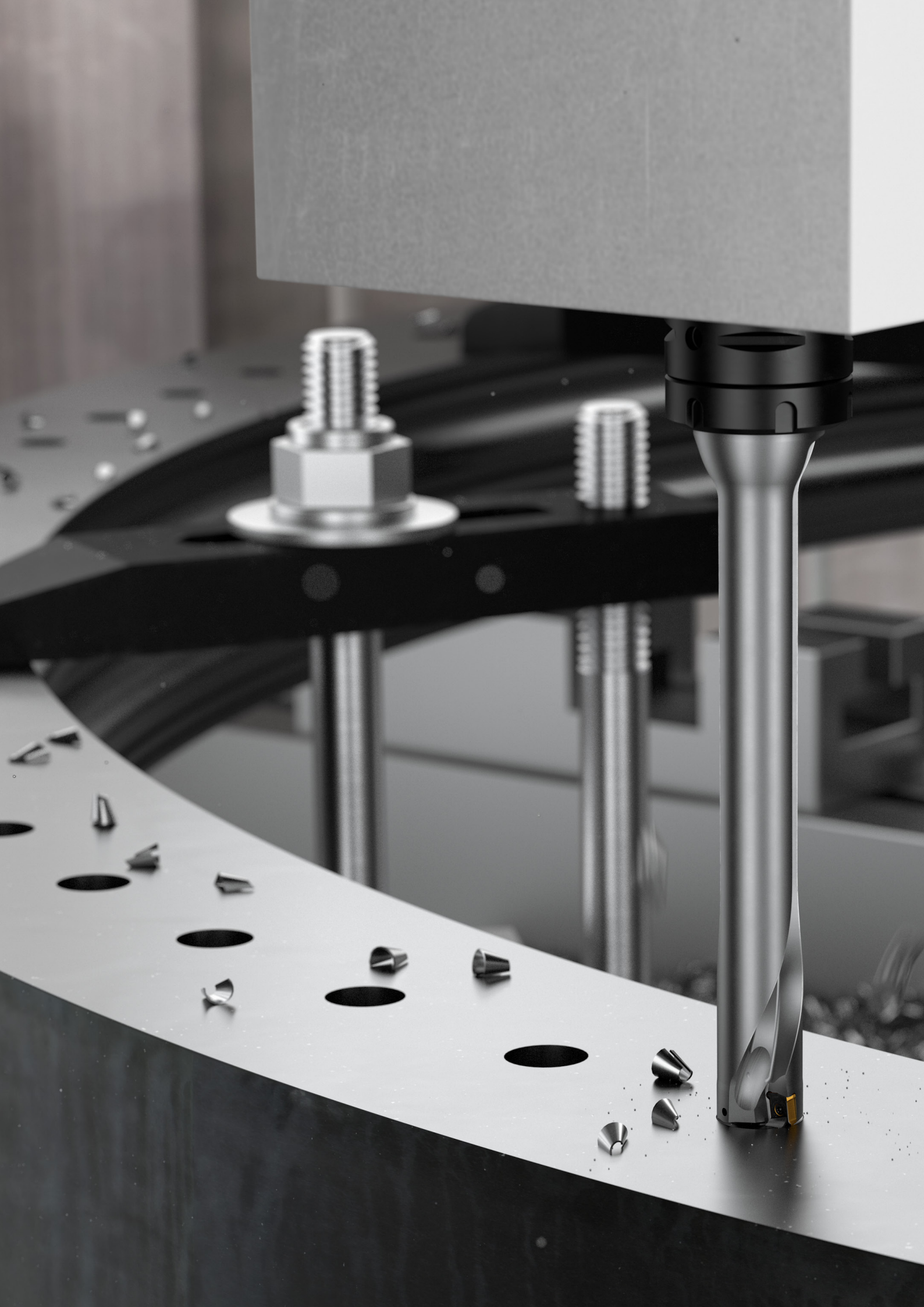
ISO	CMC No.	Material	Hardness Brinell HB	Drill dia DC mm	Feed $f_r$ mm/r	Speed $v_c$ m/min	Geometry / Grade			
							FIRST CHOICE Highest productivity		Complementary	
							P	C	P	C
M	15.21	Stainless steel Austenitic castings	150–250	12.7–17.0	0.04–0.08	110 (80–155)	-53/1120		-53/1120	-53/1020
				17.5–25.4	0.04–0.12			-53/1020	-53/1020	-53/1020
				26.0–30.0	0.05–0.12			-53/1020	-53/1020	-53/1020
				31.0–41.3	0.06–0.14			-53/1020	-53/1020	-53/1020
				42.0–80.0	0.06–0.14			-53/1020	-53/1020	-53/1020
S	20.21 20.22 20.24	Heat resistant alloys Ni based	140–425	12.7–17.0	0.03–0.08	50 (20–88)	-53/1120		-53/1120	-53/1020
				17.5–25.4	0.04–0.08			-53/1020	-53/1020	-53/1020
				26.0–30.0	0.06–0.10			-53/1020	-53/1020	-53/1020
				31.0–41.3	0.08–0.12			-53/1020	-53/1020	-53/1020
				42.0–80.0	0.09–0.14			-53/1020	-53/1020	-53/1020
	23.21 23.22	Titanium alloys $\alpha$ , near $\alpha$ and $\alpha+\beta$ alloys. Alloys in annealed or aged conditions	600–1500	12.7–17.0	0.04–0.10	60 (40–132)	-53/1120	-53/1020	-53/1120	-53/1020
				17.5–25.4	0.08–0.14		-53/H13A	-53/H13A	-53/H13A	-53/H13A
				26.0–30.0	0.12–0.16		-53/H13A	-53/H13A	-53/H13A	-53/H13A
				31.0–41.3	0.14–0.18		-53/H13A	-53/H13A	-53/H13A	-53/H13A
				42.0–80.0	0.16–0.20		-53/H13A	-53/H13A	-53/H13A	-53/H13A
K	07.1	Malleable cast iron Ferritic (short chipping)	110–145	12.7–17.0	0.04–0.14	170 (140–230)	-53/3040	-53/1020	-53/1120	-53/1020
				17.5–25.4	0.10–0.18			-53/1020	-53/1020	T-53/1020
				26.0–30.0	0.14–0.20			-53/1020	-53/1020	-53/1020
				31.0–41.3	0.16–0.26			-53/1020	-53/1020	-53/1020
	07.2	Pearlitic (long chipping)	150–270	12.7–17.0	0.04–0.10	140 (105–170)	-53/3040	-53/1020	-53/1120	-53/1020
				17.5–25.4	0.08–0.14			-53/1020	-53/1020	T-53/1020
				26.0–30.0	0.12–0.18			-53/1020	-53/1020	-53/1020
				31.0–41.3	0.14–0.20			-53/1020	-53/1020	-53/1020
	08.1	Grey cast iron Low tensile strength	150–220	12.7–17.0	0.04–0.14	250 (210–310)	-53/3040	-53/1020	-53/1120	-53/1020
				17.5–25.4	0.10–0.18			-53/1020	-53/1020	T-53/1020
				26.0–30.0	0.14–0.20			-53/1020	-53/1020	-53/1020
				31.0–41.3	0.16–0.26			-53/1020	-53/1020	-53/1020
	08.2	High tensile strength	200–330	12.7–17.0	0.04–0.10	170 (125–230)	-53/3040	-53/1020	-53/1120	-53/1020
				17.5–25.4	0.08–0.14			-53/1020	-53/1020	T-53/1020
26.0–30.0				0.12–0.18			-53/1020	-53/1020	-53/1020	
31.0–41.3				0.14–0.20			-53/1020	-53/1020	-53/1020	
09.1	Nodular cast iron Ferritic	125–230	12.7–17.0	0.04–0.10	170 (125–215)	-53/3040	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.08–0.14			-53/1020	-53/1020	T-53/1020	
			26.0–30.0	0.12–0.18			-53/1020	-53/1020	-53/1020	
			31.0–41.3	0.14–0.20			-53/1020	-53/1020	-53/1020	
09.2	Pearlitic	200–300	12.7–17.0	0.04–0.10	150 (110–200)	-53/3040	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.08–0.14			-53/1020	-53/1020	-53/1020	
			26.0–30.0	0.12–0.18			-53/1020	-53/1020	-53/1020	
			31.0–41.3	0.14–0.20			-53/1020	-53/1020	-53/1020	
H	04.1	Extra hard steel Hardened and tempered	450	12.7–17.0	0.05–0.08	40 (30–80)	-53/3040	-53/1020	-53/1020	-53/1020
N	30.12	Aluminium alloys Wrought or wrought and aged	30–150	12.7–17.0	0.04–0.12	350 (300–440)	-53/1120	-53/1020	-53/1120	-53/1020
30.21	Cast. non aging	40–100	17.5–25.4	0.06–0.16		-53/H13A	-53/H13A	-53/H13A	-53/H13A	
			26.0–30.0	0.10–0.18		-53/H13A	-53/H13A	-53/H13A	-53/H13A	
			31.0–41.3	0.12–0.22		-53/H13A	-53/H13A	-53/H13A	-53/H13A	
			42.0–80.0	0.14–0.26		-53/H13A	-53/H13A	-53/H13A	-53/H13A	
30.22	Cast or cast and aged	70–140	12.7–17.0	0.04–0.12	300 (250–385)	-53/1120	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.06–0.16			-53/H13A	-53/H13A	-53/H13A	-53/H13A
			26.0–30.0	0.10–0.18			-53/H13A	-53/H13A	-53/H13A	-53/H13A
			31.0–41.3	0.12–0.22			-53/H13A	-53/H13A	-53/H13A	-53/H13A
33.1	Copper and copper alloys Free cutting alloys (Pb $\geq$ 1%)	50–160	42.0–80.0	0.14–0.26		-53/H13A	-53/H13A	-53/H13A	-53/H13A	
			12.7–17.0	0.04–0.12	300 (250–385)	-53/1120	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.06–0.16			-53/H13A	-53/H13A	-53/H13A	-53/H13A
			26.0–30.0	0.10–0.18			-53/H13A	-53/H13A	-53/H13A	-53/H13A
31.0–41.3	0.12–0.22		-53/H13A	-53/H13A		-53/H13A	-53/H13A			
33.2	Brass and leaded alloys (Pb $\leq$ 1%)	50–160	42.0–80.0	0.14–0.26		-53/H13A	-53/H13A	-53/H13A	-53/H13A	
			12.7–17.0	0.04–0.12	230 (180–265)	-53/1120	-53/1020	-53/1120	-53/1020	
			17.5–25.4	0.06–0.16			-53/H13A	-53/H13A	-53/H13A	-53/H13A
			26.0–30.0	0.10–0.18			-53/H13A	-53/H13A	-53/H13A	-53/H13A
31.0–41.3	0.12–0.22		-53/H13A	-53/H13A		-53/H13A	-53/H13A			

Insert positioning:

C = Central

P = Peripheral







# Boring

Rough boring	K3
CoroBore® BR10	K4
CoroBore® BR20	K6
CoroBore® BR30	K17
CoroBore® 820 XL	K23
Fine boring	K34
391.37A/B boring bars and fine boring head	K38
CoroBore® 824	K35
CoroBore® 825	K43
CoroBore® 826	K44
CoroBore® 825 XL	K53
CoroBore® 826 XL	K53
Face grooving	K66
CoroCut® MB adaptor	K67
CoroBore® 825 SL	K68
SpiroGrooving™	K71
Interpolation turning	K74
Adaptors	K76
CoroBore® cartridges for boring	K78

# How to choose your boring tool

## Identify tool concepts

- 1
  - Define type of application
  - Identify your application type: roughing, finishing or face grooving. Note characteristics regarding the hole to be machined, limitations, material and the machine.
  - Select a boring system
  - Identify your operation type: multi-edge boring, single-edge boring, step-boring, backboring or external boring to find available diameter ranges and required accessories.

**Note: Always try to use the largest applicable coupling. Remember to calculate the power and torque consumption of the application.**

## Select your insert

- 2
  - Choose the inserts depending on your hole requirements: define entering angle and insert type. Dedicated boring inserts can be found here in the boring chapter. ISO inserts are found in the general turning chapter of the Turning tools catalogue.
  - For information regarding start recommendations and insert recommendations for boring operations see page K91.

## Selection of tooling systems components

- 3
  - If needed, find the complete selection of machine interface adaptors, extensions and reductions to build your modular assembly, see page L2.
  - Always try to keep the tools as short as possible.

## Boring tool components

- Included parts and additional components can be found at [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

## Accessories and spare parts

- Related accessories and spare parts to all boring tool families can be found at [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

# How to choose a face grooving tool

## Select your tool

- 1
  - The tool assembly without SL head and insert is chosen depending on your requirements of diameter and machine side coupling.

## Selection of SL heads

- 2
  - Identify SL heads for face grooving:
  - The first cut diameter of the SL head needs to correspond to the diameter of the face grooving application.
  - The width of the groove will influence the choice of SL heads and inserts.
  - Use only SL heads with machine side interface SL32, left-hand, A-curved.
  - The SL head dimension LF=18 mm grants maximum diameter according to tool kit code. LF=14 mm reduces the diameter range of face grooving tool with 8 mm.
  - See CoroCut 1-2 in the Turning tools catalogue for SL head assortment.

## Selection of inserts

- 3
  - Choose between CoroCut 1-2 system inserts. See Turning tools catalogue.

## Rough boring

	Tool concept	Diameter range, mm	Hole tolerance	Cutting edges	Operation	Insert choice	Machine side interface	Page
 <p>CoroBore® BR10</p>	Conventional	32-170	IT9	1	- Single edge back-boring	- CoroTurn® 107	- Coromant Capto® - Coromant EH	K4-K5
 <p>CoroBore® BR20</p>	Conventional	23-150	IT9	2	- Single edge back-boring - Boring - Step boring - Single edge boring	- CoroTurn® 107 - T-Max® P - CoroBore® 111	- Coromant Capto® - Coromant EH	K6-K10
	Damped	23-150	IT9	2	- Boring - Step boring - Single edge boring	- CoroTurn® 107 - CoroBore® 111	- Coromant Capto®	K14
 <p>CoroBore® BR30</p>	Conventional	35-214	IT9	3	- Boring - Step boring - Single edge boring	- CoroTurn® 107 - T-Max® P - CoroBore® 111	- Coromant Capto®	K17-K21
<p>Cavity boring</p> 	Conventional	85-205	IT9	4,6,8	- Boring - Step boring	- CoroTurn® 107* - CoroBore® 111	- Coromant Capto®	K22
 <p>CoroBore® 820 XL</p>	Conventional	148-300 (350**)	IT9	2	- Boring - Step boring - Single edge boring	- CoroTurn® 107 - T-Max® P - CoroBore® 111	- Coromant Capto®	K24-K25
		298-1260					- 40X with 4 bolt circle	K28-K31
	Lightweight	148-300	IT9	2	- Boring - Step boring - Single edge boring	- CoroTurn® 107 - CoroBore® 111	- 40S with 4 bolt circle	K26
	Damped	148-300	IT9	2	- Boring - Step boring - Single edge boring	- CoroTurn® 107 - CoroBore® 111	- A33 damped adaptor	K27

\*Not included in kit, components to be ordered separately

\*\*Components to be ordered separately

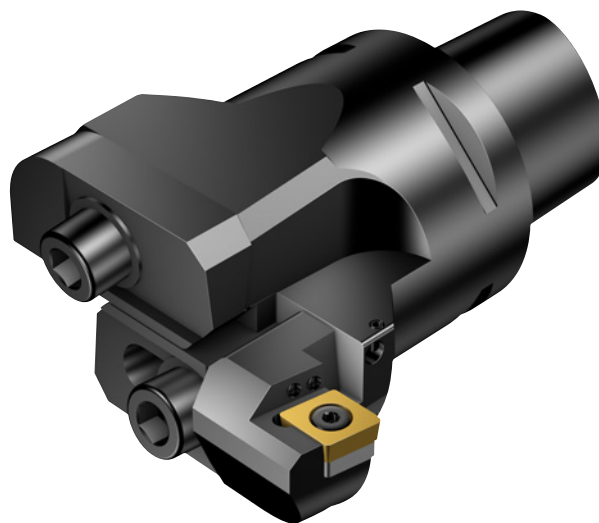
# CoroBore® BR10

## Single-edge back boring tools

### Application

- Rough boring
- Back boring

### ISO application area:



### Benefits and features

- Laser-marked scale on adaptor for increased user-friendliness when setting diameter
- Possibility to easily be assembled as a twin edge boring tool, using BR20 slides
- Coolant nozzles with high precision capability built into slide for precise coolant direction
- Cutting fluid through the tool for good chip evacuation
- Modularity with Coromant Capto® and Coromant EH

[www.sandvik.coromant.com/coroborebr10](http://www.sandvik.coromant.com/coroborebr10)

### Tools

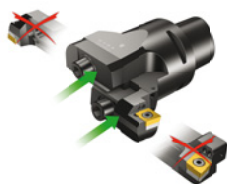
#### Couplings:

- Coromant Capto®
- Coromant EH

### Inserts

- Standard CoroTurn® 107 inserts with a wide selection of grades and geometries for all materials.

The back boring tool is based on the CoroBore® BR20 adaptor together with a unique back boring slide and cover.



Available as complete back boring assembly kit or separate back boring slide and cover as additional items.

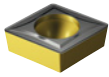
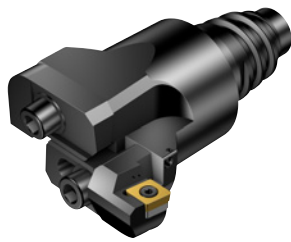


# CoroBore® BR10 rough boring tool for back-boring

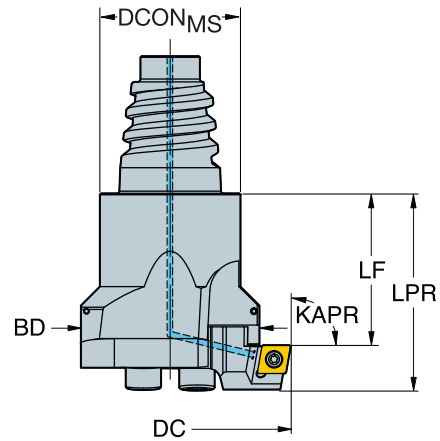
Coromant EH - Internal coolant supply

KAPR




90°



-  CCMT, CCGT  
CCGX, CCET
-  CCMW



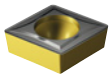
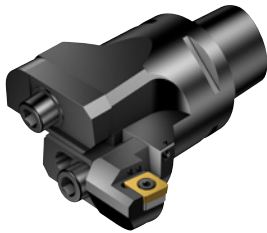
Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	LPR	BD <sub>1</sub>			CICT	MIID
32.00	38.00	06	E20	1	BR10-38CC06F-EH20	19.30	3.00	15.00	25.00	20.00	70	0.070	1	CCMT 06 02 04
37.00	45.00	06	E25	1	BR10-45CC06F-EH25	24.20	4.00	14.00	24.00	24.00	70	0.110	1	CCMT 06 02 04

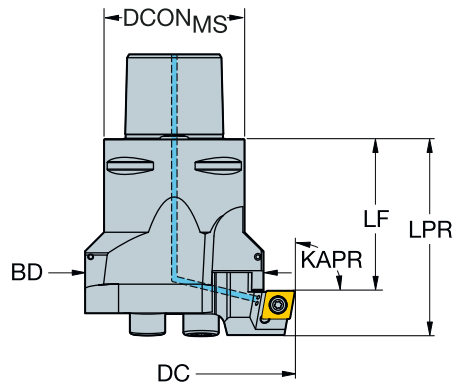
Coromant Capto® - Internal coolant supply

KAPR




90°



-  CCMT, CCGT  
CCGX, CCET
-  CCMW



Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	LPR	BD <sub>1</sub>			CICT	MIID
44.00	54.00	06	C3	3	BR10-54CC06F-C3	32.00	5.00	35.00	45.00	30.00	70	0.560	1	CCMT 06 02 04
53.00	65.00	06	C4	3	BR10-65CC06F-C4	40.00	6.00	43.00	53.00	39.00	70	0.560	1	CCMT 06 02 04
64.00	76.00	09	C4	3	BR10-76CC09F-C4	40.00	6.00	43.00	58.00	39.00	70	0.560	1	CCMT 09 T3 08
75.00	91.00	12	C5	3	BR10-91CC12F-C5	50.00	8.00	48.00	68.00	50.00	70	0.860	1	CCMT 12 04 08
90.00	110.00	12	C5	3	BR10-110CC12F-C5	50.00	10.00	50.00	70.00	63.00	70	1.230	1	CCMT 12 04 08
109.00	136.00	12	C6	3	BR10-136CC12F-C6	63.00	13.50	68.00	88.00	82.00	70	2.080	1	CCMT 12 04 08
135.00	170.00	12	C6	3	BR10-170CC12F-C6	63.00	17.50	78.00	98.00	108.00	70	2.380	1	CCMT 12 04 08

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



L2



M1



N23



N15

# CoroBore® BR20

Twin-edge rough boring tools for flexible boring

## Application

- Rough boring
- Twin-edge boring
- Step boring
- Back boring
- Single edge boring

ISO application area:



## Benefits and features

- Laser-marked scale on adaptor for increased user-friendliness when setting diameter
- Possibility to easily be assembled as a back boring tool, using a unique slide and cover
- Built-in step boring functionality without any additional need of an extra shim
- Differential pitch reduces vibration tendencies - tools can be used at longer overhangs and larger depth of cuts
- Dedicated four-edged inserts with grades optimized for rough boring
- Coolant nozzles with high precision capability built into slide for precise coolant direction.
- Cutting fluid through the tool for good chip evacuation
- Also available as damped boring tool assortment

[www.sandvik.coromant.com/coroborebr20](http://www.sandvik.coromant.com/coroborebr20)

## Tools

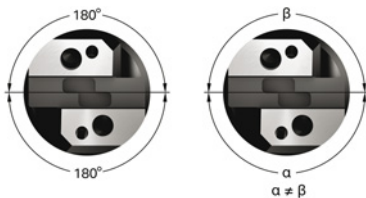
Couplings:

- Coromant Capto®
- Coromant EH

## Inserts

Standard inserts with dedicated grades and geometries for all materials

- CoroBore® 111
- CoroTurn® 107



The differential pitch reduces vibration tendencies – tools can be used at longer overhangs and larger depth of cuts.



Dedicated CoroBore® 111 rough boring inserts. With excellent chip breaking and increased lifetime.



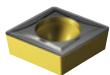
●●●● SilentTools®

Problem-solver when working with long overhangs. When using Silent Tools™, you have the opportunity to double the depth of cut, while maintaining productive boring.

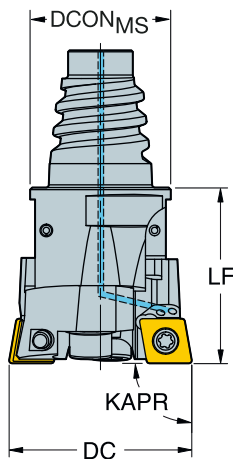
# CoroBore® BR20 twin-edge rough boring tool




Coromant EH - Internal coolant supply

KAPR 90°



-  CCMT, CCGT  
CCGX, CCET
-  CCMW



					Dimensions, mm							
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF			CICT	MIID
23.00	29.00	06	E20	1	BR20-29CC06F-EH20	19.30	3.00	25.00	70	0.070	2	CCMT 06 02 04
28.00	36.00	06	E25	1	BR20-36CC06F-EH25	24.20	4.00	25.00	70	0.110	2	CCMT 06 02 04

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)  
 For inserts, see Turning tools catalogue



L2



M1



N23



N15

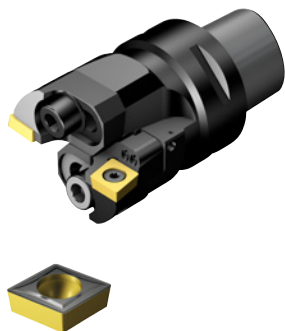


K85



# CoroBore® BR20 twin-edge rough boring tool

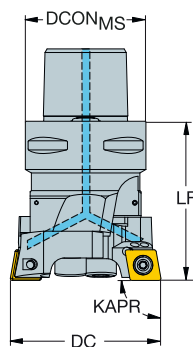
Coromant Capto® - Internal coolant supply



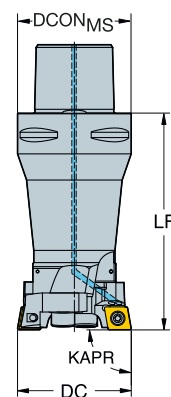
- CCMT, CCGT  
CCGX, CCET
- CCMW

KAPR  
DSGN

90°  
1



90°  
2



K

							Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	DSGN	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	ULDR	LF	BD <sub>1</sub>			CICT	MIID	
23.00	29.00	06	C3	3	2	BR20-29CC06F-C3	32.00	3.00	2.00	76.00	20.00	70	0.260	2	CCMT 06 02 04	
28.00	36.00	06	C3	3	2	BR20-36CC06F-C3	32.00	4.00	2.00	83.00	24.00	70	0.360	2	CCMT 06 02 04	
35.00	45.00	09	C3	3	1	BR20-45CC09F-C3	32.00	5.00		48.00		70	0.270	2	CCMT 09 T3 08	
35.00	45.00	09	C4	3	2	BR20-45CC09F-C4	40.00	5.00	1.50	83.00	30.00	70	0.560	2	CCMT 09 T3 08	
44.00	56.00	09	C4	3	1	BR20-56CC09F-C4	40.00	6.00		56.00		70	0.480	2	CCMT 09 T3 08	
44.00	56.00	09	C5	3	2	BR20-56CC09F-C5	50.00	6.00	1.50	98.00	39.00	70	1.030	2	CCMT 09 T3 08	
55.00	71.00	12	C5	3	1	BR20-71CC12F-C5	50.00	8.00		66.00		70	0.860	2	CCMT 12 04 08	
55.00	71.00	12	C6	3	2	BR20-71CC12F-C6	63.00	8.00	1.50	120.00	50.00	70	1.940	2	CCMT 12 04 08	
70.00	90.00	12	C5	3	1	BR20-90CC12F-C5	50.00	10.00		70.00		70	1.230	2	CCMT 12 04 08	
70.00	90.00	12	C6	3	1	BR20-90CC12F-C6	63.00	10.00		78.00		70	1.580	2	CCMT 12 04 08	
89.00	116.00	12	C6	3	1	BR20-116CC12F-C6	63.00	13.50		90.00		70	2.080	2	CCMT 12 04 08	
89.00	116.00	12	C8	3	1	BR20-116CC12F-C8	80.00	13.50		94.00		70	2.990	2	CCMT 12 04 08	
115.00	150.00	12	C6	3	1	BR20-150CC12F-C6	63.00	17.50		90.00		70	2.380	2	CCMT 12 04 08	
115.00	150.00	12	C8	3	1	BR20-150CC12F-C8	80.00	17.50		100.00		70	3.630	2	CCMT 12 04 08	

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC\*ULDR

M

N



L2



M1



N23



N15



K85

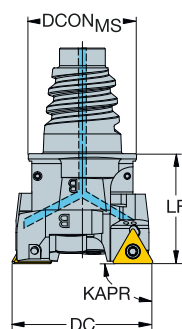




# CoroBore® BR20 twin-edge rough boring tool




Coromant EH - Internal coolant supply

KAPR

90°



-  TCMT, TCMX, TCGT, TCGX, TCEX
-  TCMW

					Dimensions, mm							
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJL <sub>RDL</sub>	LF			CICT	MIID
28.00	36.00	09	E25	1	BR20-36TC09F-EH25	24.20	4.00	25.00	70	0.130	2	TCMT 09 02 04

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



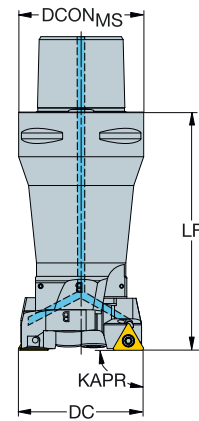
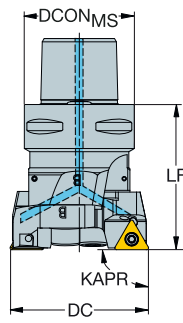
# CoroBore® BR20 twin-edge rough boring tool

Coromant Capto® - Internal coolant supply

KAPR  
DSGN

90°  
1

90°  
2



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

										Dimensions, mm						
DCN	DCX		CZC <sub>1MS</sub>	CNSC	DSGN	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	ULDR	LF	BD <sub>1</sub>			CICT	MIID	
28.00	36.00	09	C3	3	2	BR20-36TC09F-C3	32.00	4.00	2.00	83.00	24.00	70	0.380	2	TCMT 09 02 04	
35.00	45.00	11	C3	3	1	BR20-45TC11F-C3	32.00	5.00		48.00		70	0.270	2	TCMT 11 03 04	
44.00	56.00	11	C4	3	1	BR20-56TC11F-C4	40.00	6.00		56.00		70	0.500	2	TCMT 11 03 04	
55.00	71.00	16	C5	3	1	BR20-71TC16F-C5	50.00	8.00		66.00		70	0.860	2	TCMT 16 T3 08	
70.00	90.00	16	C5	3	1	BR20-90TC16F-C5	50.00	10.00		70.00		70	1.250	2	TCMT 16 T3 08	
70.00	90.00	16	C6	3	1	BR20-90TC16F-C6	63.00	10.00		78.00		70	1.600	2	TCMT 16 T3 08	
89.00	116.00	16	C6	3	1	BR20-116TC16F-C6	63.00	13.50		90.00		70	2.100	2	TCMT 16 T3 08	
115.00	150.00	16	C8	3	1	BR20-150TC16F-C8	80.00	17.50		100.00		70	3.650	2	TCMT 16 T3 08	

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC\*ULDR

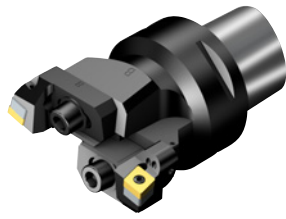


# CoroBore® BR20 twin-edge rough boring tool

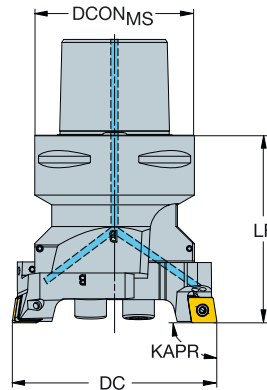
Coromant Capto® - Internal coolant supply

KAPR

90°



CNMU



					Dimensions, mm							
DCN	DCX	CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF			CICT	MIID	
70.00	90.00	12	C6	BR20-90CN12F-C6	63.00	10.00	78.00	70	2.200	2	CNMU 12 04 12	
89.00	116.00	12	C8	BR20-116CN12F-C8	80.00	13.50	94.00	70	2.900	2	CNMU 12 04 12	
115.00	150.00	12	C8	BR20-150CN12F-C8	80.00	17.50	100.00	70	3.690	2	CNMU 12 04 12	

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

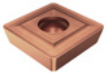
For inserts, see Turning tools catalogue



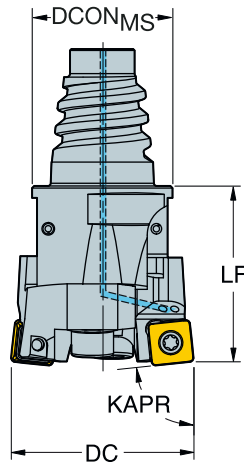
# CoroBore® BR20 twin-edge rough boring tool

Coromant EH - Internal coolant supply

KAPR 84°



SPMT



K

					Dimensions, mm								
DCN	DCX	CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF			CICT	MIID		
23.00	29.00	06	E20	1	BR20-29SP06Y-EH20	19.30	3.00	25.00	70	0.070	2	SPMT 0606-BM	
28.00	36.00	06	E25	1	BR20-36SP06Y-EH25	24.20	4.00	25.00	70	0.110	2	SPMT 0606-BM	

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L

M

N



# CoroBore® BR20 twin-edge rough boring tool

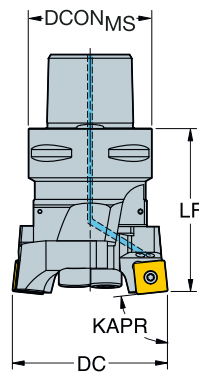
Coromant Capto® - Internal coolant supply



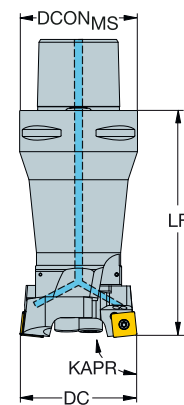
SPMT

KAPR  
DSGN

84°  
1



84°  
2



		Dimensions, mm													
DCN	DCX	CZC <sub>MS</sub>	CNSC	DSGN	Ordering code	DCON <sub>MS</sub>	ADJL <sub>RDL</sub>	ULDR	LF	BD <sub>1</sub>	BAR	KG	CICT	MIID	
23.00	29.00	06	C3	3	2	BR20-29SP06Y-C3	32.00	3.00	2.00	76.00	20.00	70	0.260	2	SPMT 0606-BM
28.00	36.00	06	C3	3	2	BR20-36SP06Y-C3	32.00	4.00	2.00	83.00	24.00	70	0.360	2	SPMT 0606-BM
35.00	45.00	08	C3	3	1	BR20-45SP08Y-C3	32.00	5.00		48.00		70	0.270	2	SPMT 0808-BM
35.00	45.00	08	C4	3	2	BR20-45SP08Y-C4	40.00	5.00	1.50	83.00	30.00	70	0.560	2	SPMT 0808-BM
44.00	56.00	08	C4	3	1	BR20-56SP08Y-C4	40.00	6.00		56.00		70	0.480	2	SPMT 0808-BM
44.00	56.00	08	C5	3	2	BR20-56SP08Y-C5	50.00	6.00	1.50	98.00	39.00	70	1.030	2	SPMT 0808-BM
55.00	71.00	12	C5	3	1	BR20-71SP12Y-C5	50.00	8.00		66.00		70	0.860	2	SPMT 1210-BM
55.00	71.00	12	C6	3	2	BR20-71SP12Y-C6	63.00	8.00	1.50	120.00	50.00	70	1.940	2	SPMT 1210-BM
70.00	90.00	12	C5	3	1	BR20-90SP12Y-C5	50.00	10.00		70.00		70	1.230	2	SPMT 1210-BM
70.00	90.00	12	C6	3	1	BR20-90SP12Y-C6	63.00	10.00		78.00		70	1.580	2	SPMT 1210-BM
89.00	116.00	12	C6	3	1	BR20-116SP12Y-C6	63.00	13.50		90.00		70	2.080	2	SPMT 1210-BM
89.00	116.00	12	C8	3	1	BR20-116SP12Y-C8	80.00	13.50		94.00		70	2.990	2	SPMT 1210-BM
115.00	150.00	12	C6	3	1	BR20-150SP12Y-C6	63.00	17.50		90.00		70	2.380	2	SPMT 1210-BM
115.00	150.00	12	C8	3	1	BR20-150SP12Y-C8	80.00	17.50		100.00		70	3.630	2	SPMT 1210-BM

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For all DSGN 2; LU = DC\*ULDR



K32



L2



M1



N23



N15



K85

# CoroBore® BR20 twin-edge damped rough boring tool

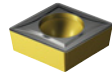
Coromant Capto® - Internal coolant supply

KAPR  
DSGN

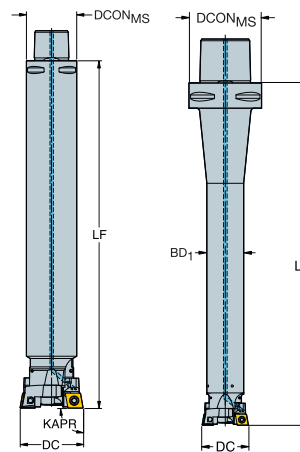
90°  
1

90°  
2

●●●● SilentTools®



- CCMT, CCGT  
CCGX, CCET
- CCMW



Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	DSGN	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	ULDR	LF	BD <sub>1</sub>			CICT	MIID
23.00	29.00	06	C4	3	2	BR20D-29CC06F-C4L	40.00	3.00	6.00	199.00	20.00	70	0.740	2	CCMT 06 02 04
28.00	36.00	06	C3	3	2	BR20D-36CC06F-C3L	32.00	4.00	6.00	216.00	25.00	70	1.030	2	CCMT 06 02 04
35.00	45.00	09	C3	3	1	BR20D-45CC09F-C3L	32.00	5.00	6.00	221.00	70	70	1.540	2	CCMT 09 T3 08
35.00	45.00	09	C4	3	2	BR20D-45CC09F-C4L	40.00	5.00	6.00	270.00	32.00	70	1.980	2	CCMT 09 T3 08
35.00	45.00	09	C6	3	2	BR20D-45CC09F-C6L	63.00	5.00	6.00	297.00	32.00	70	2.620	2	CCMT 09 T3 08
44.00	56.00	09	C4	3	1	BR20D-56CC09F-C4L	40.00	6.00	6.00	220.00	70	70	2.380	2	CCMT 09 T3 08
44.00	56.00	09	C5	3	2	BR20D-56CC09F-C5L	50.00	6.00	6.00	336.00	40.00	70	3.720	2	CCMT 09 T3 08
44.00	56.00	09	C6	3	2	BR20D-56CC09F-C6L	63.00	6.00	6.00	363.00	40.00	70	4.350	2	CCMT 09 T3 08
55.00	71.00	12	C5	3	1	BR20D-71CC12F-C5M	50.00	8.00	5.60	300.00	70	70	5.080	2	CCMT 12 04 08
55.00	71.00	12	C6	3	2	BR20D-71CC12F-C6M	63.00	8.00	5.60	400.00	50.00	70	6.940	2	CCMT 12 04 08
70.00	90.00	12	C6	3	1	BR20D-90CC12F-C6M	63.00	10.00	5.60	400.00	70	70	9.910	2	CCMT 12 04 08
70.00	90.00	12	C8	3	2	BR20D-90CC12F-C8M	80.00	10.00	5.60	500.00	63.00	70	12.660	2	CCMT 12 04 08
89.00	116.00	12	C8	3	1	BR20D-116CC12F-C8M	80.00	13.50	5.60	500.00	70	70	18.490	2	CCMT 12 04 08
89.00	116.00	12	C8	3	1	BR20D-116CC12F-C8S	80.00	13.50	5.60	410.00	70	70	16.140	2	CCMT 12 04 08
115.00	150.00	12	C8	3	1	BR20D-150CC12F-C8M	80.00	17.50	5.60	500.00	70	70	18.620	2	CCMT 12 04 08

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC\*ULDR



L2



M1



N23



N15



K85

# CoroBore® BR20 twin-edge damped rough boring tool

Coromant Capto® - Internal coolant supply

KAPR  
DSGN

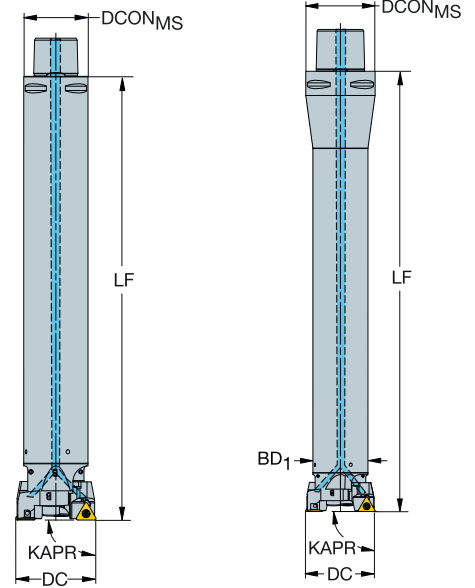
90°  
1

90°  
2

●●● SilentTools®



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



							Dimensions, mm								
DCN	DCX		CZC <sub>MS</sub>	CNSC	DSGN	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	ULDR	LF	BD <sub>1</sub>			CICT	MIID
28.00	36.00	09	C3	3	2	BR20D-36TC09F-C3L	32.00	4.00	6.00	216.00	25.00	70	1.718	2	TCMT 09 02 04
35.00	45.00	11	C3	3	1	BR20D-45TC11F-C3L	32.00	5.00		221.00		70	2.330	2	TCMT 11 03 04
35.00	45.00	11	C4	3	2	BR20D-45TC11F-C4L	40.00	5.00	6.00	270.00	32.00	70	1.980	2	TCMT 11 03 04
44.00	56.00	11	C4	3	1	BR20D-56TC11F-C4L	40.00	6.00		220.00		70	2.400	2	TCMT 11 03 04
44.00	56.00	11	C5	3	2	BR20D-56TC11F-C5L	50.00	6.00	6.00	336.00	40.00	70	5.740	2	TCMT 11 03 04
55.00	71.00	16	C5	3	1	BR20D-71TC16F-C5M	50.00	8.00		300.00		70	5.080	2	TCMT 16 T3 08
70.00	90.00	16	C6	3	1	BR20D-90TC16F-C6M	63.00	10.00		400.00		70	9.930	2	TCMT 16 T3 08
89.00	116.00	16	C8	3	1	BR20D-116TC16F-C8M	80.00	13.50		500.00		70	22.085	2	TCMT 16 T3 08
89.00	116.00	16	C8	3	1	BR20D-116TC16F-C8S	80.00	13.50		410.00		70	16.160	2	TCMT 16 T3 08
115.00	150.00	16	C8	3	1	BR20D-150TC16F-C8M	80.00	17.50		500.00		70	23.200	2	TCMT 16 T3 08

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For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC\*ULDR



L2



M1



N23



N15



K85



# CoroBore® BR20 twin-edge damped rough boring tool

Coromant Capto® - Internal coolant supply

KAPR  
DSGN

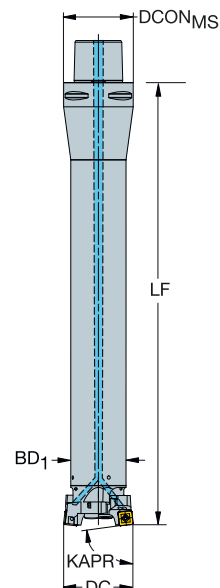
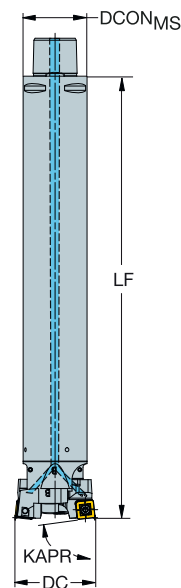
84°  
1




84°  
2

●●● SilentTools®



SPMT



						Dimensions, mm										
DCN	DCX		CZC1MS	CNSC	DSGN	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	ULDR	LF	BD <sub>1</sub>			CICT	MIID	
23.00	29.00	06	C4	3	2	BR20D-29SP06Y-C4L	40.00	3.00	6.00	199.00	20.00	70	0.740	2	SPMT 0606-BM	
28.00	36.00	06	C3	3	2	BR20D-36SP06Y-C3L	32.00	4.00	6.00	216.00	25.00	70	1.030	2	SPMT 0606-BM	
35.00	45.00	08	C3	3	1	BR20D-45SP08Y-C3L	32.00	5.00		221.00		70	2.330	2	SPMT 0808-BM	
35.00	45.00	08	C4	3	2	BR20D-45SP08Y-C4L	40.00	5.00	6.00	270.00	32.00	70	4.500	2	SPMT 0808-BM	
35.00	45.00	08	C6	3	2	BR20D-45SP08Y-C6L	63.00	5.00	6.00	297.00	32.00	70	2.630	2	SPMT 0808-BM	
44.00	56.00	08	C4	3	1	BR20D-56SP08Y-C4L	40.00	6.00		220.00		70	5.120	2	SPMT 0808-BM	
44.00	56.00	08	C5	3	2	BR20D-56SP08Y-C5L	50.00	6.00	6.00	336.00	40.00	70	3.720	2	SPMT 0808-BM	
44.00	56.00	08	C6	3	1	BR20D-56SP08Y-C6L	63.00	6.00	6.00	363.00	40.00	70	4.350	2	SPMT 0808-BM	
55.00	71.00	12	C5	3	1	BR20D-71SP12Y-C5M	50.00	8.00		300.00		70	7.672	2	SPMT 1210-BM	
55.00	71.00	12	C6	3	2	BR20D-71SP12Y-C6M	63.00	8.00	5.60	400.00	50.00	70	6.940	2	SPMT 1210-BM	
70.00	90.00	12	C6	3	1	BR20D-90SP12Y-C6M	63.00	10.00		400.00		70	12.000	2	SPMT 1210-BM	
70.00	90.00	12	C8	3	2	BR20D-90SP12Y-C8M	80.00	10.00	5.60	500.00	63.00	70	16.183	2	SPMT 1210-BM	
89.00	116.00	12	C8	3	1	BR20D-116SP12Y-C8M	80.00	13.50		500.00		70	22.125	2	SPMT 1210-BM	
89.00	116.00	12	C8	3	1	BR20D-116SP12Y-C8S	80.00	13.50		410.00		70	16.140	2	SPMT 1210-BM	
115.00	150.00	12	C8	3	1	BR20D-150SP12Y-C8M	80.00	17.50		500.00		70	18.620	2	SPMT 1210-BM	

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For all DSGN 2; LU = DC\*ULDR



L2



M1



N23



N15



K85



# CoroBore® BR30

Multi-edge rough boring tools for maximum productivity

## Application

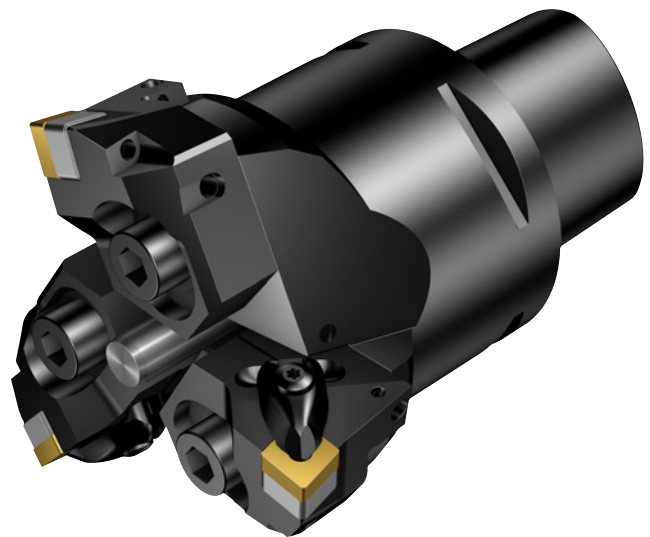
- Rough boring
- Multi-edge boring
- Step boring
- Single edge boring

## ISO application area



## Benefits and features

- Highly productive multi cutting edge tool for maximum metal removal rate.
- Laser-marked scale on adaptor for increased user-friendliness when setting diameter.
- Modularity with Coromant Capto® .
- High pressure coolant through adaptor
- Step boring: Additional shims available, to be ordered separately
- Short, rigid and compact giving maximum stability



[www.sandvik.coromant.com/coroborebr30](http://www.sandvik.coromant.com/coroborebr30)

## Tools

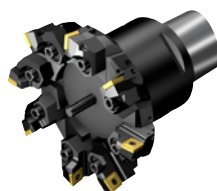
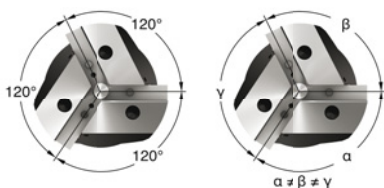
Couplings:

- Coromant Capto®

## Inserts

Standard inserts with dedicated grades and geometries for all materials

- CoroBore® 111
- CoroTurn® 107
- T-max® P



The differential pitch reduces vibration tendencies – tools can be used at longer overhangs and larger depth of cuts.

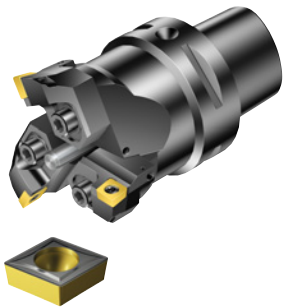
From diameter 85 to 205 mm, CoroBore® BR30 is available with up to 8 cutting edges for maximum metal removal rate.

If no pre-setter is available, adjust diameter of CoroBore BR30 by measuring the distance from pin to insert and subtract half the pin diameter. Multiply by two for the effective boring diameter.

Dedicated CoroBore® 111 rough boring inserts. With excellent chip breaking and increased lifetime.

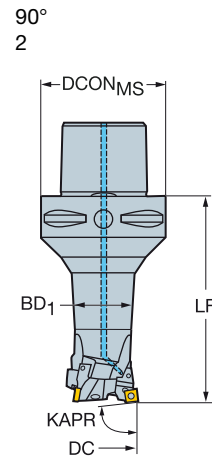
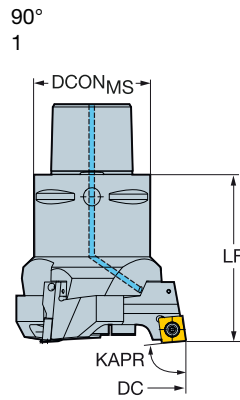
# CoroBore® BR30 three-edge rough boring tool

Coromant Capto® - Internal coolant supply



- CCMT, CCGT  
CCGX, CCET
- CCMW

KAPR  
DSGN



K

							Dimensions, mm								
DCN	DCX		CZC <sub>MS</sub>	CNSC	DSGN	Ordering code	DCN <sub>MS</sub>	ADJLX <sub>RDL</sub>	ULDR	LF	BD <sub>1</sub>			CICT	MID
35.00	40.50	06	C3	3	1	BR30-41CC06F-C3	32.00	2.75		48.00	70	0.250	3	CCMT 06 02 04	
35.00	40.50	06	C4	3	2	BR30-41CC06F-C4	40.00	2.75	1.50	83.00	31.50	70	0.640	3	CCMT 06 02 04
39.50	45.00	06	C3	3	1	BR30-45CC06F-C3	32.00	2.75		48.00	70	0.280	3	CCMT 06 02 04	
39.50	45.00	06	C4	3	2	BR30-45CC06F-C4	40.00	2.75	1.50	83.00	31.50	70	0.670	3	CCMT 06 02 04
44.00	50.50	06	C4	3	1	BR30-51CC06F-C4	40.00	3.25		56.00	70	0.620	3	CCMT 06 02 04	
44.00	50.50	06	C5	3	2	BR30-51CC06F-C5	50.00	3.25	1.50	98.00	39.60	70	1.180	3	CCMT 06 02 04
49.50	56.00	06	C4	3	1	BR30-56CC06F-C4	40.00	3.25		56.00	70	0.650	3	CCMT 06 02 04	
49.50	56.00	09	C4	3	1	BR30-56CC09F-C4	40.00	3.25		58.00	70	0.641	3	CCMT 09 T3 08	
49.50	56.00	06	C5	3	2	BR30-56CC06F-C5	50.00	3.25	1.50	98.00	39.60	70	1.210	3	CCMT 06 02 04
49.50	56.00	09	C5	3	2	BR30-56CC09F-C5	50.00	3.25	1.50	100.00	39.60	70	1.240	3	CCMT 09 T3 08
55.00	63.00	09	C5	3	1	BR30-63CC09F-C5	50.00	4.00		66.00	70	0.890	3	CCMT 09 T3 08	
55.00	63.00	09	C6	3	2	BR30-63CC09F-C6	63.00	4.00	1.50	120.00	49.50	70	1.980	3	CCMT 09 T3 08
62.00	70.00	09	C5	3	1	BR30-70CC09F-C5	50.00	4.00		66.00	70	0.920	3	CCMT 09 T3 08	
62.00	70.00	12	C5	3	1	BR30-70CC12F-C5	50.00	4.00		68.00	70	0.980	3	CCMT 12 04 08	
62.00	70.00	09	C6	3	2	BR30-70CC09F-C6	63.00	4.00	1.50	120.00	49.50	70	2.312	3	CCMT 09 T3 08
62.00	70.00	12	C6	3	2	BR30-70CC12F-C6	63.00	4.00	1.50	122.00	49.50	70	2.070	3	CCMT 12 04 08
69.00	78.50	12	C5	3	1	BR30-79CC12F-C5	50.00	4.75		70.00	70	1.180	3	CCMT 12 04 08	
69.00	78.50	12	C6	3	1	BR30-79CC12F-C6	63.00	4.75		78.00	70	2.130	3	CCMT 12 04 08	
77.50	87.00	12	C5	3	1	BR30-87CC12F-C5	50.00	4.75		70.00	70	1.210	3	CCMT 12 04 08	
77.50	87.00	12	C6	3	1	BR30-87CC12F-C6	63.00	4.75		78.00	70	1.967	3	CCMT 12 04 08	
86.00	97.00	12	C6	3	1	BR30-97CC12F-C6	63.00	5.50		90.00	70	2.280	3	CCMT 12 04 08	
86.00	97.00	12	C8	3	1	BR30-97CC12F-C8	80.00	5.50		94.00	70	3.300	3	CCMT 12 04 08	
96.00	107.00	12	C6	3	1	BR30-107CC12F-C6	63.00	5.50		90.00	70	2.340	3	CCMT 12 04 08	
96.00	107.00	12	C8	3	1	BR30-107CC12F-C8	80.00	5.50		94.00	70	3.360	3	CCMT 12 04 08	
106.00	122.00	12	C8	3	1	BR30-122CC12F-C8	80.00	8.00		100.00	70	4.100	3	CCMT 12 04 08	
121.00	137.00	12	C8	3	1	BR30-137CC12F-C8	80.00	8.00		100.00	70	4.250	3	CCMT 12 04 08	
136.00	152.00	12	C8	3	1	BR30-152CC12F-C8	80.00	8.00		100.00	70	4.760	3	CCMT 12 04 08	
151.00	167.00	12	C8	3	1	BR30-167CC12F-C8	80.00	8.00		100.00	70	4.880	3	CCMT 12 04 08	
166.00	191.00	12	C8	3	1	BR30-191CC12F-C8	80.00	12.50		115.00	70	6.860	3	CCMT 12 04 08	
189.00	214.00	12	C8	3	1	BR30-214CC12F-C8	80.00	12.50		115.00	70	7.130	3	CCMT 12 04 08	

L

M

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)  
 For inserts, see Turning tools catalogue  
 For all DSGN 2; LU = DC\*ULDR

N

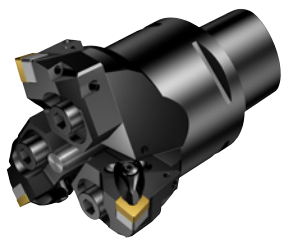


# CoroBore® BR30 three-edge rough boring tool

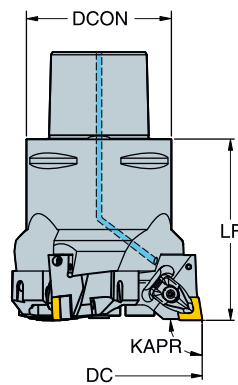
Coromant Capto® - Internal coolant supply


KAPR

90°



-  CNMM
-  CNMG
-  CNMA, CNGA



					Dimensions, mm								
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	BAR	KG	CICT	MIID	
106.00	122.00	12	C8	3	BR30-122CN12F-C8	80.00	8.00	100.00	70	4.190	3	CNMG 12 04 08	
121.00	137.00	12	C8	3	BR30-137CN12F-C8	80.00	8.00	100.00	70	4.340	3	CNMG 12 04 08	
136.00	152.00	12	C8	3	BR30-152CN12F-C8	80.00	8.00	100.00	70	4.820	3	CNMG 12 04 08	
151.00	167.00	12	C8	3	BR30-167CN12F-C8	80.00	8.00	100.00	70	4.970	3	CNMG 12 04 08	
166.00	191.00	16	C8	3	BR30-191CN16F-C8	80.00	12.50	119.00	70	7.430	3	CNMG 16 06 12	
189.00	214.00	16	C8	3	BR30-214CN16F-C8	80.00	12.50	119.00	70	22.400	3	CNMG 16 06 12	

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



L2



M1



N23



N15

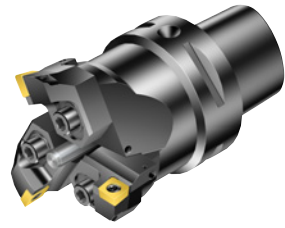


K86



# CoroBore® BR30 three-edge rough boring tool

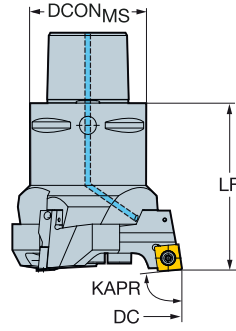
Coromant Capto® - Internal coolant supply






SPMT

KAPR

84°



K

					Dimensions, mm							
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF			CICT	MIID
35.00	40.50	06	C3	3	BR30-41SP06Y-C3	32.00	2.75	48.00	70	0.250	3	SPMT 0606-BM
39.50	45.00	06	C3	3	BR30-45SP06Y-C3	32.00	2.75	48.00	70	0.280	3	SPMT 0606-BM
44.00	50.50	06	C4	3	BR30-51SP06Y-C4	40.00	3.25	56.00	70	0.620	3	SPMT 0606-BM
49.50	56.00	08	C4	3	BR30-56SP08Y-C4	40.00	3.25	58.00	70	0.640	3	SPMT 0808-BM
55.00	63.00	08	C5	3	BR30-63SP08Y-C5	50.00	4.00	66.00	70	0.890	3	SPMT 0808-BM
62.00	70.00	12	C5	3	BR30-70SP12Y-C5	50.00	4.00	68.00	70	0.980	3	SPMT 1210-BM
69.00	78.50	12	C6	3	BR30-79SP12Y-C6	63.00	4.75	78.00	70	1.922	3	SPMT 1210-BM
77.50	87.00	12	C6	3	BR30-87SP12Y-C6	63.00	4.75	78.00	70	2.190	3	SPMT 1210-BM
86.00	97.00	12	C8	3	BR30-97SP12Y-C8	80.00	5.50	94.00	70	3.300	3	SPMT 1210-BM
96.00	107.00	12	C8	3	BR30-107SP12Y-C8	80.00	5.50	94.00	70	3.360	3	SPMT 1210-BM
106.00	122.00	12	C8	3	BR30-122SP12Y-C8	80.00	8.00	100.00	70	4.100	3	SPMT 1210-BM
121.00	137.00	12	C8	3	BR30-137SP12Y-C8	80.00	8.00	100.00	70	4.250	3	SPMT 1210-BM
136.00	152.00	12	C8	3	BR30-152SP12Y-C8	80.00	8.00	100.00	70	4.760	3	SPMT 1210-BM
151.00	167.00	12	C8	3	BR30-167SP12Y-C8	80.00	8.00	100.00	70	4.880	3	SPMT 1210-BM
166.00	191.00	12	C8	3	BR30-191SP12Y-C8	80.00	12.50	115.00	70	6.860	3	SPMT 1210-BM
189.00	214.00	12	C8	3	BR30-214SP12Y-C8	80.00	12.50	115.00	70	7.130	3	SPMT 1210-BM

L

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

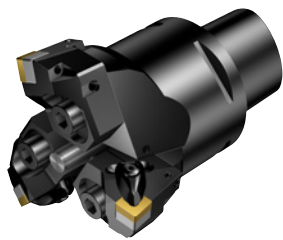
M

N



# CoroBore® BR30 three-edge rough boring tool

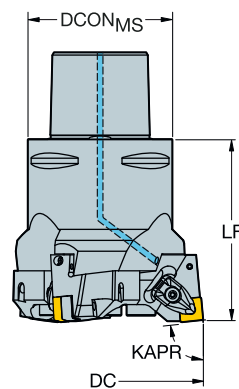
Coromant Capto® - Internal coolant supply






-  SNMM
-  SNMG
-  SNMA, SNGA

KAPR

84°



					Dimensions, mm							
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF			CICT	MIID
106.00	122.00	12	C8	3	BR30-122SN12Y-C8	80.00	8.00	100.00	70	4.190	3	SNMG 12 04 08
121.00	137.00	12	C8	3	BR30-137SN12Y-C8	80.00	8.00	100.00	70	4.340	3	SNMG 12 04 08
136.00	152.00	12	C8	3	BR30-152SN12Y-C8	80.00	8.00	100.00	70	4.820	3	SNMG 12 04 08
151.00	167.00	12	C8	3	BR30-167SN12Y-C8	80.00	8.00	100.00	70	4.970	3	SNMG 12 04 08
166.00	191.00	15	C8	3	BR30-191SN15Y-C8	80.00	12.50	119.00	70	7.480	3	SNMG 15 06 12
189.00	214.00	15	C8	3	BR30-214SN15Y-C8	80.00	12.50	119.00	70	7.790	3	SNMG 15 06 12

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



L2



M1



N23



N15



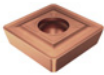
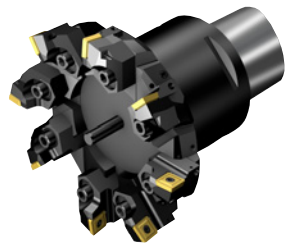
K86



# CoroBore® BR30 multi-edge rough boring tool

Coromant Capto® - Internal coolant supply

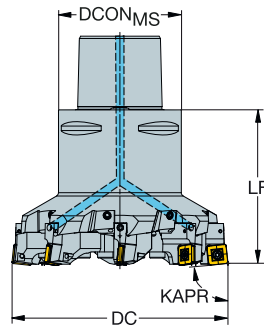
Dedicated for cavity boring operations






SPMT

KAPR

84°



					Dimensions, mm								
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RGL</sub>	LF			CICT	MIID	
85.00	94.50	12	C6	3	BR30-095-4-SP12Y-C6	63.00	4.75	80.00	70	2.050	4	SPMT 1210-BM	
93.50	103.00	12	C6	3	BR30-103-4-SP12Y-C6	63.00	4.75	80.00	70	2.130	4	SPMT 1210-BM	
102.00	111.50	12	C8	3	BR30-112-6-SP12Y-C8	80.00	4.75	100.00	70	4.110	6	SPMT 1210-BM	
110.50	120.00	12	C8	3	BR30-120-6-SP12Y-C8	80.00	4.75	100.00	70	4.230	6	SPMT 1210-BM	
119.00	128.50	12	C8	3	BR30-129-8-SP12Y-C8	80.00	4.75	100.00	70	4.510	8	SPMT 1210-BM	
127.50	137.00	12	C8	3	BR30-137-8-SP12Y-C8	80.00	4.75	100.00	70	4.670	8	SPMT 1210-BM	
136.00	145.50	12	C8	3	BR30-146-8-SP12Y-C8	80.00	4.75	100.00	70	4.900	8	SPMT 1210-BM	
144.50	154.00	12	C8	3	BR30-154-8-SP12Y-C8	80.00	4.75	100.00	70	6.300	8	SPMT 1210-BM	
153.00	162.50	12	C8	3	BR30-163-6-SP12Y-C8	80.00	4.75	100.00	70	5.150	6	SPMT 1210-BM	
161.50	171.00	12	C8	3	BR30-171-6-SP12Y-C8	80.00	4.75	100.00	70	5.270	6	SPMT 1210-BM	
170.00	179.50	12	C8	3	BR30-180-6-SP12Y-C8	80.00	4.75	100.00	70	5.730	6	SPMT 1210-BM	
178.50	188.00	12	C8	3	BR30-188-6-SP12Y-C8	80.00	4.75	100.00	70	5.850	6	SPMT 1210-BM	
187.00	196.50	12	C8	3	BR30-197-6-SP12Y-C8	80.00	4.75	100.00	70	6.470	6	SPMT 1210-BM	
195.50	205.00	12	C8	3	BR30-205-6-SP12Y-C8	80.00	4.75	100.00	70	6.590	6	SPMT 1210-BM	

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroBore® 820 XL

Rough boring tool for large diameters

## Application

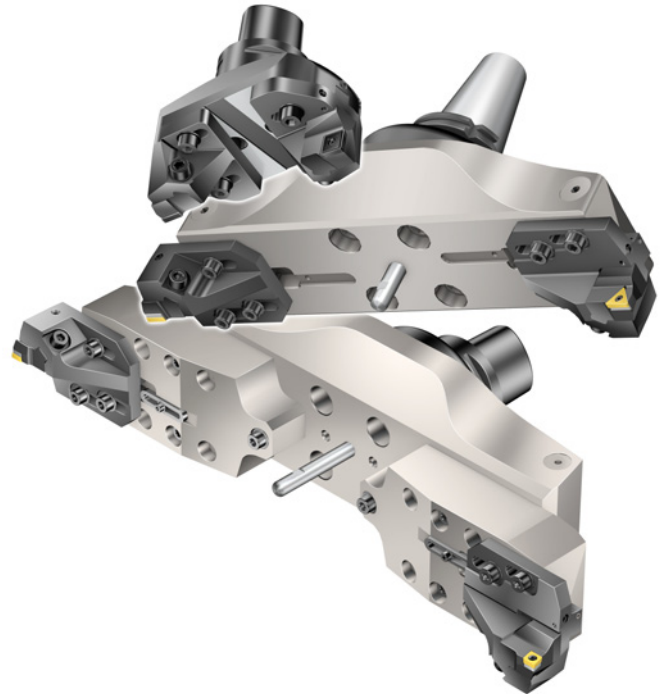
- Rough boring
- Twin-edge boring
- Step boring
- Single edge boring

## ISO application area



## Benefits and features

- Short, rigid and compact giving maximum stability at large diameter rough boring
- Axial and radial adjustable
- Cutting fluid through the tool for good chip evacuation
- Strong modular base for building assemblies in different applications (rough boring, fine boring, face grooving, spiro grooving and interpolation turning)



[www.sandvik.coromant.com/corobore820](http://www.sandvik.coromant.com/corobore820)

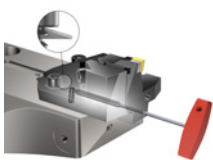
●●●● SilentTools®

## Tools

- Couplings:
- Coromant Capto®
  - Arbor

## Inserts

- Standard inserts with dedicated grades and geometries for all materials
- CoroBore® 111
  - CoroTurn® 107
  - T-max® P



For easy radial adjustment of slides, slightly tighten screws and adjust diameter with key. Cartridges are possible to adjust in axial direction, for step boring.



Use same bridge/bridge extension for roughing, finishing and face grooving from diameter 148 mm (counterweight needed for finishing).



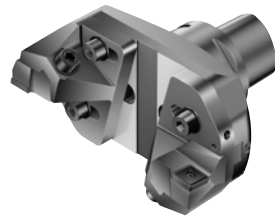
Bore large diameter without increasing tool weight.



Dedicated CoroBore® 111 rough boring inserts. With excellent chip breaking and increased lifetime.

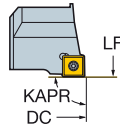
# CoroBore® 820 XL rough boring tool

Coromant Capto® - Internal coolant supply

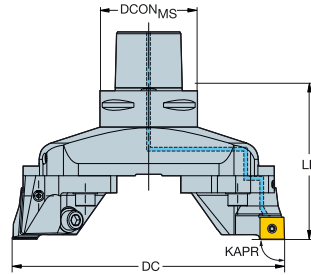
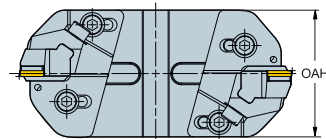


SPMT


KAPR



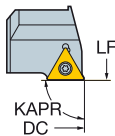
90°



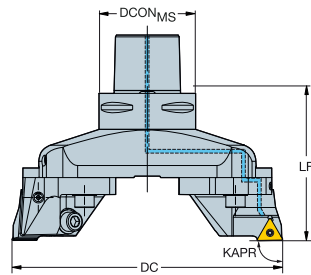
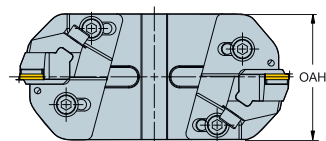
Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
148.00	200.00	18	C8	3	820-200SP18-C8	80.00	1.50	26.00	122.00	104.00	70	6.900	2	SPMT 1810-BM
148.00	200.00	18	C10	3	820-200SP18-C10	100.00	1.50	26.00	128.00	104.00	70	9.900	2	SPMT 1810-BM
198.00	250.00	18	C8	3	820-250SP18-C8	80.00	1.50	26.00	122.00	104.00	70	8.700	2	SPMT 1810-BM
198.00	250.00	18	C10	3	820-250SP18-C10	100.00	1.50	26.00	128.00	104.00	70	11.308	2	SPMT 1810-BM
248.00	300.00	18	C8	3	820-300SP18-C8	80.00	1.50	26.00	122.00	104.00	70	10.620	2	SPMT 1810-BM
248.00	300.00	18	C10	3	820-300SP18-C10	100.00	1.50	26.00	128.00	104.00	70	12.640	2	SPMT 1810-BM


KAPR



90°



Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
148.00	200.00	22	C8	3	820-200TC22-C8	80.00	1.50	26.00	122.00	104.00	70	8.390	2	TCMT 22 04 08
148.00	200.00	22	C10	3	820-200TC22-C10	100.00	1.50	26.00	128.00	104.00	70	10.170	2	TCMT 22 04 08
198.00	250.00	22	C8	3	820-250TC22-C8	80.00	1.50	26.00	122.00	104.00	70	8.800	2	TCMT 22 04 08
198.00	250.00	22	C10	3	820-250TC22-C10	100.00	1.50	26.00	128.00	104.00	70	11.400	2	TCMT 22 04 08
248.00	300.00	22	C8	3	820-300TC22-C8	80.00	1.50	26.00	122.00	104.00	70	10.600	2	TCMT 22 04 08
248.00	300.00	22	C10	3	820-300TC22-C10	100.00	1.50	26.00	128.00	104.00	70	12.660	2	TCMT 22 04 08

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

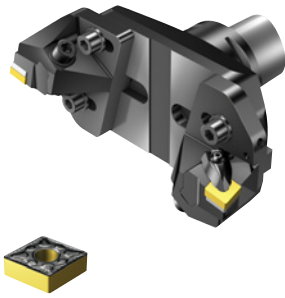
For inserts, see Turning tools catalogue





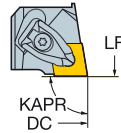
# CoroBore® 820 XL rough boring tool

Coromant Capto® - Internal coolant supply

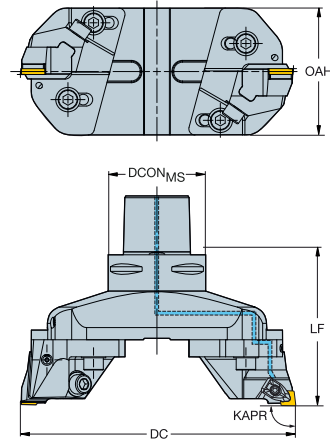


-  CNMM
-  CNMG
-  CNMA, CNGA


KAPR



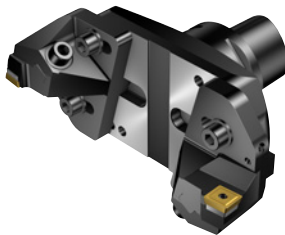
90°



Dimensions, mm

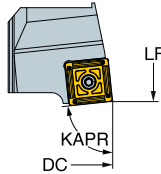
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
148.00	200.00	19	C8	3	820-200CN19-C8	80.00	1.50	26.00	122.00	104.00	70	8.240	2	CNMG 19 06 12
148.00	200.00	19	C10	3	820-200CN19-C10	100.00	1.50	26.00	128.00	104.00	70	10.100	2	CNMG 19 06 12
198.00	250.00	19	C8	3	820-250CN19-C8	80.00	1.50	26.00	122.00	104.00	70	9.620	2	CNMG 19 06 12
198.00	250.00	19	C10	3	820-250CN19-C10	100.00	1.50	26.00	128.00	104.00	70	11.520	2	CNMG 19 06 12
248.00	300.00	19	C8	3	820-300CN19-C8	80.00	1.50	26.00	122.00	104.00	70	10.000	2	CNMG 19 06 12
248.00	300.00	19	C10	3	820-300CN19-C10	100.00	1.50	26.00	128.00	104.00	70	12.685	2	CNMG 19 06 12

For inserts, see Turning tools catalogue

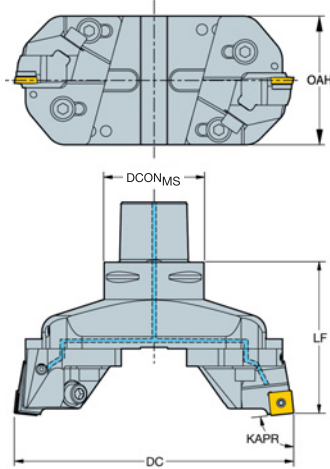


-  SPMT


KAPR



84°



Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
148.00	200.00	18	C8	3	820-200SP18Y-C8	80.00	1.50	26.00	122.00	104.00	70	7.030	2	SPMT 1810-BM
148.00	200.00	18	C10	3	820-200SP18Y-C10	100.00	1.50	26.00	128.00	104.00	70	8.940	2	SPMT 1810-BM
198.00	250.00	18	C8	3	820-250SP18Y-C8	80.00	1.50	26.00	122.00	104.00	70	8.260	2	SPMT 1810-BM
198.00	250.00	18	C10	3	820-250SP18Y-C10	100.00	1.50	26.00	128.00	104.00	70	10.190	2	SPMT 1810-BM
248.00	300.00	18	C8	3	820-300SP18Y-C8	80.00	1.50	26.00	122.00	104.00	70	9.460	2	SPMT 1810-BM
248.00	300.00	18	C10	3	820-300SP18Y-C10	100.00	1.50	26.00	128.00	104.00	70	11.510	2	SPMT 1810-BM

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

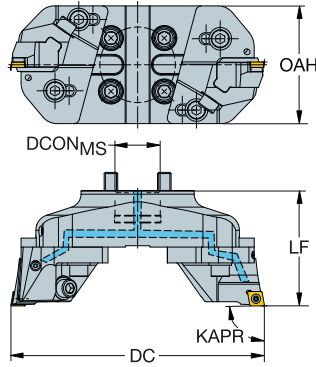
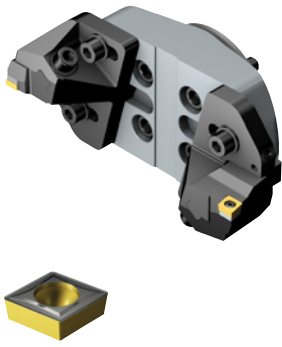


# CoroBore® 820 XL lightweight rough boring tool

Arbor - Internal coolant supply

KAPR

90°



- CCMT, CCGT  
CCGX, CCET
- CCMW

K

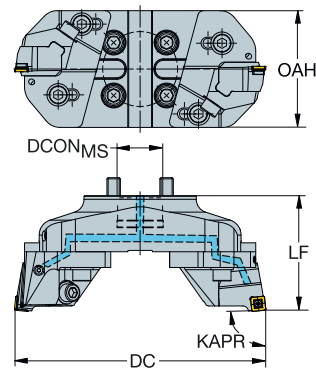
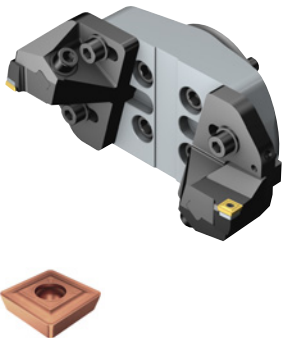
Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
148.00	200.00	12	40S	1	820L-200CC12F	40.00	1.50	26.00	102.00	104.00	70	3.860	2	CCMT 12 04 08
198.00	250.00	12	40S	1	820L-250CC12F	40.00	1.50	26.00	102.00	104.00	70	4.390	2	CCMT 12 04 08
248.00	300.00	12	40S	1	820L-300CC12F	40.00	1.50	26.00	102.00	104.00	70	4.870	2	CCMT 12 04 08

For inserts, see Turning tools catalogue

KAPR

84°



- SPMT

M

Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
148.00	200.00	12	40S	1	820L-200SP12Y	40.00	1.50	26.00	102.00	104.00	70	3.860	2	SPMT 1210-BM
198.00	250.00	12	40S	1	820L-250SP12Y	40.00	1.50	26.00	102.00	104.00	70	4.390	2	SPMT 1210-BM
248.00	300.00	12	40S	1	820L-300SP12Y	40.00	1.50	26.00	102.00	104.00	70	4.870	2	SPMT 1210-BM

Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.

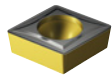
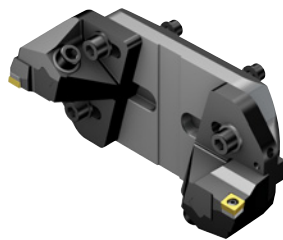
For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

N



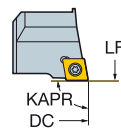
# CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply  
Dedicated for Silent Tools boring

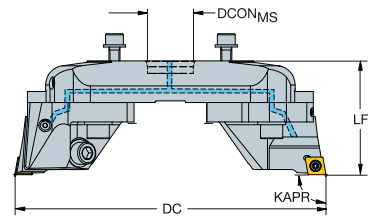
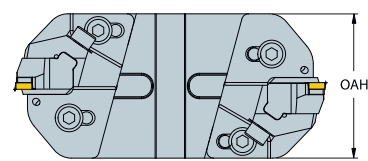


- CCMT, CCGT  
CCGX, CCET
- CCMW

KAPR

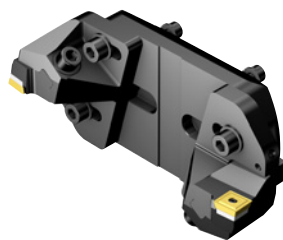


90°



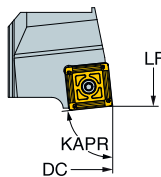
						Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJL <sub>X</sub> <sub>AXL</sub>	ADJL <sub>X</sub> <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID	
148.00	200.00	12	33	1	820D-200CC12	33.00	1.50	26.00	82.00	104.00	70	3.350	2	CCMT 12 04 08	
198.00	250.00	12	33	1	820D-250CC12	33.00	1.50	26.00	82.00	104.00	70	3.670	2	CCMT 12 04 08	
248.00	300.00	12	33	1	820D-300CC12	33.00	1.50	26.00	82.00	104.00	70	4.030	2	CCMT 12 04 08	

For inserts, see Turning tools catalogue

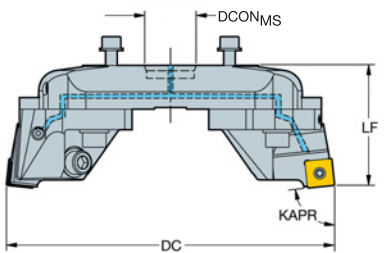
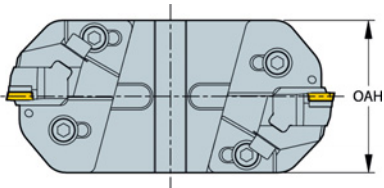


- SPMT

KAPR



84°



						Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJL <sub>X</sub> <sub>AXL</sub>	ADJL <sub>X</sub> <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID	
148.00	200.00	12	33	1	820D-200SP12Y	33.00	1.50	26.00	82.00	104.00	70	3.350	2	SPMT 1210-BM	
198.00	250.00	12	33	1	820D-250SP12Y	33.00	1.50	26.00	82.00	104.00	70	3.670	2	SPMT 1210-BM	
248.00	300.00	12	33	1	820D-300SP12Y	33.00	1.50	26.00	82.00	104.00	70	4.030	2	SPMT 1210-BM	

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

These light weight assemblies are dedicated for use with damped boring adaptors. Damped adaptors are bought separately, see page K77.



K32



N23



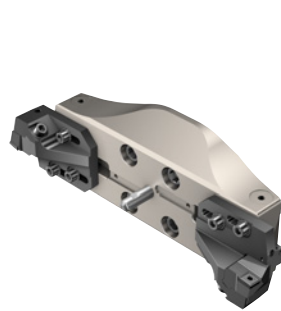
N15



K87

# CoroBore® 820 XL rough boring tool

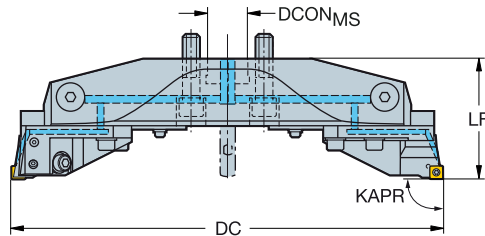
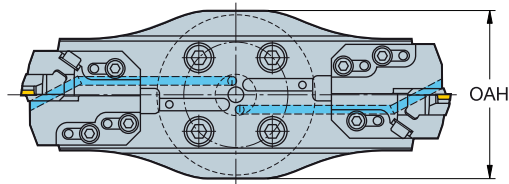
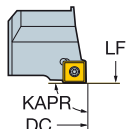
Arbor - Internal coolant supply



SPMT

KAPR

90°



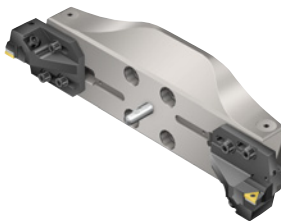
K

DCN	DCX	CZC <sub>MS</sub>	CNSC	Ordering code
298.00	380.00	18	40X	820-380SP18
378.00	460.00	18	40X	820-460SP18
458.00	540.00	18	40X	820-540SP18

Dimensions, mm

DCN <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
40.00	1.50	41.00	114.00	164.00	70	10.000	2	SPMT 1810-BM
40.00	1.50	41.00	119.00	164.00	70	13.131	2	SPMT 1810-BM
40.00	1.50	41.00	124.00	164.00	70	16.741	2	SPMT 1810-BM

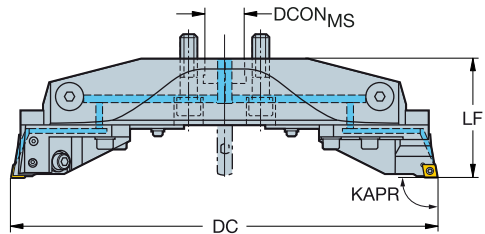
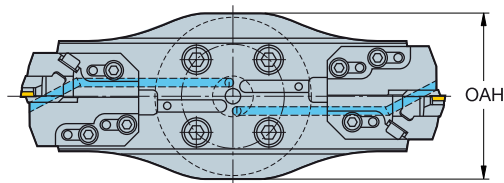
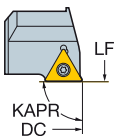
L



TCMT, TCMX, TCGT, TCGX, TCEX, TCMW

KAPR

90°



M

DCN	DCX	CZC <sub>MS</sub>	CNSC	Ordering code
298.00	380.00	22	40X	820-380TC22
378.00	460.00	22	40X	820-460TC22
458.00	540.00	22	40X	820-540TC22

Dimensions, mm

DCN <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
40.00	1.50	41.00	114.00	164.00	70	10.980	2	TCMT 22 04 08
40.00	1.50	41.00	119.00	164.00	70	12.720	2	TCMT 22 04 08
40.00	1.50	41.00	124.00	164.00	70	16.580	2	TCMT 22 04 08

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue

N



K32



K76



N23



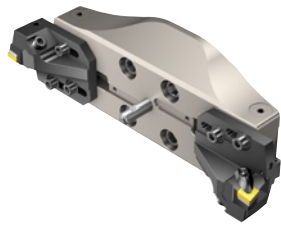
N15



K87

# CoroBore® 820 XL rough boring tool

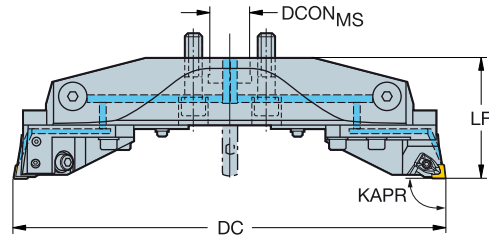
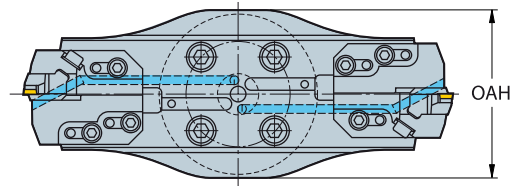
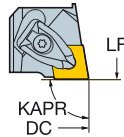
Arbor - Internal coolant supply



- CNMM
- CNMG
- CNMA, CNGA

KAPR

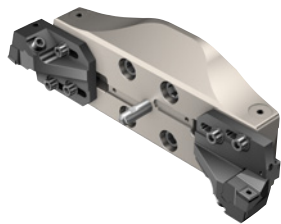
90°



Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AVL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
298.00	380.00	19	40X	1	820-380CN19	40.00	1.50	41.00	114.00	164.00	70	10.815	2	CNMG 19 06 12
378.00	460.00	19	40X	1	820-460CN19	40.00	1.50	41.00	119.00	164.00	70	12.685	2	CNMG 19 06 12
458.00	540.00	19	40X	1	820-540CN19	40.00	1.50	41.00	124.00	164.00	70	16.780	2	CNMG 19 06 12

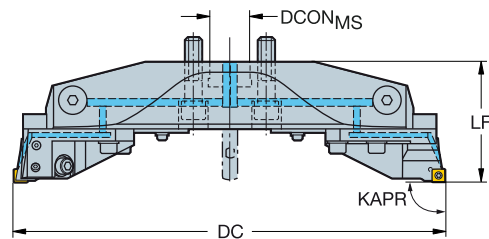
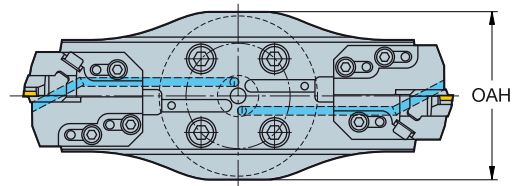
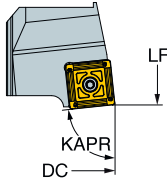
For inserts, see Turning tools catalogue



- SPMT

KAPR

84°



Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AVL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
298.00	380.00	18	40X	1	820-380SP18Y	40.00	1.50	41.00	114.00	164.00	70	9.050	2	SPMT 1810-BM
378.00	460.00	18	40X	1	820-460SP18Y	40.00	1.50	41.00	119.00	164.00	70	10.810	2	SPMT 1810-BM
458.00	540.00	18	40X	1	820-540SP18Y	40.00	1.50	41.00	124.00	164.00	70	12.740	2	SPMT 1810-BM

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.  
In case of direct flange to the machine spindle, use centering plug, see page K77

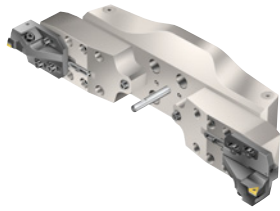
For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroBore® 820 XL rough boring tool

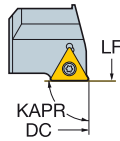
Arbor - Internal coolant supply

With bridge extension

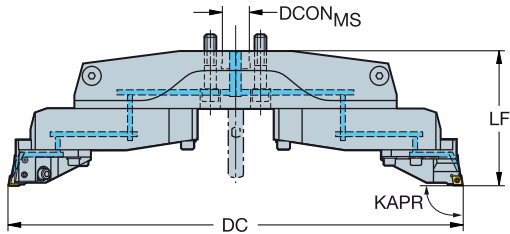
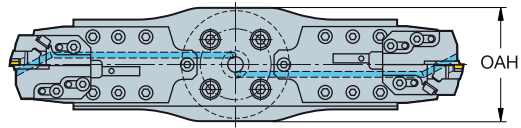


- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR

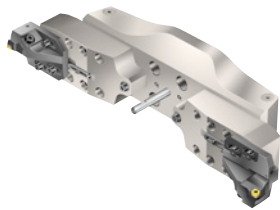


90°



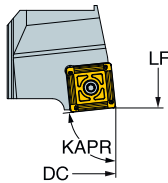
					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AVL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
538.00	780.00	22	40X	1	820-780TC22	40.00	1.50	121.00	198.00	164.00	70	28.000	2	TCMT 22 04 08
778.00	1020.00	22	40X	1	820-1020TC22	40.00	1.50	121.00	218.00	164.00	70	48.000	2	TCMT 22 04 08
1018.00	1260.00	22	40X	1	820-1260TC22	40.00	1.50	121.00	218.00	164.00	70	43.730	2	TCMT 22 04 08

For inserts, see Turning tools catalogue

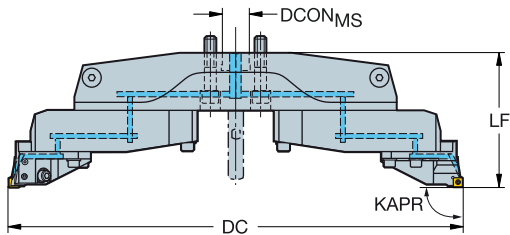
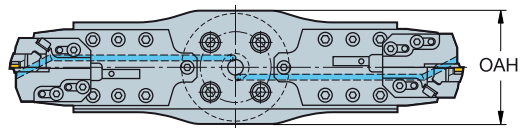


SPMT

KAPR



84°



					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AVL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
538.00	780.00	18	40X	1	820-780SP18Y	40.00	1.50	121.00	198.00	164.00	70	25.190	2	SPMT 1810-BM
778.00	1020.00	18	40X	1	820-1020SP18Y	40.00	1.50	121.00	218.00	164.00	70	36.380	2	SPMT 1810-BM
1018.00	1260.00	18	40X	1	820-1260SP18Y	40.00	1.50	121.00	218.00	164.00	70	43.810	2	SPMT 1810-BM

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

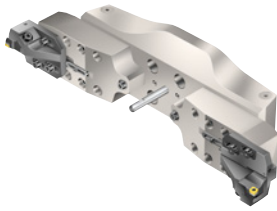
For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

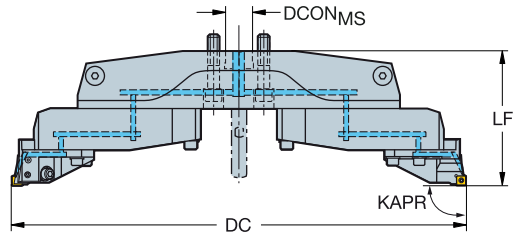
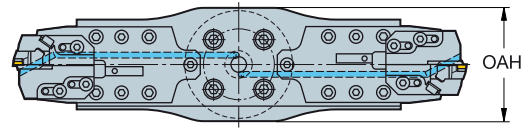
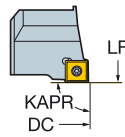
With bridge extension



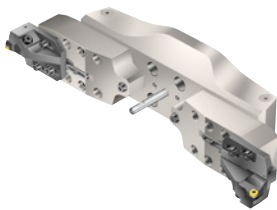
SPMT

KAPR

90°



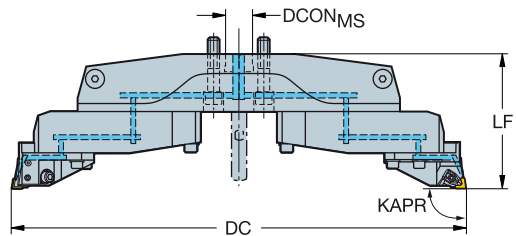
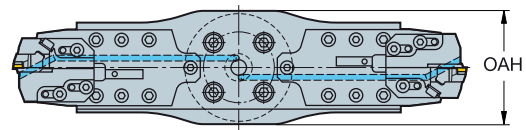
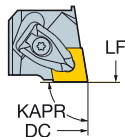
					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
538.00	780.00	18	40X	1	820-780SP18	40.00	1.50	121.00	198.00	164.00	70	39.000	2	SPMT 1810-BM
778.00	1020.00	18	40X	1	820-1020SP18	40.00	1.50	121.00	218.00	164.00	70	36.380	2	SPMT 1810-BM
1018.00	1260.00	18	40X	1	820-1260SP18	40.00	1.50	121.00	218.00	164.00	70	43.810	2	SPMT 1810-BM



- CNMM
- CNMG
- CNMA, CNGA

KAPR

90°



					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>AXL</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BAR	KG	CICT	MIID
538.00	780.00	19	40X	1	820-780CN19	40.00	1.50	121.00	198.00	164.00	70	34.000	2	CNMG 19 06 12
778.00	1020.00	19	40X	1	820-1020CN19	40.00	1.50	121.00	218.00	164.00	70	43.000	2	CNMG 19 06 12
1018.00	1260.00	19	40X	1	820-1260CN19	40.00	1.50	121.00	218.00	164.00	70	43.830	2	CNMG 19 06 12

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



K32



K76



N23



N15

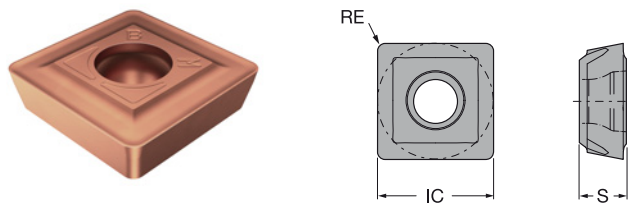



K87

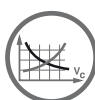


# CoroBore® 111 inserts for rough boring

S-style insert (Square)



						P	M	K	S	
		IC	S	RE	ISO CODE	4325	2025	3210	1145	
Medium	BM	06	6.0	2.60	0.60	SPMT0606-BM	☆	☆	☆	
		08	8.9	3.00	0.80	SPMT0808-BM				☆
		12	12.65	4.00	1.00	SPMT1210-BM				☆
		18	18.6	5.50	1.00	SPMT1810-BM				☆
Roughing	BR	06	6.0	2.60	0.60	SPMT0606-BR	☆		☆	
		08	8.9	3.00	0.80	SPMT0808-BR	☆		☆	
		12	12.65	4.00	1.20	SPMT1212-BR	☆		☆	
		18	18.6	5.50	1.20	SPMT1812-BR	☆		☆	



K91

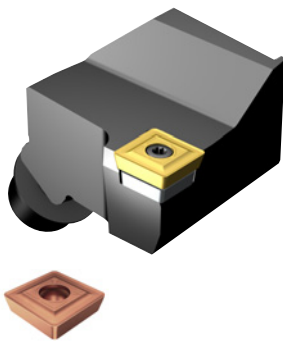


N23

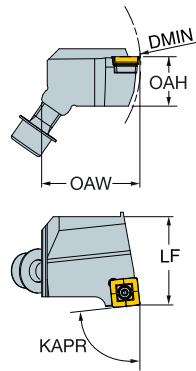


# Cartridge for CoroBore® XL

KAPR 84°



SPMT

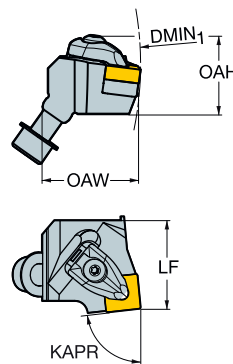


		Dimensions, mm									
DMIN <sub>1</sub>	CZC <sub>MS</sub>	Ordering code	LF	HF	WF	OAH	OAL		CICT	MIID	
148.0	12	S12	S12-R820XLR40SSYP12	40.00	22.40	42.00	30.16	43.30	0.250	1	SPMT 1210-BM

KAPR 84°



SNMM  
 SNMG  
 SNMA, SNGA



		Dimensions, mm										
DMIN <sub>1</sub>	CZC <sub>MS</sub>	Ordering code	LF	LPR	HF	WF	OAH	OAL		CICT	MIID	
148.0	15	S12	S12-R820XLR40DSYN15	40.00	41.80	20.00	42.00	39.70	43.80	0.310	1	SNMG 15 06 08

For inserts, see Turning tools catalogue

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



## Fine boring

	Tool concept	Diameter range, mm	Hole tolerance	Cutting edge	Operation	Insert choice	Machine side interface	Page
<b>CoroBore® 824</b> 	Conventional	1-20	IT6	- Solid carbide bars - Indexable carbide bars	- Single edge boring	- CoroTurn® 107 - CoroTurn® XS	- Coromant Capto® - Coromant EH	K35-K37
<b>391.37A/B</b> 	Conventional	3-36	IT6	- Solid carbide bars - Indexable carbide bars - Indexable steel bars	- Single edge boring	- CoroTurn® 107 - Solid bars with ground geometry	- Coromant Capto® - HSK	K38-K40
<b>CoroBore® 826 HP</b> 	Conventional	35-154	IT6	- Indexable cartridges	- Single edge boring	- CoroTurn® 107	- Coromant Capto®	K48-K50
<b>CoroBore® 825</b> 	Conventional	19-167	IT6	- Indexable cartridges	- Single edge boring - Back boring	- CoroTurn® 107	- Coromant Capto® - Cylindrical shank - Coromant EH	K43-K50
	Lightweight	69-167	IT6	- Indexable cartridges	- Single edge boring - Back boring	- CoroTurn® 107	- Coromant Capto®	K51
	Damped	19-167	IT6	- Indexable cartridges	- Single edge boring - Back boring	- CoroTurn® 107	- Coromant Capto®	K52
<b>CoroBore® 825 XL/CoroBore® 826 XL</b> 	Conventional	148-315 298-1275	IT6	- Indexable cartridges	- Single edge boring - Back boring - External boring	- CoroTurn® 107	- Coromant Capto®  - 40X with 4 bolt circle	K53-K61 K62-K65
	Lightweight	148-315	IT6	- Indexable cartridges	- Single edge boring - Back boring - External boring	- CoroTurn® 107	- Coromant Capto® - 40S with 4 bolt circle	K56-K59
	Damped	148-315	IT6	- Indexable cartridges	- Single edge boring - Back boring - External boring	- CoroTurn® 107	- A33 damped adaptor	K60-K61

# CoroBore® 824

## Small-diameter fine boring

### Application

- Fine boring
- Single edge boring

### ISO application area



### Benefits and features

- Broad diameter range, from 1-20 mm
- Increased accessibility with Coromant Capto and Coromant EH modular interfaces in small diameters
- Fine boring tool with precision diameter adjustment of 2 microns (nonius scale) to obtain tight tolerances of IT6
- CoroTurn® XS inserts to be used from diameter 1 mm
- Solid carbide boring bars with standard CoroTurn® 107 indexable inserts available from diameter 6 mm
- Better accessibility with small boring head diameters, making it possible to bore in hard to reach areas
- Rigid system for maximum stability with internal coolant supply



[www.sandvik.coromant.com/corobore824](http://www.sandvik.coromant.com/corobore824)

### Tools

#### Couplings:

- Coromant Capto®
- Coromant EH

### Inserts and cutting tools

Standard inserts with dedicated grades and geometries for all materials

- CoroTurn® XS
- CoroTurn® 107

DCON <sub>WS</sub>	RPMX	ADJRG (mm)
4	28000	1
6	20000	1
8	14000	1
10	10000	1.5



- CoroTurn® XS for small diameter holes. For assortment, see Turning catalogue.



Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.

# Coromant Capto® to CoroTurn® XS adaptor

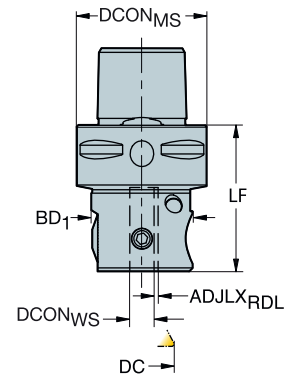
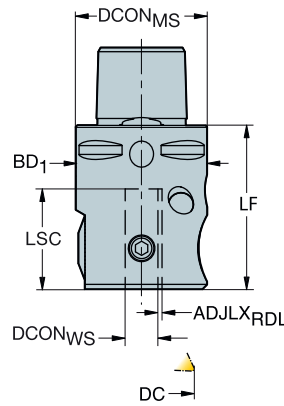
CoroBore® 824 XS

Internal coolant supply

DSGN

1

2

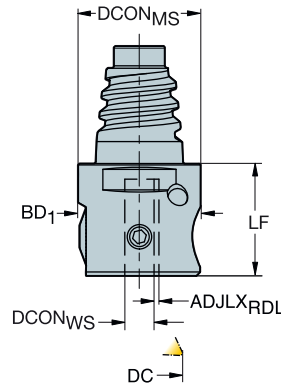


							Dimensions, mm					
DCN	DCX	CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ADJLXRDL	LF	BAR	KG
1.00	6.00	C3	4	3	2	C3-R824XS04-021	32.00	4.00	1.00	36.00	20	0.213
6.00	10.00	C3	6	3	2	C3-R824XS06-016	32.00	6.00	1.00	36.00	20	0.210
10.00	14.00	C3	8	3	1	C3-R824XS08-015	32.00	8.00	1.00	40.00	20	0.269
14.00	20.00	C4	10	3	1	C4-R824XS10-017	40.00	10.00	1.50	42.00	20	0.451

# Coromant EH to CoroTurn® XS adaptor

CoroBore® 824 XS

Internal coolant supply



							Dimensions, mm					
DCN	DCX	CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ADJLXRDL	LF	BAR	KG	
1.00	6.00	E25	4	1	EH25-R824XS04-008	24.20	4.00	1.00	23.00	20	0.174	
6.00	10.00	E25	6	1	EH25-R824XS06-003	24.20	6.00	1.00	23.00	20	0.172	
10.00	14.00	E25	8	1	EH25-R824XS08-013	24.20	8.00	1.00	38.00	20	0.285	
14.00	20.00	E25	10	1	EH25-R824XS10-013	24.20	10.00	1.50	38.00	20	0.368	

**Note:**

To be used with CoroTurn® XS boring bar for boring

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



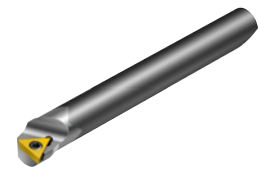
# CoroTurn® XS boring bar for boring



CXS connection - Internal coolant supply

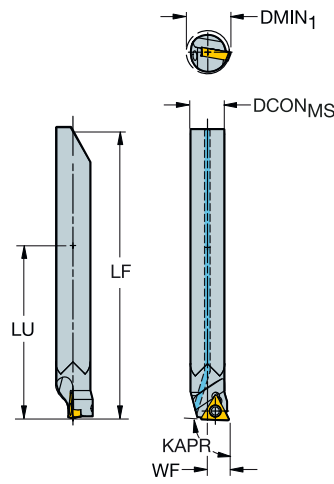
Indexable solid carbide bar

KAPR

92°



-  TCMT, TCMX,  
TCGT, TCGX  
TCEX
-  TCMW



				Dimensions, mm								
DMIN <sub>1</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	LU	LF	WF	BAR	KG	CICT	MID	
6.0	05	6	1	CXS-06-06 030TC05	6.00	30.00	49.90	3.00	20	0.028	1	TCEX 05 01 00L-F
8.0	05	6	1	CXS-06-08 030TC05	6.00	30.00	49.90	4.00	20	0.031	1	TCEX 05 01 00L-F
10.0	06	8	1	CXS-08-10 040TC06	8.00	40.00	64.04	5.00	20	0.050	1	TCMT 06 T1 02
12.0	06	8	1	CXS-08-12 040TC06	8.00	40.00	64.04	6.00	20	0.050	1	TCMT 06 T1 02
14.0	09	10	1	CXS-10-14 050TC09	10.00	50.00	73.17	7.00	20	0.104	1	TCMT 09 02 02
17.0	09	10	1	CXS-10-17 050TC09	10.00	50.00	73.17	8.50	20	0.106	1	TCMT 09 02 02

Recommended adaptors: CoroBore 824XS

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



K36



N23



N15

# 391.37A/B Fine boring head

## Small diameter boring and face grooving

### Application

- Fine boring
- Face grooving

### Benefits and features

- Boring bars with increased performance to its length/diameter ratio
- Flexible solutions for a broad diameter range (3-36 mm)
- Excellent for small o-ring grooves
- 391.37B High speed fine boring head with rotation speed on 20 000 rev/min
- Choose between conventional (.37A and high speed (.37B) fine boring head:
- Internal coolant supply
- Diameter adjustment: 0.002 mm



### Tools

#### Couplings:

- Coromant Capto®
- Coromant EH

### Inserts

Standard inserts with dedicated grades and geometries for all materials

- CoroTurn® XS
- CoroTurn® 107
- CoroCut® MB - 09FA

### 391.37A/B Fine boring head

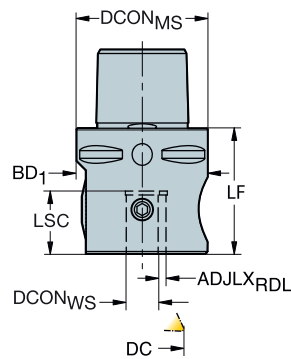
DCON <sub>WS</sub>	Max. rotation speed: RPMX	Diameter range ADJRG (mm)
12	7000	3
16	5000	3
20	3500	5



Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.

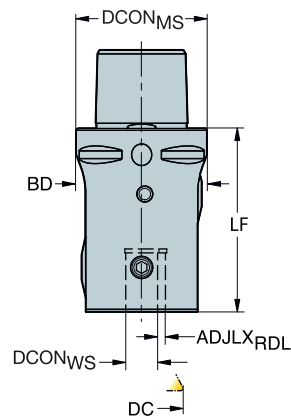
# Coromant Capto® to fine boring head adaptor

Internal coolant supply



## 391.37A adaptor

						Dimensions, mm					
DCN	DCX	CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ADJLX <sub>RDL</sub>	LF	BAR	KG
3.00	26.00	C4	12	3	C4-391.37A-12 055B	40.00	12.00	3.00	55.00	20	0.714
3.00	26.00	C5	12	3	C5-391.37A-12 048B	50.00	12.00	3.00	48.00	20	0.799
3.00	32.00	C5	16	3	C5-391.37A-16 070A	50.00	16.00	3.00	70.00	20	1.450
3.00	32.00	C6	16	3	C6-391.37A-16 075A	63.00	16.00	3.00	75.00	20	1.896
17.00	36.00	C5	20	3	C5-391.37A-20 085A	50.00	20.00	5.00	85.00	20	1.616
17.00	36.00	C6	20	3	C6-391.37A-20 085A	63.00	20.00	5.00	85.00	20	2.886



## 391.37B adaptor with adjustable counterweight

						Dimensions, mm					
DCN	DCX	CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ADJLX <sub>RDL</sub>	LF	BAR	KG
3.00	26.00	C5	12	3	C5-391.37B-12 070B	50.00	12.00	3.00	70.00	20	1.090

To be used with R429U/R429.90 boring bars

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



L2



M26



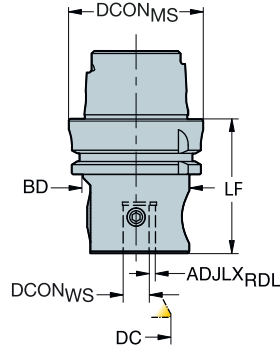
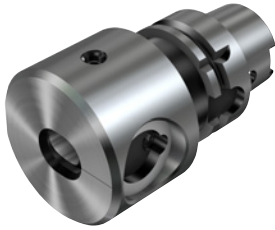
N23



N15

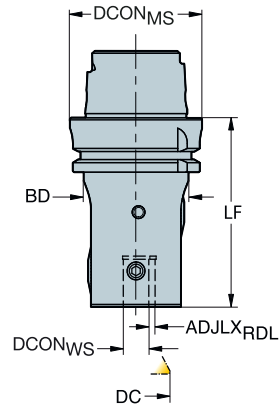
# HSK to fine boring head adaptor

Internal coolant supply



## 391.37A adaptor

						Dimensions, mm							
DCN	DCX	CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ISO	ADJL <sub>RDL</sub>	LF	BD <sub>1</sub>	BAR	KG
3.00	26.00	63	12	1	392.41037A-6312063B	63.00	12.00	A	3.00	63.00	50.00	20	1.181
3.00	26.00	100	12	1	392.41037A-10012076B	100.00	12.00	A	3.00	76.00	50.00	20	2.700
3.00	32.00	63	16	1	392.41037A-6316085A	63.00	16.00	A	3.00	85.00	63.00	20	1.770
17.00	36.00	63	20	1	392.41037A-63 20 100A	63.00	20.00	A	5.00	100.00	80.00	20	2.788



## 391.37B adaptor with adjustable counterweight

						Dimensions, mm							
DCN	DCX	CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ISO	ADJL <sub>RDL</sub>	LF	BD <sub>1</sub>	BAR	KG
3.00	26.00	63	12	1	392.41037B-6312090B	63.00	12.00	A	3.00	90.00	50.00	20	1.502

To be used with R429U/R429.90 boring bars

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)





# Boring bar with indexable insert for fine boring heads

Cylindrical shank - Internal coolant supply

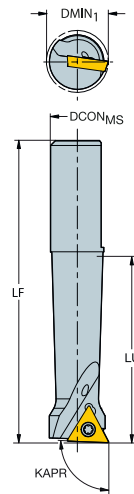
Steel bar

KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



				Dimensions, mm								
DMIN <sub>1</sub>		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	LU	LF	WF			CICT	MID
8.0	06	12	1	R429U-A12-08028TC06	12.00	28.00	54.00	4.00	20	0.036	1	TCMT 06 T1 02
8.0	06	12	1	R429U-A12-08040TC06	12.00	40.00	66.00	4.00	20	0.040	1	TCMT 06 T1 02
11.0	06	12	1	R429U-A12-11039TC06	12.00	39.00	65.00	5.50	20	0.048	1	TCMT 06 T1 02
11.0	06	12	1	R429U-A12-11055TC06	12.00	55.00	81.00	5.50	20	0.053	1	TCMT 06 T1 02
14.0	09	12	1	R429U-A12-14042TC09	12.00	42.00	68.00	7.00	20	0.060	1	TCMT 09 02 02
14.0	09	12	1	R429U-A12-14060TC09	12.00	60.00	86.00	7.00	20	0.070	1	TCMT 09 02 02
17.0	09	12	1	R429U-A12-17042TC09	12.00	42.00	68.00	8.50	20	0.060	1	TCMT 09 02 02
17.0	09	12	1	R429U-A12-17060TC09	12.00	60.00	86.00	8.50	20	0.071	1	TCMT 09 02 02
20.0	09	12	1	R429U-A12-20042TC09	12.00	42.00	68.00	10.00	20	0.063	1	TCMT 09 02 02
20.0	09	12	1	R429U-A12-20060TC09	12.00	60.00	86.00	10.00	20	0.072	1	TCMT 09 02 02
8.0	06	16	1	R429U-A16-08028 TC06A	16.00	28.00	89.00	4.00	20	0.114	1	TCMT 06 T1 02
8.0	06	16	1	R429U-A16-08040TC06	16.00	40.00	101.00	4.00	20	0.103	1	TCMT 06 T1 02
11.0	06	16	1	R429U-A16-11039 TC06A	16.00	39.00	100.00	5.50	20	0.124	1	TCMT 06 T1 02
11.0	06	16	1	R429U-A16-11055TC06	16.00	55.00	116.00	5.50	20	0.120	1	TCMT 06 T1 02
14.0	09	16	1	R429U-A16-14049 TC09A	16.00	49.00	110.00	1.50	20	0.148	1	TCMT 09 02 02
14.0	09	16	1	R429U-A16-14070TC09	16.00	70.00	131.00	7.00	20	0.156	1	TCMT 09 02 02
17.0	09	16	1	R429U-A16-17056 TC09A	16.00	56.00	117.00	8.50	20	0.165	1	TCMT 09 02 02
17.0	09	16	1	R429U-A16-17080TC09	16.00	80.00	141.00	8.50	20	0.193	1	TCMT 09 02 02
20.0	09	16	1	R429U-A16-20056 TC09A	16.00	56.00	117.00	10.00	20	7.400	1	TCMT 09 02 02
20.0	09	16	1	R429U-A16-20080TC09	16.00	80.00	141.00	10.00	20	0.195	1	TCMT 09 02 02
23.0	09	16	1	R429U-A16-23056 TC09A	16.00	56.00	117.00	11.50	20	0.160	1	TCMT 09 02 02
23.0	09	16	1	R429U-A16-23080TC09	16.00	80.00	141.00	11.50	20	0.192	1	TCMT 09 02 02
26.0	09	16	1	R429U-A16-26056 TC09A	16.00	56.00	117.00	13.00	20	0.160	1	TCMT 09 02 02
26.0	09	16	1	R429U-A16-26080TC09	16.00	80.00	141.00	13.00	20	0.194	1	TCMT 09 02 02
17.0	09	20	1	R429U-A20-17060 TC09A	20.00	60.00	134.00	8.50	20	0.260	1	TCMT 09 02 02
20.0	09	20	1	R429U-A20-20070 TC09A	20.00	70.00	144.00	10.00	20	0.270	1	TCMT 09 02 02
23.0	09	20	1	R429U-A20-23070 TC09A	20.00	70.00	144.00	11.50	20	0.290	1	TCMT 09 02 02
26.0	09	20	1	R429U-A20-26070 TC09A	20.00	70.00	144.00	13.00	20	0.290	1	TCMT 09 02 02

Recommended adaptors:

A12: 391.37A/B

A16 and A20: 391.37A

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



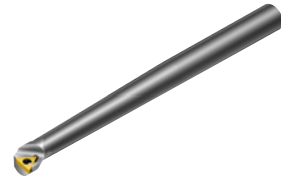
N15



# Boring bar with indexable insert for fine boring heads

Cylindrical shank - Internal coolant supply

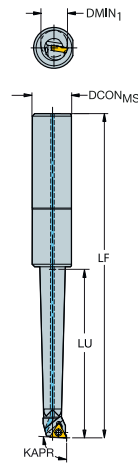
Carbide bar with brazed steel head



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR

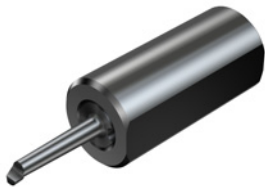
92°



				Dimensions, mm									
DMN <sub>1</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	LU	LF	WF	BAR	KG	CICT	MIID		
8.0	06	16	R429U-E16-08048TC06	16.00	48.00	109.00	4.00	20	0.130	1	TCMT 06 T1 02		
11.0	06	16	R429U-E16-11066TC06	16.00	66.00	127.00	5.50	20	0.170	1	TCMT 06 T1 02		
14.0	09	16	R429U-E16-14084TC09	16.00	84.00	145.00	7.00	20	0.275	1	TCMT 09 02 02		
17.0	09	16	R429U-E16-17096TC09	16.00	96.00	157.00	8.50	20	0.391	1	TCMT 09 02 02		
20.0	09	16	R429U-E16-20096TC09	16.00	96.00	157.00	10.00	20	0.394	1	TCMT 09 02 02		
23.0	09	16	R429U-E16-23096TC09	16.00	96.00	157.00	11.50	20	0.395	1	TCMT 09 02 02		
26.0	09	16	R429U-E16-26096TC09	16.00	96.00	157.00	13.00	20	0.395	1	TCMT 09 02 02		

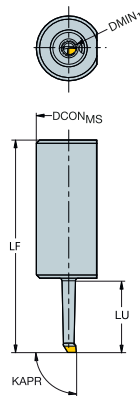
For inserts, see Turning tools catalogue

## Solid boring bar for fine boring head



KAPR

90°



				Dimensions, mm														
DMN <sub>1</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	P	M	K	N	S	HT0F	HT0F	HT0F	HT0F	DCON <sub>MS</sub>	LU	LF	WF	BAR	KG
3.0	12	1	R429.90-03-013-01-CB	*	*	*	*	*	*	*	*	*	12.00	13.50	40.00	1.50	20	0.039
5.0	12	1	R429.90-05-021-02-CB	*	*	*	*	*	*	*	*	*	12.00	21.00	48.00	2.50	20	0.042

				Dimensions, mm									
DMN <sub>1</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	DCON	LU	LF	WF	BAR	KG				
3.0	16	1	R429U-E16-0301501A	16.00	15.00	76.00	1.50	20	0.102				
5.0	16	1	R429U-E16-0502502A	16.00	25.00	86.00	2.50	20	0.100				

Recommended adaptors:  
A12: A391.37A/B  
A16: A391.37A



# CoroBore® 825

Fine boring tool for high precision boring

## Application

- Conventional fine boring
- Back boring

## ISO application area



## Benefits and features

- Flexible solutions linking to any machine interface; choose between Coromant Capto and EH modular interfaces
- Achieve required overhang even at small diameters with the EH modular system
- Reliable system with rigid interfaces between head and cartridge for stable and vibration-free boring
- CoroBore 825 accurately adjusts the cutting edge manually with a resolution of 0.01 mm on diameter
- Close hole tolerances of IT6
- Available as damped tool for vibration-free boring even at long overhangs
- Coolant through the tool



[www.sandvik.coromant.com/corobore825](http://www.sandvik.coromant.com/corobore825)

## Tools

Couplings:

- Coromant Capto®
- Coromant EH
- Cylindrical shank

## Inserts

Standard inserts with dedicated grades and geometries for all materials

- CoroTurn® 107
- CoroTurn® 111 (not available as kits)



Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.



With a Silent Tools™ damper built closer to the cutting edge and a fine boring head in aluminum with reduced length, higher performance and increased productivity can be achieved.



Also available as lightweight tools. Bore large diameters with increased stability without increasing the tool weight.

# CoroBore® 826

Fine boring tool for high precision boring

## Application

- High precision fine boring

## ISO application area



## Benefits and features

- High precision coolant directed at the cutting edge for excellent chip control up to 70 bars
- Coolant through the tool and cartridge
- Stepwise click function for easy tool setting
- Reliable system with rigid interfaces between head and cartridge for stable and vibration-free boring
- Close hole tolerances up to IT6
- CoroBore® 826 high precision adjusts the cutting edge with a resolution of 2 micrometer on diameter



[www.sandvik.coromant.com/corobore826](http://www.sandvik.coromant.com/corobore826)

## Tools

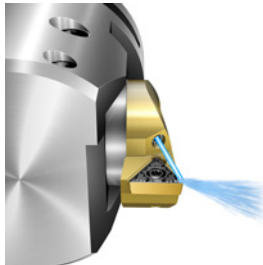
- Couplings:
- Coromant Capto®

## Inserts

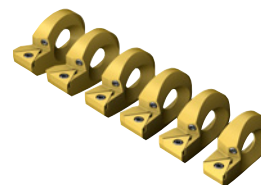
- Standard inserts with dedicated grades and geometries for all materials
- CoroTurn® 107



Each click adjusts diameter 0.002 mm. A 360° turn change diameter by 0.1 mm. Total diameter change on fine boring head 1.1-1.3 mm.



High precision coolant nozzle for precise coolant flow to cutting edge



Extend diameter range by using cartridge kits! See page K84

# CoroBore® 825 fine boring tool

Coromant Capto® - Internal coolant supply

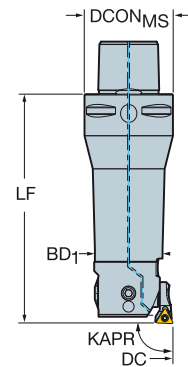
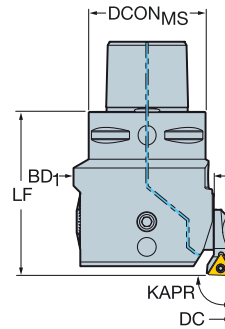
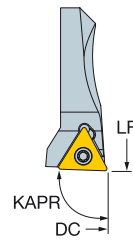


- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR  
DSGN

92°  
1

92°  
2



							Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	DSGN	Ordering code	DCON <sub>MS</sub>	ADJL <sub>RDL</sub>	ULDR	LF	BD <sub>1</sub>			CICT	MIID	
19.00	23.00	06	C3	3	2	825-23TC06-C3	32.00	2.00	3.00	89.00	18.00	70	0.430	1	TCMT 06 T1 02	
23.00	29.00	06	C3	3	2	825-29TC06-C3	32.00	3.00	2.00	76.00	20.00	70	0.414	1	TCMT 06 T1 02	
23.00	29.00	06	C4	3	2	825-29TC06-C4	40.00	3.00	2.00	85.00	20.00	70	0.897	1	TCMT 06 T1 02	
28.00	36.00	06	C3	3	2	825-36TC06-C3	32.00	4.00	2.00	83.00	25.00	70	0.692	1	TCMT 06 T1 02	
28.00	36.00	06	C4	3	2	825-36TC06-C4	40.00	4.00	2.00	95.00	25.00	70	0.992	1	TCMT 06 T1 02	
35.00	45.00	09	C3	3	1	825-45TC09-C3	32.00	5.00		48.00	32.00	70	0.641	1	TCMT 09 02 04	
35.00	45.00	09	C4	3	2	825-45TC09-C4	40.00	5.00	1.50	83.00	32.00	70	1.007	1	TCMT 09 02 04	
44.00	56.00	09	C4	3	1	825-56TC09-C4	40.00	6.00		56.00	40.00	70	0.874	1	TCMT 09 02 04	
44.00	56.00	09	C5	3	2	825-56TC09-C5	50.00	6.00	1.50	98.00	40.00	70	1.600	1	TCMT 09 02 04	
55.00	70.00	11	C5	3	1	825-70TC11-C5	50.00	7.50		66.00	50.00	70	1.430	1	TCMT 11 03 04	
55.00	70.00	11	C6	3	2	825-70TC11-C6	63.00	7.50	1.50	120.00	50.00	70	2.620	1	TCMT 11 03 04	
69.00	87.00	11	C5	3	1	825-87TC11-C5	50.00	9.00		70.00	63.00	70	1.930	1	TCMT 11 03 04	
69.00	87.00	11	C6	3	1	825-87TC11-C6	63.00	9.00		78.00	63.00	70	2.360	1	TCMT 11 03 04	
86.00	107.00	11	C5	3	1	825-107TC11-C5	50.00	10.50		76.00	80.00	70	2.240	1	TCMT 11 03 04	
86.00	107.00	11	C6	3	1	825-107TC11-C6	63.00	10.50		90.00	80.00	70	3.180	1	TCMT 11 03 04	
106.00	137.00	11	C6	3	1	825-137TC11-C6	63.00	15.50		90.00	100.00	70	3.792	1	TCMT 11 03 04	
106.00	137.00	11	C8	3	1	825-137TC11-C8	80.00	15.50		100.00	100.00	70	5.045	1	TCMT 11 03 04	
136.00	167.00	11	C6	3	1	825-167TC11-C6	63.00	15.50		90.00	130.00	70	4.430	1	TCMT 11 03 04	
136.00	167.00	11	C8	3	1	825-167TC11-C8	80.00	15.50		100.00	130.00	70	5.570	1	TCMT 11 03 04	

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC\*ULDR





K89



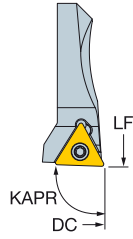
# CoroBore® 825 fine boring tool

Cylindrical shank - Internal coolant supply

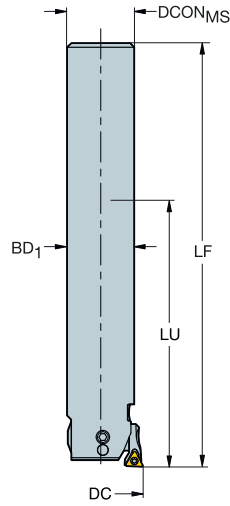


-  TCMT, TCMX, TCGT, TCGX, TCEX
-  TCMW




KAPR



92°



Dimensions, mm

DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>FDL</sub>	LU	LF	BD <sub>1</sub>			CICT	MID
19.00	23.00	06	18	1	825-23TC06-A18	18.00	2.00	77.00	128.00	18.00	70	0.731	1	TCMT 06 T1 02
23.00	29.00	06	20	1	825-29TC06-A20	20.00	3.00	81.00	132.00	20.00	70	0.606	1	TCMT 06 T1 02
28.00	36.00	06	25	1	825-36TC06-A25	25.00	4.00	101.00	158.00	25.00	70	0.951	1	TCMT 06 T1 02

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



# CoroBore® 825 fine boring tool

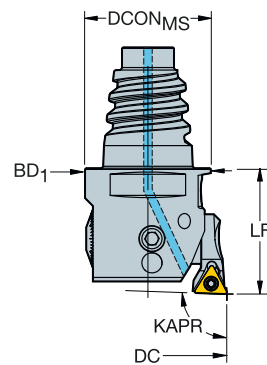
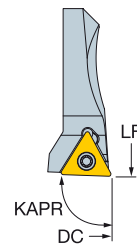
Coromant EH coupling - Internal coolant supply



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR

92°



					Dimensions, mm								
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	BD <sub>1</sub>			CICT	MIID
19.00	23.00	06	E16	1	825-23TC06-EH16	15.50	2.00	25.00	18.00	70	0.500	1	TCMT 06 T1 02
23.00	29.00	06	E20	1	825-29TC06-EH20	19.30	3.00	25.00	20.00	70	0.600	1	TCMT 06 T1 02
28.00	36.00	06	E25	1	825-36TC06-EH25	24.20	4.00	25.00	25.00	70	0.687	1	TCMT 06 T1 02

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



K89

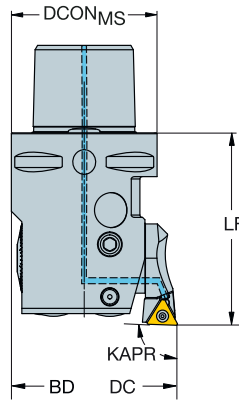


# CoroBore® 826 fine boring tool

Coromant Capto® - Precision coolant supply

KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

						Dimensions, mm							
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>FDL</sub>	LF	BD <sub>1</sub>			CICT	MIID
35.45	36.55	09	C3	3	826-36TC09-C3HP	32.00	0.55	48.00	32.00	70	0.566	1	TCMT 09 02 04
36.45	37.55	09	C3	3	826-37TC09-C3HP	32.00	0.55	48.00	32.00	70	0.565	1	TCMT 09 02 04
37.45	38.55	09	C3	3	826-38TC09-C3HP	32.00	0.55	48.00	32.00	70	0.631	1	TCMT 09 02 04
38.45	39.55	09	C3	3	826-39TC09-C3HP	32.00	0.55	48.00	32.00	70	0.640	1	TCMT 09 02 04
39.45	40.55	09	C3	3	826-40TC09-C3HP	32.00	0.55	48.00	32.00	70	0.647	1	TCMT 09 02 04
40.45	41.55	09	C3	3	826-41TC09-C3HP	32.00	0.55	48.00	32.00	70	0.290	1	TCMT 09 02 04
41.45	42.55	09	C3	3	826-42TC09-C3HP	32.00	0.55	48.00	32.00	70	0.290	1	TCMT 09 02 04
42.45	43.55	09	C3	3	826-43TC09-C3HP	32.00	0.55	48.00	32.00	70	0.290	1	TCMT 09 02 04
43.45	44.55	09	C3	3	826-44TC09-C3HP	32.00	0.55	48.00	32.00	70	0.290	1	TCMT 09 02 04
44.45	45.55	09	C4	3	826-45TC09-C4HP	40.00	0.55	56.00	40.00	70	0.591	1	TCMT 09 02 04
45.45	46.55	09	C4	3	826-46TC09-C4HP	40.00	0.55	56.00	40.00	70	0.570	1	TCMT 09 02 04
46.45	47.55	09	C4	3	826-47TC09-C4HP	40.00	0.55	56.00	40.00	70	1.104	1	TCMT 09 02 04
47.45	48.55	09	C4	3	826-48TC09-C4HP	40.00	0.55	56.00	40.00	70	0.570	1	TCMT 09 02 04
48.45	49.55	09	C4	3	826-49TC09-C4HP	40.00	0.55	56.00	40.00	70	0.570	1	TCMT 09 02 04
49.45	50.55	09	C4	3	826-50TC09-C4HP	40.00	0.55	56.00	40.00	70	0.918	1	TCMT 09 02 04
50.45	51.55	09	C4	3	826-51TC09-C4HP	40.00	0.55	56.00	40.00	70	0.570	1	TCMT 09 02 04
51.45	52.55	09	C4	3	826-52TC09-C4HP	40.00	0.55	56.00	40.00	70	0.940	1	TCMT 09 02 04
52.45	53.55	09	C4	3	826-53TC09-C4HP	40.00	0.55	56.00	40.00	70	0.570	1	TCMT 09 02 04
53.45	54.55	09	C4	3	826-54TC09-C4HP	40.00	0.55	56.00	40.00	70	0.570	1	TCMT 09 02 04
54.45	55.55	09	C4	3	826-55TC09-C4HP	40.00	0.55	56.00	40.00	70	0.570	1	TCMT 09 02 04
55.35	56.65	11	C5	3	826-56TC11-C5HP	50.00	0.65	66.00	50.00	70	1.397	1	TCMT 11 03 04
56.35	57.65	11	C5	3	826-57TC11-C5HP	50.00	0.65	66.00	50.00	70	1.455	1	TCMT 11 03 04
57.35	58.65	11	C5	3	826-58TC11-C5HP	50.00	0.65	66.00	50.00	70	1.414	1	TCMT 11 03 04
58.35	59.65	11	C5	3	826-59TC11-C5HP	50.00	0.65	66.00	50.00	70	1.070	1	TCMT 11 03 04
59.35	60.65	11	C5	3	826-60TC11-C5HP	50.00	0.65	66.00	50.00	70	1.466	1	TCMT 11 03 04
60.35	61.65	11	C5	3	826-61TC11-C5HP	50.00	0.65	66.00	50.00	70	1.070	1	TCMT 11 03 04
61.35	62.65	11	C5	3	826-62TC11-C5HP	50.00	0.65	66.00	50.00	70	1.070	1	TCMT 11 03 04
62.35	63.65	11	C5	3	826-63TC11-C5HP	50.00	0.65	66.00	50.00	70	1.426	1	TCMT 11 03 04
63.35	64.65	11	C5	3	826-64TC11-C5HP	50.00	0.65	66.00	50.00	70	1.503	1	TCMT 11 03 04
64.35	65.65	11	C5	3	826-65TC11-C5HP	50.00	0.65	66.00	50.00	70	1.520	1	TCMT 11 03 04
65.35	66.65	11	C5	3	826-66TC11-C5HP	50.00	0.65	66.00	50.00	70	1.070	1	TCMT 11 03 04
66.35	67.65	11	C5	3	826-67TC11-C5HP	50.00	0.65	66.00	50.00	70	1.070	1	TCMT 11 03 04
67.35	68.65	11	C5	3	826-68TC11-C5HP	50.00	0.65	66.00	50.00	70	1.070	1	TCMT 11 03 04
68.35	69.65	11	C5	3	826-69TC11-C5HP	50.00	0.65	66.00	50.00	70	1.070	1	TCMT 11 03 04
69.35	70.65	11	C5	3	826-70TC11-C5HP	50.00	0.65	66.00	50.00	70	1.455	1	TCMT 11 03 04
70.35	71.65	11	C5	3	826-71TC11-C5HP	50.00	0.65	66.00	50.00	70	1.070	1	TCMT 11 03 04
71.35	72.65	11	C5	3	826-72TC11-C5HP	50.00	0.65	66.00	50.00	70	1.070	1	TCMT 11 03 04
72.35	73.65	11	C5	3	826-73TC11-C5HP	50.00	0.65	66.00	50.00	70	1.557	1	TCMT 11 03 04
73.35	74.65	11	C6	3	826-74TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
74.35	75.65	11	C6	3	826-75TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
75.35	76.65	11	C6	3	826-76TC11-C6HP	63.00	0.65	78.00	63.00	70	2.400	1	TCMT 11 03 04
76.35	77.65	11	C6	3	826-77TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
77.35	78.65	11	C6	3	826-78TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
78.35	79.65	11	C6	3	826-79TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)  
 For inserts, see Turning tools catalogue



L2



N23



N15





K89



# CoroBore® 826 fine boring tool

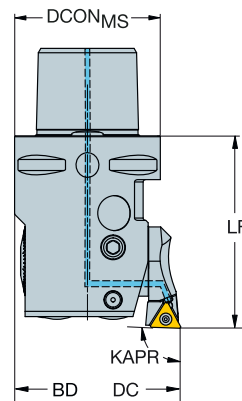
Coromant Capto® - Precision coolant supply






-  TCMT, TCMX, TCGT, TCGX, TCEX
-  TCMW

KAPR

92°



					Dimensions, mm								
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	BD <sub>1</sub>			CICT	MIID
79.35	80.65	11	C6	3	826-80TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
80.35	81.65	11	C6	3	826-81TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
81.35	82.65	11	C6	3	826-82TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
82.35	83.65	11	C6	3	826-83TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
83.35	84.65	11	C6	3	826-84TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
84.35	85.65	11	C6	3	826-85TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
85.35	86.65	11	C6	3	826-86TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
86.35	87.65	11	C6	3	826-87TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
87.35	88.65	11	C6	3	826-88TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
88.35	89.65	11	C6	3	826-89TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
89.35	90.65	11	C6	3	826-90TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04
90.35	91.65	11	C6	3	826-91TC11-C6HP	63.00	0.65	78.00	63.00	70	1.940	1	TCMT 11 03 04

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



L2



N23



N15



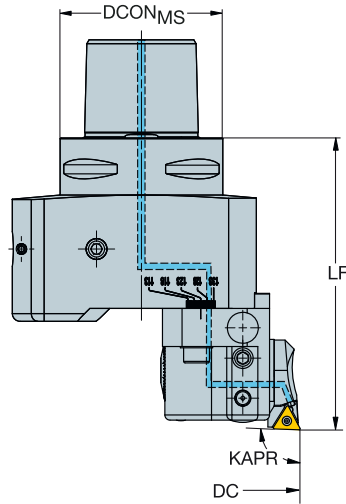
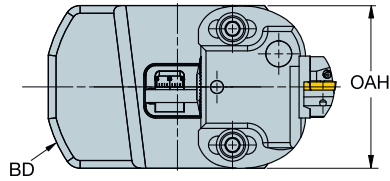
K89

# CoroBore® 826 fine boring tool

Coromant Capto® - Internal coolant supply

KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID
91.35	112.65	11	C6	3	826-112TC11-C6HP	63.00	10.65	113.00	63.00	85.00	70	3.215	1	TCMT 11 03 04
112.35	133.65	11	C6	3	826-133TC11-C6HP	63.00	10.65	113.00	63.00	105.00	70	3.645	1	TCMT 11 03 04
133.35	154.65	11	C6	3	826-154TC11-C6HP	63.00	10.65	113.00	63.00	125.00	70	3.940	1	TCMT 11 03 04

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)  
 For inserts, see Turning tools catalogue



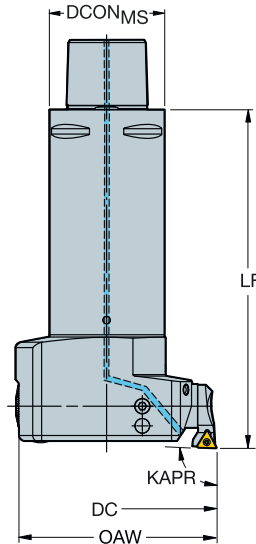
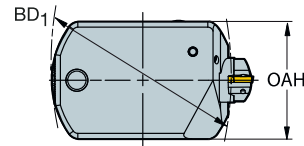
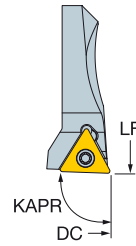
# CoroBore® 825 lightweight fine boring tool

Coromant Capto® - Internal coolant supply



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

					Dimensions, mm											
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>REDL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID		
69.00	87.00	11	C5	3	825L-87TC11-C5	50.00	9.00	150.00	51.00	63.00	70	2.150	1	TCMT 11 03 04		
86.00	107.00	11	C5	3	825L-107TC11-C5	50.00	10.50	156.00	51.00	80.00	70	2.230	1	TCMT 11 03 04		
106.00	137.00	11	C6	3	825L-137TC11-C6	63.00	15.50	190.00	64.00	100.00	70	3.970	1	TCMT 11 03 04		
106.00	137.00	11	C8	3	825L-137TC11-C8	80.00	15.50	200.00	80.00	100.00	70	4.885	1	TCMT 11 03 04		
136.00	167.00	11	C8	3	825L-167TC11-C8	80.00	15.50	200.00	80.00	130.00	70	5.160	1	TCMT 11 03 04		

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



K89



# CoroBore® 825 damped fine boring tool

Coromant Capto® - Internal coolant supply

KAPR  
DSGN

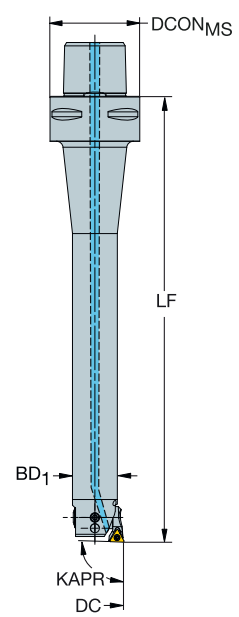
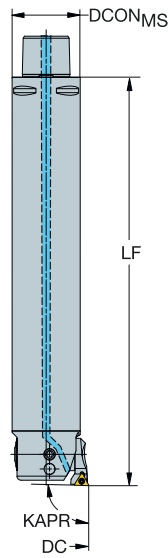
92°  
1

92°  
2

●●● SilentTools®



- TCMT, TCMX, TCGT, TCGX, TCXEX
- TCMW



		Dimensions, mm														
DCN	DCX		CZC <sub>MS</sub>	CNSC	DSGN	Ordering code	DCON <sub>MS</sub>	ADJL <sub>RDL</sub>	ULDR	LF	OAH	BD <sub>1</sub>			CICT	MIID
19.00	23.00	06	C4	3	2	825D-23TC06U-C4L	40.00	2.00	6.00	163.00	18.00	70	0.568	1	TCMT 06 T1 02	
23.00	29.00	06	C4	3	2	825D-29TC06U-C4L	40.00	3.00	6.00	199.00	20.00	70	0.728	1	TCMT 06 T1 02	
28.00	36.00	06	C3	3	2	825D-36TC06U-C3L	32.00	4.00	6.00	216.00	25.00	70	0.968	1	TCMT 06 T1 02	
35.00	45.00	09	C3	3	1	825D-45TC09U-C3L	32.00	5.00	6.00	221.00	32.00	70	1.484	1	TCMT 09 02 04	
35.00	45.00	09	C4	3	2	825D-45TC09U-C4L	40.00	5.00	6.00	270.00	32.00	70	1.924	1	TCMT 09 02 04	
35.00	45.00	09	C6	3	2	825D-45TC09U-C6L	63.00	5.00	6.00	297.00	32.00	70	2.574	1	TCMT 09 02 04	
44.00	56.00	09	C4	3	1	825D-56TC09U-C4L	40.00	6.00	6.00	220.00	40.00	70	2.124	1	TCMT 09 02 04	
44.00	56.00	09	C5	3	2	825D-56TC09U-C5L	50.00	6.00	6.00	336.00	40.00	70	3.744	1	TCMT 09 02 04	
44.00	56.00	09	C6	3	2	825D-56TC09U-C6L	63.00	6.00	6.00	363.00	40.00	70	4.384	1	TCMT 09 02 04	
55.00	70.00	11	C5	3	1	825D-70TC11U-C5M	50.00	7.50	6.00	300.00	50.00	70	4.940	1	TCMT 11 03 04	
55.00	70.00	11	C6	3	2	825D-70TC11U-C6M	63.00	7.50	5.60	400.00	50.00	70	6.789	1	TCMT 11 03 04	
69.00	87.00	11	C6	3	1	825D-87TC11U-C6M	63.00	9.00	6.00	400.00	63.00	70	9.659	1	TCMT 11 03 04	
69.00	87.00	11	C8	3	2	825D-87TC11U-C8S	80.00	9.00	5.60	500.00	63.00	70	12.869	1	TCMT 11 03 04	
86.00	107.00	11	C6	3	1	825D-107TC11U-C6M	63.00	10.50	6.00	400.00	64.00	80.00	70	9.729	1	TCMT 11 03 04
86.00	107.00	11	C8	3	1	825D-107TC11U-C8M	80.00	10.50	6.00	500.00	80.00	70	18.089	1	TCMT 11 03 04	
86.00	107.00	11	C8	3	1	825D-107TC11U-C8S	80.00	10.50	6.00	410.00	80.00	70	15.669	1	TCMT 11 03 04	
106.00	137.00	11	C6	3	1	825D-137TC11U-C6M	63.00	15.50	6.00	400.00	64.00	100.00	70	9.809	1	TCMT 11 03 04
106.00	137.00	11	C8	3	1	825D-137TC11U-C8M	80.00	15.50	6.00	500.00	81.00	100.00	70	18.199	1	TCMT 11 03 04
106.00	137.00	11	C8	3	1	825D-137TC11U-C8S	80.00	15.50	6.00	400.00	81.00	100.00	70	15.759	1	TCMT 11 03 04
136.00	167.00	11	C8	3	1	825D-167TC11U-C8S	80.00	15.50	6.00	500.00	81.00	130.00	70	18.359	1	TCMT 11 03 04

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K89

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



L2



N23



N15



K89

# CoroBore® 825 XL/CoroBore® 826 XL

Fine boring tool for large diameters

## Application

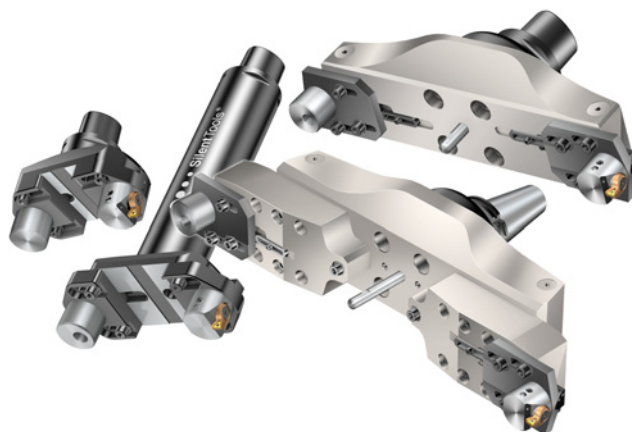
- Fine boring
- Back boring
- External operations

## ISO application area



## Benefits and features

- Reliable system with rigid interfaces between head and cartridge for stable and vibration-free boring
- Dedicated tool holders optimized for large diameter boring
- Close hole tolerances (up to IT5 for CoroBore 826)
- Cartridge designed for highest stability
- Cutting fluid through the tool
- Diameter 298-1275 mm is made of high strength aluminium, which reduces assembly weight
- Hard coated for surface protection
- Use slide extensions for radial adjustment and back boring
- Strong modular base for building assemblies in different application (rough boring, fine boring, face grooving, spiro grooving and interpolation turning)



[www.sandvik.coromant.com/corobore825](http://www.sandvik.coromant.com/corobore825)

●●●● SilentTools®

## Tools

Couplings:

- Coromant Capto®
- Arbor

## Inserts

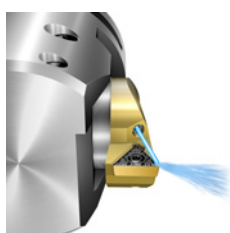
Standard inserts with dedicated grades and geometries for all materials

- CoroTurn® 107

## Diameter adjustment:

825 - Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.

826 - Each click adjusts diameter 0.002 mm. A 360° turn change diameter by 0.1 mm. Total diameter change on fine boring head 1.1-1.3 mm.



High precision coolant nozzle for precise coolant flow to cutting edge

Available as lightweight tools. Bore large diameters without increasing the tool weight.



Use same bridge/bridge extension for roughing, finishing and face grooving from diameter 150 mm (counterweight needed for finishing).

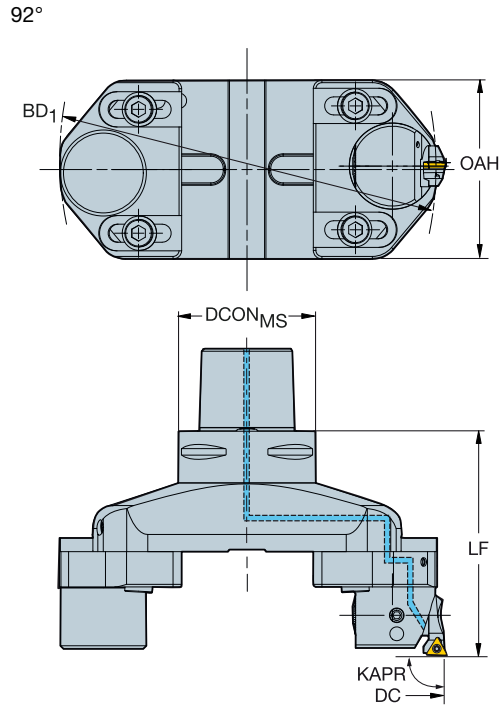
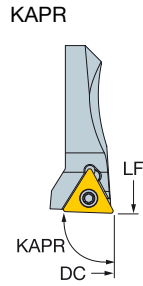
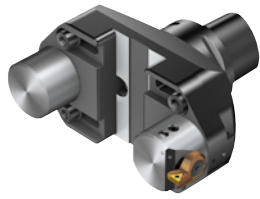


Use slide extensions for radial adjustment and back boring



# CoroBore® 825 XL fine boring tool

Coromant Capto® - Internal coolant supply



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>ROL</sub>	LF	OAH	BD <sub>1</sub>	BAR	KG	CICT	MIID
148.00	215.00	11	C6	3	825-215TC11-C6	63.00	33.50	118.00	104.00	145.00	70	4.534	1	TCMT 11 03 04
148.00	215.00	11	C8	3	825-215TC11-C8	80.00	33.50	130.00	104.00	145.00	70	7.500	1	TCMT 11 03 04
148.00	215.00	11	C10	3	825-215TC11-C10	100.00	33.50	136.00	104.00	145.00	70	9.460	1	TCMT 11 03 04
198.00	265.00	11	C6	3	825-265TC11-C6	63.00	33.50	118.00	104.00	195.00	70	4.750	1	TCMT 11 03 04
198.00	265.00	11	C8	3	825-265TC11-C8	80.00	33.50	130.00	104.00	195.00	70	9.100	1	TCMT 11 03 04
198.00	265.00	11	C10	3	825-265TC11-C10	100.00	33.50	136.00	104.00	195.00	70	10.850	1	TCMT 11 03 04
248.00	315.00	11	C6	3	825-315TC11-C6	63.00	33.50	118.00	104.00	245.00	70	5.400	1	TCMT 11 03 04
248.00	315.00	11	C8	3	825-315TC11-C8	80.00	33.50	130.00	104.00	245.00	70	10.350	1	TCMT 11 03 04
248.00	315.00	11	C10	3	825-315TC11-C10	100.00	33.50	136.00	104.00	245.00	70	12.570	1	TCMT 11 03 04

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

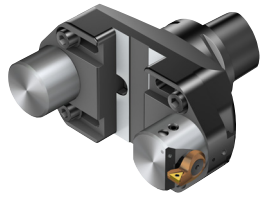
For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



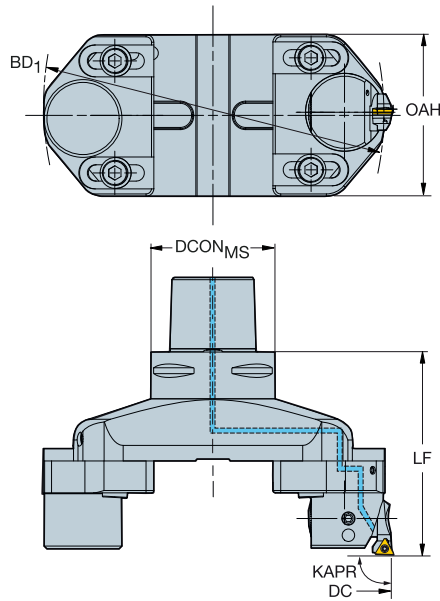
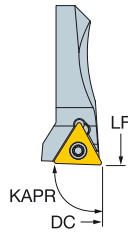
# CoroBore® 826 XL fine boring tool

Coromant Capto® - Internal coolant supply



KAPR  
STDNO

92°  
ISO26623-1



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

							Dimensions, mm								
DCN	DCX			GZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>FDL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID
154.35	207.65	11	1/4	C6	3	826-207TC11-C6HP	63.00	26.65	125.00	104.00	145.00	70	3.560	1	TCMT 11 03 04
154.35	207.65	11	1/4	C8	3	826-207TC11-C8HP	80.00	26.65	137.00	104.00	145.00	70	6.430	1	TCMT 11 03 04
204.35	257.65	11	1/4	C6	3	826-257TC11-C6HP	63.00	26.65	125.00	104.00	195.00	70	3.880	1	TCMT 11 03 04
204.35	257.65	11	1/4	C8	3	826-257TC11-C8HP	80.00	26.65	137.00	104.00	195.00	70	7.630	1	TCMT 11 03 04
254.35	307.65	11	1/4	C6	3	826-307TC11-C6HP	63.00	26.65	125.00	104.00	245.00	70	4.240	1	TCMT 11 03 04
254.35	307.65	11	1/4	C8	3	826-307TC11-C8HP	80.00	26.65	137.00	104.00	245.00	70	8.720	1	TCMT 11 03 04

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about use of slide extensions, see page K92

For more information about external boring, see page K94

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue

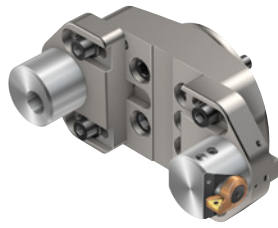


K90



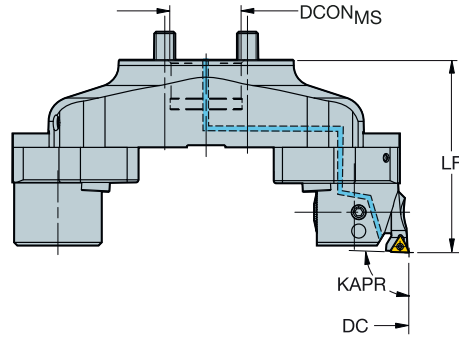
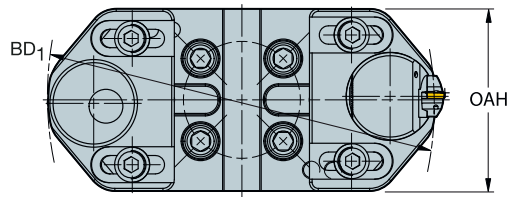
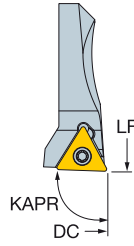
# CoroBore® 825 XL lightweight fine boring tool

Arbor - Internal coolant supply



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

					Dimensions, mm											
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>ROL</sub>	LF	OAH	BD <sub>1</sub>	BAR	KG	CICT	MIID		
148.00	215.00	11	40S	1	825L-215TC11	40.00	33.50	110.00	104.00	145.00	70	4.450	1	TCMT 11 03 04		
198.00	265.00	11	40S	1	825L-265TC11	40.00	33.50	110.00	104.00	195.00	70	4.920	1	TCMT 11 03 04		
248.00	315.00	11	40S	1	825L-315TC11	40.00	33.50	110.00	104.00	245.00	70	5.370	1	TCMT 11 03 04		

Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.

Diameters are valid when frontboring.

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

For more information about external boring, see page K94

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

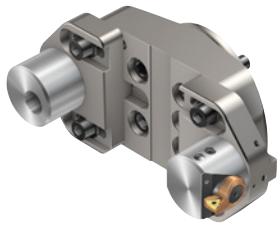
For inserts, see Turning tools catalogue





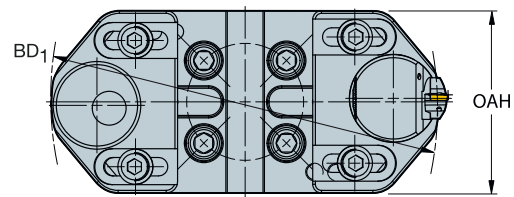
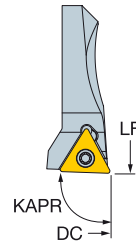
# CoroBore® 826 XL lightweight fine boring tool

Arbor - Internal coolant supply

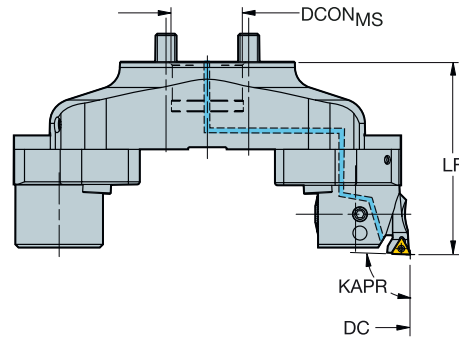


KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



						Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ISO	ADJL <sub>RDL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MID
154.35	207.65	11	40S	1	826L-207TC11HP	40.00	C	26.65	117.00	104.00	145.00	70	3.310	1	TCMT 11 03 04
204.35	257.65	11	40S	1	826L-257TC11HP	40.00	C	26.65	117.00	104.00	195.00	70	3.650	1	TCMT 11 03 04
254.35	307.65	11	40S	1	826L-307TC11HP	40.00	C	26.65	117.00	104.00	245.00	70	4.320	1	TCMT 11 03 04

Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K94

For more information about use of slide extensions, see page K90

Diameters are valid when frontboring.

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue

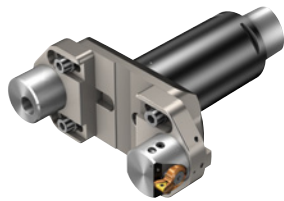


K90



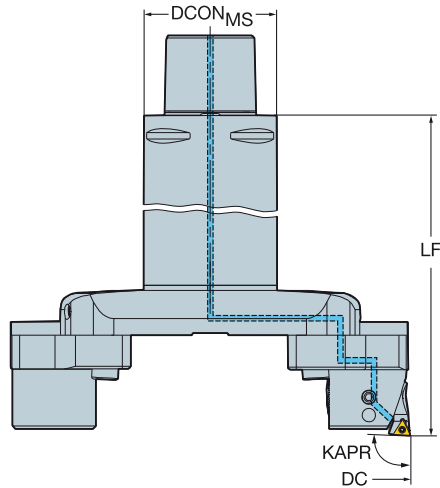
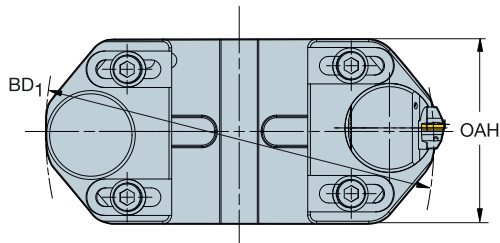
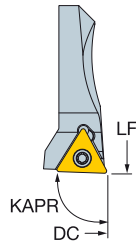
# CoroBore® 825 XL lightweight fine boring tool

Coromant Capto® - Internal coolant supply



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BD <sub>1</sub>	BAR	KG	CICT	MIID
148.00	215.00	11	C8	3	825L-215TC11-C8	80.00	33.50	230.00	104.00	145.00	70	7.640	1	TCMT 11 03 04
198.00	265.00	11	C8	3	825L-265TC11-C8	80.00	33.50	230.00	104.00	195.00	70	8.320	1	TCMT 11 03 04
248.00	315.00	11	C8	3	825L-315TC11-C8	80.00	33.50	230.00	104.00	245.00	70	8.680	1	TCMT 11 03 04

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



L2



N23



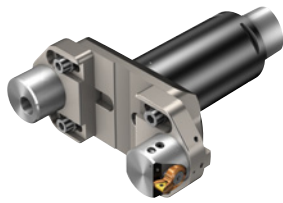
N15



K90

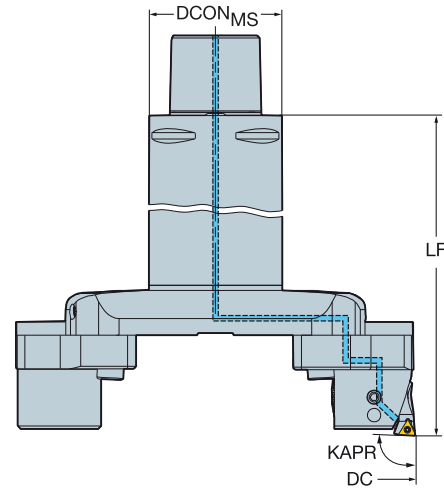
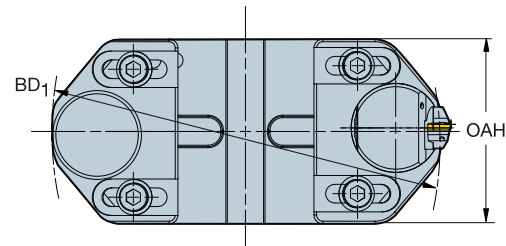
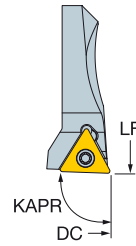
# CoroBore® 826 XL lightweight fine boring tool

Coromant Capto® - Internal coolant supply



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID
154.35	207.65	11	C8	3	826L-207TC11-C8HP	80.00	26.65	237.00	104.00	145.00	70	6.300	1	TCMT 11 03 04
204.35	257.65	11	C8	3	826L-257TC11-C8HP	80.00	26.65	237.00	104.00	195.00	70	6.660	1	TCMT 11 03 04
254.35	307.65	11	C8	3	826L-307TC11-C8HP	80.00	26.65	237.00	104.00	245.00	70	7.030	1	TCMT 11 03 04

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K94

For more information about use of slide extensions, see page K90

Diameters are valid when frontboring.

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue

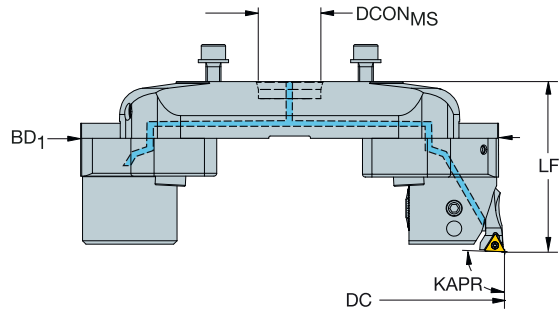
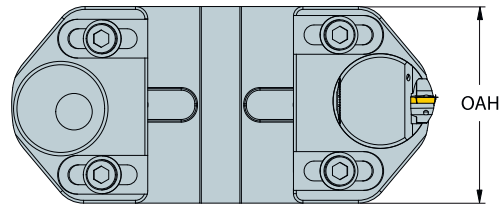
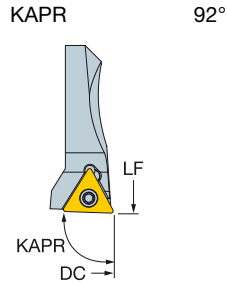
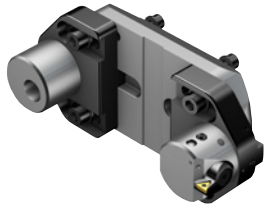


K90

# CoroBore® 825 XL fine boring tool

Arbor - Internal coolant supply

Dedicated for Silent Tools boring



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID
148.00	215.00	11	33	1	825D-215TC11	33.00	33.50	90.00	104.00	145.00	70	2.620	1	TCMT 11 03 04
198.00	265.00	11	33	1	825D-265TC11	33.00	33.50	90.00	104.00	195.00	70	2.940	1	TCMT 11 03 04
248.00	315.00	11	33	1	825D-315TC11	33.00	33.50	90.00	104.00	245.00	70	4.190	1	TCMT 11 03 04

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

These light weight assemblies are dedicated for use with damped boring adaptors. Damped adaptors are bought separately, see page K77.

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



K77



N23



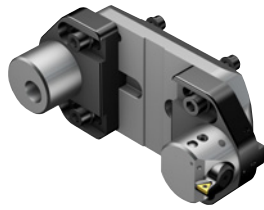
N15



K90

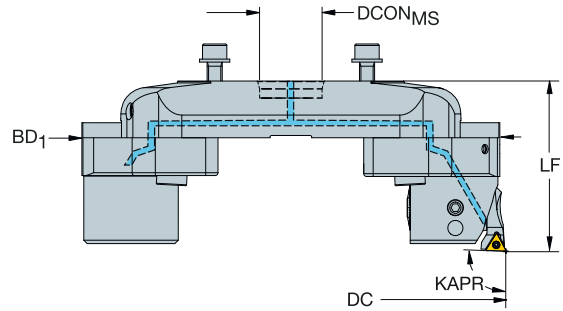
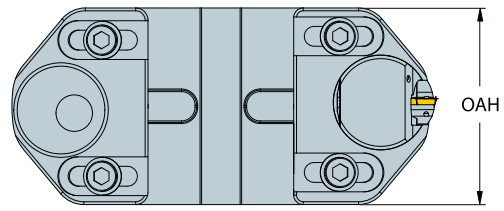
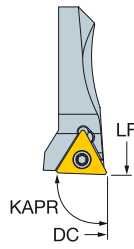
# CoroBore® 826 XL fine boring tool

Arbor - Internal coolant supply  
Dedicated for Silent Tools boring



KAPR

92°



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

						Dimensions, mm								
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID
154.35	207.65	11	33	1	826D-207TC11HP	33.00	26.65	97.00	104.00	145.00	70	2.770	1	TCMT 11 03 04
204.35	257.65	11	33	1	826D-257TC11HP	33.00	26.65	97.00	104.00	195.00	70	3.110	1	TCMT 11 03 04
254.35	307.65	11	33	1	826D-307TC11HP	33.00	26.65	97.00	104.00	245.00	70	3.470	1	TCMT 11 03 04

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K94

For more information about use of slide extensions, see page K90

These light weight assemblies are dedicated for use with damped boring adaptors. Damped adaptors are bought separately, see page K77.

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



K77



N23



N15

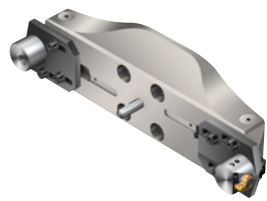


K90

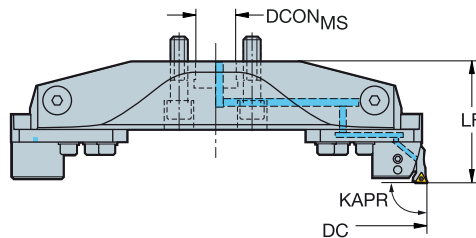
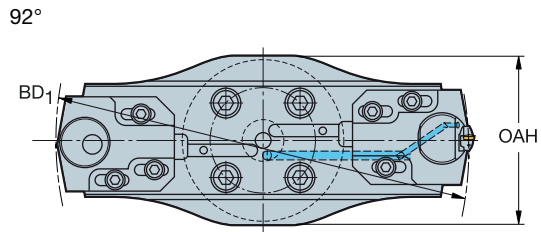
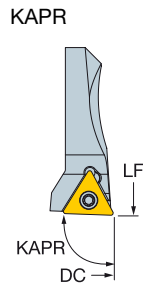


# CoroBore® 825 XL fine boring tool

Arbor - Internal coolant supply



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



					Dimensions, mm										
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>ROL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID	
298.00	395.00	11	40X	1	825-395TC11	40.00	48.50	114.00	164.00	295.00	70	10.385	1	TCMT 11 03 04	
378.00	475.00	11	40X	1	825-475TC11	40.00	48.50	119.00	164.00	375.00	70	12.280	1	TCMT 11 03 04	
458.00	555.00	11	40X	1	825-555TC11	40.00	48.50	124.00	164.00	455.00	70	16.400	1	TCMT 11 03 04	

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

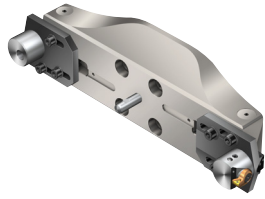
For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



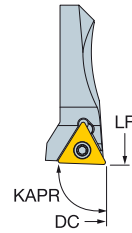
# CoroBore® 826 XL fine boring tool

Arbor - Internal coolant supply

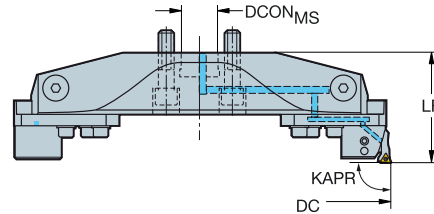
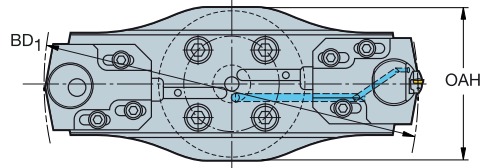


- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW

KAPR



92°



							Dimensions, mm								
DCN	DCX			CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>BDL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID
304.35	387.65	11	1/4	40X	1	826-387TC11HP	40.00	41.65	121.00	164.00	295.00	70	8.870	1	TCMT 11 03 04
384.35	467.65	11	1/4	40X	1	826-467TC11HP	40.00	41.65	126.00	164.00	375.00	70	10.400	1	TCMT 11 03 04
464.35	547.65	11	1/4	40X	1	826-547TC11HP	40.00	41.65	131.00	164.00	455.00	70	12.340	1	TCMT 11 03 04

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K94

For more information about use of slide extensions, see page K90

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



K76



N23



N15



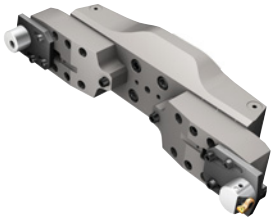
K90



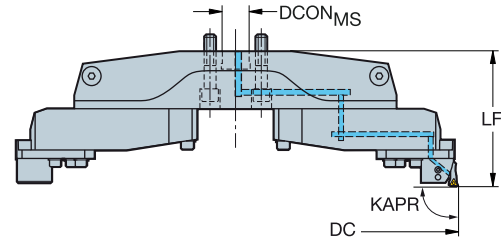
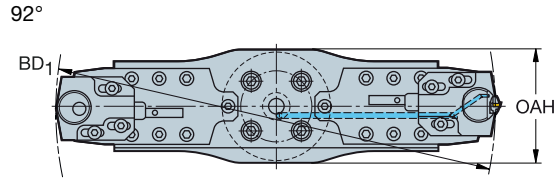
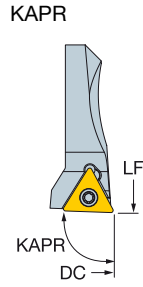
# CoroBore® 825 XL fine boring tool

Arbor - Internal coolant supply

With bridge extension



- TCMT, TCMX, TCGT, TCGX, TCEX
- TCMW



					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>TOL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID
538.00	795.00	11	40X	1	825-795TC11	40.00	128.50	198.00	164.00	535.00	70	25.640	1	TCMT 11 03 04
778.00	1035.00	11	40X	1	825-1035TC11	40.00	128.50	218.00	164.00	775.00	70	36.830	1	TCMT 11 03 04
1018.00	1275.00	11	40X	1	825-1275TC11	40.00	128.50	218.00	164.00	1015.00	70	44.260	1	TCMT 11 03 04

Diameters are valid when frontboring.

For more information about external boring, see page K94

For more information about backboring, see page K92

For more information about use of slide extensions, see page K90

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue

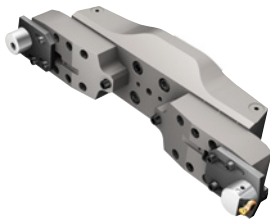




# CoroBore® 826 XL fine boring tool

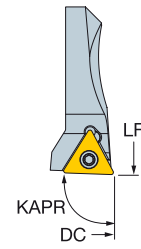
Arbor - Internal coolant supply

With bridge extension

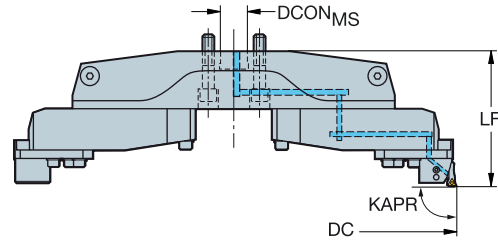
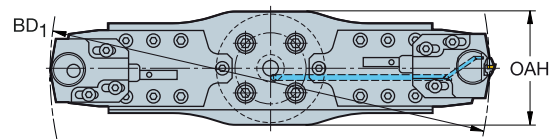


- TCMT, TCMX, TCGT, TCGX
- TCEX
- TCMW

KAPR



92°



					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LF	OAH	BD <sub>1</sub>			CICT	MIID
544.35	787.65	11	40X	1	826-787TC11HP	40.00	121.65	205.00	164.00	535.00	70	24.430	1	TCMT 11 03 04
784.35	1027.65	11	40X	1	826-1027TC11HP	40.00	121.65	225.00	164.00	775.00	70	35.060	1	TCMT 11 03 04
1024.35	1267.65	11	40X	1	826-1267TC11HP	40.00	121.65	225.00	164.00	1015.00	70	44.110	1	TCMT 11 03 04

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K94

For more information about use of slide extensions, see page K90

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



K76



N23



N15



K90

## Face grooving

	Diameter range, mm	Hole tolerance	Cutting edges	Operation	Insert choice	Machine side interface	Page
<b>CoroCut® MB</b> 	14-50	IT7	1	- Face grooving	- CoroCut® MB	- Coromant Capto®	K67
<b>CoroBore® 825 SL</b> 	47-150	IT7	1	- Face grooving	- CoroCut®	- Coromant Capto®	K68-K69
<b>CoroBore® 825 SL XL</b> 	148-1275	IT7	1	- Face grooving	- CoroCut®	- Coromant Capto® - 40X with 4 bolt circle	K70
<b>SpiroGrooving™</b> 	30-289		1 ( Internal and external )	- Spirogrooving	- CoroTurn® 107	- Coromant Capto®	K71-K73

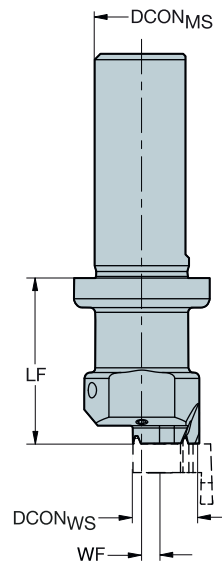
# Cylindrical shank to CoroCut® MB adaptor

For face grooving

Internal coolant supply



MB...FA



				Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	WF	BAR	KG	
16	09	1	R429U-A16-14032MB09	16.00	9.00	32.00	-2.00	20	0.115	
16	09	1	R429U-A16-19030MB09	16.00	9.00	30.00	0.50	20	0.114	
16	09	1	R429U-A16-24028MB09	16.00	9.00	28.00	3.00	20	0.120	
16	09	1	R429U-A16-29026MB09	16.00	9.00	26.00	5.50	20	0.120	
16	09	1	R429U-A16-34024MB09	16.00	9.00	24.00	8.00	20	0.129	
16	09	1	R429U-A16-39022MB09	16.00	9.00	22.00	10.50	20	0.145	
16	09	1	R429U-A16-44020MB09	16.00	9.00	20.00	13.00	20	0.153	

For CoroCut® MB cutting tools, see Turning tools catalogue

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

Recommended adaptors:

A16: 391.37A



L2



N23



N15

# CoroBore® 825 SL

## Face grooving

### Application

- Face grooving
- Axial grooving

### ISO application area:



### Benefits and features

- Increased productivity compared to milling
- Excellent chip control thanks to internal coolant to the cutting edge
- Builds on our large assortment of standard CoroTurn® SL heads and CoroCut system 1-2 inserts. ( Type left hand, A-curve )
- Radial fine-adjustable face grooving heads for pre-setting
- Rigid design with dedicated tools for small and large diameter face grooving
- Internal coolant



### Tools

#### Couplings:

- Coromant Capto®
- Arbor

### Inserts

- CoroCut® 1-2 system inserts
- Dedicated grades and geometries for all materials

CoroTurn® SL head and inserts are ordered separately.

825 - Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.



First choice geometries: -CM or -TF depending on chosen nose radius. Recommended starting value for feed: 0.15 mm/rev

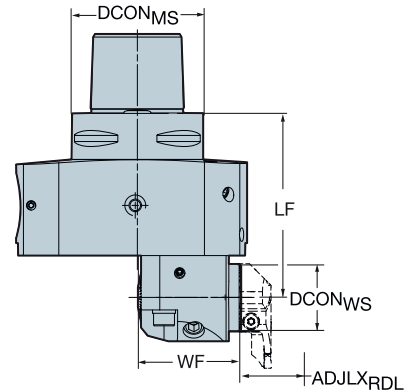
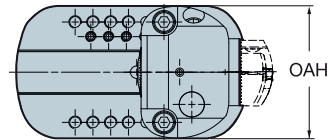
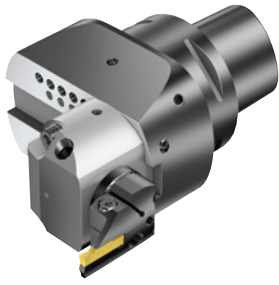
If grooves with larger width tolerance is required, chose -GF geometry. Recommended starting value for feed: 0.10 mm/rev



Radially fine adjustable face grooving heads for pre-setting with same interface as CoroBore 825 fine boring head

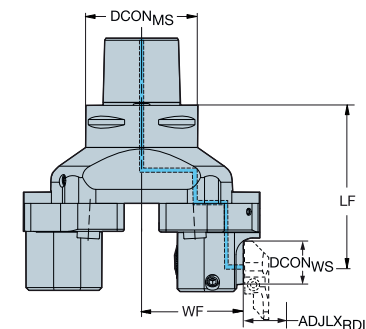
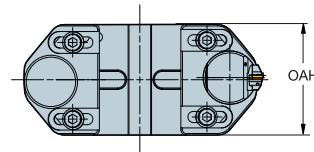
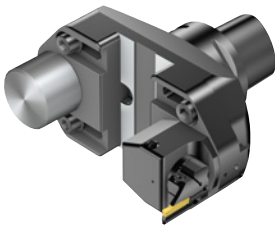
# Coromant Capto® to CoroTurn® SL adjustable adaptor

Coromant Capto® - Internal coolant supply



## CoroBore® 825 fine adjustment

				Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ADJLXR <sub>D</sub> L	LF	LPR	WF	OAH	OAW	BAR	KG
C6	32	3	825-150SL32-C6	63.00	32.00	51.50	88.00	109.00	5.50	63.40	106.00	20	4.320
C8	32	3	825-150SL32-C8	80.00	32.00	51.50	96.00	117.00	5.50	80.40	106.00	20	5.470



## CoroBore® 825 XL

				Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ADJLXR <sub>D</sub> L	LF	LPR	WF	OAH	OAW	BAR	KG
C8	32	3	825-215SL32-C8	80.00	32.00	33.50	112.00	133.00	56.00	104.00	130.00	20	8.040
C8	32	3	825-265SL32-C8	80.00	32.00	33.50	112.00	133.00	81.00	104.00	180.00	20	9.120
C8	32	3	825-315SL32-C8	80.00	32.00	33.50	112.00	133.00	106.00	104.00	230.00	20	10.750

CoroTurn® SL head diameter and tool diameter range should match the requirement of the component. For more information about CoroTurn® SL heads, see Turning tools catalogue

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



L2



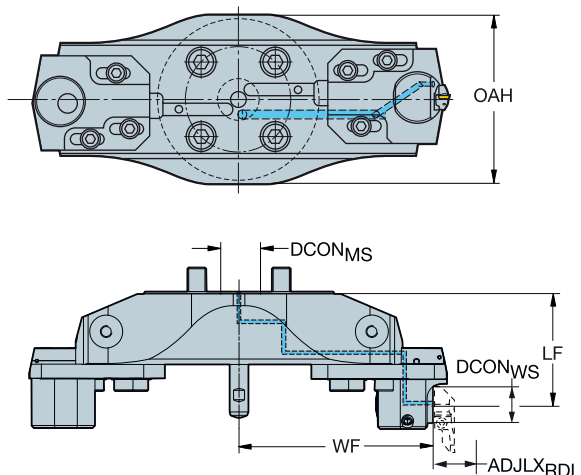
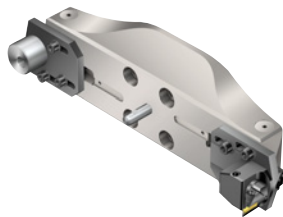
N23



N15

# Arbor to CoroTurn® SL adjustable adaptor

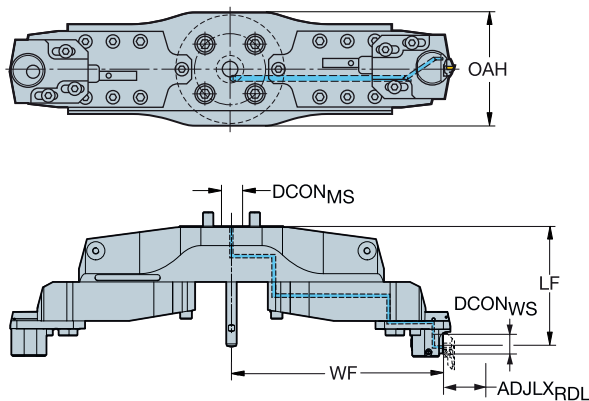
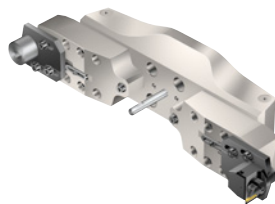
Arbor - Internal coolant supply



K

				Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ADJLXRDL	LF	LPR	WF	OAH	OAW	BAR	KG		
40X	32	1	825-395SL32	40.00	32.00	48.50	96.00	117.00	131.00	164.00	334.00	20	8.980		
40X	32	1	825-475SL32	40.00	32.00	48.50	101.00	122.00	171.00	164.00	414.00	20	12.830		
40X	32	1	825-555SL32	40.00	32.00	48.50	106.00	127.00	211.00	104.00	494.00	20	12.670		

L



M

## With bridge extension

				Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ADJLXRDL	LF	LPR	WF	OAH	OAW	BAR	KG		
40X	32	1	825-1035SL32	40.00	32.00	128.50	200.00	221.00	371.00	164.00	838.00	20	36.310		
40X	32	1	825-1275SL32	40.00	32.00	128.50	200.00	221.00	491.00	164.00	1078.00	20	43.740		
40X	32	1	825-795SL32	40.00	32.00	128.50	180.00	201.00	251.00	164.00	598.00	20	25.120		

CoroTurn® SL head diameter and tool diameter range should match the requirement of the component. For more information about CoroTurn® SL heads, see Turning tools catalogue

Use with 40X CoroBore XL holders only. To be ordered separately. See page K76.

In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

N



K76



N23



N15

# SpiroGrooving™

Machining of seal ring grooves with maximum productivity

## Application

- All 23°, R-RX and BX grooves
- Not to be used for 45° chamfer on the outer flank on BX grooves
- The SpiroGrooving™ software is required
- Recommended to programming 'mid-tolerance' sizes for depth & diameter.
- Transfer the generated NC-code to the machine control

## ISO application area:



## Benefits and features

### Process security

- Controlled chip breakage with SpiroGrooving™ tool path
- Internal coolant
- Vibration-free

### High productivity

- High machine utilization due to good chip control
- Highly efficient machining method
- Reduced cutting time through higher cutting data

### Quick and easy programming

- SpiroGrooving™ calculator for NC-code generation
- Strong modular base for building assemblies in different application (rough boring, fine boring, face grooving, spiro grooving and interpolation turning)



[www.sandvik.coromant.com/spirogrooving](http://www.sandvik.coromant.com/spirogrooving)

## Tools

- Coromant Capto®
- Built on CoroBore® XL - rigid and reliable system for maximum stability
- Cartridges available with axial and radial adjustability



## Inserts

- CoroTurn® 107 inserts (VCMT) for size 30-75 mm
- CoroTurn® 107 inserts (VBMT) for size 48-289 mm

SpiroGrooving uses a circular spirograph tool movement in a taper. This reduces chip thickness, enabling light cutting action and increased feed. Parts of the insert cutting edge have an interrupted cutting behaviour, eliminating long chips tangling to the tool and spindle.

SpiroGrooving is a unique solution for secure and productive machining of seal ring grooves on non-rotating components. Get the complete package for this unique machining method with tools and NC-code generator.

## Wondering how to program?

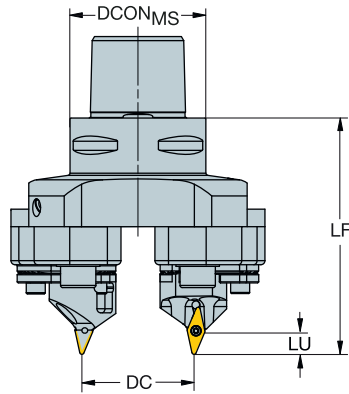
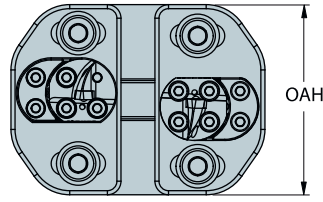
With the SpiroGrooving NC-code generator you can get your NC code in a few quick steps.

NC-code generator – input groove geometry and cutting parameters and receive an NC-code

# CoroBore® XL adjustable tool for SpiroGrooving™

Coromant Capto® - Internal coolant supply

KAPR 67°



VCMT

Radially and axially adjustable

					Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>FDL</sub>	LU	LF	OAH	BAR	KG	CICT	MIID
30.00	75.60	11	C5	1	820-75VC11X-C5	50.00	22.80	9.00	87.00	70.00	80	2.655	1	VBMT 11 03 04

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)  
 For inserts, see Turning tools catalogue



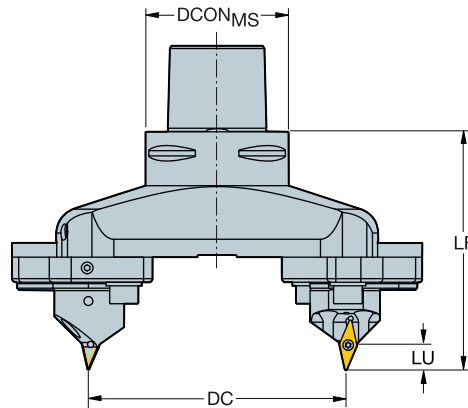
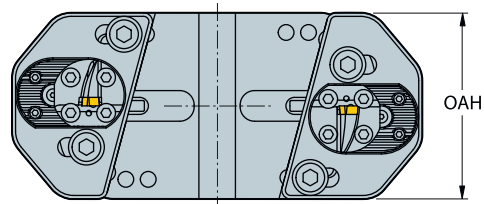
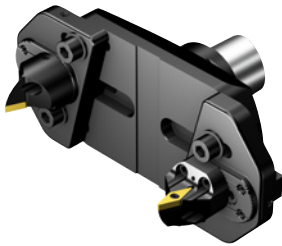


# CoroBore® XL adjustable tool for SpiroGrooving™

Coromant Capto® - Internal coolant supply




KAPR

67°



 VBMT

Radially and axially adjustable

						Dimensions, mm									
DCN	DCX		CZC <sub>MS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	ADJLX <sub>RDL</sub>	LU	LF	OAH			CICT	MIID	
48.00	139.60	16	C6	1	820-139VB16X-C6	63.00	45.80	15.00	121.00	104.00	80	5.060	1	VBMT 16 04 08	
48.00	139.60	16	C8	1	820-139VB16X-C8	80.00	45.80	15.00	133.00	104.00	80	6.390	1	VBMT 16 04 08	
98.00	189.60	16	C6	1	820-189VB16X-C6	63.00	45.80	15.00	121.00	104.00	80	6.210	1	VBMT 16 04 08	
98.00	189.60	16	C8	1	820-189VB16X-C8	80.00	45.80	15.00	133.00	104.00	80	7.620	1	VBMT 16 04 08	
148.00	239.60	16	C8	1	820-239VB16X-C8	80.00	45.80	15.00	133.00	104.00	80	8.820	1	VBMT 16 04 08	
198.00	289.60	16	C8	1	820-289VB16X-C8	80.00	45.80	15.00	133.00	104.00	80	9.860	1	VBMT 16 04 08	

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For inserts, see Turning tools catalogue



L2



N23



N15

# Interpolation turning

## Turning the unturnable

### Application

Interpolation turning is a new, flexible turning method developed for advanced machining centres and B-axis multi-task machines.

### ISO application area:



### Benefits and features

- Flexible solution, making it possible to use machining centres with modular tool set-ups instead of dedicated boring machines with U- or W-axis facing heads
- The component can be machined completely without moving it - especially beneficial for large non-symmetrical components
- Reduced tool investment cost
- Built on CoroBore® XL - rigid and reliable system for maximum stability for building assemblies in different application (rough boring, fine boring, face grooving, spiro grooving and interpolation turning)

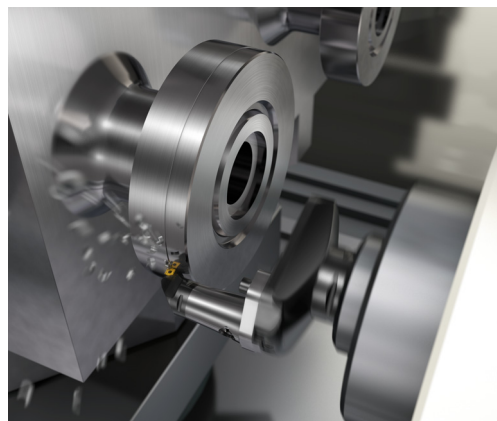


### Tools

- Coromant Capto®

### Inserts

- CoroTurn® 107

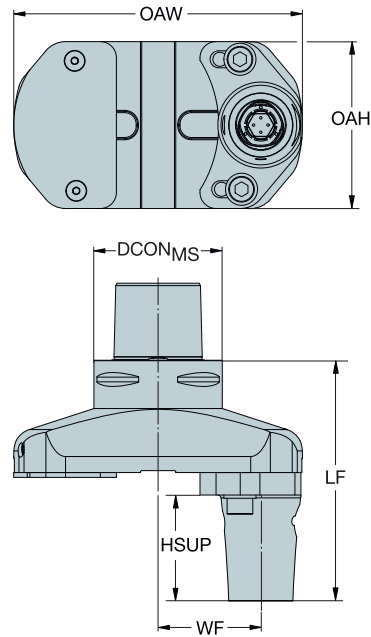
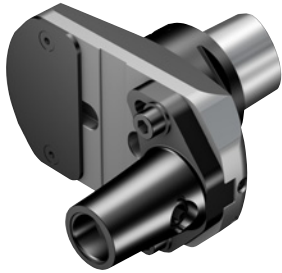


Component can be machined completely without moving it - especially beneficial for large non-symmetrical components

# Coromant Capto® adjustable adaptor with Quick change

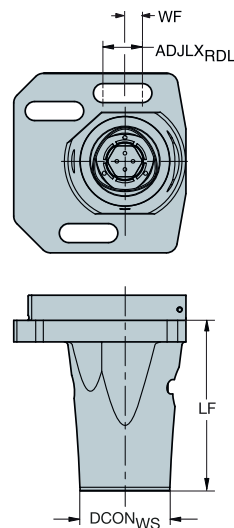
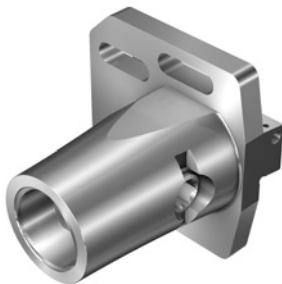
For Interpolation Turning

Internal coolant supply



				Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	ADJLX <sub>RDL</sub>	LF	WF	OAH	OAW	BAR	KG	
C8	C4	3	820-100C4-QC-C8	80.00	40.00	26.00	150.00	51.00	104.00	180.00	70	7.090	
C8	C4	3	820-150C4-QC-C8	80.00	40.00	51.00	150.00	51.00	104.00	230.00	70	9.430	
C8	C4	3	820-50C4-QC-C8	80.00	40.00	13.50	150.00	38.50	104.00	130.00	70	5.860	

## Slide for CoroBore® XL



				Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>WS</sub>	ADJLX <sub>RDL</sub>	LF	WF	OAH	OAW	BAR	KG		
S24R	C5	4	S24-R820XLC5QC-095	50.00	22.00	95.00	9.75	100.00	96.00	70	2.350		

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

For cutting heads and inserts, see Turning tools catalogue



L2



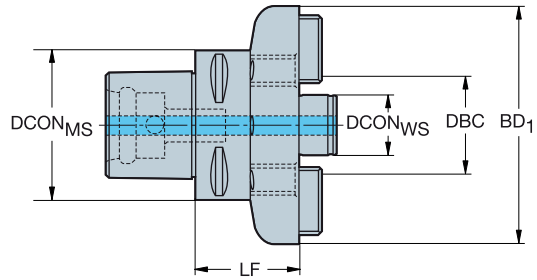
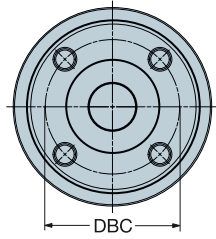
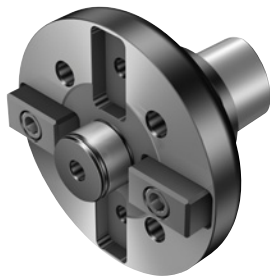
N23



N15

## Coromant Capto® to CoroBore® XL adaptor

Internal coolant supply

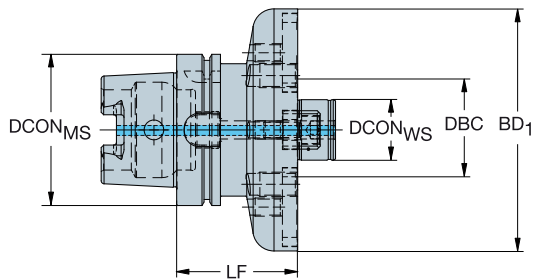
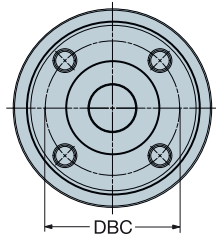
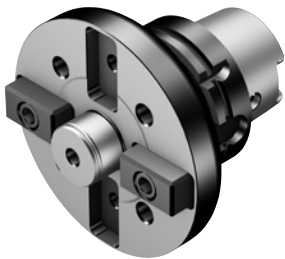


Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LF	BD <sub>1</sub>	BAR	KG
C8	40X	1	1	C8-391.XL-40 065	80.0	101.6	40.0	65.0	160.0	80	7.09
C10	40X	1	1	C10-391.XL-40 070	100.0	101.6	40.0	70.0	160.0	80	8.67

## HSK to CoroBore® XL adaptor

Internal coolant supply

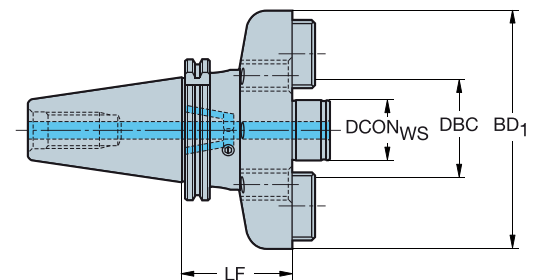
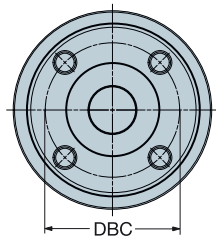
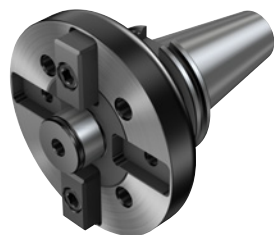


Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LF	BD <sub>1</sub>	BAR	KG
100	40X	1	1	1	392.410XL-10040 080	100.0	101.6	40.0	80.0	160.0	80	8.16

## ISO 7388-1 to CoroBore® XL adaptor

Internal coolant supply



ISO7388.1/MAS-BT 403

Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DBC	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>1</sub>	BAR	KG
50	40X	7	1	1	392.644XL-5040 075	101.6	40.0	75.0	75.0	160.0	80	8.46
	40X	7	1	1	392.646XL-5040 080	101.6	40.0	80.0	80.0	160.0	80	8.46

All CoroBore XL solid holders have ground backside of flange and threads for the option to mount a shim to increase stability if needed. Shim needs to be ordered separately and ground to fit the specific machine and holder, see accessories page M12.



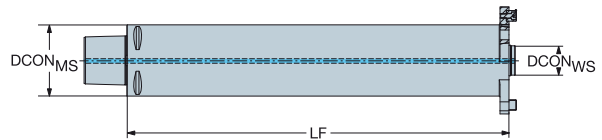
N23



N15

# Coromant Capto® to CoroBore® XL damped tool body

Internal coolant supply



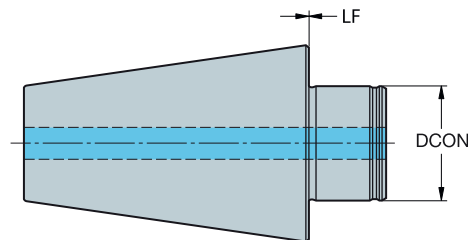
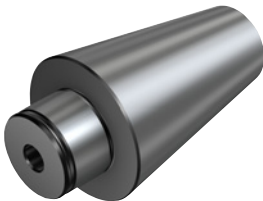
● ● ● ● SilentTools®

				Dimensions, mm				
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	BAR	KG
C8	33	3	C8-R822XLA33-F410	80.00	33.00	410.00	70	17.800
C10	33	3	C10-R822XLA33-F560	100.00	33.00	560.00	70	26.400

For boring tool components, accessories and spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)  
See page K27 for boring tool kit to be used with this adaptor

## Centering plug

Internal coolant supply



ISO7388.1/MAS-BT 403

				Dimensions, mm			
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	LF	BAR	KG
50	40 plug	1	1	392.647XL-5040	0.0	80	8.93



L2



N23



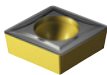
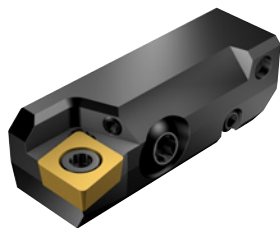
N15

# Indexable boring cartridge

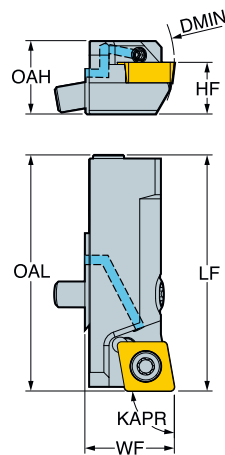
Axial and radial adjustment

KAPR

90°



 CCMT, CCGT  
CCGX, CCET  
 CCMW



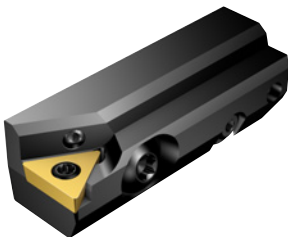
K



		Dimensions, mm													
DMIN <sub>1</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	ADJLX <sub>AVL</sub>	ADJLX <sub>RDL</sub>	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID	
25.0	06	08CB	2	SCFCR08CBX06	0.50	0.20	40.00	8.00	13.50	12.20	40.00	70	0.050	1	CCMT 06 02 04
40.0	09	10CB	2	SCFCR10CBX09	0.50	0.20	45.00	10.00	16.50	14.20	45.00	70	0.070	1	CCMT 09 T3 08
50.0	12	12CB	2	SCFCR12CBX12	0.50	0.20	50.00	12.00	19.00	16.20	50.00	70	0.100	1	CCMT 12 04 08

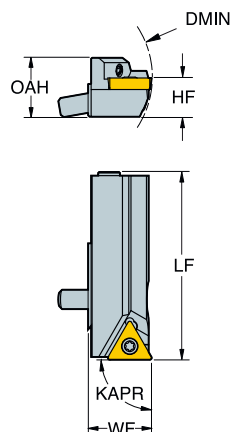
L

KAPR

90°



 TCMT, TCMX,  
TCGT, TCGX  
TCEX  
 TCMW



M

		Dimensions, mm													
DMIN <sub>1</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	ADJLX <sub>AVL</sub>	ADJLX <sub>RDL</sub>	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID	
25.0	09	08CB	2	STFCR08CBX09	0.50	0.20	40.00	8.00	13.50	12.20	40.00	70	0.050	1	TCMT 09 02 04
40.0	11	10CB	2	STFCR10CBX11	0.50	0.20	45.00	10.00	16.50	14.20	45.00	70	0.070	1	TCMT 11 03 04
50.0	16	12CB	2	STFCR12CBX16	0.50	0.20	50.00	12.00	19.00	16.20	50.00	70	0.100	1	TCMT 16 T3 08

For inserts, see Turning tools catalogue

N



N23



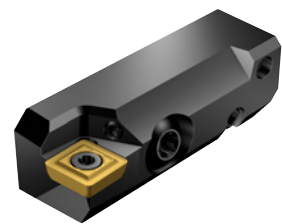
N15

# Indexable boring cartridge

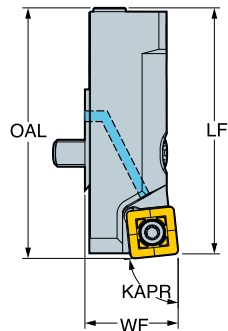
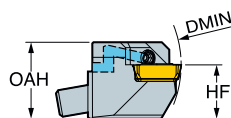
Axial and radial adjustment

KAPR

84°



SPMT



		Dimensions, mm													
DMIN <sub>i</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	ADJLX <sub>4YL</sub>	ADJLX <sub>4DL</sub>	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID	
25.0	06	08CB	2	SSYPR08CBX06	0.50	0.20	40.00	8.00	13.50	12.20	40.60	70	0.050	1	SPMT 0606-BM
40.0	08	10CB	2	SSYPR10CBX08	0.50	0.20	45.00	10.00	16.50	14.20	45.80	70	0.070	1	SPMT 0808-BM
50.0	12	12CB	2	SSYPR12CBX12	0.50	0.20	50.00	12.00	19.00	16.20	51.20	70	0.100	1	SPMT 1210-BM



K32



N23

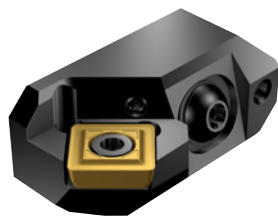


N15

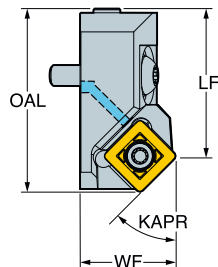
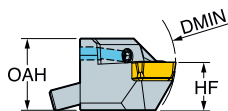
# Indexable boring cartridge

Axial adjustment

KAPR 45°



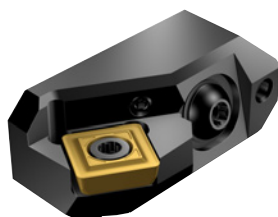
SPMT



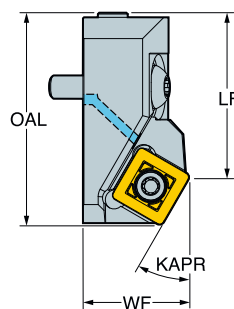
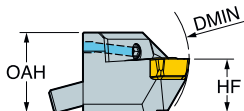
K

		Dimensions, mm												
DMIN <sub>1</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	ADJLX <sub>AVL</sub>	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID	
20.0	06	06CC	SSSPR06CCX06	0.50	21.00	6.00	11.00	10.20	24.80	70	0.020	1	SPMT 0606-BM	
25.0	08	08CC	SSSPR08CCX08	0.50	25.00	8.00	16.00	12.20	30.70	70	0.040	1	SPMT 0808-BM	
40.0	12	10CC	SSSPR10CCX12	0.50	32.00	10.00	21.00	14.00	40.20	70	0.070	1	SPMT 1210-BM	

KAPR 30°



SPMT



L

		Dimensions, mm												
DMIN <sub>1</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	ADJLX <sub>AVL</sub>	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID	
20.0	06	06CC	SSTPR06CCX06	0.50	21.00	6.00	11.00	10.20	25.60	70	0.020	1	SPMT 0606-BM	
25.0	08	08CC	SSTPR08CCX08	0.50	25.00	8.00	16.00	12.20	31.90	70	0.040	1	SPMT 0808-BM	
40.0	12	10CC	SSTPR10CCX12	0.50	32.00	10.00	21.00	14.20	42.00	70	0.080	1	SPMT 1210-BM	

For inserts, see Turning tools catalogue

M

N



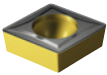
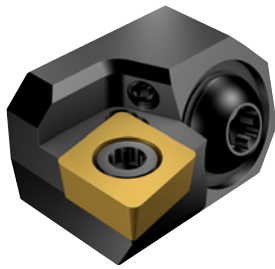


# Indexable boring cartridge

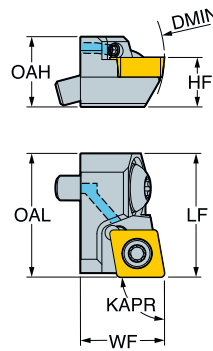
No adjustment

KAPR

90°



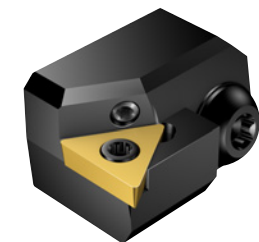
- CCMT, CCGT  
CCGX, CCET
- CCMW



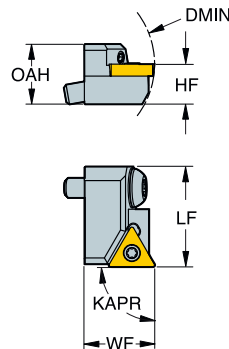
		Dimensions, mm											
DMIN <sub>1</sub>		CZC <sub>MS</sub>	CNSC	Ordering code	LF	HF	WF	OAH	OAL			CICT	MIID
20.0	06	06CD	2	STFCR06CDX06	16.00	6.00	11.00	10.20	16.00	70	0.020	1	CCMT 06 02 04
25.0	06	08CD	2	STFCR08CDX06	20.00	8.00	14.00	12.20	20.00	70	0.030	1	CCMT 06 02 04
40.0	09	10CD	2	STFCR10CDX09	25.00	10.00	17.00	14.20	25.00	70	0.050	1	CCMT 09 T3 08
50.0	12	12CD	2	STFCR12CDX12	30.00	12.00	20.00	16.20	30.00	70	0.070	1	CCMT 12 04 08

KAPR

90°



- TCMT, TCMX,  
TCGT, TCGX  
TCEX
- TCMW



		Dimensions, mm											
DMIN <sub>1</sub>		CZC <sub>MS</sub>	CNSC	Ordering code	LF	HF	WF	OAH	OAL			CICT	MIID
20.0	06	06CD	2	STFCR06CDX06	16.00	6.00	11.00	10.20	16.00	70	0.020	1	TCMT 06 T1 02
25.0	09	08CD	2	STFCR08CDX09	20.00	8.00	14.00	12.20	20.00	70	0.030	1	TCMT 09 02 04
40.0	11	10CD	2	STFCR10CDX11	25.00	10.00	17.00	14.20	25.00	70	0.050	1	TCMT 11 03 04
50.0	16	12CD	2	STFCR12CDX16	30.00	12.00	20.00	16.20	30.00	70	0.070	1	TCMT 16 T3 08

For inserts, see Turning tools catalogue



N23



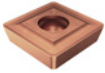
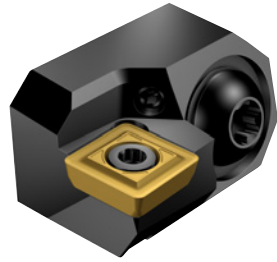
N15

# Indexable boring cartridge

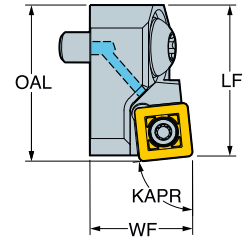
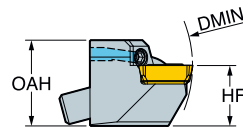
No adjustment

KAPR

84°



SPMT



Dimensions, mm

DMIN <sub>1</sub>	CZC <sub>MS</sub>	CNSC	Ordering code	Dimensions, mm								CICT	MIID
				LF	HF	WF	OAH	OAL	BAR	KG			
20.0	06	06CD	2	SSYPR06CDX06	16.00	6.00	11.00	10.20	16.60	70	0.020	1	SPMT 0606-BM
25.0	08	08CD	2	SSYPR08CDX08	20.00	8.00	14.00	12.20	20.80	70	0.030	1	SPMT 0808-BM
40.0	08	10CD	2	SSYPR10CDX08	25.00	10.00	17.00	14.00	25.80	70	0.050	1	SPMT 0808-BM
50.0	12	12CD	2	SSYPR12CDX12	30.00	12.00	20.00	16.20	31.20	70	0.070	1	SPMT 1210-BM



K32



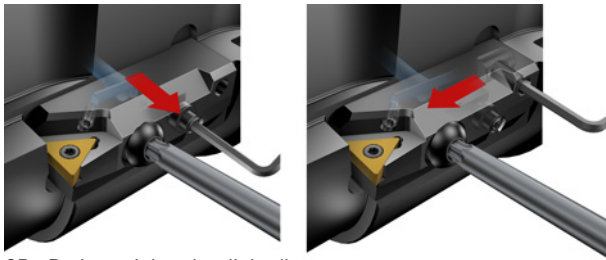
N23



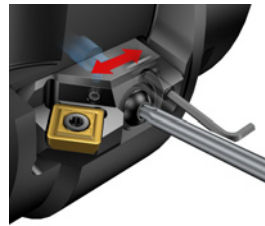
N15

# CoroBore®

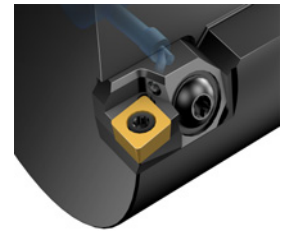
Built-in cartridges - CB, CC and CD



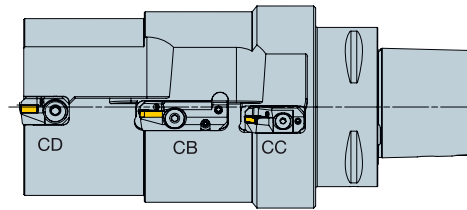
CB - Boring axial and radial adjustment



CC - Chamfer axial adjustment



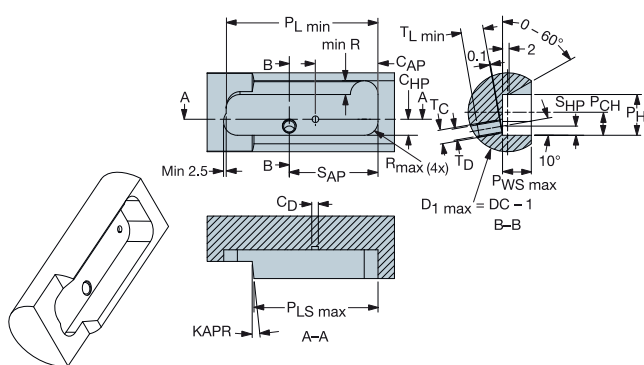
CD - Fixed, no adjustment



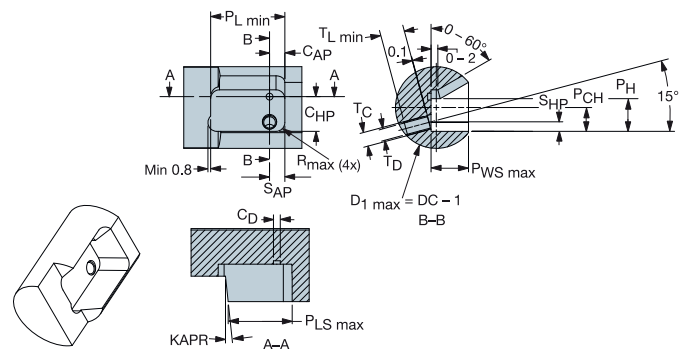
Size/type	Clamping set	Clamping torque (Nm)	Key size
06CB	5519 201-01	4.8	15IP
10CB	5519 201-02	9.0	20IP
12CB	5519 201-03	16.0	25IP
06CC	5519 202-01	3.2	10IP
08CC	5519 202-02	4.8	15IP
10CC	5519 202-04	16.0	25IP
06CD	5519 202-01	3.2	10IP
08CD	5519 202-02	4.8	15IP
10CD	5519 202-03	16.0	25IP
12CD	5519 202-04	16.0	25IP

Parameter	Description
P <sub>L</sub> min	Pocket length min
P <sub>CH</sub>	Pocket center height
P <sub>H</sub>	Pocket height
P <sub>LS</sub> max	Pocket length support max
KAPR	Tool cutting edge angle
P <sub>WS</sub> max	Pocket width support max
R <sub>max</sub>	Radius max
S <sub>AP</sub>	Screw axial position
S <sub>HP</sub>	Screw height position
T <sub>D</sub>	Thread size
T <sub>C</sub>	Thread counterbore dia
T <sub>L</sub> min	Thread length min
C <sub>AP</sub>	Coolant axial position
C <sub>HP</sub>	Coolant height position
C <sub>D</sub>	Coolant hole dia

## Type CB

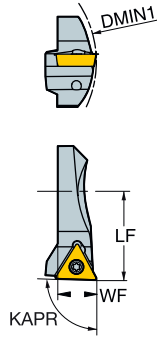
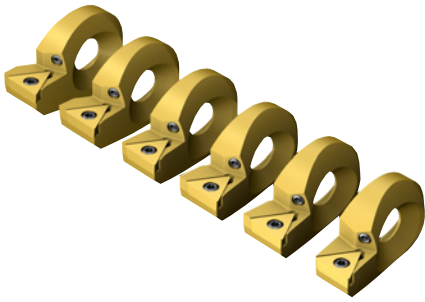


## Type CC and CD



**CoroBore® 826 HP**

## Cartridge set



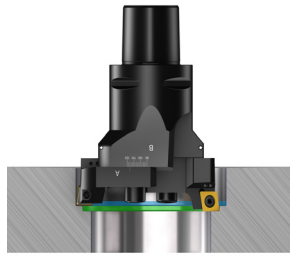
	Ordering code	Included cartridges	WF
Size B set	826B-4-TC09U	R826B-AF17STUC09HP	7.0
		R826B-BF17STUC09HP	7.5
		R826B-CF17STUC09HP	8.0
		R826B-DF17STUC09HP	8.5
Size C set	826C-6-TC11U	R826C-AF23STUC11HP	10.0
		R826C-BF23STUC11HP	10.5
		R826C-CF23STUC11HP	11.0
		R826C-DF23STUC11HP	11.5
		R826C-EF23STUC11HP	12.0
		R826C-FF23STUC11HP	12.5

# CoroBore® BR20

## Operations



1



2

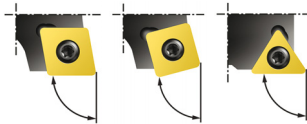
### 1. Twin-edge boring

- Increased feed rate is applicable.

### 2. Twin-edge step boring

- High cutting depth is applicable.
- Built in functionality in slide

## Insert choice



Entering angle  
Lead angle

90°  
0°

84°  
6°

90°  
0°

### CoroTurn® 107 screw clamping

For applications that require lower cutting forces



84°  
6°

### CoroBore® 111 screw clamping

Dedicated rough boring insert with optimized grade selection for P,M,K,S

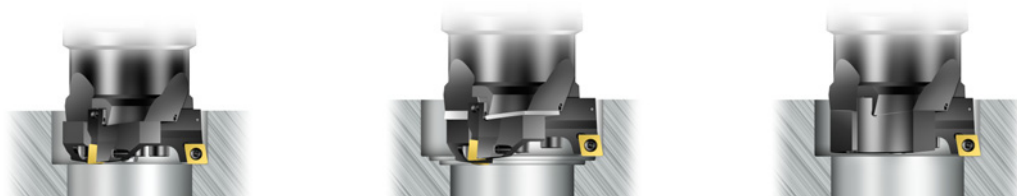
## Maximum cutting speed, $V_c$ max:

BR20: 1200 m/min

BR20 Damped: 900 m/min

# CoroBore® BR30

## Operations



1

2

3

1. Multi-edge boring
  - Increased feed rate is applicable.
  
2. Multi-edge step boring
  - High cutting depth is applicable.
  - Shim-set is required, to be ordered separately. LF-dimension when using shim set increases 1-2 mm.
  - Slides of R820x-AR... and R820x-BR... with kappa 90 degree can be combined
  
3. Single-edge boring:
  - Two covers are required, to be ordered separately.

### Shim-set and cover - CoroBore® BR30

Adaptor size	Shim set	Thickness mm	Cover
A	R820A-AS00B	0.5+1	R820A-AC10B
B	R820B-AS00B	0.5+1	R820B-AC11B
C	R820C-AS00B	0.5+1	R820C-AC15B
D	R820D-AS00B	0.5+1	R820D-AC17A
E	R820E-AS00B	0.8+1.6	R820E-AC20A
F	R820F-AS00B	0.8+1.6	R820F-AC22A
G	R820G-AS00B	0.8+1.6	R820G-AC22A
H	R820H-AS00B	1+2	R820H-BC24A

Maximum cutting speed, Vc max: Conventional: Vc 1200 m/min

### Insert choice



Entering angle  
Lead angle

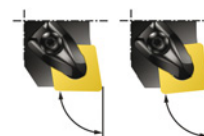
90°  
0°

**CoroTurn® 107 screw clamping**  
For applications that require lower cutting forces



84°  
6°

**CoroBore® 111 screw clamping**  
Dedicated rough boring insert with optimized grade selection for P,M,K,S

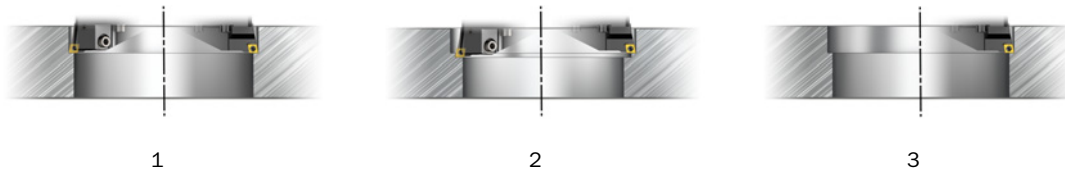


90°  
0°      84°  
6°

**T-Max® P, CoroTurn® RC rigid clamping**  
For applications that require strong inserts in stable conditions

# CoroBore® 820 XL

## Operations



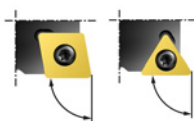
1. Twin-edge boring
  - Increased feed rate is applicable.
  
2. Twin-edge step boring
  - High cutting depth is applicable.
  - Axially adjustable cartridges +1.5 mm.
  - Cartridges with Kappa 90° (0°) entering angle (lead angle) should be used when step-boring.
  
3. Single-edge boring:
  - Adjust unused cutting edge to a smaller diameter and use it as a counterweight.

### Holders for CoroBore XL, diameter 150–1275 mm

Must be bought separately. Available interfaces: C8,C10, HSK-A 100, HSK-A 125, CAT-V 50, ISO 7388/1 50, MAS BT 50

Maximum cutting speed,  $V_c$  max: Conventional: 1200 m/min, Light weight: 600 m/min

## Insert choice

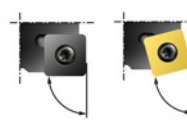


Entering angle  
Lead angle

90° 90°  
0° 0°

### CoroTurn® 107 screw clamping

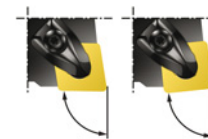
- For applications that require lower cutting forces



90° 84°  
0° 6°

### CoroBore® 111 screw clamping

- Dedicated rough boring insert with optimized grade selection for PM,K,S



90° 84°  
0° 6°

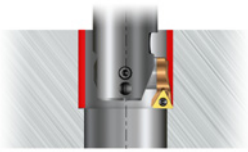
### T-Max® P, CoroTurn® RC rigid clamping

- For applications that require strong inserts in stable conditions

# CoroBore® 826 HP

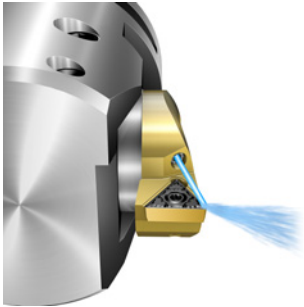
## Operations

J



Boring

K



- Use the High precision coolant for improved chip breaking

L



- Feel the microns! Every diameter increment of 0.002 mm can be felt with a click

M

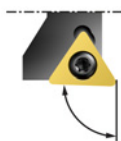


- The CB826 cartridge is rotated 90 degrees compared to CB825 cartridge!

Maximum cutting speed,  $V_c$  max:  $V_c$  1200 m/min

## Insert choice

CoroTurn® 107 inserts



Entering angle 92°  
Lead angle -2°



CoroTurn® 107:  
TC.. 1103

N



# CoroBore® 825

## Operations



### Conventional:

The geometrical restriction (LU) is only valid when boring diameter (DC) is smaller than the coupling diameter (DCON<sub>MS</sub>). Maximum recommended hole depth (for forward boring) when the boring diameter (DC) is larger than the coupling diameter (DCON<sub>MS</sub>)

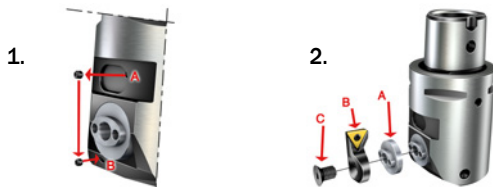
### CoroBore® 825 EH:

The single cutting-edge position will be correct when using cylindrical or conical EH holders (available in steel, solid carbide, heavy metal) as it is possible to rotate the assembly in the chuck (using a CoroChuck 930, shrink fit, collet chuck) to find the single edge cutting position.

### Backboring with CoroBore® 825 (Conventional)

1. Remove grub screw from coolant duct A and screw it into coolant duct B.
2. Lock A (if used) + B + C with correct torque.
3. Change spindle direction to counter clockwise (M04).

### Backboring for CoroBore® 825D (Damped)



Diameter mm	Slide extension	Thickness mm	Diameter extension mm
19-36	825A-030A	3	+6
35-56	825B-036A	3.6	+7.2
55-1275	825C-048A	4.8	+9.6

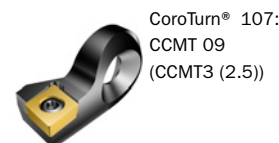
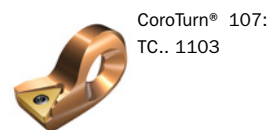
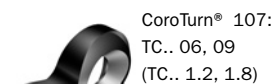
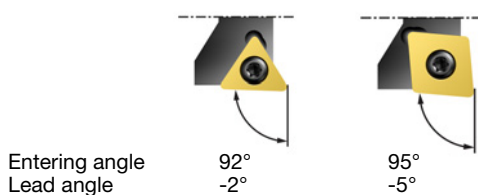
Diameter range, forward boring, mm	Diameter range, back boring, mm	Back boring cartridge kit (1pcs cartridge, 1pcs slide extension)	Back boring cartridge	Slide extension
19-36	31-48	825A-TC06U-BW	L825A-AF11STUC06T1	825A-030A
35-56	48-69	825B-TC06U-BW	L825B-AF15STUC06T1	825B-036A
55-167	69-181	825C-TC09U-BW	L825C-AF20STUC0902	825C-048A

Every back boring kit includes 1 slide extension and 1 back boring cartridge. Be aware that back boring diameters are different from forward boring. Please check the information table for correct diameter ranges.

Maximum cutting speed, V<sub>c</sub> max: **Conventional:** V<sub>c</sub> 1200 m/min, **Light weight:** V<sub>c</sub> 600 m/min **Damped:** V<sub>c</sub> 900m/min

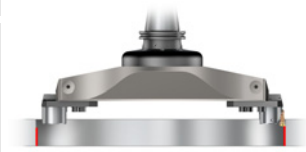
## Insert choice

### CoroTurn® 107 inserts

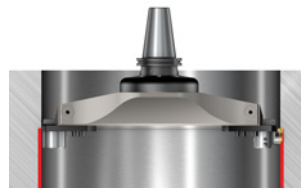


# CoroBore® 825 XL/CoroBore® 826 XL

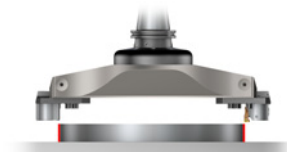
## Operations



Boring



Back boring



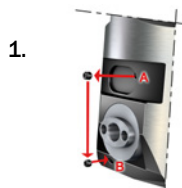
External operations

### Holders for CoroBore XL

Must be bought separately. Available interfaces: C8,C10, HSK-A 100, HSK-A 125, CAT-V 50, ISO 7388/1 50, MAS BT 50

### Back boring (not for CoroBore® 826HP and 825 SL)

1. Remove grub screw from coolant duct A and screw it into coolant duct B.
2. Lock A (if used) + B + C with correct torque.
3. Change spindle direction to counter clockwise (M04).



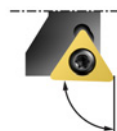
Diameter mm	Slide extension (A)	Thickness mm	Diameter extension mm
55-1275	825C-048A	+4.8	+9.6

Maximum cutting speed,  $V_c$  max:

Conventional: $V_c$  1200 m/min, Light weight:  $V_c$  600 m/min, Damped: $V_c$  600 m/min

### Insert choice

#### CoroTurn® 107 inserts



Entering angle  
Lead angle

92°  
-2°



95°  
-5°



CoroTurn® 107  
TCMT1103  
(TCMT 22)



CoroTurn® 107:  
TC.. 1103



CoroTurn® 107:  
CCMT 09  
(CCMT3 (2.5))

## Start recommendations

- Cutting speed must be reduced when working with long overhangs. Silent Tools can be used to achieve higher cutting speeds at certain overhangs.

### Rough boring

- Maximum recommended starting value for cutting speed is 200 m/min for rough boring to ensure proper chip evacuation and to secure a stable process.

CoroBore® 111		Feed ( $f_n$ ) mm/r			Cutting depth ( $a_p$ ), mm			Cutting speed ( $v_c$ ) m/min		
Grade	Ordering code	Min	Max	Rec	Min	Max	Rec	Min	Max	Rec
4325	SPMT0606-BR	0.10	0.25	0.20	0.6	4.5	2.0	365	460	395
	SPMT0808-BR	0.15	0.35	0.20	0.8	6.5	2.5	325	425	395
	SPMT1212-BR	0.15	0.40	0.25	1.2	9.0	3.0	305	425	365
	SPMT1812-BR	0.20	0.40	0.30	1.2	12.0	3.8	305	395	345
2025	SPMT0606-BM	0.10	0.15	0.10	0.6	4.5	1.8	260	265	265
	SPMT0808-BM	0.10	0.25	0.20	0.8	6.5	2.2	225	265	240
	SPMT1210-BM	0.10	0.30	0.20	1.0	9.0	2.5	205	265	240
	SPMT1810-BM	0.20	0.30	0.25	1.0	12.0	3.0	205	240	225
3210	SPMT0606-BR	0.15	0.30	0.25	0.6	4.5	2.0	285	330	300
	SPMT0808-BR	0.20	0.50	0.30	0.8	6.5	2.5	235	315	285
	SPMT1212-BR	0.20	0.50	0.30	1.2	9.0	3.0	235	315	285
	SPMT1812-BR	0.25	0.50	0.30	1.2	12.0	3.8	235	300	285
1145	SPMT0606-BM	0.10	0.15	0.10	0.6	4.5	1.8	15	20	20
	SPMT0808-BM	0.10	0.15	0.10	0.8	6.5	2.2	15	20	20
	SPMT1210-BM	0.10	0.20	0.15	1.0	9.0	2.5	10	20	15
	SPMT1810-BM	0.10	0.20	0.15	1.0	12.0	3.0	10	20	15

### Fine boring

- Maximum recommended starting value for cutting speed is 240 m/min for fine boring, to ensure proper chip evacuation and to secure a stable process.
- The recommended starting value for cutting speed for fine boring head 391.37A with steel or carbide bars with inserts is 90-120 m/min, use lower values for long steel bars). Recommended starting value for ground carbide bars is 60 m/min.
- See below matrix for selection of geometry and grade depending on your fine boring application.
- Maximum recommended depth of cut for fine boring is 0.5 mm. If the tool is adjusted to the minimum possible diameter, chip evacuation will be more critical and a reduction of cutting depth might be necessary.
- Maximum feed in fine boring is limited by desired surface finish. The possibility to influence chip form is therefore limited. By using a wiper insert, the surface finish can be retained at higher feeds. However, the wiper inserts exert more radial pressure, increasing the risk for an unstable process.

These start recommendations are general. For more detailed information, please visit CoroPlus ToolGuide on [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

Fine boring												
AP	Nose radius	Max feed for required surface		Material								
		Ra 1.6	Ra 0.8	P		M		K	N	S (nickel)		S (titanium)
0.1-0.15	02	0.08	0.05	PF 5015	L-K 1515	MF-1115	L-K 1515	PF 1515	AL H10	MF 1115	L-K 1115	AL H10
0.15-0.3	04	0.12	0.07	PF 5015	L-K 1515	MF 2015	L-K 1515	PF 4215	AL H10	MF 1115	L-K 1115	AL H10
0.3-0.5	08	0.15	0.10	PF 5015		MF 2015		PF 4215	AL H10	MF 1115	L-K 1115	AL H10

### Face grooving

First choice is the CoroCut 2-system insert.

Use -TF geometry for low feed, -CM geometry for medium feed and -RM geometry for radial bottom face grooving.

The -TF and -CM geometries have positive geometries that eliminate the risk of built-up edge. The -TF geometry gives good chip control and generates high surface finish due to the Wiper design. The -GF enables larger widths to be selected.

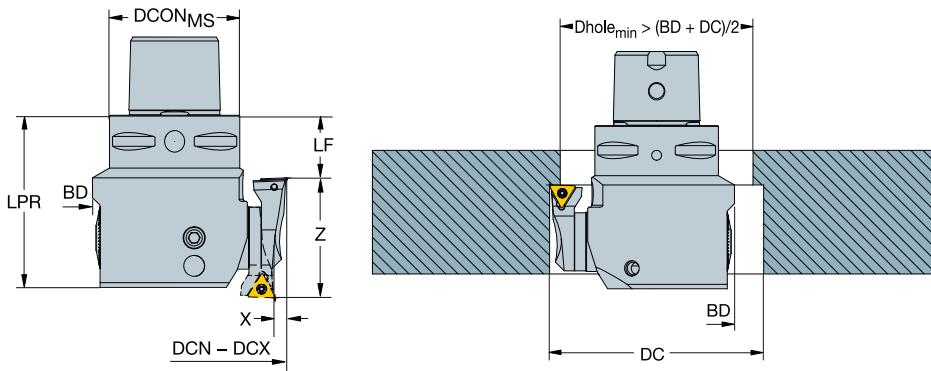
Depending on chosen nose radius:

- Choose -CM for smaller nose radius (0.2)
- Choose -TF for larger nose radius (>0.3)
- Recommended start feed: 0.15 mm/rev
- If grooves with tighter tolerance are required, choose -GF
- Recommended start feed: 0.10 mm/rev

To improve chip control:

- increase feed rate
- increase cutting speed

## Backboring with CoroBore® 825 (Conventional)



Cartridge size	Z (mm)	X (mm)
A	22	3.0
B	34	3.6
C	46	4.8

### Backboring for CoroBore® 825

In case of backboring, LF will be reduced by twice LF of cartridge. That means:

- LF – 22 mm for Size A (e.g. R825A-AF11STUC06T1A)
- LF – 34 mm for Size B (e.g. R825B-AF17STUC0902A)
- LF – 46 mm for Size C (e.g. R825C-AF23STUC1103A)
- Attention change rotation direction -> left hand!

DC will be increased by twice WF of slide extension. That means:

- $2 \times 3.0 = 6.0$  mm for Size A (825A-030A)
- $2 \times 3.6 = 7.2$  mm for Size B (825B-036A)
- $2 \times 4.8 = 9.6$  mm for Size C (825C-048A)
- Calculation of minimum possible hole diameter:  $D_{hole_{min}} = (BD+DC)/2+1$

### Backboring for CoroBore® 825XL

In case of backboring, LF will be reduced by twice LF of cartridge. That means:

- LF – 46 mm for Size C (e.g. R825C-AF23STUC1103A)
- Attention change rotation direction -> left hand!

DC will be increased by twice WF of slide extension. That means:

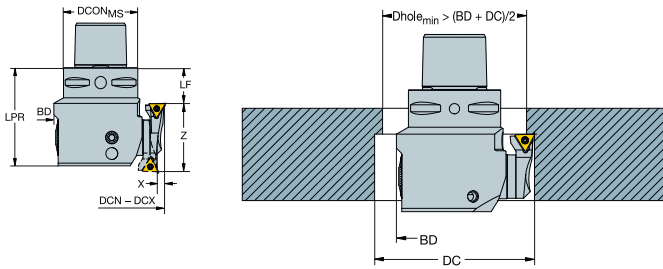
- $2 \times 4.8 = 9.6$  mm for Size C (825C-048A)
- Calculation of minimum possible hole diameter:  $D_{hole_{min}} > (DC+DC-26)/2$

Additionally it is necessary to adjust A34 fine boring head to maximum.

Example: Diameter range for 825-215TC11-C6

- **DCN (backboring)** = (DCN(forward)) + (2x A34-R825 stroke) + (2x slide extension) = 148 mm + 15 mm + 9,6 mm = **172,6 mm**
- **DCX (backboring)** = (DCX(forward)) + (2x slide extension) = 215 mm + 9,6 mm = **224,6 mm**

## Backboring for CoroBore® 825D (Damped)



Cartridge

Slide extension

Size	Cartridge		Slide extension				
	LF Forward	WF Forward	LF Backward	WF Backward	WF	X	Z
A	11	5	11	8.0	3.0	6.0	22
B	17	7	15	9.9	3.6	6.5	32
C	23	10	20	12.2	4.8	7.0	43

### Backboring for CoroBore® 825D

In case of backboring, LF will be reduced by the LF forward + LF backward. That means:

- LF – 22 mm for Size A
- LF – 32 mm for Size B
- LF – 43 mm for Size C
- Attention: rotation direction will stay right hand!

DC will be increased by twice the WF of slide extension - WF forward + WF backward. That means:

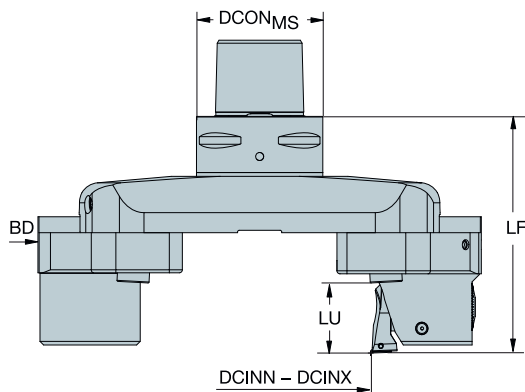
- $DC + 2 \times (3.0 - 5.0 + 8.0) = 12.0$  mm for Size A
- $DC + 2 \times (3.6 - 7.0 + 9.9) = 13.0$  mm for Size B
- $DC + 2 \times (4.8 - 10.0 + 12.2) = 14.0$  mm for Size C
- Calculation of minimum possible hole diameter:  $D_{hole_{min}} = (BD+DC)/2+1$

Note! Backboring is only valid for CoroBore® 825D and not CoroBore® 825D XL or CoroBore® 825



N23

## External boring



### External boring for CoroBore® 825XL

In case of external boring, LF will remain the same.

Example: Diameter range for 825-215TC11-C6

- **DCN (external)** = DCN(forward)-(2x DMIN A34-R825)-(2x A34-R825 stroke) = 148 mm-110 mm-15 mm = **23 mm**
- **DCX (external)** = DCX(forward)-(2x DMIN A34-R825)-(2x A34-R825 stroke) = 215 mm- 110 mm -15 mm = **90 mm**
- Attention change rotation direction -> left hand!

The usable length for external boring at diameter 23 mm to 190 mm (Forward boring: 148 mm to 315 mm) is 34 mm.

The usable length for external at diameter 173 mm to 1150 mm (Forward boring: 298 mm to 1275 mm) is 28 mm.

### External boring for CoroBore® 826XL

In case of external boring, LF will remain the same.

Example: Diameter range for 826-200TC11-C6

- **DCN (external)** = DCN(forward)-(2x DMIN A34-R825) = 148 mm-110 mm = **38 mm**
- **DCX (external)** = DCX(forward)-(2x DMIN A34-R825) = 200 mm- 110 mm = **90 mm**
- Attention change rotation direction -> left hand!

The usable length for external boring at diameter 38 mm to 190 mm (Forward boring: 148 mm to 300 mm) is 34 mm.

The usable length for external at diameter 188 mm to 1150 mm (Forward boring: 298 mm to 1260 mm) is 28 mm.

# Tightening torque

## Coromant Capto®

Coromant Capto® size	NM
C3	40-50
C4	50-60
C5	90-100
C6-C8	160-180
C10	380

### Insert screw

Insert	NM
TC05 / TC06 / TP06	0.6
TC09 / TP09 / SP06	0.8
TC1103 / TP1103 / CC06	0.9
SP08	1.7
SP12	2
CC09 / CC12 / SC09 / SC12 / TC16 / TC22 / SP18	3
CN12 / SN12	3.9
CN16 / SN15	6.4

## Coromant EH coupling

Size	NM
16	30
20	50
25	65

## CoroBore® BR10

Tightening torque for slide.				
Size	DCN mm	DCX mm	NM	Screw size
A	32	38	4.8	M4
B	37	45	4.8	M4
C	44	54	9	M5
D	53	65	16	M6
DX	64	76	16	M6
E	75	91	38	M8
F	90	110	75	M10
G	109	136	75	M10
H	135	170	75	M10

## CoroBore® BR20

Tightening torque for slide.				
Size	DCN mm	DCX mm	NM	Screw size
A	23	29	4.8	M4
B	28	36	4.8	M4
C	35	45	9	M5
D	44	56	16	M6
E	55	71	38	M8
F	70	90	75	M10
G	89	116	75	M10
H	115	150	75	M10

## CoroBore® BR30

Tightening torque for slide.				
Size	DCN mm	DCX mm	NM	Screw size
A	35	45	4.8	M4
B	44	56	9	M5
C	55	70	16	M6
D	69	87	16	M6
E	86	107	38	M8
F	106	137	75	M10
G	136	167	75	M10
H	166	214	75; 120	M10; M12

## Tightening torque

### CoroBore® 820 XL / 820L XL

Diameter range, mm	NM		Screw size
148-300			
Bridge	100		M12
Slide	60		M10
Cartridge	60		M10

### CoroBore® 820 XL

Diameter range, mm	NM		Screw size
298-1260			
Bridge	200		M16
Bridge extension	100		M12
Slide	60		M10
Cartridge	60		M10

### CoroBore® 825 XL / 826 XL / 825D XL / 826D XL / 825L XL / 826L XL

Diameter range, mm	NM		Screw size
825: 148-315 826: 148-300			
Bridge	100		M12
Slide	60		M10
Counterweight	60		M10
Fine boring head	14		M6
Locking screw CB825	6		M8
Locking screw CB826HP	8		M8
Cartridge screw	6		M8

### CoroBore® 825 XL / 826 XL

Diameter range, mm	NM		Screw size
825: 298-1275 826: 298-1260			
Bridge	200		M16
Bridge extension	100		M12
Slide	60		M10
Counterweight	60		M10
Fine boring head	14		M6
Locking screw CB825	6		M8
Locking screw CB826HP	8		M8
Cartridge screw	6		M8

### CoroBore® 825, 825D and 826HP

	NM		Screw size
<b>Cartridge screw</b>			
R825A...	1.2		M3.5
R825B..., R826B...	3.0		M5
R825C..., R826C...	6.0		M8
<b>Locking screw</b>			
...R825A-xA18/...R825A-xAA	0.9		M4
...R825A-xAB	1.2		M5
...R825B...;...R826B	3.0; 4.0		M6
...R825C...;...R826C	6.0; 8.0		M8

### CoroBore® 824 XS

Diameter range, mm	NM		Screw size
1-20			
Locking screw / Boring bar (Insert) screw			
Size			
XS04	1.2		M5
XS06	1.2		M5
XS08	3		M6
XS10	3		M6

### CoroBore® 825 SL

Diameter range, mm	NM		Screw size
47-150			
Face grooving head (S20)	14		M6
Locking screw	8		M10
Counterweight	8		M10
Blade	9		M5

### CoroBore® 825 SL XL

Diameter range, mm	NM		Screw size
150-1275			
Face grooving head (A34)	14		M6
Locking screw	12		M10
Blade	9		M5

Other components, see CoroBore® 825XL

### Fine boring head, 391.37A / 391.37B / Boring bars

Diameter mm	NM		Screw size
<b>Screw for boring bar:</b>			
12	10		M8
16	10		M8
20	18		M10
<b>Locking screw:</b>			
12	8		M8
16	8		M8
20	12		M10



# Rotating tool adaptors

## Adaptors

Coromant Capto®	L4-L26
HSK	L27-L41
BIG-PLUS® ISO	L42-L50
BIG-PLUS® MAS-BT	L51-L59
ISO 7388-1	L60-L72
MAS-BT	L73-L85
DIN 2080	L86-L88
DIN 2079	L89-L90
Cylindrical shank	L91-L98
Weldon shank	L99-L100
Bridgeport	L101-L102
Coromant EH	L103-L104
ER	L105-L107
Coolant inducer	L108

## Damped adaptors

	L109
Coromant Capto®	L110-L111
HSK	L112

# Adaptors

		Machine side					
		Coromant Capto®	HSK	BIG-PLUS® ISO	BIG-PLUS® MAS-BT	ISO 7388-1	MAS-BT
Workpiece side	<b>Coromant Capto®</b>	-Extension -Extension with Quick change -Reduction  L4-L7 Coolant inducer L108	-Adaptor -Quick change	-Adaptor -Quick change	-Adaptor -Quick change	-Adaptor -Quick change	-Adaptor -Quick change
	<b>Coromant EH</b>	-Adaptor  L8-L9	-Adaptor			-Adaptor  L62	-Adaptor  L74-L75  L76
	<b>Arbor</b>	-Adaptor -With driving screws -Side and face mill  L10-L12	-Adaptor -With driving screws	-Adaptor	-Adaptor	-Adaptor -With driving screws -Side and face mill	-Adaptor -With driving screws -Side and face mill
	<b>VL</b>	-Adaptor  L13	-Adaptor	-Adaptor	-Adaptor	-Adaptor	-Adaptor
	<b>Weldon</b>	-Adaptor  L14	-Adaptor			-Adaptor  L66	-Adaptor  L79
	<b>MDI</b>	-Adaptor  L15	-Adaptor				
	<b>ISO 9766</b>	-Adaptor  L16 Coolant inducer L108	-Adaptor			-Adaptor -Adjustable adaptor	-Adaptor -Adjustable adaptor
	<b>Weldon/ISO 9766</b>	-Adaptor  L17		-Adaptor	-Adaptor		
	<b>CoroMill® 327</b>	-Adaptor  L17					
	<b>CoroChuck™ 930</b>	-Adaptor  L18-L22	-Adaptor	-Adaptor	-Adaptor	-Adaptor	-Adaptor
	<b>Shrink fit chuck</b>	-Adaptor  L23	-Adaptor				
	<b>ER</b>	-Collet chuck -Drill chuck  L24-L25	-Collet chuck	-Collet chuck	-Collet chuck	-Collet chuck	-Collet chuck
	<b>CoroChuck™ 970</b>	-Adaptor  L26	-Adaptor	-Adaptor	-Adaptor	-Adaptor	-Adaptor

## Damped adaptors

		Machine side	
		Coromant Capto®	HSK
Workpiece side	<b>Coromant EH</b>	-Adaptor  L110	
	<b>Arbor</b>	-Adaptor -With driving screws  L111	-Adaptor  L112

ENG

DIN 2080	DIN 2079	Cylindrical shank	Weldon shank	Bridgeport	Coromant EH	ER
-Adaptor	-Adaptor -Quick change					
L87	L90					
		-Adaptor L92-L95				-Adaptor L106
		-With driving screws L96		-Adaptor L102		
			-Adaptor L100		-Adaptor L104	-Adaptor L107
		-Collet chuck L98			-Adaptor L104	
		-Adaptor L98	-Adaptor L100		-Adaptor L104	

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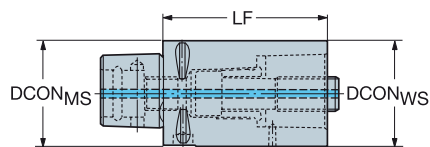
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N

# Coromant Capto® extension adaptor



				Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	BAR	NM	KG
C3	C3	3	1	C3-391.01-32 060A	32.0	32.0	60.0	80	45.00	0.36
	C3	3	1	C3-391.01-32 080A	32.0	32.0	80.0	80	45.00	0.47
	C3	3	1	C3-391.01-32 095	32.0	32.0	95.0	80	45.00	0.56
	C4	3	1	C4-391.01-40 060A	40.0	40.0	60.0	80	55.00	0.57
	C4	3	1	C4-391.01-40 080A	40.0	40.0	80.0	80	55.00	0.70
	C4	3	1	C4-391.01-40 120	40.0	40.0	120.0	80	55.00	1.11
	C5	3	1	C5-391.01-50 080A	50.0	50.0	80.0	80	95.00	1.15
	C5	3	1	C5-391.01-50 100A	50.0	50.0	100.0	80	95.00	1.38
	C5	3	1	C5-391.01-50 150	50.0	50.0	150.0	80	95.00	2.17
	C6	3	1	C6-391.01-63 100A	63.0	63.0	100.0	80	170.00	2.26
	C6	3	1	C6-391.01-63 140A	63.0	63.0	140.0	80	170.00	3.17
	C6	3	1	C6-391.01-63 185	63.0	63.0	185.0	80	170.00	4.19
	C8	3	1	C8-391.01-80 100A	80.0	80.0	100.0	80	170.00	3.70
	C8	3	1	C8-391.01-80 125A	80.0	80.0	125.0	80	170.00	4.64
	C8	3	1	C8-391.01-80 200	80.0	80.0	200.0	80	170.00	7.47
	C10	3	1	C10-391.01-100 140	100.0	100.0	140.0	80	380.00	7.93
	C10	3	1	C10-391.01-100 200	100.0	100.0	200.0	80	380.00	11.49

## Short design, for segment clamping only

				Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	BAR	NM	KG
C3	C3	3	1	C3-391.01-32 035	32.0	32.0	35.0	80	45.00	0.22
	C4	3	1	C4-391.01-40 040	40.0	40.0	40.0	80	55.00	0.40
	C5	3	1	C5-391.01-50 050	50.0	50.0	50.0	80	95.00	0.73
	C6	3	1	C6-391.01-63 060	63.0	63.0	60.0	80	170.00	1.36
	C8	3	1	C8-391.01-80 065	80.0	80.0	65.0	80	170.00	2.41

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23

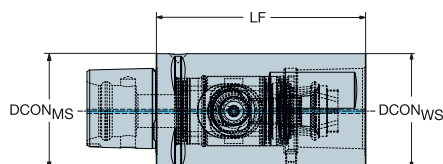


N6



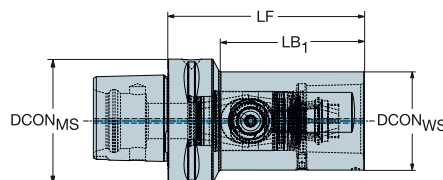
N15

## Coromant Capto® extension adaptor with Quick change



				Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	BAR	NM	KG	RPMX
C4	C4	3	1	C4-QC-C4-085	40.0	40.0	85.0	150	50.00	0.75	39000
C5	C5	3	1	C5-QC-C5-100	50.0	50.0	100.0	150	70.00	1.39	28000
C6	C6	3	1	C6-QC-C6-115	63.0	63.0	115.0	150	90.00	2.53	20000
C8	C8	3	1	C8-QC-C8-145	80.0	80.0	145.0	150	130.00	5.16	14000

## Coromant Capto® reduction adaptor with Quick change



				Dimensions, mm								
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BAR	NM	KG	RPMX
C5	C4	3	1	C5-QC-C4-085	50.0	40.0	85.0	60.5	150	50.00	0.95	28000
C6	C5	3	1	C6-QC-C5-100	63.0	50.0	100.0	73.0	150	70.00	1.75	20000
C8	C6	3	1	C8-QC-C6-120	80.0	63.0	120.0	84.5	150	90.00	3.48	14000
C10	C8	3	1	C10-QC-C8-150	100.0	80.0	150.0	108.0	150	130.00	6.83	10000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23

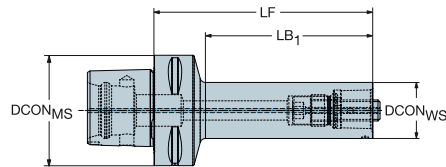


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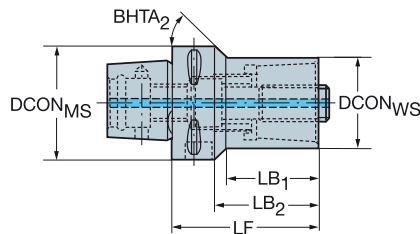


N15

# Coromant Capto® reduction adaptor



					Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BAR	NM	KG
C4	C3	3	1	C4-391.02-32 055A	40.0	32.0	55.0	31.0	80	45.00	0.49
	C3	3	1	C4-391.02-32 120	40.0	32.0	120.0	95.7	80	45.00	0.81
C5	C3	3	1	C5-391.02-32 060A	50.0	32.0	60.0	34.8	80	45.00	0.68
	C3	3	1	C5-391.02-32 120	50.0	32.0	120.0	94.4	80	45.00	0.99
	C4	3	1	C5-391.02-40 065A	50.0	40.0	65.0	40.0	80	55.00	0.80
	C4	3	1	C5-391.02-40 140	50.0	40.0	140.0	115.5	80	55.00	1.46
C6	C3	3	1	C6-391.02-32 070A	63.0	32.0	70.0	39.0	80	45.00	1.12
	C3	3	1	C6-391.02-32 125	63.0	32.0	125.0	95.6	80	45.00	1.43
	C4	3	1	C6-391.02-40 080A	63.0	40.0	80.0	51.4	80	55.00	1.32
	C4	3	1	C6-391.02-40 145	63.0	40.0	145.0	116.7	80	55.00	1.86
	C5	3	1	C6-391.02-50 080A	63.0	50.0	80.0	51.5	80	95.00	1.53
	C5	3	1	C6-391.02-50 175	63.0	50.0	175.0	148.1	80	95.00	2.79
C8	C3	3	1	C8-391.02-32 060B	80.0	32.0	60.0	20.7	80	45.00	2.07
	C3	3	1	C8-391.02-32 135	80.0	32.0	135.0	95.7	80	45.00	2.53
	C4	3	1	C8-391.02-40 070B	80.0	40.0	70.0	31.4	80	55.00	2.20
	C4	3	1	C8-391.02-40 155	80.0	40.0	155.0	116.4	80	55.00	2.97
	C5	3	1	C8-391.02-50 080B	80.0	50.0	80.0	42.8	80	95.00	2.43
	C5	3	1	C8-391.02-50 185	80.0	50.0	185.0	147.8	80	95.00	3.88
	C6	3	1	C8-391.02-63 080B	80.0	63.0	80.0	44.5	80	170.00	2.65
	C6	3	1	C8-391.02-63 200	80.0	63.0	200.0	164.5	80	170.00	5.37
C10	C6	3	1	C10-391.02-63 200	100.0	63.0	200.0	155.8	80	170.00	6.92
	C8	3	1	C10-391.02-80 200	100.0	80.0	200.0	158.1	80	170.00	8.92



					Dimensions, mm								
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>	BAR	NM	KG
C8	C6	3	1	C8-391.02-63 120A	80.0	63.0	120.0	10.0	89.2	6°	80	170.00	4.10
C10	C3	3	1	C10-391.02-32 085	100.0	32.0	85.0	36.7	48.2	71°	80	45.00	4.15
	C4	3	1	C10-391.02-40 090	100.0	40.0	90.0	42.7	53.2	71°	80	55.00	4.25
	C5	3	1	C10-391.02-50 095	100.0	50.0	95.0	49.1	58.2	70°	80	95.00	4.42
	C6	3	1	C10-391.02-63 095	100.0	63.0	95.0	50.8	58.2	68°	80	170.00	4.68
	C8	3	1	C10-391.02-80 100	100.0	80.0	100.0	58.1	63.2	63°	80	170.00	5.25

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23

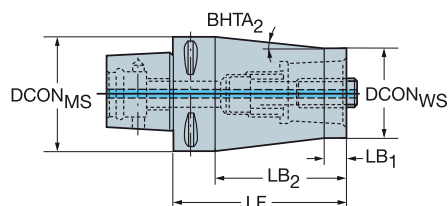


N6



N15

## Coromant Capto® reduction adaptor



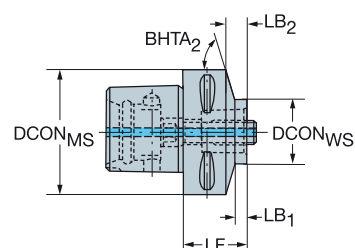
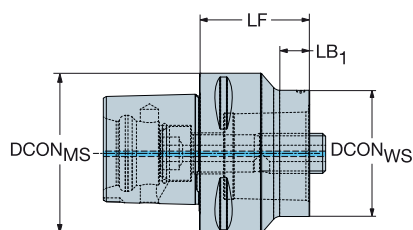
					Dimensions, mm								
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>	BAR	NM	KG
C4	C3	3	1	C4-391.02-32 070A	40.0	32.0	70.0	10.0	59.2	6°	80	45.00	0.59
C5	C3	3	1	C5-391.02-32 150	50.0	32.0	150.0	5.0	129.2	4°	80	45.00	1.65
	C4	3	1	C5-391.02-40 085A	50.0	40.0	85.0	10.0	64.2	5°	80	45.00	1.10
C6	C3	3	1	C6-391.02-32 185	63.0	32.0	185.0	5.0	162.2	6°	80	45.00	2.99
	C4	3	1	C6-391.02-40 185	63.0	40.0	185.0	5.0	162.2	4°	80	55.00	3.23
C6	C5	3	1	C6-391.02-50 110A	63.0	50.0	110.0	10.0	87.2	5°	80	95.00	2.23
	C4	3	1	C8-391.02-40 200	80.0	40.0	200.0	5.0	169.2	7°	80	55.00	5.42
C8	C5	3	1	C8-391.02-50 200	80.0	50.0	200.0	5.0	169.2	5°	80	95.00	5.84

## Short design, for segment clamping only

DSGN

2

7



						Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BAR	NM	KG
C5	C3	3	1	2	C5-391.02-32 033A	50.0	32.0	33.0	5.0	33.0		50.0		0°	80	45.00	0.54
	C4	3	1	2	C5-391.02-40 040A	50.0	40.0	40.0	15.0	40.0		50.0		0°	80	55.00	0.59
C6	C3	3	1	2	C6-391.02-32 032	63.0	32.0	32.0	6.0	32.0		63.0		0°	80	45.00	0.91
	C4	3	1	2	C6-391.02-40 040	63.0	40.0	40.0	11.0	40.0		63.0		0°	80	55.00	0.98
	C5	3	1	2	C6-391.02-50 050A	63.0	50.0	50.0	20.0	50.0		63.0		0°	80	95.00	1.11
C8	C5	3	1	2	C8-391.02-50 045A	80.0	50.0	45.0	5.0	45.0		80.0		0°	80	95.00	2.00
	C6	3	1	2	C8-391.02-63 055A	80.0	63.0	55.0	15.0	55.0		80.0		0°	80	170.00	2.15
C10	C6	3	1	7	C10-391.02-63 055	100.0	63.0	55.0	14.0	19.0	55.0	63.0	100.0	75°	80	170.00	3.70
	C8	3	1	7	C10-391.02-80 065	100.0	80.0	65.0	25.4	29.0	65.0	80.0	100.0	70°	80	170.00	3.92

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23



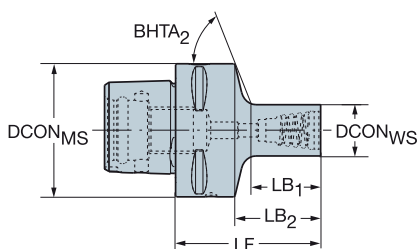
N6



N15

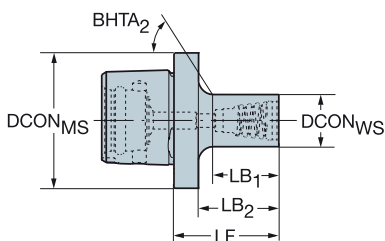
# Coromant Capto® to Coromant EH adaptor

Short design



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
C3	E10	3	1	C3-391.EH-10 035	32.0	9.6	35.0	13.2	20.0	58°	150	12.00	0.19	40000
	E12	3	1	C3-391.EH-12 038	32.0	11.6	38.0	16.4	23.0	57°	150	15.00	0.21	40000
	E16	3	1	C3-391.EH-16 043	32.0	15.4	43.0	21.9	28.0	53°	150	30.00	0.26	40000
C4	E10	3	1	C4-391.EH-10 041	40.0	9.6	41.0	13.1	21.0	62°	150	12.00	0.35	39000
	E12	3	1	C4-391.EH-12 044	40.0	11.6	44.0	16.4	24.0	61°	150	15.00	0.36	39000
	E16	3	1	C4-391.EH-16 049	40.0	15.4	49.0	21.9	29.0	59°	150	30.00	0.42	39000
	E20	3	1	C4-391.EH-20 046	40.0	19.2	46.0	19.4	26.0	57°	150	50.00	0.43	39000
	E25	3	1	C4-391.EH-25 051	40.0	24.1	51.0	25.0	31.0	53°	150	65.00	0.50	39000
C5	E10	3	1	C5-391.EH-10 042	50.0	9.6	42.0	12.8	22.0	65°	150	12.00	0.56	28000
	E12	3	1	C5-391.EH-12 045	50.0	11.6	45.0	16.0	25.0	64°	150	15.00	0.57	28000
	E16	3	1	C5-391.EH-16 050	50.0	15.4	50.0	21.5	30.0	63°	150	30.00	0.63	28000
	E20	3	1	C5-391.EH-20 047	50.0	19.2	47.0	19.0	27.0	62°	150	50.00	0.64	28000
	E25	3	1	C5-391.EH-25 052	50.0	24.1	52.0	24.7	32.0	60°	150	65.00	0.70	28000
C6	E10	3	1	C6-391.EH-10 046	63.0	9.6	46.0	13.0	24.0	67°	150	12.00	0.94	20000
	E12	3	1	C6-391.EH-12 049	63.0	11.6	49.0	16.3	27.0	67°	150	15.00	0.95	20000
	E16	3	1	C6-391.EH-16 054	63.0	15.4	54.0	21.8	32.0	66°	150	30.00	1.01	20000
	E20	3	1	C6-391.EH-20 051	63.0	19.2	51.0	19.3	29.0	66°	150	50.00	1.02	20000
	E25	3	1	C6-391.EH-25 056	63.0	24.1	56.0	25.0	34.0	65°	150	65.00	1.08	20000

## Short design, for segment clamping only



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
C3	E10	3	1	C3-391.EH-10 026	32.0	9.6	26.0	13.0	18.0	45°	150	12.00	0.15	40000
	E12	3	1	C3-391.EH-12 029	32.0	11.6	29.0	16.0	21.0	45°	150	15.00	0.17	40000
	E16	3	1	C3-391.EH-16 027	32.0	15.4	27.0	14.0	19.0	45°	150	30.00	0.24	55000
	E20	3	1	C3-391.EH-20 031	32.0	19.2	31.0	18.0	23.0	45°	150	50.00	0.27	55000
C4	E10	3	1	C4-391.EH-10 026	40.0	9.6	26.0	13.0	18.0	45°	150	12.00	0.24	39000
	E12	3	1	C4-391.EH-12 029	40.0	11.6	29.0	16.0	21.0	45°	150	15.00	0.26	39000
	E16	3	1	C4-391.EH-16 035	40.0	15.4	35.0	22.0	27.0	45°	150	30.00	0.31	39000
	E20	3	1	C4-391.EH-20 031	40.0	19.2	31.0	18.0	23.0	45°	150	50.00	0.34	39000
	E25	3	1	C4-391.EH-25 038	40.0	24.1	38.0	25.0	30.0	45°	150	65.00	0.28	39000
C5	E10	3	1	C5-391.EH-10 026	50.0	9.6	26.0	13.0	18.0	45°	150	12.00	0.38	28000
	E12	3	1	C5-391.EH-12 029	50.0	11.6	29.0	16.0	21.0	45°	150	15.00	0.40	28000
	E16	3	1	C5-391.EH-16 035	50.0	15.4	35.0	22.0	27.0	45°	150	30.00	0.45	28000
	E20	3	1	C5-391.EH-20 031	50.0	19.2	31.0	18.0	23.0	45°	150	50.00	0.47	28000
	E25	3	1	C5-391.EH-25 038	50.0	24.1	38.0	25.0	30.0	45°	150	65.00	0.53	28000

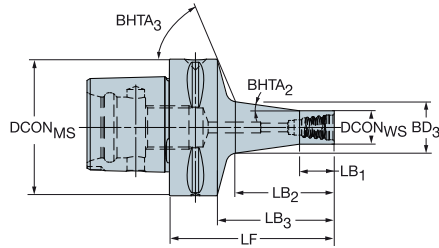
For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)





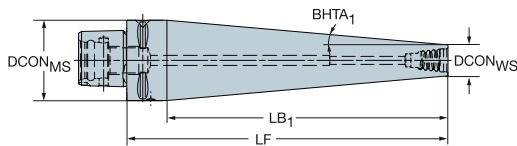
## Coromant Capto® to Coromant EH adaptor

Long design



				Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BHTA <sub>3</sub>	BAR	NM	KG	RPMX
C3	E10	3	1	C3-391.EH-10 049	32.0	9.6	49.0	10.0	28.5	34.0	14.8	8°	57°	150	12.00	0.20	40000
	E12	3	1	C3-391.EH-12 054	32.0	11.6	54.0	12.0	33.9	39.0	17.8	8°	54°	150	15.00	0.25	40000
	E16	3	1	C3-391.EH-16 065	32.0	15.4	65.0	16.0	45.7	50.0	23.8	8°	44°	150	30.00	0.32	40000
C4	E10	3	1	C4-391.EH-10 055	40.0	9.6	55.0	10.0	28.5	32.6	22.1	8°	62°	150	12.00	0.37	39000
	E12	3	1	C4-391.EH-12 060	40.0	11.6	60.0	12.0	33.9	40.0	17.7	8°	61°	150	15.00	0.39	39000
	E16	3	1	C4-391.EH-16 071	40.0	15.4	71.0	16.0	45.7	51.0	23.7	8°	56°	150	30.00	0.48	39000
	E20	3	1	C4-391.EH-20 084	40.0	19.2	84.0	20.0	59.6	64.0	30.3	8°	47°	150	50.00	0.59	39000
	E25	3	1	C4-391.EH-25 074	40.0	24.1	74.0	25.0	49.6	54.0	31.0	8°	45°	150	65.00	0.61	39000
C5	E10	3	1	C5-391.EH-10 056	50.0	9.6	56.0	10.0	28.1	36.0	14.7	8°	65°	150	12.00	0.57	28000
	E12	3	1	C5-391.EH-12 061	50.0	11.6	61.0	12.0	33.5	41.0	17.6	8°	65°	150	15.00	0.60	28000
	E16	3	1	C5-391.EH-16 072	50.0	15.4	72.0	16.0	45.3	52.0	23.6	8°	63°	150	30.00	0.69	28000
	E20	3	1	C5-391.EH-20 085	50.0	19.2	85.0	20.0	59.2	65.0	30.2	8°	59°	150	50.00	0.79	28000
	E25	3	1	C5-391.EH-25 100	50.0	24.1	100.0	25.0	75.3	80.0	38.2	8°	51°	150	65.00	1.01	28000
C6	E10	3	1	C6-391.EH-10 060	63.0	9.6	60.0	10.0	28.4	38.0	14.8	8°	68°	150	12.00	0.95	20000
	E12	3	1	C6-391.EH-12 065	63.0	11.6	65.0	12.0	33.8	43.0	17.7	8°	67°	150	15.00	0.97	20000
	E16	3	1	C6-391.EH-16 076	63.0	15.4	76.0	16.0	45.6	54.0	23.7	8°	66°	150	30.00	1.07	20000
	E20	3	1	C6-391.EH-20 088	63.0	19.2	88.0	20.0	58.4	66.0	30.0	8°	65°	150	50.00	1.16	20000
	E25	3	1	C6-391.EH-25 103	63.0	24.1	103.0	25.0	74.5	81.0	38.0	8°	62°	150	65.00	1.37	20000
C8	E20	3	1	C8-391.EH-20 100	80.0	19.2	100.0	20.0	60.2	70.0	30.5	8°	68°	150	50.00	2.25	14000
	E25	3	1	C8-391.EH-25 114	80.0	24.1	114.0	25.0	75.3	84.0	38.2	8°	68°	150	65.00	2.45	14000

Long conical design



				Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX			
C3	E10	3	1	C3-391.EH-10 143	32.0	9.6	143.0	128.0	5°	150	12.00	0.55	40000			
	E12	3	1	C3-391.EH-12 132	32.0	11.6	132.0	117.0	5°	150	15.00	0.56	40000			
	E16	3	1	C3-391.EH-16 110	32.0	15.4	110.0	95.0	5°	150	30.00	0.57	40000			
C4	E10	3	1	C4-391.EH-10 128	40.0	9.6	128.0	108.0	8°	150	12.00	0.78	39000			
	E12	3	1	C4-391.EH-12 121	40.0	11.6	121.0	101.0	8°	150	15.00	0.78	39000			
	E16	3	1	C4-391.EH-16 160	40.0	15.4	160.0	140.0	5°	150	30.00	1.06	39000			
	E20	3	1	C4-391.EH-20 139	40.0	19.2	139.0	119.0	5°	150	50.00	1.03	39000			
C5	E16	3	1	C5-391.EH-16 143	50.0	15.4	143.0	123.0	8°	150	30.00	1.43	28000			
	E20	3	1	C5-391.EH-20 130	50.0	19.2	130.0	110.0	8°	150	50.00	1.40	28000			

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23

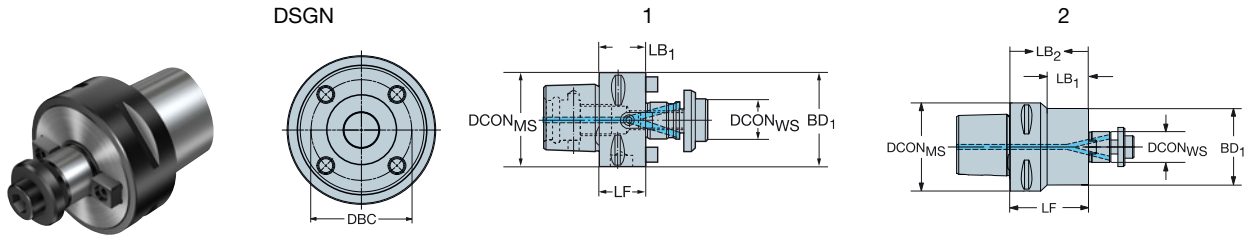


N15



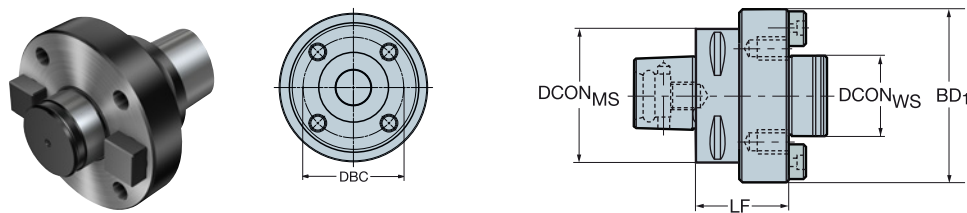
N3

# Coromant Capto® to arbor adaptor



## Coolant through arbor

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNCS	CXSC	DSGN	Ordering code	Dimensions, mm												
						DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX	
C3	16	3	4	1	C3-391.05C-16 030	32.0		16.0	30.0	30.0		32.0		80	22.00	0.25	20000	
C4	16	3	4	2	C4-391.05C-16 032	40.0		16.0	32.0	10.0	32.0	40.0	40.0	80	22.00	0.38	20000	
	16	3	4	2	C4-391.05C-16 055	40.0		16.0	55.0	33.0	55.0	32.0	40.0	80	22.00	0.40	20000	
	22	3	4	1	C4-391.05C-22 025	40.0		22.0	25.0	25.0		40.0		80	45.00	0.40	16000	
	22	3	4	1	C4-391.05C-22 055	40.0		22.0	55.0	55.0		40.0		80	45.00	0.60	16000	
C5	16	3	4	2	C5-391.05C-16 035	50.0		16.0	35.0	10.0	35.0	32.0	50.0	80	22.00	0.60	20000	
	16	3	4	2	C5-391.05C-16 070	50.0		16.0	70.0	44.8	70.0	32.0	50.0	80	22.00	0.70	20000	
	22	3	4	1	C5-391.05C-22 025M	50.0		22.0	25.0	25.0		50.0		80	45.00	0.62	16000	
	22	3	4	2	C5-391.05C-22 070	50.0		22.0	70.0	47.0	70.0	40.0	50.0	80	45.00	0.90	16000	
	27	3	4	1	C5-391.05C-27 025M	50.0		27.0	25.0	25.0		56.0		80	80.00	0.68	17000	
	32	3	4	1	C5-391.05C-32 040	50.0		32.0	40.0	40.0		63.0		80	180.00	1.14	16000	
C6	16	3	4	2	C6-391.05C-16 040	63.0		16.0	40.0	10.0	40.0	32.0	63.0	80	22.00	1.00	20000	
	22	3	4	1	C6-391.05C-22 025M	63.0		22.0	25.0	25.0		63.0		80	45.00	0.96	16000	
	22	3	4	2	C6-391.05C-22 080	63.0		22.0	80.0	40.0	80.0	40.0	63.0	80	45.00	1.40	16000	
	27	3	4	1	C6-391.05C-27 025M	63.0		27.0	25.0	25.0		63.0		80	80.00	1.01	17000	
	27	3	4	2	C6-391.05C-27 080	63.0		27.0	80.0	55.0	80.0	50.0	63.0	80	80.00	1.60	17000	
	32	3	4	1	C6-391.05C-32 025M	63.0		32.0	25.0	25.0		65.0		80	180.00	1.09	16000	
	40S	3	4	1	C6-391.05C-40 050M	63.0	66.7	40.0	50.0	50.0		87.0		80	300.00	2.40	17000	
C8	16	3	4	2	C8-391.05C-16 050	80.0		16.0	50.0	10.0	50.0	32.0	80.0	80	22.00	2.10	14000	
	22	3	4	1	C8-391.05C-22 030M	80.0		22.0	30.0	30.0		80.0		80	45.00	1.86	14000	
	22	3	4	2	C8-391.05C-22 090	80.0		22.0	90.0	45.0	90.0	40.0	80.0	80	45.00	2.40	14000	
	27	3	4	1	C8-391.05C-27 030M	80.0		27.0	30.0	30.0		80.0		80	80.00	1.91	14000	
	27	3	4	2	C8-391.05C-27 090	80.0		27.0	90.0	50.0	90.0	50.0	80.0	80	80.00	2.70	14000	
	32	3	4	1	C8-391.05C-32 030M	80.0		32.0	30.0	30.0		80.0		80	180.00	2.02	14000	
	40S	3	4	1	C8-391.05C-40 060M	80.0	66.7	40.0	60.0	60.0		87.0		80	300.00	3.47	14000	
C10	27	3	4	2	C10-391.05C-27 075	100.0		27.0	75.0	29.0	75.0	60.0	100.0	80	80.00	4.52	10000	
	32	3	4	2	C10-391.05C-32 075	100.0		32.0	75.0	33.0	75.0	78.0	100.0	80	180.00	5.04	10000	
	40S	3	4	1	C10-391.05C-40 040M	100.0	66.7	40.0	40.0	40.0		100.0		80	300.00	3.95	10000	

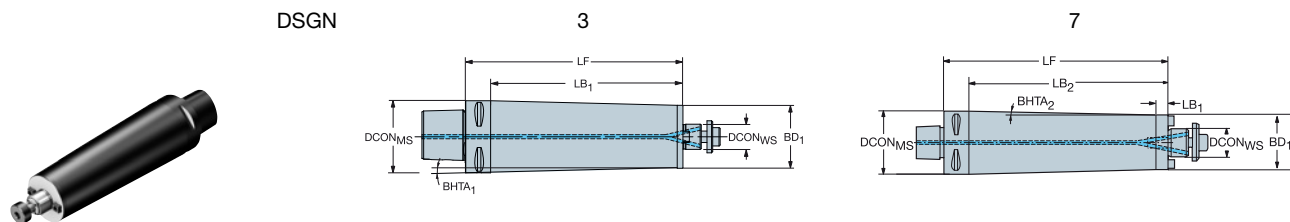


CZC <sub>MS</sub>	CZC <sub>WS</sub>	Ordering code	Dimensions, mm							RPMX
			DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LF	BD <sub>1</sub>	NM	KG	
C8	60	C8-391.05-60 060	80.0	101.6	60.0	60.0	130.0	180.00	6.03	14000
C10	60	C10-391.05-60 075	100.0	101.6	60.0	75.0	130.0	180.00	8.50	10000

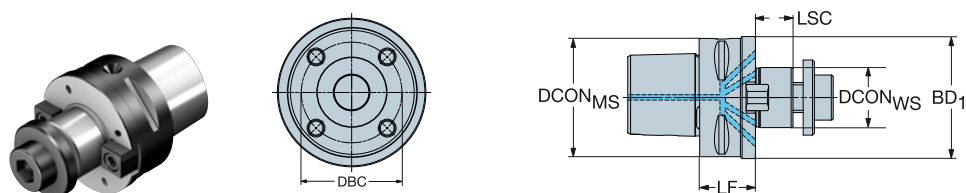
For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



## Coromant Capto® to arbor adaptor



					Dimensions, mm															
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
C4	16	3	4	7	C4-391.05C-16 120	40.0	16.0	120.0	22.0	100.0	120.0	32.0	32.0	40.0	0°	2°	80	22.00	0.99	18000
C5	22	3	4	7	C5-391.05C-22 150	50.0	22.0	150.0	12.0	130.0	150.0	40.0	40.0	50.0	0°	2°	80	45.00	2.04	16000
C6	22	3	4	3	C6-391.05C-22 120	63.0	22.0	120.0	98.0	120.0		55.0	63.0		2°	0°	80	45.00	2.82	16000
	22	3	4	3	C6-391.05C-22 190	63.0	22.0	190.0	168.0	190.0		55.0	63.0		1°	0°	80	45.00	4.25	14000
C8	27	3	4	3	C8-391.05C-27 150	80.0	27.0	150.0	120.0	150.0		65.0	80.0		3°	0°	80	80.00	5.62	12000
	27	3	4	3	C8-391.05C-27 240	80.0	27.0	240.0	210.0	240.0		65.0	80.0		2°	0°	80	80.00	8.42	10000



					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LSC	LF	BD <sub>1</sub>	BAR	NM	KG	RPMX				
C6	32	3	3	C6-391.07C-32 030	63.0	32.0	20	25.0	65.0	80	180.00	1.23	12000					
C8	40S	3	3	C8-391.07C-40 060	80.0	66.7	40.0	23	60.0	87.0	80	300.00	3.48	10000				

Coolant supply for CoroMill QD with driving collars. For driving collars see page M27.

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



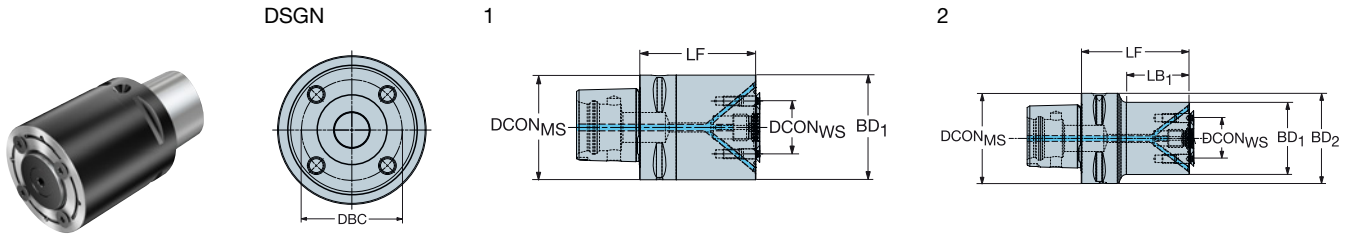
N23



N15

# Coromant Capto® to arbor with driving screws adaptor

For CoroMill® QD with internal coolant supply



					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
C3	X10	3	3	1	C3-X10-032-040	32.0	22.0	10.0	2	40.0	40.0		32.0	40.0	80	6.40	0.28	12000
C4	X10	3	3	2	C4-X10-032-050	40.0	22.0	10.0	2	50.0	25.5	50.0	32.0	40.0	80	6.40	0.46	12000
	X22	3	3	1	C4-X22-040-050	40.0	32.0	22.0	2	50.0	50.0		40.0		80	3.90	0.56	11000
C5	X22	3	3	2	C5-X22-040-060	50.0	32.0	22.0	2	60.0	35.0	60.0	40.0	50.0	80	3.90	0.85	11000
	X32	3	3	1	C5-X32-063-070	50.0	45.0	32.0	2	70.0	70.0		63.0		80	6.40	1.64	10000
C6	X32	3	3	1	C6-X32-063-070	63.0	45.0	32.0	2	70.0	70.0		63.0		80	6.40	1.93	10000
	X40	3	3	1	C6-X40-080-090	63.0	63.0	40.0	2	90.0	90.0		80.0		80	70.00	3.46	8000
C8	X40	3	3	1	C8-X40-080-095	80.0	63.0	40.0	2	95.0	95.0		80.0		80	70.00	4.34	8000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1

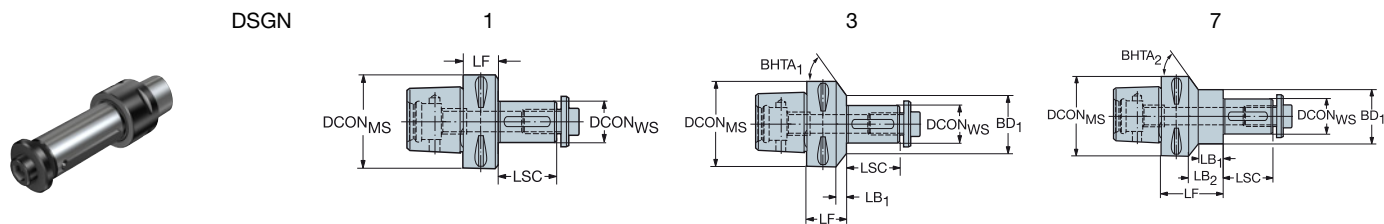


N23



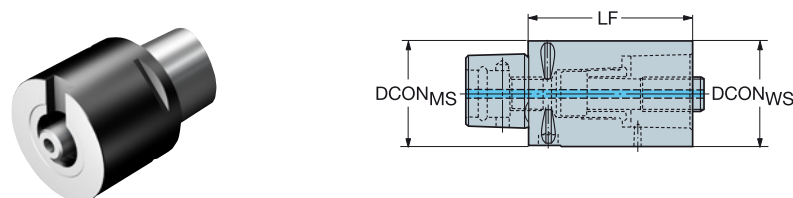
N15

## Coromant Capto® to side and face mill arbor adaptor



					Dimensions, mm																
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
C3	16	3	1	3	C3-391.10-16 020	32.0	16.0	30	20.0	5.0	20.0		28.0	32.0		21°	0°	80	22.00	0.22	8000
C4	16	3	1	3	C4-391.10-16 025	40.0	16.0	30	25.0	5.0	25.0		28.0	40.0		50°	0°	80	22.00	0.37	8000
	22	3	1	3	C4-391.10-22 025	40.0	22.0	40	25.0	5.0	25.0		36.0	40.0		22°	0°	80	45.00	0.46	8000
	27	3	1	1	C4-391.10-27 025	40.0	27.0	60	25.0	25.0			40.0					80	80.00	0.62	7000
C5	22	3	1	3	C5-391.10-22 025	50.0	22.0	40	25.0	5.1	25.0		36.0	50.0		54°	0°	80	45.00	0.72	8000
	27	3	1	3	C5-391.10-27 025	50.0	27.0	60	25.0	5.0	25.0		43.0	50.0		35°	0°	80	80.00	0.83	7000
	32	3	1	1	C5-391.10-32 025	50.0	32.0	60	25.0	25.0			50.0					80	180.00	0.96	6000
C6	16	3	1	3	C6-391.10-16 030	63.0	16.0	30	30.0	7.8	30.0		28.0	63.0		66°	0°	80	22.00	0.97	10000
	22	3	1	3	C6-391.10-22 030	63.0	22.0	40	30.0	7.9	30.0		36.0	63.0		59°	0°	80	45.00	1.10	8000
	27	3	1	3	C6-391.10-27 030	63.0	27.0	60	30.0	7.8	30.0		43.0	63.0		52°	0°	80	80.00	1.25	7000
	32	3	1	3	C6-391.10-32 025	63.0	32.0	60	25.0	3.0	25.0		48.0	63.0		68°	0°	80	180.00	1.30	6000
	40	3	1	3	C6-391.10-40 025	63.0	40.0	60	25.0	3.0	25.0		56.0	63.0		49°	0°	80	300.00	1.57	5000
C8	22	3	1	3	C8-391.10-22 040	80.0	22.0	40	40.0	10.2	40.0		36.0	80.0		65°	0°	80	45.00	2.26	8000
	27	3	1	3	C8-391.10-27 030	80.0	27.0	60	30.0	7.8	30.0		43.0	80.0		67°	0°	80	80.00	2.00	7000
	32	3	1	3	C8-391.10-32 030	80.0	32.0	60	30.0	7.6	30.0		48.0	80.0		64°	0°	80	180.00	2.12	6000
	40	3	1	3	C8-391.10-40 030	80.0	40.0	60	30.0	7.9	30.0		56.0	80.0		56°	0°	80	300.00	2.38	5000
	50	3	1	3	C8-391.10-50 030	80.0	50.0	60	30.0	3.0	30.0		70.0	80.0		58°	0°	80	120.00	2.90	4500
	60	3	1	1	C8-391.10-60 030	80.0	60.0	60	30.0	30.0			80.0					80	180.00	3.51	4000
C10	32	3	1	7	C10-391.10-32 065	100.0	32.0	60	65.0	20.0	29.0	65.0	48.0	48.0	100.0	0°	71°	80	180.00	4.43	6000
	40	3	1	7	C10-391.10-40 070	100.0	40.0	60	70.0	25.0	34.0	70.0	56.0	56.0	100.0	0°	67°	80	300.00	4.87	5000
	50	3	1	7	C10-391.10-50 055	100.0	50.0	80	55.0	10.0	19.0	55.0	70.0	70.0	100.0	0°	59°	80	120.00	5.44	4500
	60	3	1	3	C10-391.10-60 040	100.0	60.0	90	40.0	4.0	40.0		84.0	100.0		63°	0°	80	180.00	5.93	4000

## Coromant Capto® to VL adaptor



					Dimensions, mm					
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	BAR	NM	KG
C8	80	3	1	C8-391.01-V80 065	80.0	80.0	65.0	80	170.00	3.05

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23



N15

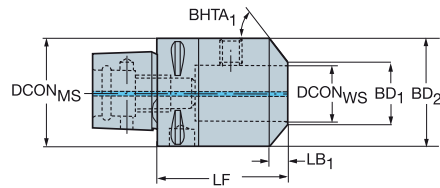
# Coromant Capto® to Weldon adaptor

Workpiece side interface DIN 6535-HB and DIN 1835-B

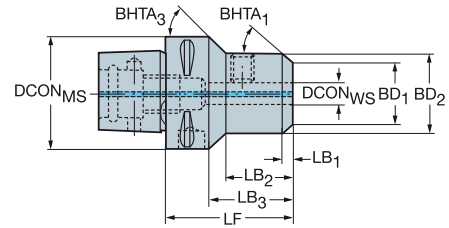


DSGN

3



14



					Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>1</sub>	BHTA <sub>3</sub>	BAR	NM	KG	RPMX
C3	6	3	1	14	C3-391.20-06 045A	32.0	6.0	46.0	4.0	27.5	29.5	46.0	17.0	25.0	25.0	32.0	45°	60°	20	3.00	0.24	32000
	8	3	1	14	C3-391.20-08 045A	32.0	8.0	46.0	4.0	29.0	31.0	46.0	20.0	28.0	28.0	32.0	45°	45°	20	7.00	0.26	32000
	10	3	1	3	C3-391.20-10 050	32.0	10.0	50.0	4.0	50.0			27.0	35.0			45°		20	10.00	0.40	32000
	12	3	1	3	C3-391.20-12 055	32.0	12.0	55.0	5.0	55.0			32.0	42.0			45°		20	12.00	0.51	32000
C4	6	3	1	14	C4-391.20-06 050	40.0	6.0	50.0	4.0	25.5	29.8	50.0	17.0	25.0	25.0	40.0	45°	60°	20	3.00	0.40	30000
	8	3	1	14	C4-391.20-08 050	40.0	8.0	50.0	4.0	26.5	32.5	50.0	20.0	28.0	28.0	40.0	45°	45°	20	7.00	0.40	30000
	10	3	1	14	C4-391.20-10 050A	40.0	10.0	51.0	4.0	29.6	31.0	51.0	27.0	35.0	35.0	40.0	45°	60°	20	10.00	0.50	30000
	12	3	1	3	C4-391.20-12 055A	40.0	12.0	56.0	5.0	56.0			32.0	42.0			45°		20	12.00	0.61	30000
	14	3	1	3	C4-391.20-14 055	40.0	14.0	55.0	5.0	55.0			34.0	44.0			45°		20	12.00	0.62	30000
	16	3	1	3	C4-391.20-16 055	40.0	16.0	55.0	5.0	55.0			38.0	48.0			45°		20	15.00	0.70	30000
C5	6	3	1	14	C5-391.20-06 050	50.0	6.0	50.0	4.0	25.5	30.0	50.0	17.0	25.0	25.0	50.0	45°	70°	20	3.00	0.62	28000
	8	3	1	14	C5-391.20-08 050	50.0	8.0	50.0	4.0	26.0	30.0	50.0	20.0	28.0	28.0	50.0	45°	70°	20	7.00	0.60	28000
	10	3	1	14	C5-391.20-10 055	50.0	10.0	55.0	4.0	27.5	35.0	55.0	27.0	35.0	35.0	50.0	45°	45°	20	10.00	0.72	28000
	12	3	1	14	C5-391.20-12 060	50.0	12.0	60.0	5.0	36.0	40.0	60.0	32.0	42.0	42.0	50.0	45°	45°	20	12.00	0.90	28000
	14	3	1	14	C5-391.20-14 060	50.0	14.0	60.0	5.0	37.0	40.0	60.0	34.0	44.0	44.0	50.0	45°	45°	20	12.00	0.90	28000
	16	3	1	14	C5-391.20-16 060	50.0	16.0	60.0	5.0	39.0	40.0	60.0	38.0	48.0	48.0	50.0	45°	45°	20	15.00	1.00	28000
	18	3	1	3	C5-391.20-18 060	50.0	18.0	60.0	5.0	60.0			40.0	50.0			45°		20	15.00	0.95	28000
	20	3	1	3	C5-391.20-20 060	50.0	20.0	60.0	5.0	60.0			42.0	52.0			45°		20	20.00	1.00	28000
	25	3	1	3	C5-391.20-25 080	50.0	25.0	80.0	8.0	80.0			49.0	65.0			45°		20	25.00	1.68	28000
C6	6	3	1	14	C6-391.20-06 055	63.0	6.0	55.0	4.0	25.0	32.7	55.0	17.0	25.0	25.0	63.0	45°	68°	20	3.00	0.99	20000
	8	3	1	14	C6-391.20-08 055	63.0	8.0	55.0	4.0	26.0	33.1	55.0	20.0	28.0	28.0	63.0	45°	68°	20	7.00	1.00	20000
	10	3	1	14	C6-391.20-10 060	63.0	10.0	60.0	4.0	30.0	38.1	60.0	27.0	35.0	35.0	63.0	45°	60°	20	10.00	1.12	20000
	12	3	1	14	C6-391.20-12 060	63.0	12.0	60.0	5.0	33.0	37.9	60.0	32.0	42.0	42.0	63.0	45°	65°	20	12.00	1.20	20000
	14	3	1	14	C6-391.20-14 060	63.0	14.0	60.0	5.0	33.5	37.9	60.0	34.0	44.0	44.0	63.0	45°	65°	20	12.00	1.20	20000
	16	3	1	14	C6-391.20-16 065	63.0	16.0	65.0	5.0	35.5	43.0	65.0	38.0	48.0	48.0	63.0	45°	45°	20	15.00	1.36	20000
	18	3	1	14	C6-391.20-18 065	63.0	18.0	65.0	5.0	39.0	42.7	65.0	40.0	50.0	50.0	63.0	45°	60°	20	15.00	1.38	20000
	20	3	1	14	C6-391.20-20 065	63.0	20.0	65.0	5.0	37.5	43.0	65.0	42.0	52.0	52.0	63.0	45°	45°	20	20.00	1.30	20000
	25	3	1	3	C6-391.20-25 080	63.0	25.0	80.0	8.0	80.0			49.0	65.0			45°		20	25.00	2.00	20000
	32	3	1	3	C6-391.20-32 090	63.0	32.0	90.0	8.0	90.0			56.0	72.0			45°		20	45.00	2.48	20000
	40	3	1	3	C6-391.20-40 100	63.0	40.0	100.0	8.0	100.0			74.0	90.0			45°		20	45.00	3.88	20000
C8	6	3	1	14	C8-391.20-06 070	80.0	6.0	70.0	4.0	27.0	40.0	70.0	17.0	25.0	25.0	80.0	45°	65°	20	3.00	2.18	14000
	8	3	1	14	C8-391.20-08 070	80.0	8.0	70.0	4.0	28.0	40.0	70.0	20.0	28.0	28.0	80.0	45°	65°	20	7.00	2.18	14000
	10	3	1	14	C8-391.20-10 070	80.0	10.0	70.0	4.0	29.5	40.0	70.0	27.0	35.0	35.0	80.0	45°	65°	20	10.00	2.22	14000
	12	3	1	14	C8-391.20-12 070	80.0	12.0	70.0	5.0	31.0	40.0	70.0	32.0	42.0	42.0	80.0	45°	65°	20	12.00	2.31	14000
	14	3	1	14	C8-391.20-14 070	80.0	14.0	70.0	5.0	31.6	40.0	70.0	34.0	44.0	44.0	80.0	45°	65°	20	12.00	2.38	14000
	16	3	1	14	C8-391.20-16 070	80.0	16.0	70.0	5.0	33.0	40.0	70.0	38.0	48.0	48.0	80.0	45°	65°	20	15.00	2.38	14000
	18	3	1	14	C8-391.20-18 070	80.0	18.0	70.0	5.0	33.0	40.0	70.0	40.0	50.0	50.0	80.0	45°	65°	20	15.00	2.40	14000
	20	3	1	14	C8-391.20-20 070	80.0	20.0	70.0	5.0	35.5	40.0	70.0	42.0	52.0	52.0	80.0	45°	70°	20	20.00	2.39	14000
	25	3	1	14	C8-391.20-25 080	80.0	25.0	80.0	8.0	53.7	58.0	80.0	49.0	65.0	65.0	80.0	45°	60°	20	25.00	2.73	14000
	32	3	1	14	C8-391.20-32 080	80.0	32.0	80.0	8.0	55.7	58.0	80.0	56.0	72.0	72.0	80.0	45°	60°	20	45.00	2.88	14000
	40	3	1	3	C8-391.20-40 110	80.0	40.0	110.0	8.0	110.0			74.0	90.0			45°		20	45.00	5.05	14000
	50	3	1	3	C8-391.20-50 120	80.0	50.0	120.0	8.0	120.0			84.0	100.0			45°		20	60.00	5.91	14000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1

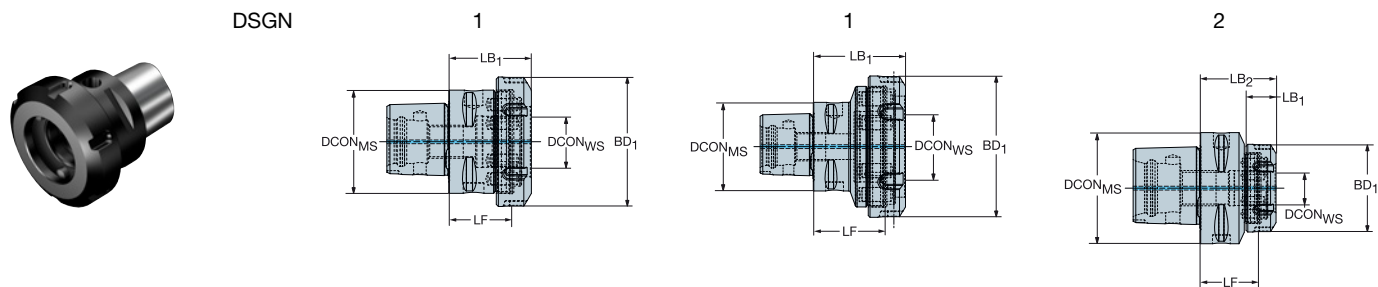


N23



N15

## Coromant Capto® to MDI adaptor



					Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
C3	MDI-20	3	1	1	C3-DM20-N-032	32.0	20.0	32.0	42.0		49.7		80	135.00	0.31	55000
C4	MDI-20	3	1	1	C4-DM20-N-028	40.0	20.0	28.0	38.0		49.7		80	135.00	0.40	39000
	MDI-25	3	1	1	C4-DM25-N-035	40.0	25.0	35.0	45.0		62.7		80	170.00	0.58	39000
C4	MDI-32	3	1	1	C4-DM32-N-042	40.0	32.0	42.0	52.0		67.7		80	200.00	0.71	39000
	MDI-20	3	1	2	C5-DM20-N-028	50.0	20.0	28.0	18.0	38.0	49.7	50.0	80	135.00	0.57	28000
C5	MDI-25	3	1	1	C5-DM25-N-030	50.0	25.0	30.0	40.0		62.7		80	170.00	0.67	28000
	MDI-32	3	1	1	C5-DM32-N-035	50.0	32.0	35.0	45.0		67.7		80	200.00	0.77	28000
C5	MDI-40	3	1	1	C5-DM40-N-040	50.0	40.0	40.0	52.0		79.7		80	230.00	1.00	28000
	MDI-20	3	1	2	C6-DM20-N-033	63.0	20.0	33.0	18.0	43.0	49.7	63.0	80	135.00	0.96	20000
C6	MDI-25	3	1	2	C6-DM25-N-030	63.0	25.0	30.0	18.0	40.0	62.7	63.0	80	170.00	1.00	20000
	MDI-32	3	1	1	C6-DM32-N-030	63.0	32.0	30.0	40.0		67.7		80	200.00	0.99	20000
C6	MDI-40	3	1	1	C6-DM40-N-040	63.0	40.0	40.0	52.0		79.7		80	230.00	1.34	20000
	MDI-32	3	1	2	C8-DM32-N-040	80.0	32.0	40.0	18.0	50.0	67.7	80.0	80	200.00	2.01	14000
C8	MDI-40	3	1	2	C8-DM40-N-040	80.0	40.0	40.0	22.0	52.0	79.7	80.0	80	230.00	2.09	14000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



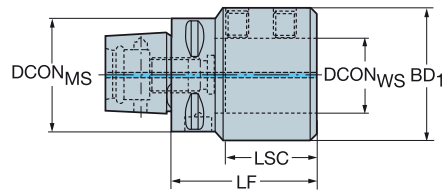
N15

# Coromant Capto® to ISO 9766 adaptor

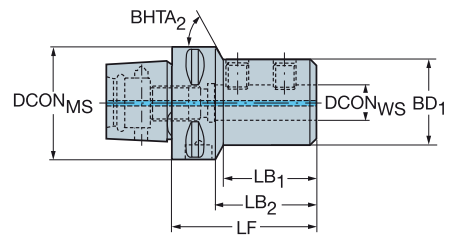


DSGN

1



7



		Dimensions, mm																		
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
C3	16	3	1	1	C3-391.27-16 056	32.0	16.0	49	56.0	56.0			36.0				20	10.00	0.40	32000
	20	3	1	1	C3-391.27-20 060	32.0	20.0	51	60.0	60.0			40.0				20	12.00	0.46	32000
	25	3	1	1	C3-391.27-25 080	32.0	25.0	57	80.0	80.0			45.0				20	20.00	0.70	32000
C4	16	3	1	7	C4-391.27-16 056	40.0	16.0	49	56.0	32.5	36.0	56.0	36.0	36.0	40.0	30°	20	10.00	0.49	30000
	20	3	1	1	C4-391.27-20 060	40.0	20.0	51	60.0	60.0			40.0				20	12.00	0.55	30000
	25	3	1	1	C4-391.27-25 077	40.0	25.0	57	77.0	77.0			45.0				20	20.00	0.75	30000
	32	3	1	1	C4-391.27-32 088	40.0	32.0	61	88.0	88.0			52.0				20	30.00	0.99	30000
C5	16	3	1	7	C5-391.27-16 065	50.0	16.0	49	65.0	41.7	45.0	65.0	36.0	36.0	50.0	65°	20	10.00	0.75	28000
	20	3	1	7	C5-391.27-20 060	50.0	20.0	51	60.0	37.7	40.0	60.0	40.0	40.0	50.0	65°	20	12.00	0.74	28000
	25	3	1	7	C5-391.27-25 071	50.0	25.0	57	71.0	46.7	51.0	71.0	45.0	45.0	50.0	30°	20	20.00	0.46	28000
	32	3	1	1	C5-391.27-32 075	50.0	32.0	61	75.0	75.0			52.0				20	30.00	0.97	28000
	40	3	1	1	C5-391.27-40 100	50.0	40.0	71	100.0	100.0			65.0				20	40.00	1.79	28000
C6	16	3	1	7	C6-391.27-16 070	63.0	16.0	49	70.0	43.0	47.9	70.0	36.0	36.0	63.0	70°	20	10.00	1.14	20000
	20	3	1	7	C6-391.27-20 070	63.0	20.0	51	70.0	43.8	48.0	70.0	40.0	40.0	63.0	70°	20	12.00	1.18	20000
	25	3	1	7	C6-391.27-25 070A	63.0	25.0	57	72.0	45.8	50.0	72.0	45.0	45.0	63.0	65°	20	20.00	1.23	20000
	32	3	1	7	C6-391.27-32 075	63.0	32.0	61	75.0	49.8	53.0	75.0	52.0	52.0	63.0	60°	20	30.00	1.30	20000
	40	3	1	1	C6-391.27-40 085	63.0	40.0	71	85.0	85.0			65.0				20	40.00	1.74	20000
C8	16	3	1	7	C8-391.27-16 080	80.0	16.0	49	80.0	42.0	50.0	80.0	36.0	36.0	80.0	70°	20	10.00	2.25	14000
	20	3	1	7	C8-391.27-20 080	80.0	20.0	51	80.0	43.8	49.9	80.0	40.0	40.0	80.0	73°	20	12.00	2.26	14000
	25	3	1	7	C8-391.27-25 085	80.0	25.0	57	85.0	49.8	55.1	85.0	45.0	45.0	80.0	73°	20	20.00	2.32	14000
	32	3	1	7	C8-391.27-32 090	80.0	32.0	61	90.0	53.8	60.0	90.0	52.0	52.0	80.0	66°	20	30.00	2.46	14000
	40	3	1	7	C8-391.27-40 095	80.0	40.0	71	95.0	62.8	65.1	95.0	65.0	65.0	80.0	73°	20	40.00	2.78	14000
50	3	1	7	C8-391.27-50 100	80.0	50.0	81	100.0	68.6	70.0	100.0	75.0	75.0	80.0	61°	20	45.00	2.94	14000	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



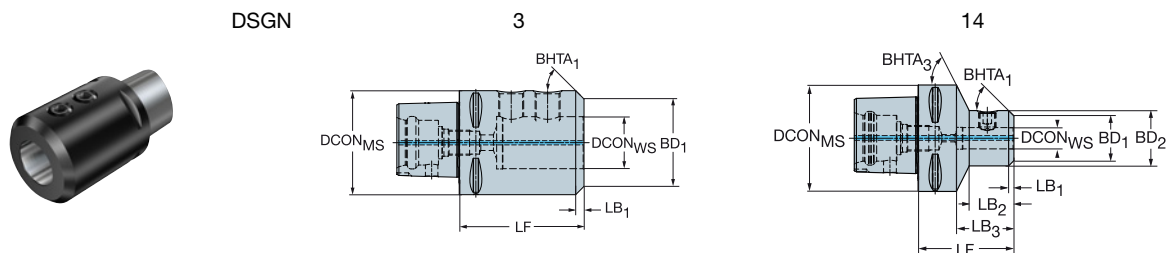
N23



N15



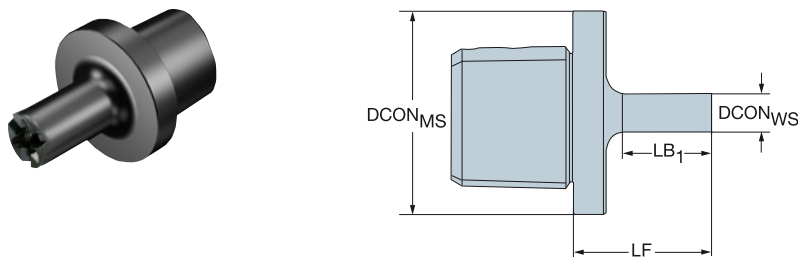
## Coromant Capto® to Weldon / ISO 9766 adaptor



		Dimensions, mm																				
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C10	20	3	1	14	C10-391.23-20 090	100.0	20.0	90.0	5.0	42.0	54.0	90.0	42.0	52.0	52.0	100.0	45°	63°	20	20.00	4.00	10000
	25	3	1	14	C10-391.23-25 105	100.0	25.0	105.0	8.0	61.0	69.0	105.0	49.0	65.0	65.0	100.0	45°	65°	20	25.00	5.09	10000
	32	3	1	14	C10-391.23-32 110	100.0	32.0	110.0	8.0	66.0	74.0	110.0	56.0	72.0	72.0	100.0	45°	60°	20	45.00	5.41	10000
	40	3	1	14	C10-391.23-40 115	100.0	40.0	115.0	8.0	76.0	79.0	115.0	74.0	90.0	90.0	100.0	45°	59°	20	45.00	6.58	10000
	50	3	1	3	C10-391.23-50 120	100.0	50.0	120.0	8.0	120.0				84.0	100.0			45°		20	60.00	7.20

## Coromant Capto® to CoroMill® 327 adaptor

Short design, for segment clamping only



		Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	NM	KG			RPMX			
C3	09	C3-391.327-09 035	32.0	9.0	35.0	22.0	4.30	0.14			55000			
C4	09	C4-391.327-09 035	40.0	9.0	35.0	22.0	4.30	0.21			39000			
	12	C4-391.327-12 043	40.0	12.0	43.0	30.0	6.50	0.29			39000			
C5	12	C5-391.327-12 043	50.0	12.0	43.0	30.0	6.50	0.41			28000			
	14	C5-391.327-14 048	50.0	14.3	48.0	35.0	6.50	0.43			28000			

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23



N15

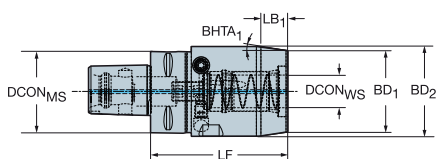
# Coromant Capto® to CoroChuck™ 930

Heavy Duty design

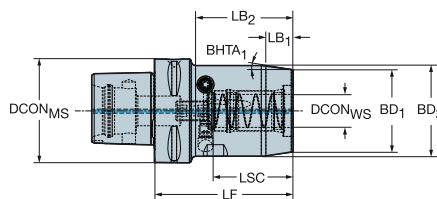


DSGN

3



6



		Dimensions, mm																		
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX
C4	20	3	1	3	930-C4-HD-20-084	40.0	20.0	51	84.0	17.8	84.0		50.0	55.0		8°	80	10.00	1.25	39000
C5	20	3	1	3	930-C5-HD-20-082	50.0	20.0	51	82.0	17.8	82.0		50.0	55.0		8°	80	10.00	1.40	28000
	25	3	1	3	930-C5-HD-25-088	50.0	25.0	57	88.0	18.8	88.0		57.0	65.0		12°	80	10.00	1.86	28000
C6	20	3	1	6	930-C6-HD-20-084	63.0	20.0	51	84.0	17.8	59.0	84.0	50.0	55.0	63.0	8°	80	10.00	1.76	20000
	25	3	1	3	930-C6-HD-25-087	63.0	25.0	57	87.0	18.8	87.0		57.0	65.0		12°	80	10.00	2.16	20000
	25	3	1	3	930-C6-HD-25-150	63.0	25.0	57	150.0	18.8	150.0		57.0	65.0		12°	80	10.00	3.63	20000
C8	32	3	1	3	930-C6-HD-32-091	63.0	32.0	61	91.0	18.8	91.0		68.0	76.0		12°	80	10.00	2.75	20000
	20	3	1	6	930-C8-HD-20-097	80.0	20.0	51	97.0	17.8	62.0	97.0	50.0	55.0	80.0	8°	80	10.00	2.88	14000
	25	3	1	6	930-C8-HD-25-097	80.0	25.0	57	97.0	18.8	63.0	97.0	57.0	65.0	80.0	12°	80	10.00	3.22	14000
	32	3	1	6	930-C8-HD-32-085	80.0	32.0	61	85.0	18.8	53.3	85.0	67.8	76.0	80.0	12°	80	10.00	3.25	14000
C10	32	3	1	6	930-C8-HD-32-180	80.0	32.0	61	180.0	18.8	148.0	180.0	68.0	76.0	80.0	12°	80	10.00	6.54	14000
	20	3	1	6	930-C10-HD-20-102	100.0	20.0	51	102.0	17.8	59.0	102.0	50.0	55.0	100.0	8°	80	10.00	4.49	10000
	25	3	1	6	930-C10-HD-25-105	100.0	25.0	57	105.0	18.8	63.0	105.0	57.0	65.0	100.0	12°	80	10.00	4.89	10000
	32	3	1	6	930-C10-HD-32-098	100.0	32.0	61	98.0	18.8	56.2	98.0	67.8	76.0	100.0	12°	80	10.00	5.14	10000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N6



N15



N4

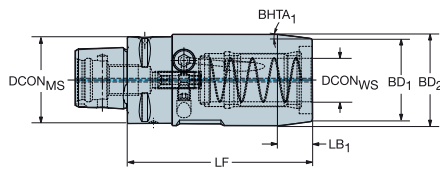
# Coromant Capto® to CoroChuck™ 930

Slender design

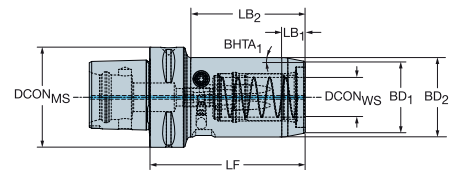


DSGN

3



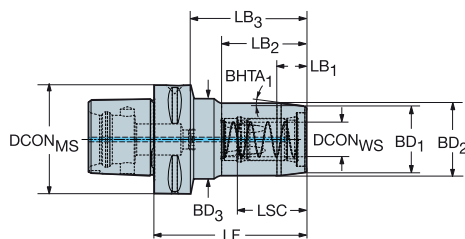
6



						Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX			
C3	6	3	1	6	930-C3-S-06-064	32.0	6.0	37	64.0	11.3	33.2	64.0	22.0	26.0	32.0	10°	80	8.00	0.32	55000			
	8	3	1	6	930-C3-S-08-065	32.0	8.0	37	65.0	11.3	35.3	65.0	24.0	28.0	32.0	10°	80	8.00	0.36	55000			
	10	3	1	6	930-C3-S-10-070	32.0	10.0	41	70.0	11.3	39.6	70.0	26.0	30.0	32.0	10°	80	8.00	0.38	55000			
	12	3	1	3	930-C3-S-12-074	32.0	12.0	46	74.0	11.3	74.0		28.0	32.0		10°	80	8.00	0.45	55000			
C4	6	3	1	6	930-C4-S-06-066	40.0	6.0	37	66.0	11.3	30.2	66.0	22.0	26.0	40.0	10°	80	8.00	0.48	39000			
	8	3	1	6	930-C4-S-08-066	40.0	8.0	37	66.0	11.3	30.2	66.0	24.0	28.0	40.0	10°	80	8.00	0.50	39000			
	10	3	1	6	930-C4-S-10-072	40.0	10.0	41	72.0	11.3	34.2	72.0	26.0	30.0	40.0	10°	80	8.00	0.55	39000			
	12	3	1	6	930-C4-S-12-080A	40.0	12.0	46	80.0	11.3	40.0	80.0	28.0	32.0	40.0	15°	80	8.00	0.65	39000			
	20	3	1	3	930-C4-S-20-090A	40.0	20.0	51	90.0	16.0	90.0		38.0	42.0		7°	80	8.00	0.85	39000			
C5	6	3	1	6	930-C5-S-06-068	50.0	6.0	37	68.0	11.3	30.2	68.0	22.0	26.0	50.0	10°	80	8.00	0.75	28000			
	8	3	1	6	930-C5-S-08-070	50.0	8.0	37	70.0	11.3	32.2	70.0	24.0	28.0	50.0	10°	80	8.00	0.77	28000			
	10	3	1	6	930-C5-S-10-072	50.0	10.0	41	72.0	11.3	34.2	72.0	26.0	30.0	50.0	10°	80	8.00	0.80	20000			
	12	3	1	6	930-C5-S-12-075	50.0	12.0	46	75.0	11.3	38.2	75.0	28.0	32.0	50.0	10°	80	8.00	0.85	28000			
	20	3	1	6	930-C5-S-20-085	50.0	20.0	51	85.0	16.0	49.2	85.0	38.0	42.0	50.0	7°	80	8.00	1.04	28000			
	20	3	1	6	930-C5-S-20-125	50.0	20.0	51	125.0	16.0	49.2	125.0	38.0	42.0	50.0	7°	80	8.00	1.63	28000			
C6	25	3	1	3	930-C5-S-25-091	50.0	25.0	57	91.0	12.9	91.0		45.0	50.0		11°	80	8.00	1.28	28000			
	25	3	1	6	930-C6-S-25-098	63.0	25.0	57	98.0	12.9	72.1	98.0	45.0	50.0	63.0	11°	80	8.00	1.70	20000			
C8	25	3	1	6	930-C8-S-25-108	80.0	25.0	57	108.0	12.9	72.0	108.0	45.0	50.0	80.0	11°	80	8.00	2.74	14000			

DSGN

10



						Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX			
C6	6	3	1	10	930-C6-S-06-074	63.0	6.0	37	74.0	11.3	30.2	48.1	22.0	26.0	50.0	10°	80	8.00	1.15	20000			
	8	3	1	10	930-C6-S-08-076	63.0	8.0	37	76.0	11.3	32.2	50.1	24.0	28.0	50.0	10°	80	8.00	1.17	20000			
	10	3	1	10	930-C6-S-10-078	63.0	10.0	41	78.0	11.3	34.2	52.1	26.0	30.0	50.0	10°	80	8.00	1.20	20000			
	12	3	1	10	930-C6-S-12-082	63.0	12.0	46	82.0	11.3	38.2	56.0	28.0	32.0	50.0	10°	80	8.00	1.26	20000			
	20	3	1	10	930-C6-S-20-091	63.0	20.0	51	91.0	16.0	49.2	65.1	38.0	42.0	50.0	7°	80	8.00	1.45	20000			
C8	20	3	1	10	930-C6-S-20-150	63.0	20.0	51	150.0	16.0	49.2	66.8	38.0	42.0	50.0	7°	80	8.00	2.55	20000			
	12	3	1	10	930-C8-S-12-094	80.0	12.0	46	94.0	11.3	38.2	59.0	28.0	32.0	50.0	10°	80	8.00	2.36	14000			
	20	3	1	10	930-C8-S-20-103	80.0	20.0	51	103.0	16.0	49.2	68.0	38.0	42.0	50.0	7°	80	8.00	2.54	14000			
	20	3	1	10	930-C8-S-20-175	80.0	20.0	51	175.0	16.0	49.2	70.0	38.0	42.0	50.0	7°	80	8.00	4.39	14000			

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N6



N15



N4



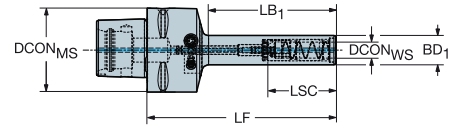
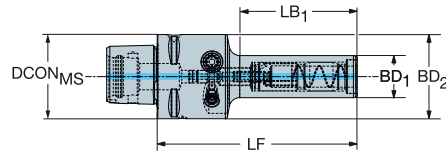
# Coromant Capto® to CoroChuck™ 930

Pencil design

DSGN

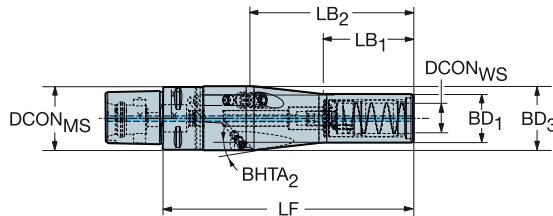
2

5



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BAR	NM	KG	RPMX
C4	6	3	1	2	930-C4-P-06-085	40.0	6.0	37	85.0	45.8	85.0		14.5	40.0		80	8.00	0.42	39000
	8	3	1	2	930-C4-P-08-085	40.0	8.0	37	85.0	45.8	85.0		17.5	40.0		80	8.00	0.45	39000
	10	3	1	2	930-C4-P-10-095	40.0	10.0	41	95.0	55.8	95.0		20.0	40.0		80	8.00	0.50	39000
	10	3	1	2	930-C4-P-10-135	40.0	10.0	41	135.0	95.8	135.0		20.0	40.0		80	8.00	0.59	39000
	12	3	1	2	930-C4-P-12-100	40.0	12.0	46	100.0	60.8	100.0		22.0	40.0		80	8.00	0.56	39000
12	3	1	2	930-C4-P-12-135	40.0	12.0	46	135.0	95.8	135.0		22.0	40.0		80	8.00	0.66	39000	
C5	6	3	1	5	930-C5-P-06-088	50.0	6.0	37	88.0	47.9	88.0		14.5	40.0	50.0	80	8.00	0.67	28000
	8	3	1	5	930-C5-P-08-088	50.0	8.0	37	88.0	45.8	88.0		17.5	40.0	50.0	80	8.00	0.65	28000
	10	3	1	5	930-C5-P-10-098	50.0	10.0	41	98.0	55.8	98.0		20.0	40.0	50.0	80	8.00	0.70	28000
	10	3	1	5	930-C5-P-10-138	50.0	10.0	41	138.0	95.8	114.9	138.0	20.0	40.0	50.0	80	8.00	0.80	28000
	12	3	1	5	930-C5-P-12-103	50.0	12.0	46	103.0	60.8	80.0	103.0	22.0	40.0	50.0	80	8.00	0.78	28000
12	3	1	5	930-C5-P-12-138	50.0	12.0	46	138.0	95.8	115.0	138.0	22.0	40.0	50.0	80	8.00	0.88	28000	
C6	6	3	1	5	930-C6-P-06-091	63.0	6.0	37	91.0	47.9	64.9	91.0	14.5	40.0	63.0	80	8.00	1.03	20000
	8	3	1	5	930-C6-P-08-091	63.0	8.0	37	91.0	45.8	64.9	91.0	17.5	40.0	63.0	80	8.00	1.00	20000
	10	3	1	5	930-C6-P-10-102	63.0	10.0	41	102.0	55.8	75.0	102.0	20.0	40.0	63.0	80	8.00	1.07	20000
	10	3	1	5	930-C6-P-10-142	63.0	10.0	41	142.0	95.8	115.0	142.0	20.0	40.0	63.0	80	8.00	1.16	20000
	12	3	1	5	930-C6-P-12-107	63.0	12.0	46	107.0	60.8	80.0	107.0	22.0	40.0	63.0	80	8.00	1.14	20000
12	3	1	5	930-C6-P-12-142	63.0	12.0	46	142.0	95.8	115.0	142.0	22.0	40.0	63.0	80	8.00	1.25	20000	
C8	12	3	1	5	930-C8-P-12-120	80.0	12.0	46	120.0	60.8	83.0	120.0	22.0	40.0	80.0	80	8.00	2.23	14000
	12	3	1	5	930-C8-P-12-155	80.0	12.0	46	155.0	95.8	118.0	155.0	22.0	40.0	80.0	80	8.00	2.38	14000



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
C4	20	3	1	930-C4-P-20-160	40.0	20.0	51	160.0	60.0	108.0	32.0	42.0	5°	80	8.00	1.22	39000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N6



N15



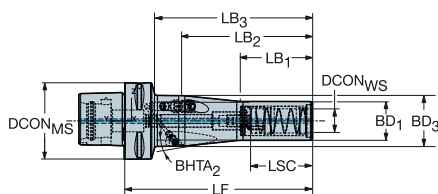
N4

## Coromant Capto® to CoroChuck™ 930

Pencil design

DSGN

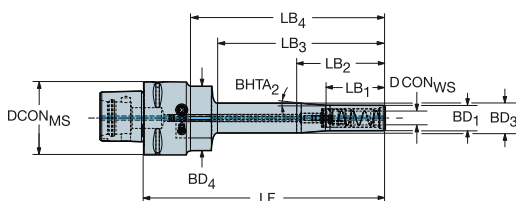
11



					Dimensions, mm														
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
C4	12	3	1	11	930-C4-P-12-185	40.0	12.0	46	185.0	50.0	75.0	145.8	22.0	26.0	4°	80	8.00	0.94	39000
C5	20	3	1	11	930-C5-P-20-151	50.0	20.0	51	151.0	60.0	108.0	128.0	32.0	42.0	6°	80	8.00	1.32	28000
					930-C5-P-20-231	50.0	20.0	51	231.0	60.0	188.0	208.0	32.0	42.0	2°	80	8.00	2.00	28000
C6	20	3	1	11	930-C6-P-20-155	63.0	20.0	51	155.0	60.0	108.0	128.1	32.0	42.0	6°	80	8.00	1.68	20000
					930-C6-P-20-235	63.0	20.0	51	235.0	60.0	188.0	208.1	32.0	42.0	2°	80	8.00	2.38	20000
C8	20	3	1	11	930-C8-P-20-165	80.0	20.0	51	165.0	60.0	108.0	128.1	32.0	42.0	6°	80	8.00	2.80	14000
					930-C8-P-20-245	80.0	20.0	51	245.0	60.0	188.0	208.1	32.0	42.0	2°	80	8.00	3.44	14000

DSGN

17



					Dimensions, mm																
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
C5	12	3	1	17	930-C5-P-12-188	50.0	12.0	46	188.0	50.0	75.0	145.8	167.0	22.0	26.0	40.0	4°	80	8.00	1.18	28000
C6	12	3	1	17	930-C6-P-12-192	63.0	12.0	46	192.0	50.0	75.0	145.8	167.0	22.0	26.0	40.0	4°	80	8.00	1.57	20000
C8	12	3	1	17	930-C8-P-12-205	80.0	12.0	46	205.0	50.0	75.0	145.8	170.0	22.0	26.0	40.0	4°	80	8.00	2.63	14000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23



N6



N15



N4

# Coromant Capto® to CoroChuck™ 930

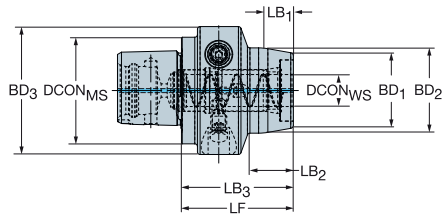
For driven tool holders

Segment clamping and manual tool change only

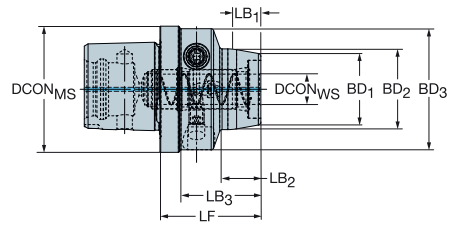


DSGN

6



10



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>1</sub>	BAR	KG	RPMX
C3	12	3	1	6	930-C3-T-12-046	32.0	12.0	46	46.0	11.3	22.8	46.0		28.0	32.0	48.0		10°	80	0.39	10000
C4	12	3	1	6	930-C4-T-12-042	40.0	12.0	46	42.0	11.3	17.0	42.0		28.0	32.0	48.0		10°	80	0.46	10000
	20	3	1	6	930-C4-T-20-058	40.0	20.0	51	58.0	16.0	34.3	58.0		38.1	42.0	57.0		7°	80	0.70	10000
C5	12	3	1	10	930-C5-T-12-040	50.0	12.0	46	40.0	11.3	16.1	32.0	40.0	28.0	32.0	48.0	50.0	10°	80	0.56	10000
	20	3	1	6	930-C5-T-20-046	50.0	20.0	51	46.0	11.3	22.1	46.0		38.1	42.0	57.0		10°	80	0.68	10000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N6

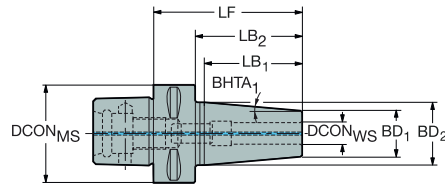


N15



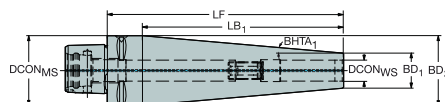
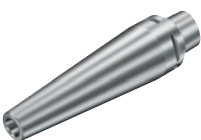
N4

## Coromant Capto® to shrink fit chuck



## Short design

				Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BHTA <sub>1</sub>	BAR	KG	RPMX		
C4	6	3	1	C4-391.19-06 075	40.0	6.0	75.0	44.1	55.0	20.0	27.0	4°	80	0.43	39000		
	8	3	1	C4-391.19-08 075	40.0	8.0	75.0	44.1	55.0	20.0	27.0	4°	80	0.45	39000		
	10	3	1	C4-391.19-10 075	40.0	10.0	75.0	50.5	55.0	24.0	32.0	4°	80	0.52	39000		
	12	3	1	C4-391.19-12 075	40.0	12.0	75.0	50.5	55.0	24.0	32.0	4°	80	0.50	39000		
	14	3	1	C4-391.19-14 080	40.0	14.0	80.0	44.1	60.0	27.0	34.0	4°	80	0.58	39000		
	16	3	1	C4-391.19-16 080	40.0	16.0	80.0	44.1	60.0	27.0	34.0	4°	80	0.56	39000		
C5	6	3	1	C5-391.19-06 075	50.0	6.0	75.0	44.1	55.0	20.0	27.0	4°	80	0.64	28000		
	8	3	1	C5-391.19-08 075	50.0	8.0	75.0	43.9	55.0	20.0	27.0	4°	80	0.63	28000		
	10	3	1	C5-391.19-10 075	50.0	10.0	75.0	50.2	55.0	24.0	32.0	4°	80	0.70	28000		
	12	3	1	C5-391.19-12 075	50.0	12.0	75.0	50.2	55.0	24.0	32.0	4°	80	0.68	28000		
	14	3	1	C5-391.19-14 080	50.0	14.0	80.0	44.1	60.0	27.0	34.0	4°	80	0.76	28000		
	16	3	1	C5-391.19-16 080	50.0	16.0	80.0	44.1	60.0	27.0	34.0	4°	80	0.73	28000		
	18	3	1	C5-391.19-18 080	50.0	18.0	80.0	56.9	60.0	33.0	42.0	4°	80	0.90	28000		
	20	3	1	C5-391.19-20 085	50.0	20.0	85.0	56.9	65.0	33.0	42.0	4°	80	0.90	28000		
C6	6	3	1	C6-391.19-06 080	63.0	6.0	80.0	44.1	58.0	20.0	27.0	4°	80	0.99	20000		
	8	3	1	C6-391.19-08 080	63.0	8.0	80.0	44.1	58.0	20.0	27.0	4°	80	0.99	20000		
	10	3	1	C6-391.19-10 080	63.0	10.0	80.0	50.5	58.0	24.0	32.0	4°	80	1.05	20000		
	12	3	1	C6-391.19-12 080	63.0	12.0	80.0	50.5	58.0	24.0	32.0	4°	80	1.05	20000		
	14	3	1	C6-391.19-14 085	63.0	14.0	85.0	44.1	63.0	27.0	34.0	4°	80	1.11	20000		
	16	3	1	C6-391.19-16 085	63.0	16.0	85.0	44.1	63.0	27.0	34.0	4°	80	1.10	20000		
	18	3	1	C6-391.19-18 085	63.0	18.0	85.0	56.9	63.0	33.0	42.0	4°	80	1.27	20000		
	20	3	1	C6-391.19-20 085	63.0	20.0	85.0	56.9	63.0	33.0	42.0	4°	80	1.24	20000		
	25	3	1	C6-391.19-25 090	63.0	25.0	90.0	56.9	68.0	44.0	53.0	4°	80	1.60	20000		
	32	3	1	C6-391.19-32 095	63.0	32.0	95.0	56.9	73.0	44.0	53.0	4°	80	1.51	20000		
C8	10	3	1	C8-391.19-10 090	80.0	10.0	90.0	50.2	60.0	24.0	32.0	4°	80	2.07	14000		
	12	3	1	C8-391.19-12 090	80.0	12.0	90.0	50.2	60.0	24.0	32.0	4°	80	2.06	14000		
	16	3	1	C8-391.19-16 095	80.0	16.0	95.0	43.8	65.0	27.0	34.0	4°	80	2.09	14000		
	20	3	1	C8-391.19-20 095	80.0	20.0	95.0	56.5	65.0	33.0	42.0	4°	80	2.21	14000		
	25	3	1	C8-391.19-25 100	80.0	25.0	100.0	56.5	70.0	44.0	53.0	4°	80	2.58	14000		
C10	12	3	1	C10-391.19-12 095	100.0	12.0	95.0	50.5	59.0	24.0	32.0	4°	80	3.65	10000		
	16	3	1	C10-391.19-16 100	100.0	16.0	100.0	44.1	64.0	27.0	34.0	4°	80	3.72	10000		
	20	3	1	C10-391.19-20 100	100.0	20.0	100.0	56.9	64.0	33.0	42.0	4°	80	3.83	10000		
	25	3	1	C10-391.19-25 110	100.0	25.0	110.0	56.9	74.0	44.0	53.0	4°	80	4.31	10000		



## Long conical design

				Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BHTA <sub>1</sub>	BAR	KG	RPMX			
C3	6	3	1	C3-391.19-06 118	32.0	6.0	118.0	103.0	14.0	32.0	5°	80	0.45	55000			
	8	3	1	C3-391.19-08 107	32.0	8.0	107.0	92.0	16.0	32.0	5°	80	0.44	55000			
	10	3	1	C3-391.19-10 095	32.0	10.0	95.0	80.0	18.0	32.0	5°	80	0.40	55000			
	12	3	1	C3-391.19-12 084	32.0	12.0	84.0	69.0	20.0	32.0	5°	80	0.38	55000			
C4	12	3	1	C4-391.19-12 135	40.0	12.0	135.0	115.0	20.0	40.0	5°	80	0.84	39000			
	16	3	1	C4-391.19-16 112	40.0	16.0	112.0	92.0	24.0	40.0	5°	80	0.77	39000			
	18	3	1	C4-391.19-18 080	40.0	18.0	80.0	56.9	33.0	42.0	4°	80	0.69	39000			
	20	3	1	C4-391.19-20 085	40.0	20.0	85.0	56.9	33.0	42.0	4°	80	0.71	39000			
C5	20	3	1	C5-391.19-20 146	50.0	20.0	146.0	126.0	28.0	50.0	5°	80	1.45	28000			
	25	3	1	C5-391.19-25 090	50.0	25.0	90.0	56.9	44.0	53.0	4°	80	1.26	28000			
	25	3	1	C5-391.19-25 118	50.0	25.0	118.0	98.0	33.0	50.0	5°	80	1.25	28000			

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23

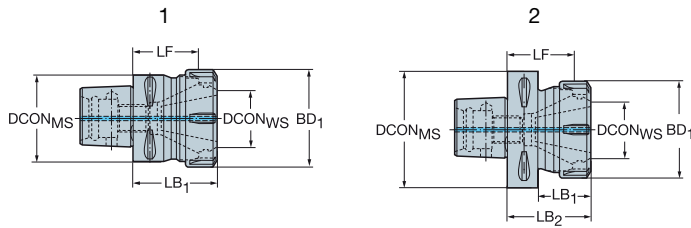


N15

# Coromant Capto® to ER collet chuck

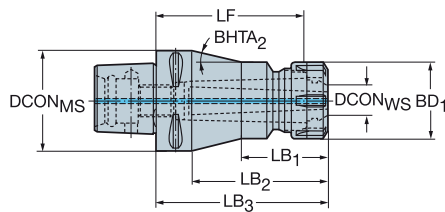
Workpiece side interface DIN 6499-B

DSGN



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	KG	RPMX
C3	ER16	3	1	2	C3-391.14-16 045	32.0	17.0	34.4	29.0	45.0	28.0	32.0	80	0.20	55000
	ER20	3	1	1	C3-391.14-20 045	32.0	21.0	33.5	45.0		33.7		80	0.22	55000
C4	ER20	3	1	2	C4-391.14-20 052	40.0	21.0	40.5	30.8	52.0	33.7	40.0	80	0.37	39000
	ER25	3	1	1	C4-391.14-25 052	40.0	26.0	40.0	52.0		42.0		80	0.42	39000
	ER32	3	1	1	C4-391.14-32 054	40.0	33.0	41.0	54.0		50.0		80	0.46	39000
C5	ER20	3	1	2	C5-391.14-20 055	50.0	21.0	43.5	31.1	55.0	33.7	50.0	80	0.62	28000
	ER25	3	1	2	C5-391.14-25 055	50.0	26.0	43.0	33.0	55.0	42.0	50.0	80	0.63	28000
	ER32	3	1	1	C5-391.14-32 057	50.0	33.0	44.0	57.0		50.0		80	0.68	28000
	ER32	3	1	1	C5-391.14-32 100	50.0	33.0	87.0	100.0		50.0		80	1.28	28000
	ER40	3	1	1	C5-391.14-40 060	50.0	41.0	45.0	60.0		63.0		80	0.81	28000
C6	ER25	3	1	2	C6-391.14-25 060	63.0	26.0	48.0	32.9	60.0	42.0	63.0	80	1.04	20000
	ER25	3	1	2	C6-391.14-25 100	63.0	26.0	88.0	75.0	100.0	42.0	63.0	80	1.44	20000
	ER32	3	1	2	C6-391.14-32 060	63.0	33.0	47.0	35.3	60.0	50.0	63.0	80	1.06	20000
	ER32	3	1	2	C6-391.14-32 100	63.0	33.0	87.0	75.0	100.0	50.0	63.0	80	1.60	20000
	ER40	3	1	1	C6-391.14-40 065	63.0	41.0	50.0	65.0		63.0		80	1.22	20000
	ER40	3	1	1	C6-391.14-40 130	63.0	41.0	115.0	130.0		63.0		80	2.77	20000
C8	ER20	3	1	2	C8-391.14-20 065	80.0	21.0	53.5	29.9	65.0	35.0	80.0	80	2.02	14000
	ER25	3	1	2	C8-391.14-25 070	80.0	26.0	58.0	32.4	70.0	42.0	80.0	80	2.10	14000
	ER32	3	1	2	C8-391.14-32 070	80.0	33.0	57.0	35.0	70.0	50.0	80.0	80	2.13	14000
	ER40	3	1	2	C8-391.14-40 070	80.0	41.0	55.0	38.0	70.0	63.0	80.0	80	2.19	14000
ER50	3	1	2	C8-391.14-50 080	80.0	52.0	59.0	50.0	80.0	78.0	80.0	80	2.46	14000	



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BHTA <sub>2</sub>	BAR	KG	RPMX
C4	ER16	3	1	C4-391.14-16 070	40.0	17.0	59.4	44.0	50.0	70.0	28.0	45°	80	0.42	39000
C5	ER16	3	1	C5-391.14-16 100	50.0	17.0	89.4	60.0	80.0	100.0	28.0	29°	80	0.90	28000
	ER20	3	1	C5-391.14-20 100	50.0	21.0	88.5	55.0	80.0	100.0	35.0	16°	80	1.00	28000
	ER20	3	1	C5-391.14-20 130	50.0	21.0	118.5	55.0	109.9	130.0	35.0	7°	80	1.31	28000
ER25	3	1	C5-391.14-25 100	50.0	26.0	88.0	65.0	80.0	100.0	42.0	14°	80	1.13	28000	
C6	ER16	3	1	C6-391.14-16 100	63.0	17.0	89.4	60.0	78.0	100.0	28.0	44°	80	1.26	20000
	ER20	3	1	C6-391.14-20 060	63.0	21.0	48.5	31.1	38.0	60.0	33.7	65°	80	1.00	20000
	ER25	3	1	C6-391.14-25 130	63.0	26.0	118.0	65.0	108.0	130.0	42.0	13°	80	1.90	20000
	ER25	3	1	C6-391.14-25 160	63.0	26.0	148.0	65.0	138.0	160.0	42.0	8°	80	2.50	20000
	ER32	3	1	C6-391.14-32 130	63.0	33.0	117.0	75.0	108.0	130.0	50.0	11°	80	2.22	20000
	ER32	3	1	C8-391.14-32 160	80.0	33.0	147.0	75.0	130.0	160.0	50.0	15°	80	0.30	14000
C8	ER40	3	1	C8-391.14-40 160	80.0	41.0	145.0	95.0	130.0	160.0	63.0	13°	80	4.58	14000
	ER32	3	1	C10-391.14-32 160	100.0	33.0	147.0	75.0	124.0	160.0	50.0	27°	80	5.98	10000
C10	ER40	3	1	C10-391.14-40 160	100.0	41.0	145.0	95.0	124.0	160.0	63.0	32°	80	6.32	10000
	ER50	3	1	C10-391.14-50 160	100.0	52.0	139.0	100.0	124.0	160.0	80.0	22°	80	7.21	10000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



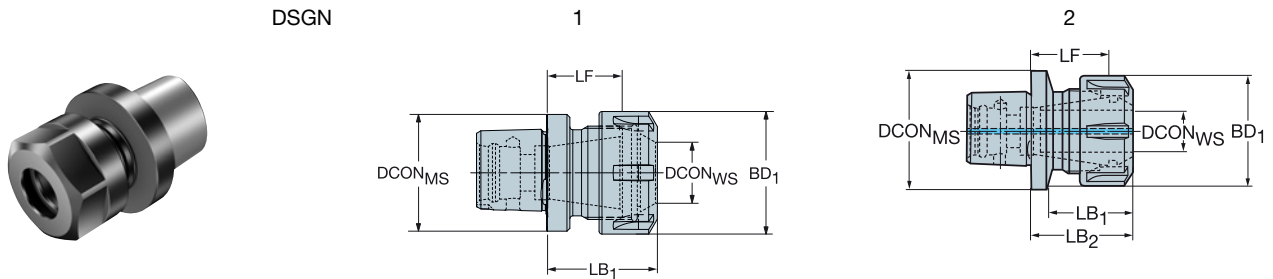
N15



# Coromant Capto® to ER collet chuck

Workpiece side interface DIN 6499-B

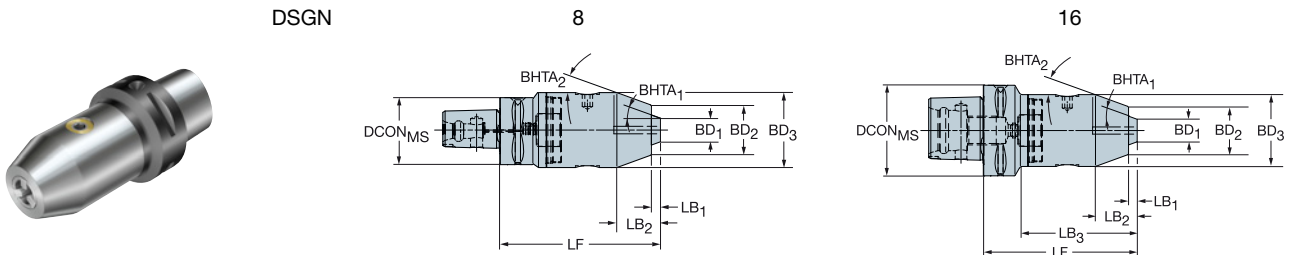
Short design, for segment clamping only



					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	KG	RPMX		
C3	ER16	3	1	2	C3-391.14-16 035	32.0	17.0	24.0	26.6	34.6	28.0	32.0	80	0.10	55000		
	ER20	3	1	1	C3-391.14-20 036	32.0	21.0	24.5	36.0		33.7		80	0.17	55000		
C4	ER16	3	1	2	C4-391.14-16 035	40.0	17.0	24.0	26.6	34.6	28.0	40.0	80	0.20	39000		
	ER20	3	1	2	C4-391.14-20 035	40.0	21.0	23.5	27.0	35.0	33.7	40.0	80	0.25	39000		
	ER25	3	1	1	C4-391.14-25 038	40.0	26.0	26.0	38.0		42.0		80	0.30	39000		
C5	ER20	3	1	2	C5-391.14-20 036	50.0	21.0	24.0	27.5	35.5	35.0	50.0	80	0.30	28000		
	ER25	3	1	2	C5-391.14-25 037	50.0	26.0	25.0	29.0	37.0	42.0	50.0	80	0.30	28000		
	ER32	3	1	1	C5-391.14-32 045	50.0	33.0	32.0	45.0		50.0		80	0.52	28000		

# Coromant Capto® to drill chuck

Internal and external coolant supply



					Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>1</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX	
C3	8-1	3	1	8	C3-391.32-08 076	32.0	76.0	3.0	19.1	76.0		9.9	24.1	36.0		19°	20°	50	10.00	0.54	8000	
	1-13	3	1	8	C3-391.32-13 102	32.0	96.0	6.0	22.2	102.0		15.7	38.1	50.0		19°	20°	50	20.00	1.14	8000	
C4	8-1	3	1	16	C4-391.32-08 077	40.0	77.0	3.0	19.1	55.8	77.0	9.9	24.1	36.0	40.0		19°	20°	50	10.00	0.64	8000
	1-13	3	1	8	C4-391.32-13 104	40.0	98.0	6.0	22.2	104.0		15.7	38.1	50.0		19°	20°	50	20.00	1.24	8000	
C5	8-1	3	1	16	C5-391.32-08 079	50.0	76.0	3.0	19.1	53.6	79.0	9.9	24.1	36.0	50.0		19°	20°	50	10.00	0.85	8000
	1-13	3	1	8	C5-391.32-13 103	50.0	97.0	6.0	22.2	103.0		15.7	38.1	50.0		19°	20°	50	20.00	1.41	8000	
C6	1-13	3	1	16	C6-391.32-13 107	63.0	101.0	6.0	22.2	79.8	107.0	15.7	38.1	50.0	63.0		19°	20°	50	20.00	1.79	8000
	16-1	3	1	16	C6-391.32-16 112	63.0	106.0	6.0	22.2	88.4	112.0	15.7	45.1	57.0	63.0		19°	20°	50	20.00	2.02	8000
C8	1-13	3	1	16	C8-391.32-13 112	80.0	106.0	6.0	22.2	77.1	112.0	15.7	38.1	50.0	80.0		19°	20°	50	20.00	2.78	8000
	16-1	3	1	16	C8-391.32-16 117	80.0	111.0	6.0	31.2	84.2	117.0	15.7	38.1	57.0	80.0		19°	20°	50	20.00	3.02	8000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

N23

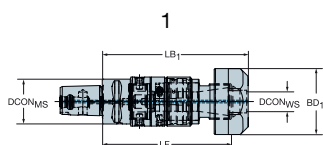


N15

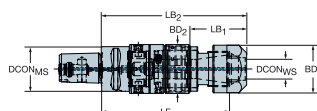
# Coromant Capto® to CoroChuck™ 970

Workpiece side interface DIN 6499-B

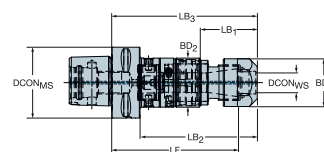
DSGN



2



5



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	(BAR)	(KG)	RPMX
C3	ER11	M5	3	1	5	970-C3-11-078	32.0	11.3	74.2	24.1	63.0	78.0	18.7	23.5	32.0	80	0.27	8000
	ER20	M12	3	1	2	970-C3-20-102	32.0	20.8	89.2	35.3	97.2		33.7	35.0		80	0.60	8000
C4	ER11	M5	3	1	5	970-C4-11-080	40.0	11.3	76.2	24.1	60.0	80.0	18.7	23.5	40.0	80	0.40	8000
	ER20	M12	3	1	5	970-C4-20-102	40.0	20.8	89.2	35.3	76.9	97.2	33.7	35.0	40.0	80	0.68	8000
	ER25	M20	3	1	2	970-C4-25-122	40.0	25.8	108.1	37.1	116.6		42.0	44.0		80	1.04	8000
C5	ER20	M12	3	1	5	970-C5-20-103	50.0	20.8	89.7	35.3	77.6	97.7	33.7	35.0	50.0	80	0.88	8000
	ER25	M20	3	1	5	970-C5-25-122	50.0	25.8	108.6	37.1	97.1	117.1	42.0	44.0	50.0	80	1.24	8000
	ER40	M30	3	1	1	970-C5-40-154	50.0	40.8	137.2	148.6			63.0			80	2.66	8000
C6	ER20	M12	3	1	5	970-C6-20-105	63.0	20.8	91.7	35.3	77.6	99.7	33.7	35.0	63.0	80	1.21	8000
	ER25	M20	3	1	5	970-C6-25-124	63.0	25.8	110.6	37.1	97.1	119.1	42.0	44.0	63.0	80	1.57	8000
	ER32	M27	3	1	2	970-C6-32-128	63.0	32.8	118.3	105.8	127.8		50.0	63.0		80	1.53	8000
	ER40	M30	3	1	1	970-C6-40-154	63.0	40.8	136.7	148.1			63.0			80	2.95	8000
	ER50	M48	3	1	5	970-C6-50-210	63.0	52.0	187.5	76.5	134.5	208.0	77.7	80.0	86.0	80	4.90	8000
C8	ER20	M12	3	1	5	970-C8-20-112	80.0	20.8	98.7	35.3	76.6	106.7	33.7	35.0	80.0	80	2.22	8000
	ER25	M20	3	1	5	970-C8-25-131	80.0	25.8	117.6	37.1	96.1	126.1	42.0	44.0	80.0	80	2.58	8000
	ER32	M27	3	1	2	970-C8-32-135	80.0	32.8	125.3	104.8	134.8		50.0	80.0		80	2.50	8000
	ER40	M30	3	1	2	970-C8-40-161	80.0	40.8	143.7	125.1	155.1		63.0	80.0		80	4.00	8000
	ER50	M48	3	1	5	970-C8-50-215	80.0	52.0	192.0	76.5	134.5	212.5	77.7	80.0	86.0	80	6.87	8000
C10	ER25	M20	3	1	5	970-C10-25-143	100.0	25.8	129.6	37.1	102.1	138.1	42.0	44.0	100.0	80	4.29	8000
	ER40	M30	3	1	2	970-C10-40-173	100.0	40.8	155.7	131.1	167.1		63.0	100.0		80	5.76	8000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23

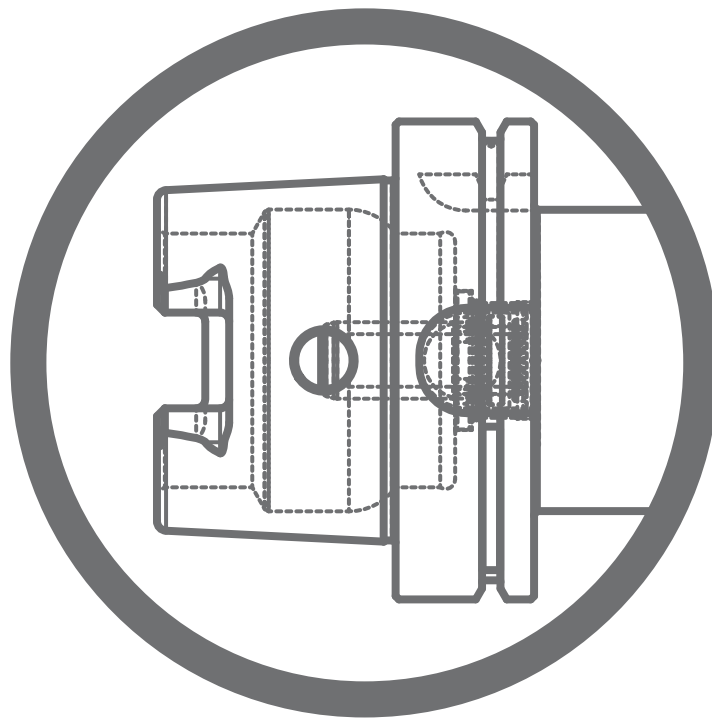


N15



N5

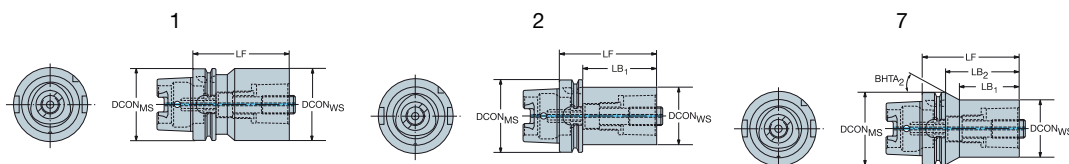
# Machine side interface HSK



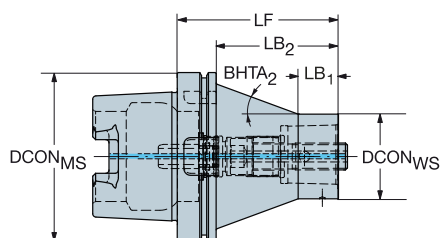
# HSK to Coromant Capto® adaptor

Machine side interface HSK A/C

DSGN



					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BAR	NM	KG	
50	C3	1	1	2	C3-390.410-50 075A	50.0	32.0	75.0	49.0	75.0		50.0		0°	100	45.00	0.67	
	C4	1	1	2	C4-390.410-50 080A	50.0	40.0	80.0	54.0	80.0		50.0		0°	100	55.00	0.85	
63	C3	1	1	2	C3-390.410-63 075C	63.0	32.0	75.0	49.0	75.0		63.0		0°	100	45.00	0.97	
	C4	1	1	2	C4-390.410-63 080C	63.0	40.0	80.0	54.0	80.0		63.0		0°	100	55.00	1.14	
	C5	1	1	2	C5-390.410-63 090C	63.0	50.0	90.0	64.0	90.0		63.0		0°	100	95.00	1.47	
80	C4	1	1	2	C4-390.410-80 090	80.0	40.0	90.0	64.0	90.0		80.0		0°	100	55.00	1.69	
	C5	1	1	2	C5-390.410-80 095	80.0	50.0	95.0	69.0	95.0		80.0		0°	100	95.00	2.02	
	C6	1	1	2	C6-390.410-80 110	80.0	63.0	110.0	84.0	110.0		80.0		0°	100	170.00	2.79	
100	C3	1	1	7	C3-390.410-100 080A	100.0	32.0	80.0	43.0	51.0	80.0	32.0	100.0	45°	100	45.00	2.42	
	C4	1	1	2	C4-390.410-100 090A	100.0	40.0	90.0	61.0	90.0		100.0		0°	100	55.00	2.63	
	C5	1	1	2	C5-390.410-100 100A	100.0	50.0	100.0	71.0	100.0		100.0		0°	100	95.00	3.02	
	C6	1	1	2	C6-390.410-100 110A	100.0	63.0	110.0	81.0	110.0		100.0		0°	100	170.00	3.70	
	C8	1	1	2	C8-390.410-100 120A	100.0	80.0	120.0	91.0	120.0		100.0		0°	100	170.00	4.87	
	C10	1	1	1	C10-390.410-100 155	100.0	100.0	155.0	155.0						100	380.00	7.64	
125	C4	1	1	7	C4-390.410-125 095	125.0	40.0	95.0	46.0	66.0	95.0	40.0	125.0	45°	100	55.00	4.15	
	C5	1	1	7	C5-390.410-125 105	125.0	50.0	105.0	66.0	76.0	105.0	50.0	125.0	45°	100	95.00	4.46	
	C6	1	1	2	C6-390.410-125 120	125.0	63.0	120.0	91.0	120.0		125.0		0°	100	170.00	5.35	
	C8	1	1	2	C8-390.410-125 130	125.0	80.0	130.0	101.0	130.0		125.0		0°	100	170.00	6.70	
	C10	1	1	2	C10-390.410-125 160	125.0	100.0	160.0	131.0	160.0		125.0		0°	100	380.00	9.66	
160	C6	1	1	2	C6-390.410-160 125	160.0	63.0	125.0	94.0	125.0		160.0		0°	100	170.00	8.55	
	C8	1	1	2	C8-390.410-160 135	160.0	80.0	135.0	104.0	135.0		160.0		0°	100	170.00	10.16	
	C10	1	1	2	C10-390.410-160 160	160.0	100.0	160.0	129.0	160.0		160.0		0°	100	380.00	12.94	



## Heavy Duty design

					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>	BAR	NM	KG					
100	C3	1	1	C3-390.410-100080HD	100.0	32.0	80.0	20.0	51.0	41°	100	45.00	2.93					
	C4	1	1	C4-390.410-100090HD	100.0	40.0	90.0	20.0	61.0	29°	100	55.00	3.27					
	C5	1	1	C5-390.410-100100HD	100.0	50.0	100.0	30.0	71.0	23°	100	95.00	3.58					
	C6	1	1	C6-390.410-100110HD	100.0	63.0	110.0	30.0	81.0	12°	100	170.00	4.22					
125	C4	1	1	C4-390.410-125095HD	125.0	40.0	95.0	20.0	66.0	36°	100	55.00	5.25					
	C5	1	1	C5-390.410-125105HD	125.0	50.0	105.0	20.0	76.0	27°	100	95.00	5.82					
	C6	1	1	C6-390.410-125120HD	125.0	63.0	120.0	30.0	91.0	20°	100	170.00	6.57					
	C8	1	1	C8-390.410-125130HD	125.0	80.0	130.0	30.0	101.0	11°	100	170.00	7.76					

A special coolant tube is delivered together with the HSK basic holders.

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



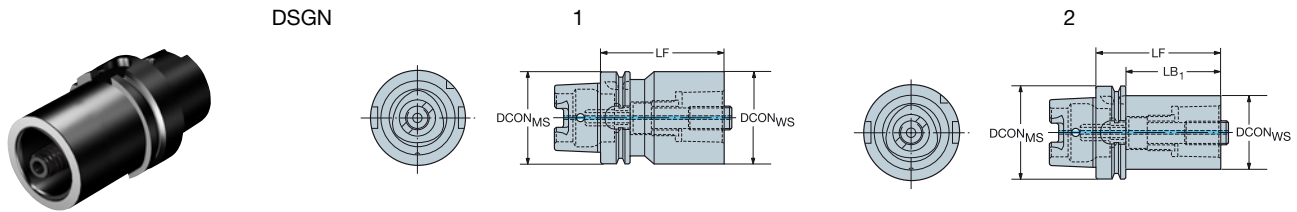
N23



N15

# HSK to Coromant Capto® adaptor

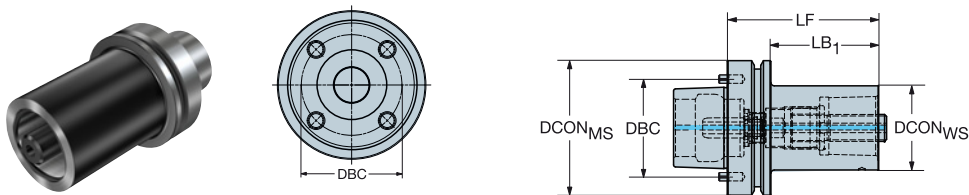
Machine side interface HSK A/C/T



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>2</sub>	BAR	NM	KG
40	C3	1	1	2	C3-390.419-40 065	40.0	32.0	65.0	45.0	65.0	40.0	100	45.00	0.46
	C4	1	1	1	C4-390.419-40 075	40.0	40.0	75.0	75.0			100	55.00	0.60
63	C5	1	1	2	C5-390.419-63 090	63.0	50.0	90.0	64.0	90.0	63.0	100	95.00	1.46
	C6	1	1	1	C6-390.419-63 110	63.0	63.0	110.0	110.0			100	170.00	2.14
100	C6	1	1	2	C6-390.419-100 110	100.0	63.0	110.0	81.0	110.0	100.0	100	170.00	3.72
	C8	1	1	2	C8-390.419-100 120	100.0	80.0	120.0	91.0	120.0	100.0	100	170.00	4.88

## Machine side interface HSK F with pins

For Makino MAG machine family



					Dimensions, mm								
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BAR	NM	KG	
80	C5	1	1	C5-390.612-80 090	80.0	58.0	50.0	90.0	64.0	100	95.00	1.92	

A special coolant tube is delivered together with the HSK basic holders.

HSK80F - Compatible with the Makino MAG machine family 1, 3, 4, 7 - for aerospace frame aluminium machining

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



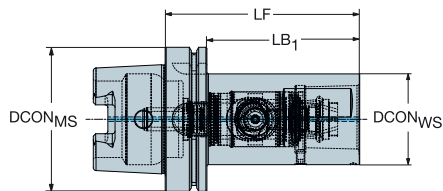
N23



N15

# HSK to Coromant Capto® adaptor with Quick change

Machine side interface HSK A/C



				Dimensions, mm								
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BAR	NM	KG	RPMX
63	C5	1	1	HA06-QC-C5-115	63.0	50.0	115.0	88.0	100	70.00	1.77	20500
100	C6	1	1	HA10-QC-C6-135	100.0	63.0	135.0	105.0	100	90.00	4.17	12500
	C8	1	1	HA10-QC-C8-165	100.0	80.0	165.0	135.0	100	130.00	6.32	12500

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



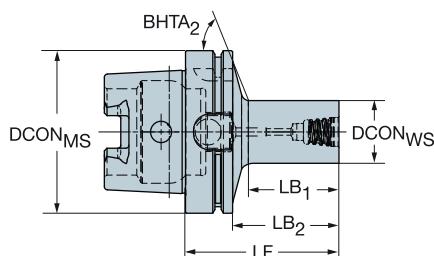
N6



N15

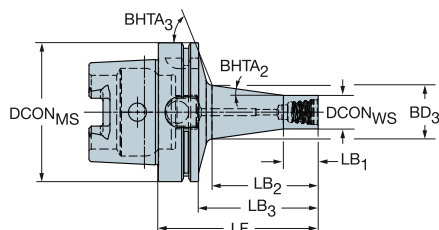
# HSK to Coromant EH adaptor

Machine side interface HSK A/C



## Short design

					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
40	E10	1	1	392.410EH-40 10 040	40.0	9.6	40.0	13.0	20.0	59°	100	12.00	0.28	30000
	E12	1	1	392.410EH-40 12 043	40.0	11.6	43.0	16.3	23.0	58°	100	15.00	0.30	30000
	E16	1	1	392.410EH-40 16 048	40.0	15.4	48.0	21.9	28.0	55°	100	30.00	0.35	30000
	E20	1	1	392.410EH-40 20 045	40.0	19.2	45.0	19.4	25.0	50°	100	50.00	0.37	30000
50	E10	1	1	392.410EH-50 10 047	50.0	9.6	47.0	13.0	21.0	63°	100	12.00	0.49	25000
	E12	1	1	392.410EH-50 12 050	50.0	11.6	50.0	16.3	24.0	62°	100	15.00	0.51	25000
	E16	1	1	392.410EH-50 16 055	50.0	15.4	55.0	21.8	29.0	60°	100	30.00	0.57	25000
	E20	1	1	392.410EH-50 20 052	50.0	19.2	52.0	19.3	26.0	58°	100	50.00	0.58	25000
	E25	1	1	392.410EH-50 25 057	50.0	24.1	57.0	24.9	31.0	54°	100	65.00	0.63	25000
63	E10	1	1	392.410EH-63 10 049	63.0	9.6	49.0	13.5	23.0	66°	100	12.00	0.78	20500
	E12	1	1	392.410EH-63 12 051	63.0	11.6	51.0	15.8	25.0	65°	100	15.00	0.81	20500
	E16	1	1	392.410EH-63 16 056	63.0	15.4	56.0	21.3	30.0	65°	100	30.00	0.85	20500
	E20	1	1	392.410EH-63 20 053	63.0	19.2	53.0	18.8	27.0	63°	100	50.00	0.87	20500
	E25	1	1	392.410EH-63 25 059	63.0	24.1	59.0	25.5	33.0	61°	100	65.00	0.93	20500



## Long design

					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BHTA <sub>3</sub>	BAR	NM	KG	RPMX
63	E10	1	1	392.410EH-63 10 062	63.0	9.6	62.0	10.0	27.9	36.0	14.6	8°	66°	100	12.00	0.80	20500
	E12	1	1	392.410EH-63 12 068	63.0	11.6	68.0	12.0	34.3	42.0	17.9	8°	65°	100	15.00	0.83	20500
	E16	1	1	392.410EH-63 16 078	63.0	15.4	78.0	16.0	45.1	52.0	23.6	8°	64°	100	30.00	0.92	20500
	E20	1	1	392.410EH-63 20 091	63.0	19.2	91.0	20.0	59.0	65.0	30.1	8°	61°	100	50.00	1.01	20500
100	E25	1	1	392.410EH-63 25 105	63.0	24.1	105.0	25.0	74.0	79.0	37.6	8°	54°	100	65.00	1.21	20500
	E20	1	1	392.410EH-100 20 100	100.0	19.2	100.0	20.0	60.3	71.0	30.5	8°	70°	100	50.00	2.58	12500
	E25	1	1	392.410EH-100 25 115	100.0	24.1	115.0	25.0	76.4	86.0	38.6	8°	70°	100	65.00	2.68	12500

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23



N15



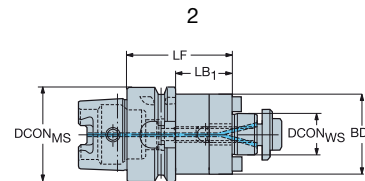
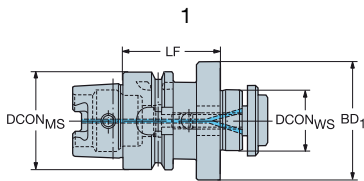
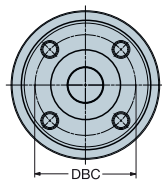
N3

# HSK to arbor adaptor

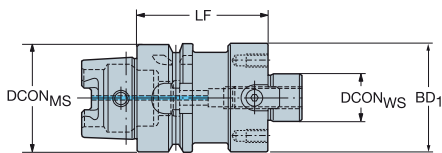
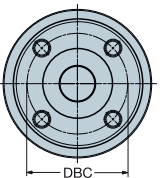
Machine side interface HSK A/C

Coolant through arbor

DSGN



					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
40	16	1	4	2	392.41005C-4016050	40.0	16.0	50.0	30.0	50.0	32.0	40.0	80	22.00	0.45	30000	
	22	1	4	1	392.41005C-4022050	40.0	22.0	50.0	50.0	48.0	80	45.00	0.60	30000			
50	16	1	4	2	392.41005C-5016050	50.0	16.0	50.0	24.0	50.0	32.0	50.0	80	22.00	0.62	25000	
	22	1	4	2	392.41005C-5022060	50.0	22.0	60.0	34.0	60.0	48.0	50.0	80	45.00	0.92	25000	
63	16	1	4	2	392.41005C6316050	63.0	16.0	50.0	24.0	50.0	32.0	63.0	80	22.00	0.87	20500	
	22	1	4	2	392.41005C6322050	63.0	22.0	50.0	24.0	50.0	50.0	63.0	80	45.00	1.12	20500	
	27	1	4	2	392.41005C6327060	63.0	27.0	60.0	24.0	60.0	60.0	63.0	80	80.00	1.45	20500	
	32	1	4	1	392.41005C6332060	63.0	32.0	60.0	60.0	78.0	80	180.00	1.80	20500			
40S	1	4	1	392.41005C6340060M	63.0	66.7	40.0	60.0	60.0	87.0	80	300.00	2.13	20500			
80	22	1	4	2	392.41005C8022050	80.0	22.0	50.0	24.0	50.0	50.0	80.0	80	45.00	1.59	14000	
	27	1	4	2	392.41005C8027050	80.0	27.0	50.0	24.0	50.0	60.0	80.0	80	80.00	1.78	14000	
	32	1	4	2	392.41005C8032060	80.0	32.0	60.0	34.0	60.0	78.0	80.0	80	180.00	2.42	14000	
	40	1	4	1	392.41005C8040060	80.0	40.0	60.0	60.0	87.0	80	300.00	2.74	14000			
100	22	1	4	2	392.41005C10022100	100.0	22.0	100.0	71.0	100.0	50.0	100.0	80	45.00	3.25	12500	
	27	1	4	2	392.41005C10027100	100.0	27.0	100.0	71.0	100.0	60.0	100.0	80	80.00	3.76	12500	
	32	1	4	2	392.41005C10032100	100.0	32.0	100.0	71.0	100.0	78.0	100.0	80	180.00	4.90	12500	
	40S	1	4	2	392.41005C10040100M	100.0	66.7	40.0	100.0	71.0	100.0	87.0	100.0	80	300.00	5.62	12500
125	32	1	4	2	392.41005C12532100	125.0	32.0	100.0	71.0	100.0	78.0	125.0	80	180.00	6.19	9500	
	40S	1	4	2	392.41005C12540100M	125.0	66.7	40.0	100.0	71.0	100.0	87.0	125.0	80	300.00	7.05	9500



					Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>WS</sub>	DSGN	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LF	BD <sub>1</sub>	NM	KG	RPMX
100	60	1	392.41005-10060075	100.0	101.6	60.0	75.0	130.0	180.00	6.30	12500
125	60	1	392.41005-12560085	125.0	101.6	60.0	85.0	130.0	180.00	9.70	9500

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



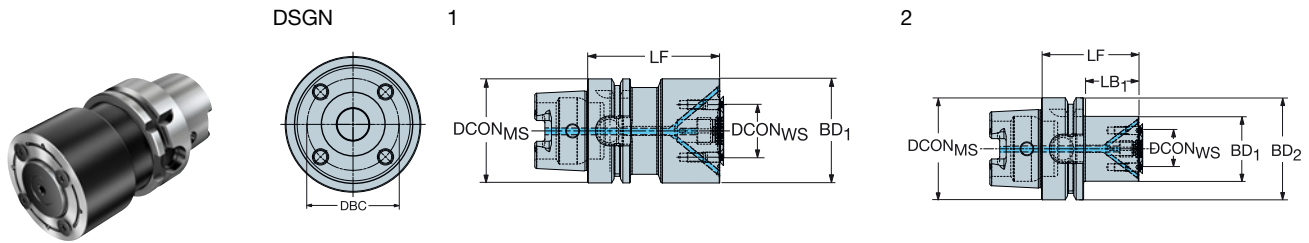
N15



# HSK to arbor with driving screws adaptor

Machine side interface HSK A/C

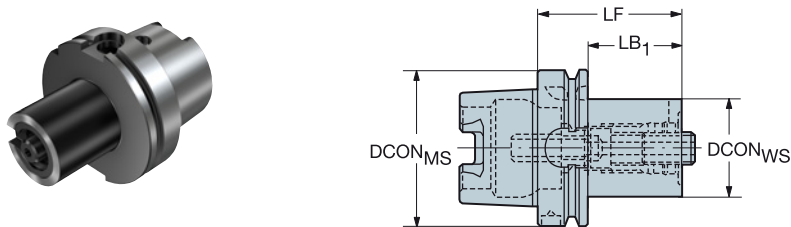
For CoroMill® QD with internal coolant supply



					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
63	X10	1	3	2	HA06-X10-032-055	63.0	22.0	10.0	2	55.0	28.0	55.0	32.0	63.0	80	6.40	0.85	12000
	X22	1	3	2	HA06-X22-040-060	63.0	32.0	22.0	2	60.0	33.0	60.0	40.0	63.0	80	3.90	1.01	11000
	X32	1	3	1	HA06-X32-063-080	63.0	45.0	32.0	2	80.0	80.0		63.0	80	6.40	1.82	10000	

## HSK to VL adaptor

Machine side interface HSK A/C



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BAR	NM	KG			
100	80	1	1	390.410-100 80 090	100.0	80.0	90.0	61.0	100	170.00	4.39			

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23



N15

# HSK to Weldon adaptor

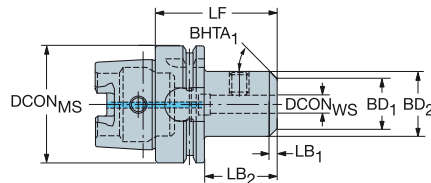
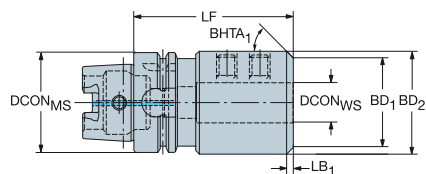
Machine side interface HSK A/C

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN

3

6



						Dimensions, mm														
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX	
63	8	1	1	6	392.41020-63 08 065B	63.0	8.0	65.0	2.0	39.0	65.0	24.0	28.0	63.0	45°	20	7.00	0.83	20500	
	10	1	1	6	392.41020-63 10 065B	63.0	10.0	65.0	2.0	39.0	65.0	31.0	35.0	63.0	45°	20	10.00	1.02	20500	
	12	1	1	6	392.41020-63 12 080B	63.0	12.0	80.0	2.0	54.0	80.0	38.0	42.0	63.0	45°	20	12.00	1.18	20500	
	16	1	1	6	392.41020-63 16 080B	63.0	16.0	80.0	2.0	54.0	80.0	44.0	48.0	63.0	45°	20	15.00	1.32	20500	
	20	1	1	6	392.41020-63 20 080B	63.0	20.0	80.0	4.0	54.0	80.0	44.0	52.0	63.0	45°	20	20.00	1.39	20500	
	25	1	1	3	392.41020-63 25 110B	63.0	25.0	110.0	5.0	110.0			55.0	65.0		45°	20	25.00	2.35	20500
100	32	1	1	3	392.41020-63 32 110B	63.0	32.0	110.0	5.0	110.0			62.0	72.0		45°	20	45.00	2.60	20500
	12	1	1	6	392.41020-100 12 080A	100.0	12.0	80.0	5.0	51.0	80.0	32.0	42.0	100.0	45°	20	12.00	2.62	12500	
	16	1	1	6	392.41020-100 16 100A	100.0	16.0	100.0	5.0	71.0	100.0	32.0	42.0	100.0	45°	20	15.00	2.98	12500	
	20	1	1	6	392.41020-100 20 100A	100.0	20.0	100.0	5.0	71.0	100.0	42.0	52.0	100.0	45°	20	20.00	3.12	12500	
	25	1	1	6	392.41020-100 25 100A	100.0	25.0	100.0	8.0	71.0	100.0	49.0	65.0	100.0	45°	20	25.00	3.59	12500	
	32	1	1	6	392.41020-100 32 100A	100.0	32.0	100.0	8.0	71.0	100.0	56.0	72.0	100.0	45°	20	45.00	3.84	12500	
40	1	1	6	392.41020-100 40 120A	100.0	40.0	120.0	8.0	91.0	120.0	74.0	90.0	100.0	45°	20	45.00	5.64	12500		

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23

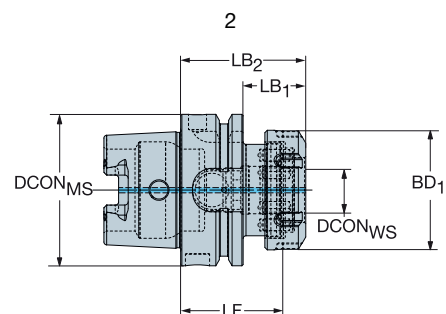
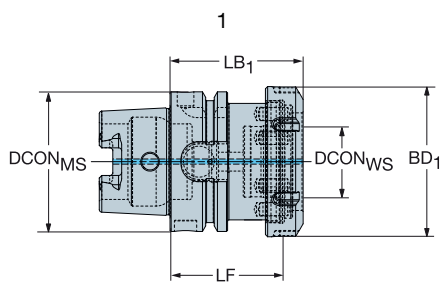


N15

# HSK to MDI adaptor

Machine side interface HSK A/C/T

DSGN



					Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
63	MDI-20	1	1	2	HT06-DM20-N-042	63.0	20.0	42.0	26.0	52.0	49.7	63.0	80	135.00	0.86	20000
	MDI-25	1	1	2	HT06-DM25-N-050	63.0	25.0	50.0	34.0	60.0	62.7	63.0	80	170.00	1.10	20000
	MDI-32	1	1	1	HT06-DM32-N-050	63.0	32.0	50.0	60.0		67.7		80	200.00	1.18	20000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23



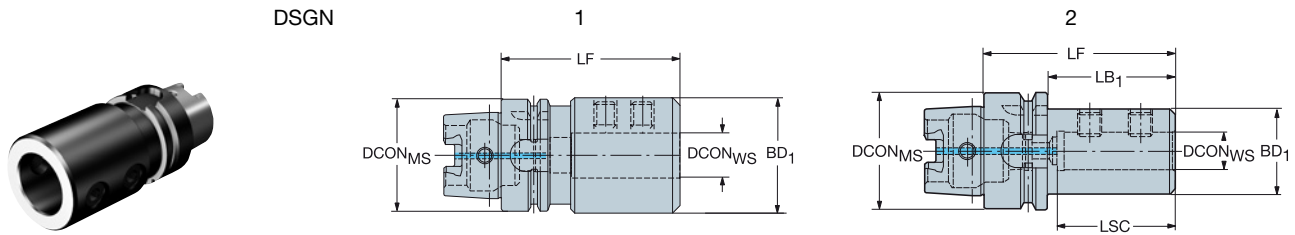
N15



N5

# HSK to ISO 9766 adaptor

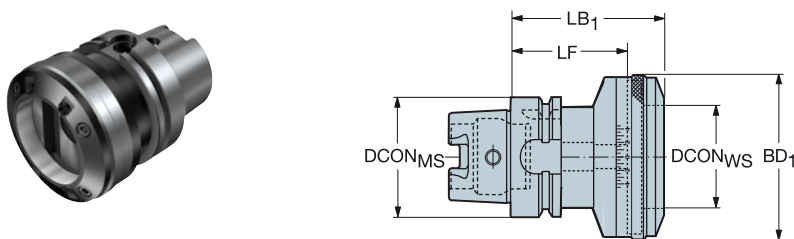
Machine side interface HSK A/C



					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
63	16	1	1	2	392.41027-63 16 080B	63.0	16.0	49	80.0	54.0	80.0	36.0	63.0	20	10.00	1.02	20500
	20	1	1	2	392.41027-63 20 080B	63.0	20.0	51	80.0	54.0	80.0	40.0	63.0	20	12.00	1.06	20500
	25	1	1	2	392.41027-63 25 090B	63.0	25.0	57	90.0	64.0	90.0	45.0	63.0	20	20.00	0.12	20500
	32	1	1	2	392.41027-63 32 090B	63.0	32.0	61	90.0	64.0	90.0	52.0	63.0	20	30.00	1.32	20500
80	40	1	1	2	392.41027-63 40 110	63.0	40.0	71	110.0	110.0		65.0	20	40.00	1.93	20500	
	20	1	1	2	392.41027-80 20 085	80.0	20.0	51	85.0	59.0	85.0	40.0	80.0	20	12.00	1.59	14000
	25	1	1	2	392.41027-80 25 090	80.0	25.0	57	90.0	64.0	90.0	45.0	80.0	20	20.00	1.70	14000
	32	1	1	2	392.41027-80 32 095	80.0	32.0	61	95.0	69.0	95.0	52.0	80.0	20	30.00	1.88	14000
100	40	1	1	2	392.41027-80 40 110	80.0	40.0	71	110.0	84.0	110.0	65.0	80.0	20	40.00	2.58	14000
	16	1	1	2	392.41027-100 16 090A	100.0	16.0	49	90.0	61.0	90.0	36.0	100.0	20	10.00	2.52	12500
	20	1	1	2	392.41027-100 20 090A	100.0	20.0	51	90.0	61.0	90.0	40.0	100.0	20	12.00	2.58	12500
	25	1	1	2	392.41027-100 25 100A	100.0	25.0	57	100.0	71.0	100.0	45.0	100.0	20	20.00	2.73	12500
100	32	1	1	2	392.41027-100 32 100A	100.0	32.0	61	100.0	71.0	100.0	52.0	100.0	20	30.00	2.84	12500
	40	1	1	2	392.41027-100 40 110A	100.0	40.0	71	110.0	81.0	110.0	65.0	100.0	20	40.00	3.43	12500
	50	1	1	2	392.41027-100 50 120	100.0	50.0	81	120.0	91.0	120.0	75.0	100.0	20	45.00	3.95	12500

# HSK to ISO 9766 adjustable adaptor

Machine side interface HSK A/C



					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>1</sub>	BAR	KG	RPMX
63	1	1	1	392.410277-63 01 060B	63.0	78.0	60.0	84.6	86.0	20	2.09	12000
100	2	1	1	392.410277-100 02 065A	100.0	98.0	65.0	89.6	106.0	20	4.64	9000
	3	1	1	392.410277-100 03 085A	100.0	136.0	85.0	95.0	140.0	20	6.58	6000

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M1



N23



N15

# HSK to CoroChuck™ 930

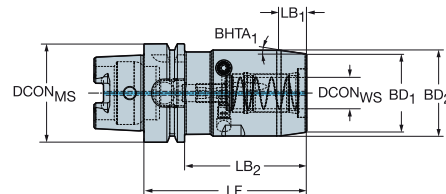
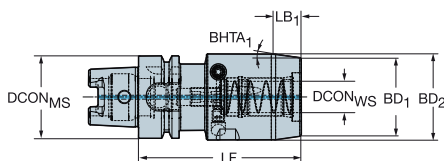
Heavy Duty design

Machine side interface HSK A/C

DSGN

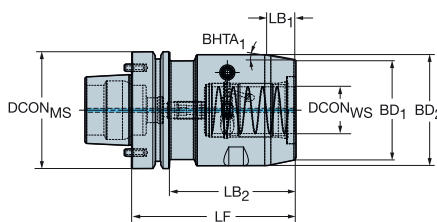
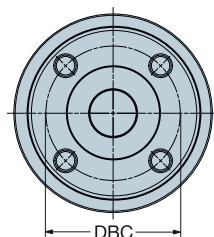
3

6



						Dimensions, mm														
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX
63	20	1	1	6	930-HA06-HD-20-104	63.0	20.0	51	104.0	17.8	78.0	104.0	50.0	55.0	62.9	8°	80	10.00	1.89	20000
	25	1	1	3	930-HA06-HD-25-110	63.0	25.0	57	110.0	18.8	110.0		57.0	65.0		12°	80	10.00	2.35	20000
	32	1	1	3	930-HA06-HD-32-112	63.0	32.0	61	112.0	18.8	112.0		68.0	76.0		12°	80	10.00	2.90	20000
	32	1	1	6	930-HA08-HD-32-110	80.0	32.0	61	110.0	18.8	84.0	110.0	68.0	76.0	80.0	12°	80	10.00	3.44	14000
100	20	1	1	6	930-HA10-HD-20-100	100.0	20.0	51	100.0	17.8	71.0	100.0	50.0	55.0	99.9	8°	80	10.00	3.18	10000
	25	1	1	6	930-HA10-HD-25-106	100.0	25.0	57	106.0	18.8	77.0	106.0	57.0	65.0	99.9	12°	80	10.00	3.72	10000
	32	1	1	6	930-HA10-HD-32-110	100.0	32.0	61	110.0	18.8	81.0	110.0	68.0	76.0	99.9	12°	80	10.00	4.40	10000
	32	1	1	6	930-HA10-HD-32-180	100.0	32.0	61	180.0	18.8	151.0	180.0	68.0	76.0	100.0	12°	80	10.00	6.84	10000

## Machine side interface HSK F with pins for Makino



						Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX	
80	32	1	1	930-HF08-HD-32-112	80.0	58.0	32.0	61	112.0	18.8	86.0	68.0	76.0	12°	80	10.00	3.48	24000	

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M1



N23



N6



N15



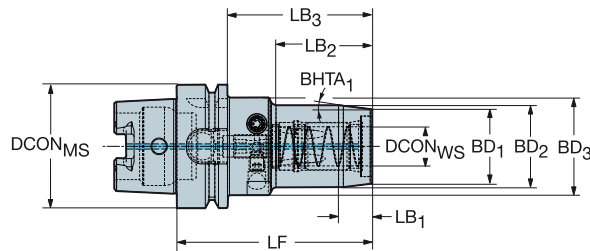
N4



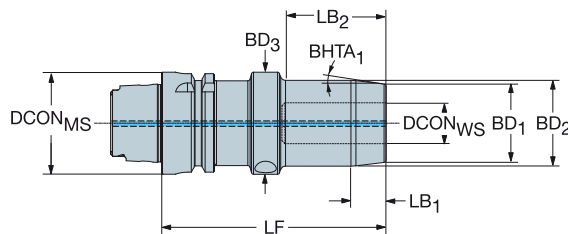
# HSK to CoroChuck™ 930

Slender design

Machine side interface HSK A/C



				Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX		
40	6	1	1	930-HA04-S-06-070	40.0	6.0	37	70.0	11.3	33.2	50.0	22.0	26.0	32.0	10°	80	8.00	0.40	30000		
	8	1	1	930-HA04-S-08-070	40.0	8.0	37	70.0	11.3	35.3	50.0	24.0	28.0	32.0	10°	80	8.00	0.42	30000		
	10	1	1	930-HA04-S-10-075	40.0	10.0	41	75.0	11.3	39.6	55.0	26.0	30.0	32.0	10°	80	8.00	0.46	30000		
	12	1	1	930-HA04-S-12-080	40.0	12.0	46	80.0	11.3	41.0	60.0	28.0	32.0	33.5	10°	80	8.00	0.51	30000		
50	6	1	1	930-HA05-S-06-074	50.0	6.0	37	74.0	11.3	30.2	48.0	22.0	26.0	40.0	10°	80	8.00	0.64	25000		
	8	1	1	930-HA05-S-08-074	50.0	8.0	37	74.0	11.3	30.2	48.0	24.0	28.0	40.0	10°	80	8.00	0.65	25000		
	10	1	1	930-HA05-S-10-080	50.0	10.0	41	80.0	11.3	34.2	54.0	26.0	30.0	40.0	10°	80	8.00	0.71	25000		
	12	1	1	930-HA05-S-12-085	50.0	12.0	46	85.0	11.3	38.2	59.0	28.0	32.0	40.0	10°	80	8.00	0.75	25000		
63	6	1	1	930-HA06-S-06-074	63.0	6.0	37	74.0	11.3	30.2	48.0	22.0	26.0	40.0	10°	80	8.00	0.90	20000		
	8	1	1	930-HA06-S-08-074	63.0	8.0	37	74.0	11.3	30.2	48.0	24.0	28.0	40.0	10°	80	8.00	0.91	20000		
	10	1	1	930-HA06-S-10-080	63.0	10.0	41	80.0	11.3	34.2	54.0	26.0	30.0	40.0	10°	80	8.00	0.99	20000		
	12	1	1	930-HA06-S-12-090	63.0	12.0	46	90.0	11.3	38.2	64.0	28.0	32.0	50.0	10°	80	8.00	1.21	20000		
20	1	1	1	930-HA06-S-20-100	63.0	20.0	51	100.0	16.0	49.2	74.0	38.0	42.0	50.0	7°	80	8.00	1.40	20000		
	1	1	1	930-HA10-S-20-100	100.0	20.0	51	100.0	16.0	49.2	71.0	38.0	42.0	50.0	7°	80	8.00	2.74	10000		



				Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX				
40	12	1	1	930-HA04-S-12-096	40.0	12.0	46	96.0	11.3	38.2	28.0	32.0	10°	80	8.00	0.70	40000				
50	20	1	1	930-HA05-S-20-090	50.0	20.0	51	90.0	16.0	64.0	37.6	41.5	7°	80	8.00	0.89	25000				
	20	1	1	930-HA05-S-20-110	50.0	20.0	51	110.0	16.0	49.2	38.0	42.0	7°	80	8.00	1.19	36000				
63	25	1	1	930-HA06-S-25-108	63.0	25.0	57	108.0	12.9	81.1	45.0	50.0	11°	80	8.00	1.66	20000				
80	25	1	1	930-HA08-S-25-110	80.0	25.0	57	110.0	12.9	83.1	45.0	50.0	11°	80	8.00	2.13	14000				
100	25	1	1	930-HA10-S-25-110	100.0	25.0	57	110.0	12.9	80.1	45.0	50.0	11°	80	8.00	3.02	10000				

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M1



N23



N6



N15

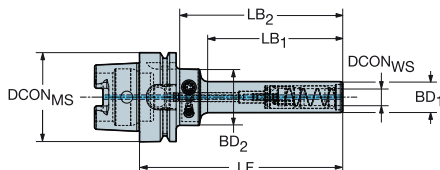


N4

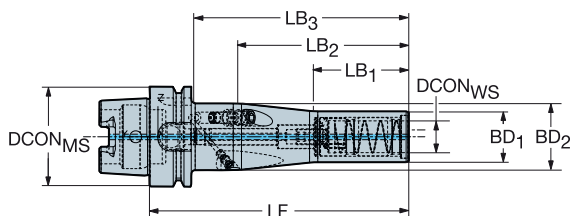
# HSK to CoroChuck™ 930

Pencil design

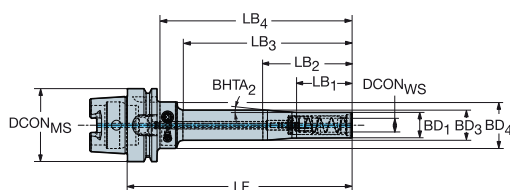
Machine side interface HSK A/C



					Dimensions, mm																		
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63	6	1	1	930-HA06-P-06-094	63.0	6.0	37	94.0	45.8	52.1	68.0	94.0	14.5	14.5	40.0	63.0	62°	80	8.00	0.89	20000		
	8	1	1	930-HA06-P-08-094	63.0	8.0	37	94.0	45.8	65.5	94.0		17.5	40.0	63.0		0°	80	8.00	0.87	20000		
	10	1	1	930-HA06-P-10-104	63.0	10.0	41	104.0	55.8	75.5	104.0		20.0	40.0	63.0		0°	80	8.00	0.91	20000		
	10	1	1	930-HA06-P-10-144	63.0	10.0	41	144.0	95.8	115.5	144.0		20.0	40.0	63.0		0°	80	8.00	1.01	20000		
	12	1	1	930-HA06-P-12-109	63.0	12.0	46	109.0	60.8	66.4	83.0	109.0	22.0	22.0	40.0	63.0	55°	80	8.00	0.98	20000		
	12	1	1	930-HA06-P-12-144	63.0	12.0	46	144.0	95.8	101.4	118.0	144.0	22.0	22.0	40.0	63.0	55°	80	8.00	1.09	20000		
100	12	1	1	930-HA10-P-12-115	100.0	12.0	46	115.0	60.8	66.4	86.0	115.0	22.0	22.0	40.0	100.0	55°	80	8.00	2.40	10000		
	12	1	1	930-HA10-P-12-150	100.0	12.0	46	150.0	95.8	101.4	121.0	150.0	22.0	22.0	40.0	100.0	55°	80	8.00	2.51	10000		



					Dimensions, mm																		
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX					
63	20	1	1	930-HA06-P-20-163	63.0	20.0	51	163.0	60.0	108.0	137.0	32.0	42.0	6°	80	8.00	1.59	20000					
100	20	1	1	930-HA10-P-20-170	100.0	20.0	51	170.0	60.0	108.0	141.0	32.0	42.0	6°	80	8.00	3.06	10000					



					Dimensions, mm																		
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX			
63	12	1	1	930-HA06-P-12-194	63.0	12.0	46	194.0	50.0	75.0	145.8	168.0	22.0	26.0	40.0	4°	80	8.00	1.39	20000			
100	12	1	1	930-HA10-P-12-200	100.0	12.0	46	200.0	50.0	75.0	145.8	171.0	22.0	26.0	40.0	4°	80	8.00	2.79	10000			

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M1



N23



N6



N15

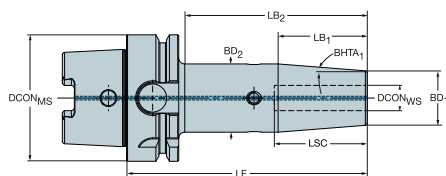


N4

# HSK to shrink fit chuck

Machine side interface HSK A/C

Internal coolant supply



For MQL machining

					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BHTA <sub>1</sub>	(BAR)	(KG)	RPMX		
63	6	1	1	HA06-SH06Q-S-080	63.0	6.0	22	80.0	38.1	54.0	21.0	27.0	4°	10	0.83	20500		
	6	1	1	HA06-SH06Q-S-120	63.0	6.0	22	120.0	38.1	94.0	21.0	27.0	4°	10	1.01	20500		
	8	1	1	HA06-SH08Q-S-080	63.0	8.0	26	80.0	38.1	54.0	21.0	27.0	4°	10	0.82	20500		
	8	1	1	HA06-SH08Q-S-120	63.0	8.0	26	120.0	38.1	94.0	21.0	27.0	4°	10	1.00	20500		
	10	1	1	HA06-SH10Q-S-085	63.0	10.0	31	85.0	50.8	59.0	24.0	32.0	4°	10	0.90	20500		
	10	1	1	HA06-SH10Q-S-120	63.0	10.0	31	120.0	50.8	94.0	24.0	32.0	4°	10	1.11	20500		
	12	1	1	HA06-SH12Q-S-090	63.0	12.0	34	90.0	50.8	64.0	24.0	32.0	4°	10	0.91	20500		
	12	1	1	HA06-SH12Q-S-120	63.0	12.0	34	120.0	50.8	94.0	24.0	32.0	4°	10	1.09	20500		
	16	1	1	HA06-SH16Q-S-095	63.0	16.0	39	95.0	44.4	69.0	27.0	34.0	4°	10	0.97	20500		
	16	1	1	HA06-SH16Q-S-120	63.0	16.0	39	120.0	44.4	94.0	27.0	34.0	4°	10	1.14	20500		
	20	1	1	HA06-SH20Q-S-100	63.0	20.0	41	100.0	57.2	74.0	33.0	42.0	4°	10	1.17	20500		
	20	1	1	HA06-SH20Q-S-120	63.0	20.0	41	120.0	57.2	94.0	33.0	42.0	4°	10	1.38	20500		
	25	1	1	HA06-SH25Q-S-115	63.0	25.0	47	115.0	57.2	89.0	44.0	53.0	4°	10	1.75	20500		
	32	1	1	HA06-SH32Q-S-120	63.0	32.0	51	120.0	57.2	94.0	44.0	53.0	4°	10	1.64	20500		
100	6	1	1	HA10-SH06Q-S-085	100.0	6.0	22	85.0	38.1	56.0	21.0	27.0	4°	10	2.19	12500		
	6	1	1	HA10-SH06Q-S-120	100.0	6.0	22	120.0	38.1	91.0	21.0	27.0	4°	10	2.34	12500		
	8	1	1	HA10-SH08Q-S-085	100.0	8.0	26	85.0	38.1	56.0	21.0	27.0	4°	10	2.18	12500		
	8	1	1	HA10-SH08Q-S-120	100.0	8.0	26	120.0	38.1	91.0	21.0	27.0	4°	10	2.33	12500		
	10	1	1	HA10-SH10Q-S-090	100.0	10.0	31	90.0	50.8	61.0	24.0	32.0	4°	10	2.26	12500		
	10	1	1	HA10-SH10Q-S-120	100.0	10.0	31	120.0	50.8	91.0	24.0	32.0	4°	10	2.44	12500		
	12	1	1	HA10-SH12Q-S-095	100.0	12.0	34	95.0	50.8	66.0	24.0	32.0	4°	10	2.28	12500		
	12	1	1	HA10-SH12Q-S-120	100.0	12.0	34	120.0	50.8	91.0	24.0	32.0	4°	10	2.42	12500		
	16	1	1	HA10-SH16Q-S-100	100.0	16.0	39	100.0	44.4	71.0	27.0	34.0	4°	10	2.34	12500		
	16	1	1	HA10-SH16Q-S-130	100.0	16.0	39	130.0	44.4	101.0	27.0	34.0	4°	10	2.54	12500		
	20	1	1	HA10-SH20Q-S-105	100.0	20.0	41	105.0	57.2	76.0	33.0	42.0	4°	10	2.54	12500		
	20	1	1	HA10-SH20Q-S-130	100.0	20.0	41	130.0	57.2	101.0	33.0	42.0	4°	10	2.80	12500		
	25	1	1	HA10-SH25Q-S-115	100.0	25.0	47	115.0	57.2	86.0	44.0	53.0	4°	10	3.06	12500		
	32	1	1	HA10-SH32Q-S-120	100.0	32.0	51	120.0	57.2	91.0	44.0	53.0	4°	10	2.95	12500		

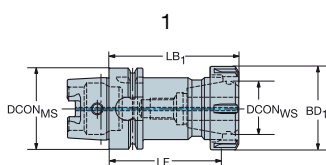
Balance: Fine adjustment possibility

# HSK to ER collet chuck

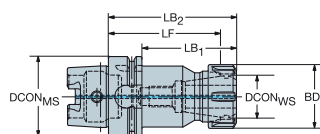
Workpiece side interface DIN 6499-B



DSGN



2



					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	(BAR)	(KG)	RPMX			
40	ER25	1	1	1	392.41014-4025062	40.0	26.0	50.0	62.0		42.0		80	0.42	30000			
50	ER32	1	1	1	392.41014-5032072	50.0	33.0	59.0	72.0		50.0		80	0.70	25000			
63	ER16	1	1	2	392.41014-63 16 100	63.0	17.0	89.4	71.0	100.0	28.0	63.0	80	0.96	20500			
	ER25	1	1	2	392.41014-63 25 100	63.0	26.0	88.0	74.0	100.0	42.0	63.0	80	1.24	20500			
	ER32	1	1	2	392.41014-63 32 100B	63.0	33.0	87.0	74.0	100.0	50.0	63.0	80	1.37	20500			
	ER40	1	1	1	392.41014-63 40 120B	63.0	41.0	105.0	120.0		63.0		80	1.88	20500			
100	ER32	1	1	2	392.41014-100 32 100A	100.0	33.0	87.0	71.0	100.0	50.0	100.0	80	2.75	12500			
	ER40	1	1	2	392.41014-100 40 120A	100.0	41.0	105.0	91.0	120.0	63.0	100.0	80	3.48	12500			
	ER50	1	1	2	392.41014-100 50 130A	100.0	52.0	109.0	101.0	130.0	78.0	100.0	80	4.45	12500			

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M1



N23



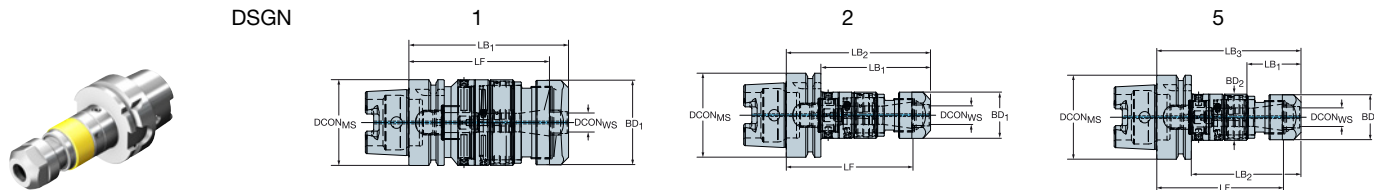
N15



# HSK to CoroChuck™ 970

Machine side interface HSK A/C

Workpiece side interface DIN 6499-B



							Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">BAR</span>	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">KG</span>	RPMX	
63	ER32	M27	1	1	2	970-HA06-32-131	63.0	32.8	121.7	105.2	131.2	50.0	63.0	80	1.41	8000	
		ER40	M30	1	1	1	970-HA06-40-160	63.0	41.0	143.1	154.5		63.0	80	2.91	8000	
100	ER32	M27	1	1	2	970-HA10-32-138	100.0	32.8	128.2	108.7	137.7	50.0	100.0	80	2.80	8000	
		ER40	M30	1	1	2	970-HA10-40-164	100.0	40.8	146.6	129.1	158.0	63.0	100.0	80	4.35	8000

## For MQL machining

							Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">BAR</span>	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">KG</span>	RPMX
63	ER20	M12	1	1	5	970-HA06-20-108	63.0	20.8	95.1	35.3	77.1	103.1	33.7	35.0	80	1.09	8000
		M12	1	1	5	970-HA06Q-20-108	63.0	20.8	95.1	35.3	77.1	103.1	33.7	35.0	80	1.10	8000
		M20	1	1	5	970-HA06-25-128	63.0	25.8	114.0	37.1	96.5	122.5	42.0	44.0	80	1.44	8000
		M20	1	1	5	970-HA06Q-25-128	63.0	25.8	114.0	37.1	96.5	122.5	42.0	44.0	80	1.44	8000
100	ER20	M12	1	1	5	970-HA10-20-115	100.0	20.8	101.6	35.3	80.5	109.6	33.7	35.0	80	2.58	8000
		M12	1	1	5	970-HA10Q-20-115	100.0	20.8	101.6	35.3	80.5	109.6	33.7	35.0	80	2.53	8000
		M20	1	1	5	970-HA10-25-134	100.0	25.8	120.5	37.1	100.0	129.0	42.0	44.0	80	2.92	8000
		M20	1	1	5	970-HA10Q-25-134	100.0	25.8	120.5	37.1	100.0	129.0	42.0	44.0	80	2.89	8000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23

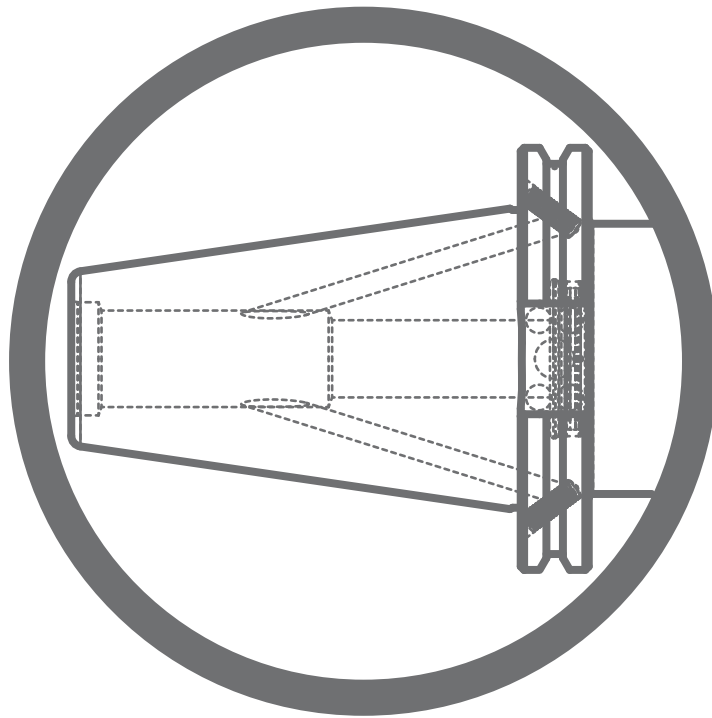


N15



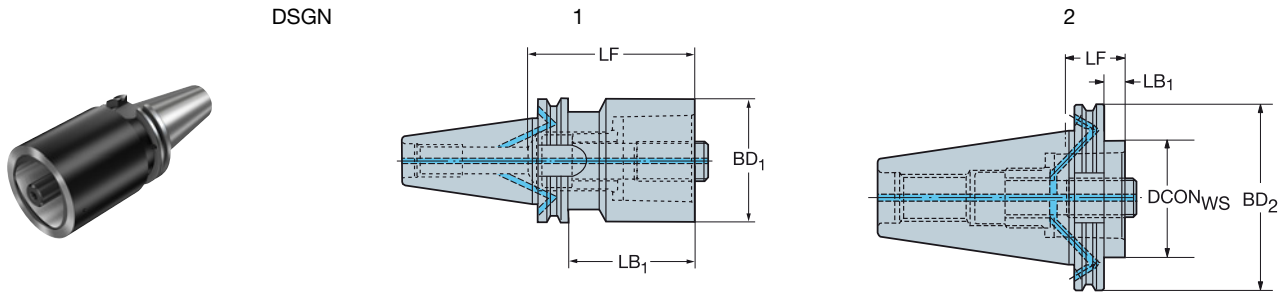
N5

# Machine side interface BIG-PLUS® ISO



# BIG-PLUS ISO to Coromant Capto® adaptor

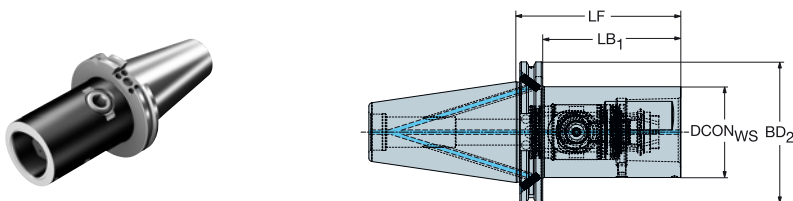
Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>2</sub>	BAR	NM	KG
40	C3	7	1	2	C3-390B.540-40 030	M16	32.0	30.0	10.9	30.0	63.5	80	45.00	0.89
	C4	7	1	2	C4-390B.540-40 040	M16	40.0	40.0	20.9	40.0	63.5	80	55.00	0.96
	C5	7	1	2	C5-390B.540-40 050	M16	50.0	50.0	30.9	50.0	63.5	80	95.00	1.12
	C6	7	1	2	C6-390B.540-40 085	M16	63.0	85.0	30.9	50.0	63.5	80	170.00	1.81
50	C3	7	1	2	C3-390.540-50 030A	M24	32.0	30.0	10.9	30.0	97.5	80	45.00	2.80
	C3	7	1	2	C3-390.540-50 060	M24	32.0	60.0	40.9	60.0	97.5	80	45.00	2.91
	C4	7	1	2	C4-390.540-50 030A	M24	40.0	30.0	10.9	30.0	97.5	80	55.00	2.80
	C4	7	1	2	C4-390.540-50 060	M24	40.0	60.0	40.9	60.0	97.5	80	55.00	3.01
	C5	7	1	2	C5-390.540-50 030A	M24	50.0	30.0	10.9	30.0	97.5	80	95.00	2.75
	C5	7	1	2	C5-390.540-50 070	M24	50.0	70.0	50.9	70.0	97.5	80	95.00	3.27
	C6	7	1	2	C6-390.540-50 050A	M24	63.0	50.0	30.9	50.0	97.5	80	170.00	3.10
	C6	7	1	2	C6-390.540-50 100	M24	63.0	100.0	80.9	100.0	97.5	80	170.00	4.22
	C8	7	1	2	C8-390.540-50 070A	M24	80.0	70.0	50.9	70.0	97.5	80	170.00	3.90
	C8	7	1	2	C8-390.540-50 120	M24	80.0	120.0	100.9	120.0	97.5	80	170.00	5.74
C10	7	1	1	C10-390.540-50 140	M24	100.0	140.0	140.0			80	380.00	7.72	

# BIG-PLUS ISO to Coromant Capto® adaptor with Quick change

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG		
50	C6	7	1	IB50-QC-C6-115	M24	63.0	115.0	95.0	97.4	80	90.00	4.48		

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M1



N23

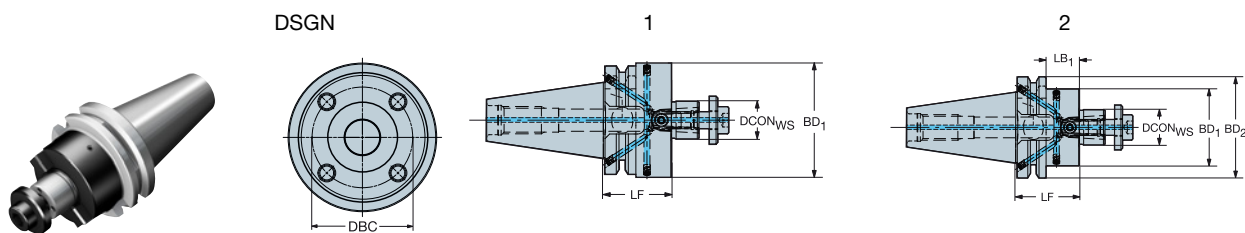


N15

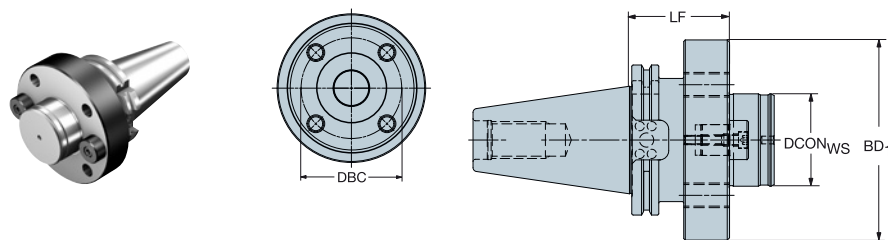
# BIG-PLUS ISO to arbor adaptor

Coolant through arbor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



		Dimensions, mm															
CZC <sub>MIS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DBC	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
40	16	7	4	2	392.54005C4016045	M16	16.0	45.0	25.9	45.0	32.0	63.5	80	22.00	1.04	18000	
	22	7	4	2	392.54005C4022040	M16	22.0	40.0	20.9	40.0	48.0	63.5	80	45.00	1.20	18000	
	27	7	4	2	392.54005C4027050	M16	27.0	50.0	30.9	50.0	60.0	63.5	80	80.00	1.51	18000	
	32	7	4	1	392.54005C4032055	M16	32.0	55.0	55.0		78.0		80	180.00	2.03	18000	
40S	7	4	1	392.54005C4040055M	66.7	M16	40.0	55.0	55.0		87.0		80	300.00	2.37	18000	
50	22	7	4	2	392.54005C5022040	M24	22.0	40.0	21.0	40.0	48.0	97.5	80	45.00	3.04	12000	
	27	7	4	2	392.54005C5027050	M24	27.0	50.0	30.9	50.0	60.0	97.5	80	80.00	3.45	12000	
	32	7	4	2	392.54005C5032055	M24	32.0	55.0	35.9	55.0	78.0	97.5	80	180.00	4.11	12000	
	40S	7	4	2	392.54005C5040060	66.7	M24	40.0	60.0	40.9	60.0	87.0	97.0	80	300.00	4.65	12000



		Dimensions, mm									
CZC <sub>MIS</sub>	CZC <sub>WS</sub>	Ordering code	DBC	CRKS	DCON <sub>WS</sub>	LF	BD <sub>1</sub>	NM	KG	RPMX	
50	60	392.54005-5060065	101.6	M24	60.0	65.0	130.0	180.00	7.70	12000	

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M1



N23

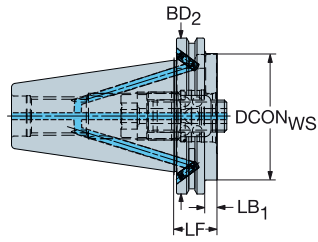


N15

# BIG-PLUS ISO to VL adaptor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

Workpiece side interface DIN 6499-B



				Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
50	80	7	1	390B.540-50 80 027	M24	80.0	27.0	7.9	97.5	80	170.00	2.87	12000

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M1



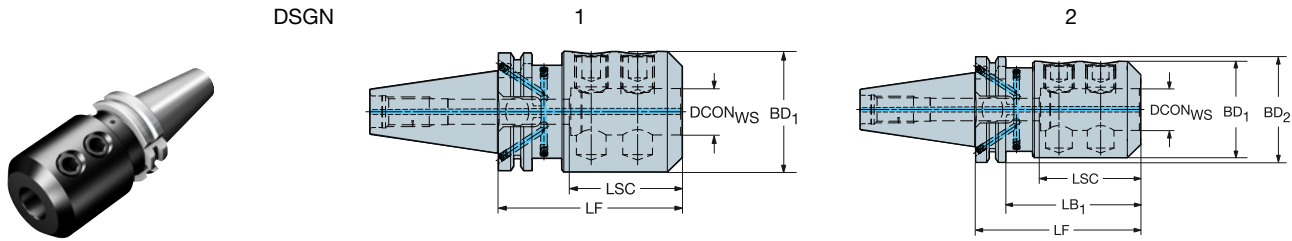
N23



N15

# BIG-PLUS ISO to Weldon / ISO 9766 adaptor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



		Dimensions, mm															
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
40	16	7	1	2	392.54023-4016060	M16	16.0		60.0	40.9	60.0	48.0	63.5	20	25.00	1.32	18000
	20	7	1	2	392.54023-4020070	M16	20.0		70.0	50.9	70.0	52.0	63.5	20	25.00	1.52	18000
	25	7	1	1	392.54023-4025100	M16	25.0		100.0	100.0		65.0		20	25.00	2.43	18000
	32	7	1	1	392.54023-4032105	M16	32.0		105.0	105.0		72.0		20	45.00	2.80	18000
	40	7	1	1	392.54023-4040115	M16	40.0		115.0	115.0		90.0		20	45.00	4.28	18000
50	25	7	1	2	392.54023-5025085	M24	25.0	60	85.0	65.9	85.0	65.0	97.5	20	25.00	4.05	12000
	32	7	1	2	392.54023-5032090	M24	32.0	64	90.0	69.9	90.0	72.0	97.5	20	45.00	4.42	12000
	40	7	1	2	392.54023-5040115	M24	40.0	74	115.0	95.9	115.0	90.0	97.0	20	45.00	6.35	12000

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M1



N23



N15

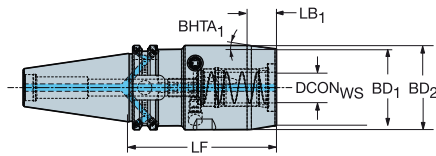
# BIG-PLUS ISO to CoroChuck™ 930

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

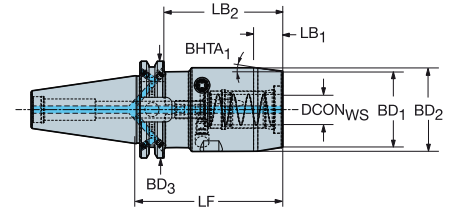


DSGN

3



6



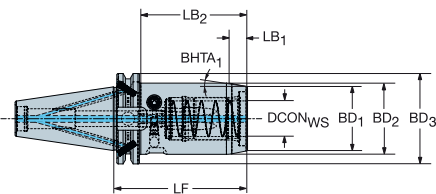
## Heavy Duty design

						Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX			
40	20	7	1	6	930-IB40-HD-20-097	M16	20.0	51	97.0	17.8	77.9	97.0	50.0	55.0	63.5	8°	80	10.00	2.03	18000			
	25	7	1	3	930-IB40-HD-25-103	M16	25.0	57	103.0	18.8	103.0		57.0	65.0		12°	80	10.00	2.50	18000			
50	20	7	1	6	930-IB50-HD-20-083	M24	20.0	51	83.0	17.8	63.9	83.0	50.0	55.0	97.4	8°	80	10.00	3.72	12000			
	25	7	1	6	930-IB50-HD-25-087	M24	25.0	57	87.0	18.8	67.9	87.0	57.0	65.0	97.4	12°	80	10.00	4.17	12000			
	32	7	1	6	930-IB50-HD-32-077	M24	32.0	61	77.0	18.8	57.9	77.0	68.0	76.0	97.4	12°	80	10.00	4.27	12000			

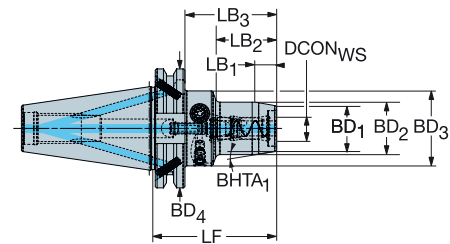


DSGN

6



10



## Slender design

						Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX	
40	6	7	1	10	930-IB40-S-06-068	M16	6.0	37	68.0	11.3	30.2	48.9	68.0	22.0	26.0	40.0	63.5	10°	80	8.00	1.08	18000	
	8	7	1	10	930-IB40-S-08-068	M16	8.0	37	68.0	11.3	30.2	48.9	68.0	24.0	28.0	40.0	63.5	10°	80	8.00	1.10	18000	
	10	7	1	10	930-IB40-S-10-072	M16	10.0	41	72.0	11.3	34.2	52.9	72.0	26.0	30.0	40.0	63.5	10°	80	8.00	1.13	18000	
	12	7	1	10	930-IB40-S-12-080	M16	12.0	46	80.0	11.3	38.2	60.9	80.0	28.0	32.0	50.0	63.5	10°	80	8.00	1.33	18000	
	20	7	1	10	930-IB40-S-20-090	M16	20.0	51	90.0	16.0	49.2	70.9	90.0	38.0	42.0	50.0	63.5	7°	80	8.00	1.52	18000	
50	25	7	1	6	930-IB40-S-25-095	M16	25.0	57	95.0	12.9	75.0	95.0		45.0	50.0	63.5		11°	80	8.00	1.74	18000	
	20	7	1	10	930-IB50-S-20-089	M24	20.0	51	89.0	16.0	49.2	69.9	89.0	38.0	42.0	50.0	97.4	7°	80	8.00	3.40	12000	
	25	7	1	6	930-IB50-S-25-095	M24	25.0	57	95.0	12.9	73.5	95.0		45.0	50.0	97.4		11°	80	8.00	3.61	12000	

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M1



N23



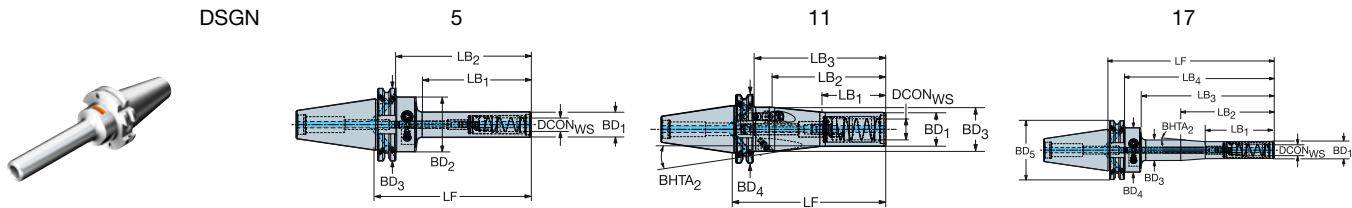
N15



N4

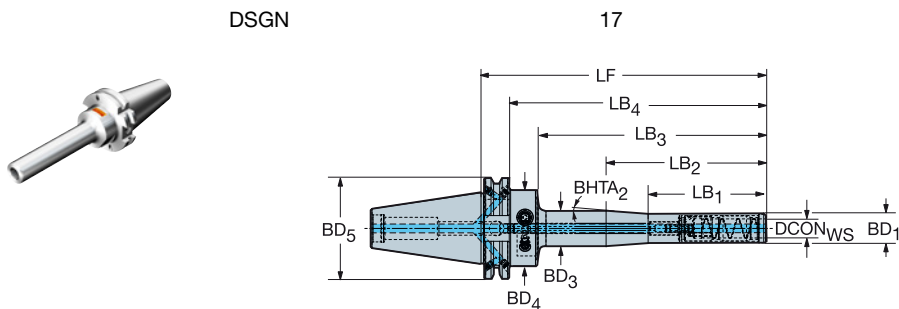
# BIG-PLUS ISO to CoroChuck™ 930

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



## Pencil design

					Dimensions, mm																	BAR	NM	KG	RPMX
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	LB <sub>5</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BD <sub>5</sub>	BHTA <sub>2</sub>					
40	8	7	1	5	930-IB40-P-08-088	M16	8.0	37	88.0	45.8	66.5	88.0			17.5	40.0	63.5			0°	80	8.00	1.06	18000	
	10	7	1	5	930-IB40-P-10-098	M16	10.0	41	98.0	55.8	76.5	98.0			20.0	40.0	63.5			0°	80	8.00	1.10	18000	
	10	7	1	5	930-IB40-P-10-138	M16	10.0	41	138.0	95.8	116.5	138.0			20.0	40.0	63.5			0°	80	8.00	1.20	18000	
	12	7	1	5	930-IB40-P-12-103	M16	12.0	46	103.0	65.0	83.9	103.0			22.0	40.0	63.5			0°	80	8.00	1.19	18000	
	12	7	1	5	930-IB40-P-12-138	M16	12.0	46	138.0	100.0	118.9	138.0			22.0	40.0	63.5			0°	80	8.00	1.29	18000	
	12	7	1	17	930-IB40-P-12-188	M16	12.0	46	188.0	50.0	75.0	150.0	168.9	188	22.0	22.0	26.0	40.0	63	4°	80	8.00	1.58	18000	
	20	7	1	11	930-IB40-P-20-145	M16	20.0	51	145.0	60.0	108.0	125.9	145.0		32.0	32.0	42.0	63.5		5°	80	8.00	1.66	18000	



					Dimensions, mm																	BAR	NM	KG	RPMX
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	LB <sub>5</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BD <sub>5</sub>	BHTA <sub>2</sub>					
40	12	7	1	17	930-IB40-P-12-188	M16	12.0	46	188.0	50.0	75.0	150.0	168.9	22.0	26.0	40.0	63	4°	80	8.00	1.58	18000			

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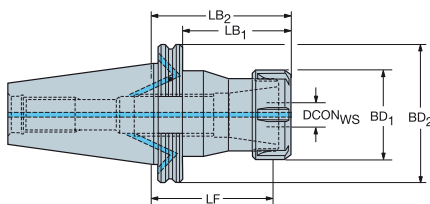




# BIG-PLUS ISO to ER collet chuck

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

Workpiece side interface DIN 6499-B



				Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	KG	RPMX
40	ER25	7	1	392.54014-4025070	M16	26.0	58.0	30.9	70.0	42.0	63.5	80	1.17	18000
	ER40	7	1	392.54014-4040075	M16	41.0	60.0	55.9	75.0	63.0	63.5	80	1.43	18000

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M1



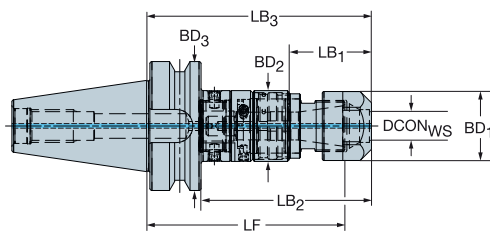
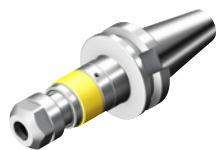
N23



N15

# BIG-PLUS ISO to CoroChuck™ 970

Workpiece side interface DIN 6499-B

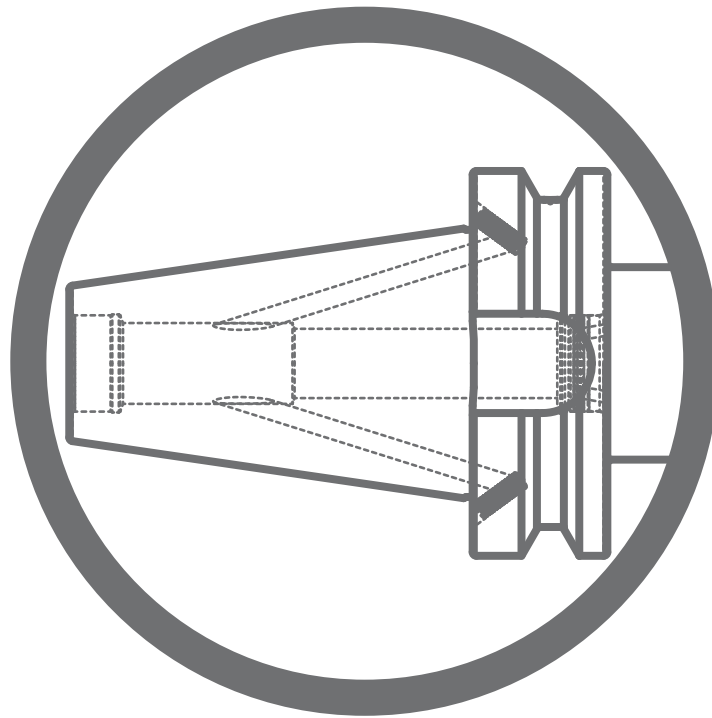


					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BAR	KG	RPMX
50	ER20	M12	7	1	970-IB50-20-106	M24	20.8	93.2	35.3	82.1	101.2	33.7	35.0	97.5	80	3.00	8000
	ER25	M20	7	1	970-IB50-25-126	M24	25.8	112.1	37.1	101.5	120.6	42.0	44.0	97.5	80	3.50	8000

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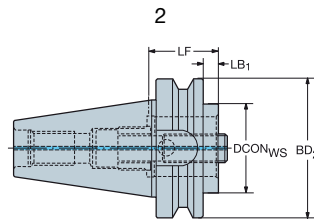
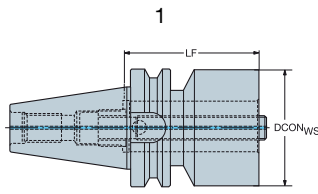
# Machine side interface BIG-PLUS® MAS-BT



# BIG-PLUS MAS-BT to Coromant Capto® adaptor

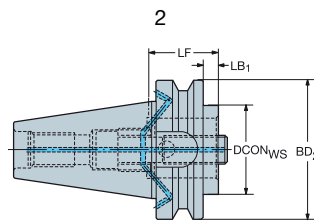
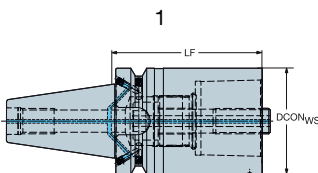
Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN



						Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>2</sub>	BAR	NM	KG	
30	C3	1	1	2	C3-390.555-30 040	M12	32.0	40.0	18.0	40.0	46.0	80	45.00	0.48	
	C4	1	1	2	C4-390.555-30 060	M12	40.0	60.0	38.0	60.0	46.0	80	55.00	0.67	
	C5	1	1	1	C5-390.555-30 080	M12	50.0	80.0	80.0			80	95.00	1.08	

DSGN



						Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>2</sub>	BAR	NM	KG	
40	C3	7	1	2	C3-390B.555-40 030	M16	32.0	30.0	3.0	30.0	63.0	80	45.00	1.00	
	C4	7	1	2	C4-390B.555-40 040	M16	40.0	40.0	13.0	40.0	63.0	80	55.00	1.04	
	C4	7	1	2	C4-390B.555-40 070	M16	40.0	70.0	43.0	70.0	63.0	80	55.00	1.32	
	C5	7	1	2	C5-390B.555-40 050	M16	50.0	50.0	23.0	50.0	63.0	80	95.00	1.16	
	C5	7	1	2	C5-390B.555-40 090	M16	50.0	90.0	63.0	90.0	63.0	80	95.00	1.73	
	C6	7	1	1	C6-390B.555-40 075	M16	63.0	75.0	75.0			80	170.00	1.75	
50	C3	7	1	2	C3-390B.558-50 040	M24	32.0	40.0	2.0	40.0	100.0	80	45.00	3.72	
	C3	7	1	2	C3-390B.558-50 070	M24	32.0	70.0	32.0	70.0	100.0	80	45.00	3.82	
	C4	7	1	2	C4-390B.558-50 040	M24	40.0	40.0	2.0	40.0	100.0	80	55.00	3.72	
	C4	7	1	2	C4-390B.558-50 070	M24	40.0	70.0	32.0	70.0	100.0	80	55.00	3.90	
	C5	7	1	2	C5-390B.558-50 040	M24	50.0	40.0	2.0	40.0	100.0	80	95.00	3.59	
	C5	7	1	2	C5-390B.558-50 080	M24	50.0	80.0	42.0	80.0	100.0	80	95.00	4.13	
	C6	7	1	2	C6-390B.558-50 050	M24	63.0	50.0	12.0	50.0	100.0	80	170.00	3.64	
	C6	7	1	2	C6-390B.558-50 100	M24	63.0	100.0	62.0	100.0	100.0	80	170.00	4.75	
	C8	7	1	2	C8-390B.558-50 070	M24	80.0	70.0	32.0	70.0	100.0	80	170.00	4.16	
	C8	7	1	2	C8-390B.558-50 120	M24	80.0	120.0	82.0	120.0	100.0	80	170.00	6.02	
	C10	7	1	1	C10-390B.558-50 140	M24	100.0	140.0	140.0			80	380.00	8.01	

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M1



N23

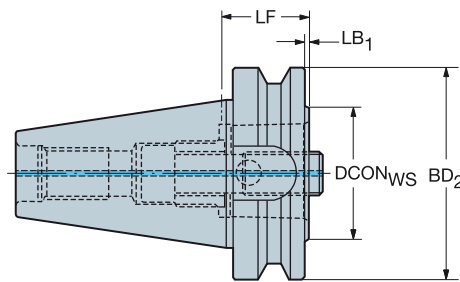


N15

## BIG-PLUS MAS-BT to Coromant Capto® adaptor

90° rotated polygon for precision tool tip control

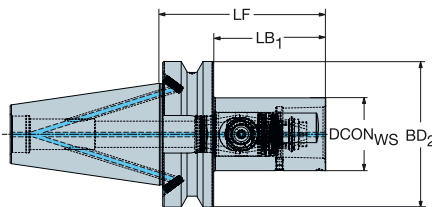
Designed for Mazak™ e-machine and Mori Seiki NT™ -Series



				Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG		
40	C5	1	1	C5-390.562-40 050	M16	50.0	50.0	23.0	63.0	80	45.00	1.16		
50	C6	1	1	C6-390.562-50 050	M24	63.0	50.0	12.0	100.0	80	65.00	3.66		
	C8	1	1	C8-390.562-50 070	M24	80.0	70.0	32.0	100.0	80	65.00	4.18		

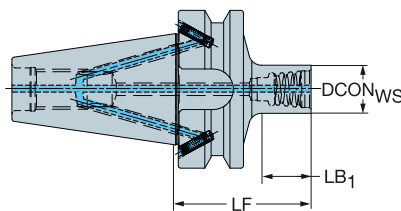
## BIG-PLUS MAS-BT to Coromant Capto® adaptor with Quick change

Machine side interface compatible with MAS-BT 403 and JIS B 6339



				Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG		
50	C6	7	1	BB50-QC-C6-135	M24	63.0	135.0	96.0	135.0	80	90.00	5.52		

## BIG-PLUS MAS-BT to Coromant EH adaptor



				Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX	
30	E12	1	1	EH-BB30-12-044	M12	11.6	44.0	15.4	46.0	80	15.00	0.41	25000	
	E16	1	1	EH-BB30-16-050	M12	15.4	50.0	22.0	46.0	80	30.00	0.43	25000	
	E20	1	1	EH-BB30-20-047	M12	19.2	47.0	19.4	46.0	80	50.00	0.43	25000	
	E25	1	1	EH-BB30-25-052	M12	24.1	52.0	25.1	46.0	80	65.00	0.46	25000	

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M1



N23



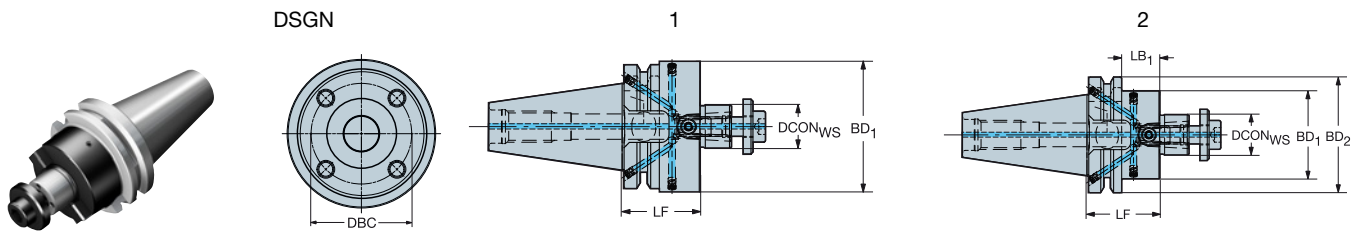
N15



N3

# BIG-PLUS MAS-BT to arbor adaptor

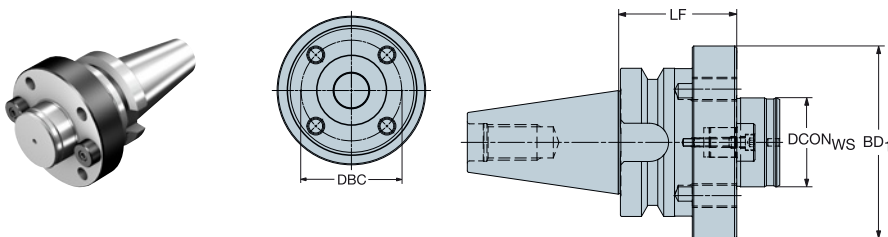
Machine side interface compatible with MAS-BT 403 and JIS B 6339



		Dimensions, mm															
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DBC	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
30	16	1	4	2	392.55505C3016040		M12	16.0	40.0	18.0	40.0	32.0	46.0	80	22.00	0.55	25000
	22	1	4	1	392.55505C3022040		M12	22.0	40.0	40.0		48.0		80	45.00	0.73	25000
	27	1	4	1	392.55505C3027040		M12	27.0	40.0	40.0		60.0		80	80.00	0.91	25000
	32	1	4	1	392.55505C3032045		M12	32.0	45.0	45.0		78.0		80	180.00	1.40	25000
40	16	7	4	2	392.55505C4016050		M16	16.0	50.0	23.0	50.0	32.0	63.0	80	22.00	1.18	18000
	22	7	4	2	392.55505C4022045		M16	22.0	45.0	18.0	45.0	48.0	63.0	80	45.00	1.32	18000
	27	7	4	2	392.55505C4027045		M16	27.0	45.0	18.0	45.0	60.0	63.0	80	80.00	1.50	18000
	32	7	4	1	392.55505C4032050		M16	32.0	50.0	50.0		78.0		80	180.00	2.01	18000
	40S	7	4	1	392.55505C4040055M	66.7	M16	40.0	55.0	55.0		87.0		80	300.00	2.58	18000
50	22	7	4	2	392.55805C5022055		M24	22.0	55.0	17.0	55.0	48.0	100.0	80	45.00	3.96	12000
	27	7	4	2	392.55805C5027055		M24	27.0	55.0	17.0	55.0	60.0	100.0	80	80.00	4.14	12000
	32	7	4	2	392.55805C5032055		M24	32.0	55.0	17.0	55.0	78.0	100.0	80	180.00	4.43	12000
	40S	7	4	2	392.55805C5040055	66.7	M24	40.0	55.0	17.0	55.0	87.0	100.0	80	300.00	4.69	12000

# BIG-PLUS MAS-BT to arbor adaptor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



		Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	Ordering code	DBC	CRKS	DCON <sub>WS</sub>	LF	BD <sub>1</sub>	NM	KG	RPMX		
50	60	392.55805-5060080	101.6	M24	60.0	80.0	130.0	180.00	8.82	12000		

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M1



N23

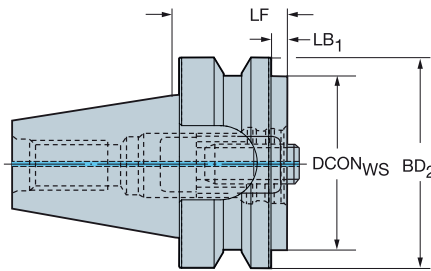


N15

## BIG-PLUS MAS-BT to VL adaptor

Machine side interface compatible with MAS-BT 403 and JIS B 6339

Coolant through centre



					Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG			
50	80	1	1	390.558-50 80 040	M24	80.0	40.0	2.0	100.0	80	180.00	3.50			

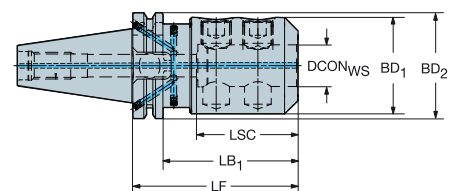
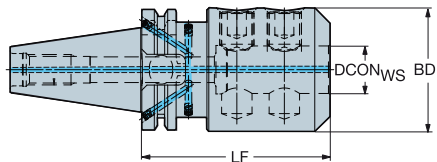
## BIG-PLUS MAS-BT to Weldon / ISO 9766 adaptor

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN

1

2



					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX		
30	16	1	1	1	392.55523-3016060	M12	16.0	60.0	60.0		48.0		20	20.00	0.86	25000		
	20	1	1	1	392.55523-3020065	M12	20.0	65.0	65.0		52.0		20	20.00	0.97	25000		
	25	1	1	1	392.55523-3025090	M12	25.0	90.0	90.0		65.0		20	65.00	1.80	25000		
	32	1	1	1	392.55523-3032095	M12	32.0	95.0	95.0		72.0		20	45.00	2.16	25000		
40	16	7	1	2	392.55523-4016065	M16	16.0	65.0	38.0	65.0	48.0	63.0	20	20.00	1.43	18000		
	20	7	1	2	392.55523-4020065	M16	20.0	65.0	38.0	65.0	52.0	63.0	20	20.00	1.49	18000		
	25	7	1	1	392.55523-4025090	M16	25.0	90.0	90.0		65.0		20	25.00	2.30	18000		
	32	7	1	1	392.55523-4032100	M16	32.0	100.0	100.0		72.0		20	45.00	2.80	18000		
	40	7	1	1	392.55523-4040110	M16	40.0	110.0	110.0		90.0		20	45.00	4.28	18000		
50	25	7	1	2	392.55823-5025100	M24	25.0	100.0	62.0	100.0	65.0	100.0	20	25.00	4.94	12000		
	32	7	1	2	392.55823-5032105	M24	32.0	105.0	67.0	105.0	72.0	100.0	20	45.00	5.26	12000		
	40	7	1	2	392.55823-5040115	M24	40.0	115.0	77.0	115.0	90.0	100.0	20	45.00	6.60	12000		
	50	7	1	1	392.55823-5050130	M24	50.0	130.0	100.0		100.0		20	60.00	7.81	12000		

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M1



N23



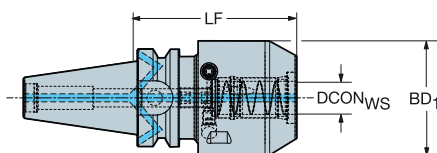
N15

# BIG-PLUS MAS-BT to CoroChuck™ 930

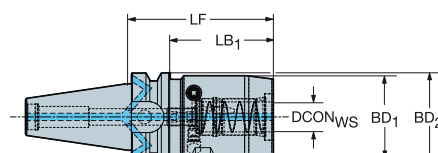
Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN

3



6

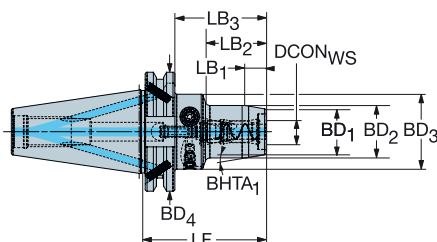


## Heavy Duty design

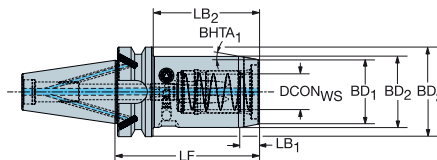
						Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX			
40	20	7	1	6	930-BB40-HD-20-088	M16	20.0	51	88.0	17.8	61.0	88.0	50.0	55.0	63.0	8°	80	10.00	1.95	18000			
	25	7	1	3	930-BB40-HD-25-094	M16	25.0	57	94.0	18.8	94.0		57.0	65.0		12°	80	10.00	2.40	18000			
50	20	7	1	6	930-BB50-HD-20-102	M24	20.0	51	102.0	17.8	64.0	102.0	50.0	55.0	100.0	8°	80	10.00	4.75	12000			
	25	7	1	6	930-BB50-HD-25-106	M24	25.0	57	106.0	18.8	68.0	106.0	57.0	65.0	100.0	12°	80	10.00	5.16	12000			
	32	7	1	6	930-BB50-HD-32-096	M24	32.0	61	96.0	18.8	58.0	96.0	68.0	76.0	100.0	12°	80	10.00	5.25	12000			

DSGN

10



6



## Slender design

						Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX	
30	6	1	1	6	930-BB30-S-06-048	M12	6.0	37	48.0	9.3	12.8	48.0		22.0	26.0	46.0		12°	80	8.00	0.56	25000	
	8	1	1	6	930-BB30-S-08-048	M12	8.0	37	48.0	9.3	12.8	48.0		24.0	28.0	46.0		12°	80	8.00	0.57	25000	
	10	1	1	6	930-BB30-S-10-048	M12	10.0	41	48.0	9.3	13.8	48.0		26.0	30.0	46.0		12°	80	8.00	0.56	25000	
	12	1	1	10	930-BB30-S-12-082	M12	12.0	46	82.0	11.3	38.2	60.0	82.0	28.0	32.0	40.0	46.0		10°	80	8.00	0.76	25000
	20	1	1	6	930-BB30-S-20-088	M12	20.0	51	88.0	16.0	66.0	88.0		38.0	42.0	46.0		7°	80	8.00	0.94	25000	
40	6	7	1	10	930-BB40-S-06-075	M16	6.0	37	75.0	11.3	30.2	48.0	75.0	22.0	26.0	40.0	63.0	10°	80	8.00	1.23	18000	
	8	7	1	10	930-BB40-S-08-075	M16	8.0	37	75.0	11.3	30.2	48.0	75.0	24.0	28.0	40.0	63.0	10°	80	8.00	1.25	18000	
	10	7	1	10	930-BB40-S-10-080	M16	10.0	41	80.0	11.3	34.2	53.0	80.0	26.0	30.0	40.0	63.0	10°	80	8.00	1.29	18000	
	12	7	1	10	930-BB40-S-12-085	M16	12.0	46	85.0	11.3	40.0	58.0	85.0	26.0	32.0	50.0	63.0	10°	80	8.00	1.40	18000	
	20	7	1	10	930-BB40-S-20-094	M16	20.0	51	94.0	16.0	49.2	67.0	94.0	37.9	42.0	50.0	63.0	7°	80	8.00	1.62	18000	
50	25	7	1	6	930-BB40-S-25-102	M16	25.0	57	102.0	12.9	74.0	102.0		45.0	50.0	63.0		11°	80	10.00	1.87	18000	
	20	7	1	10	930-BB50-S-20-108	M24	20.0	51	108.0	16.0	49.2	70.0	108.0	37.9	42.0	50.0	100.0	7°	80	8.00	4.41	12000	
	25	7	1	6	930-BB50-S-25-114	M24	25.0	57	114.0	12.9	73.5	114.0		45.0	50.0	100.0		11°	80	10.00	4.62	12000	

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M1



N23



N15



N4



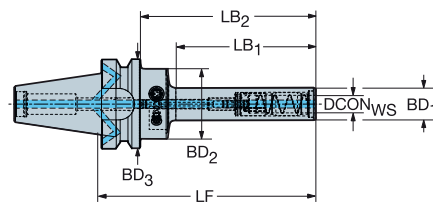
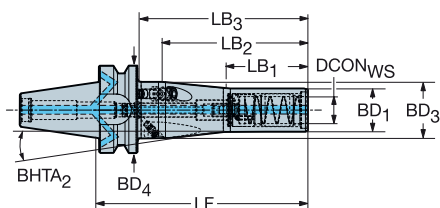
# BIG-PLUS MAS-BT to CoroChuck™ 930

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN

11

5

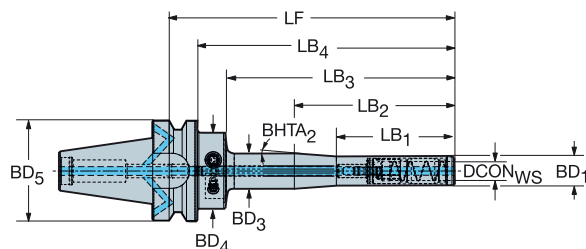


## Pencil design

					Dimensions, mm																		
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX	
30	6	1	1	5	930-BB30-P-06-088	M12	6.0	37	88.0	50.0	66.0	88.0		14.5	40.0	46.0		0°	80	8.00	0.62	25000	
	8	1	1	5	930-BB30-P-08-088	M12	8.0	37	88.0	45.8	66.0	88.0		17.5	40.0	46.0		0°	80	8.00	0.60	25000	
	10	1	1	5	930-BB30-P-10-098	M12	10.0	41	98.0	55.8	76.0	98.0		20.0	40.0	46.0		0°	80	8.00	0.64	25000	
	10	1	1	5	930-BB30-P-10-138	M12	10.0	41	138.0	95.8	116.0	138.0		20.0	40.0	46.0		0°	80	8.00	0.74	25000	
	12	1	1	5	930-BB30-P-12-103	M12	12.0	46	103.0	65.0	81.0	103.0		22.0	40.0	46.0		0°	80	8.00	0.71	25000	
40	12	1	1	5	930-BB30-P-12-138	M12	12.0	46	138.0	100.0	116.0	138.0		22.0	40.0	46.0		0°	80	8.00	0.80	25000	
	8	7	1	5	930-BB40-P-08-095	M16	8.0	37	95.0	45.8	65.5	95.0		17.5	40.0	63.0		0°	80	8.00	1.21	18000	
	10	7	1	5	930-BB40-P-10-105	M16	10.0	41	105.0	55.8	75.5	105.0		20.0	40.0	63.0		0°	80	8.00	1.25	18000	
	10	7	1	5	930-BB40-P-10-145	M16	10.0	41	145.0	95.8	115.5	145.0		20.0	40.0	63.0		0°	80	8.00	1.35	18000	
	12	7	1	5	930-BB40-P-12-110	M16	12.0	46	110.0	65.0	83.0	110.0		22.0	40.0	63.0		0°	80	8.00	1.33	18000	
	12	7	1	5	930-BB40-P-12-145	M16	12.0	46	145.0	100.0	118.0	145.0		22.0	40.0	63.0		0°	80	8.00	1.47	18000	
	20	7	1	11	930-BB40-P-20-153	M16	20.0	51	153.0	60.0	108.0	126.0	153.0		32.0	32.0	42.0	63.0	5°	80	8.00	1.85	18000

DSGN

17



					Dimensions, mm																		
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BD <sub>5</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX	
30	12	1	1	17	930-BB30-P-12-188	M12	12.0	46	188.0	50.0	75.0	150.0	166.0	22.0	26.0	40.0	46	4°	80	8.00	1.08	25000	
40	12	7	1	17	930-BB40-P-12-195	M16	12.0	46	195.0	50.0	75.0	150.0	168.0	22.0	26.0	40.0	63	4°	80	8.00	1.68	18000	

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M1



N23



N15

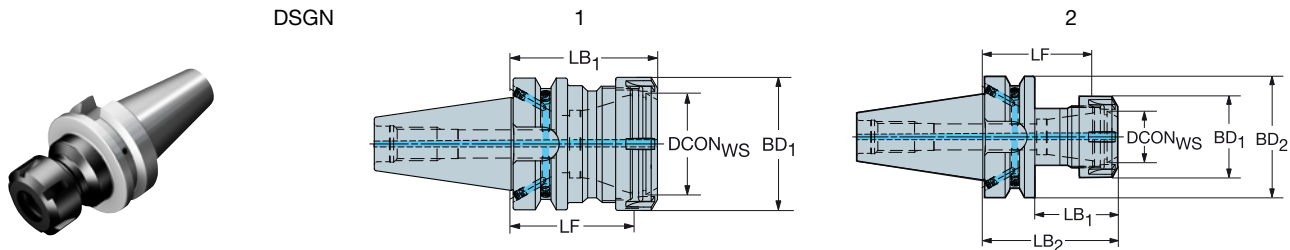


N4



# BIG-PLUS MAS-BT to ER collet chuck

Machine side interface compatible with MAS-BT 403 and JIS B 6339



## Workpiece side interface DIN 6499-B

					Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">BAR</span>	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">KG</span>	RPMX
30	ER11	1	1	2	392.55514-3011050	M12	11.4	43.4	28.0	50.0	18.7	46.0	80	0.45	25000
	ER16	1	1	2	392.55514-3016050	M12	17.0	39.4	28.0	50.0	28.0	46.0	80	0.47	25000
	ER20	1	1	2	392.55514-3020052	M12	21.0	40.5	30.0	52.0	33.7	46.0	80	0.49	25000
	ER25	1	1	2	392.55514-3025060	M12	26.0	48.0	38.0	60.0	42.0	46.0	80	0.60	25000
	ER32	1	1	1	392.55514-3032060	M12	33.0	47.0	60.0		50.0		80	0.64	25000
40	ER25	7	1	2	392.55514-4025070	M16	26.0	58.0	43.0	70.0	42.0	63.0	80	1.24	18000
	ER40	7	1	1	392.55514-4040070	M16	41.0	55.0	70.0		63.0		80	1.39	18000

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M1



N23



N15

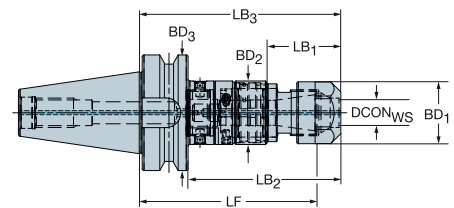
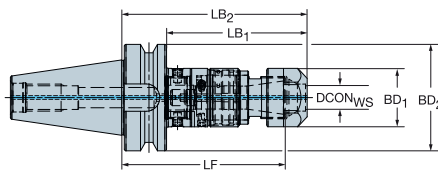
# BIG-PLUS MAS-BT to CoroChuck™ 970

Workpiece side interface DIN 6499-B

DSGN

2

5



							Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BAR	KG	RPMX
30	ER11	M5	1	1	5	970-BB30-11-082	M12	11.3	78.2	24.1	60.0	82.0	18.7	23.5	46.0	80	0.52	8000
	ER20	M12	1	1	5	970-BB30-20-105	M12	20.8	92.2	40.3	83.1	105.2	33.7	35.0	46.0	80	0.84	8000
	ER25	M20	1	1	5	970-BB30-25-125	M12	25.8	111.1	42.1	102.6	124.6	42.0	44.0	46.0	80	1.20	8000
40	ER20	M12	7	1	5	970-BB40-20-110	M16	20.8	97.2	40.3	83.1	110.2	33.7	35.0	63.0	80	1.43	8000
	ER25	M20	7	1	5	970-BB40-25-130	M16	25.8	116.1	42.1	102.6	129.6	42.0	44.0	63.0	80	1.79	8000
50	ER20	M12	7	1	5	970-BB50-20-125	M24	20.8	112.2	40.3	87.1	125.2	33.7	35.0	100.0	80	4.11	8000
	ER25	M20	7	1	5	970-BB50-25-145	M24	25.8	131.1	42.1	106.6	144.6	42.0	44.0	100.0	80	4.50	8000
	ER40	M30	7	1	2	970-BB50-40-174	M24	40.8	157.2	136.0	174.0		63.0	100.0	80	5.66	8000	

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M1



N23

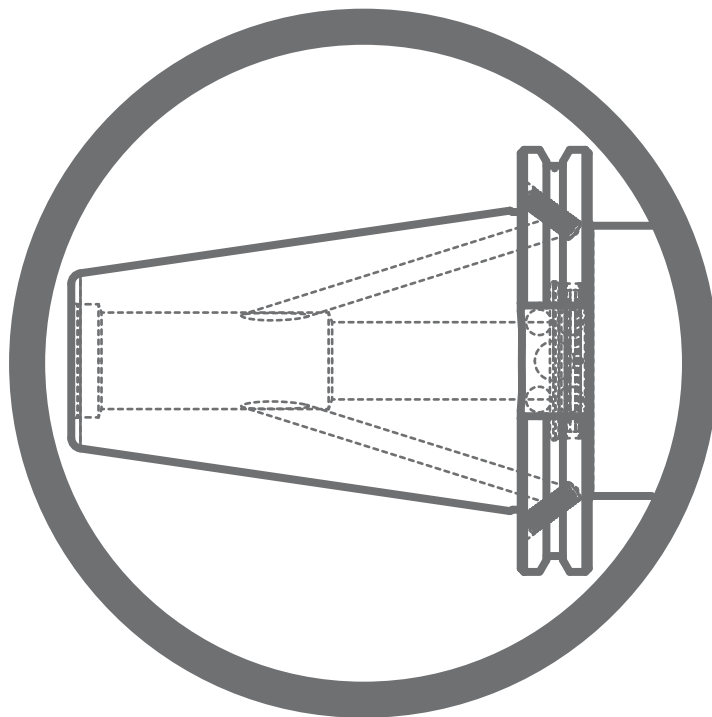


N15



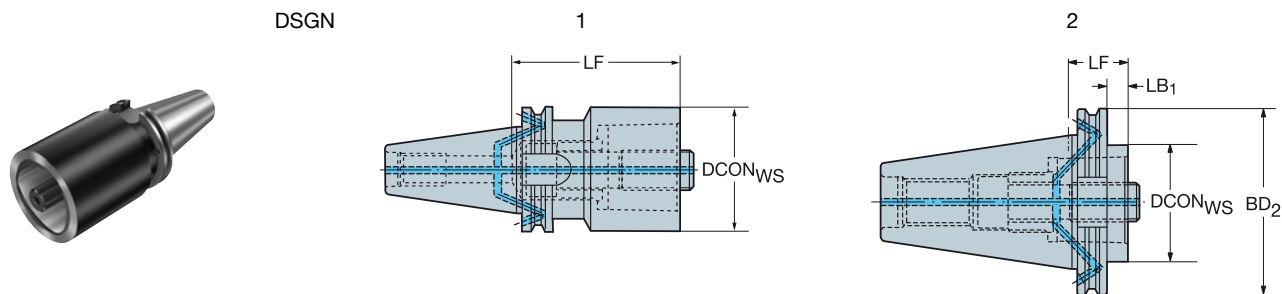
N5

# Machine side interface ISO 7388-1



# ISO 7388-1 to Coromant Capto® adaptor

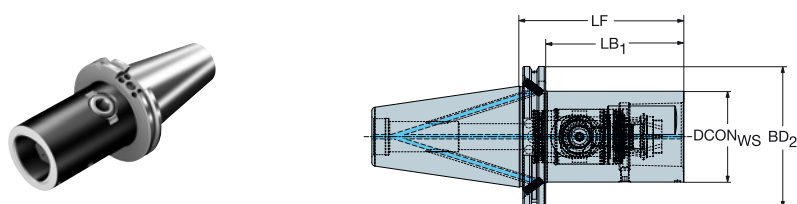
Machine side interface compatible with DIN 69871-ADB



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>2</sub>	BAR	NM	KG
40	C3	7	1	2	C3-390B.140-40 030	M16	32.0	30.0	10.9	30.0	63.5	80	45.00	0.87
	C3	7	1	2	C3-390B.140-40 060	M16	32.0	60.0	40.9	60.0	63.5	80	45.00	1.02
	C4	7	1	2	C4-390B.140-40 030	M16	40.0	30.0	10.9	30.0	63.5	80	55.00	0.86
	C4	7	1	2	C4-390B.140-40 060	M16	40.0	60.0	40.9	60.0	63.5	80	55.00	1.12
	C5	7	1	2	C5-390B.140-40 040	M16	50.0	40.0	20.9	40.0	63.5	80	95.00	0.96
	C5	7	1	2	C5-390B.140-40 080	M16	50.0	80.0	60.9	80.0	63.5	80	95.00	1.52
	C6	7	1	2	C6-390B.140-40 085	M16	63.0	85.0	65.9	85.0	63.5	80	170.00	1.84
50	C3	7	1	2	C3-390B.140-50 030	M24	32.0	30.0	10.9	30.0	97.5	80	45.00	2.73
	C3	7	1	2	C3-390B.140-50 060	M24	32.0	60.0	40.9	60.0	97.5	80	45.00	2.86
	C4	7	1	2	C4-390B.140-50 030	M24	40.0	30.0	10.9	30.0	97.5	80	55.00	2.74
	C4	7	1	2	C4-390B.140-50 060	M24	40.0	60.0	40.9	60.0	97.5	80	55.00	2.96
	C5	7	1	2	C5-390B.140-50 030	M24	50.0	30.0	10.9	30.0	97.5	80	95.00	2.70
	C5	7	1	2	C5-390B.140-50 070	M24	50.0	70.0	50.9	70.0	97.5	80	95.00	3.21
	C6	7	1	2	C6-390B.140-50 030	M24	63.0	30.0	10.9	30.0	97.5	80	170.00	2.62
	C6	7	1	2	C6-390B.140-50 080	M24	63.0	80.0	60.9	80.0	97.5	80	170.00	3.71
	C8	7	1	2	C8-390B.140-50 070	M24	80.0	70.0	50.9	70.0	97.5	80	170.00	3.83
	C8	7	1	2	C8-390B.140-50 120	M24	80.0	120.0	100.9	120.0	97.5	80	170.00	5.69
	C10	7	1	1	C10-390B.140-50 140	M24	100.0	140.0	140.0			80	380.00	7.66
60	C8	1	1	2	C8-390.140-60 120	M30	80.0	120.0	100.9	120.0	155.0	80	170.00	12.57
	C10	1	1	2	C10-390.140-60 050	M30	100.0	50.0	30.9	50.0	155.0	80	380.00	9.35

# ISO 7388-1 to Coromant Capto® adaptor with Quick change

Machine side interface compatible with DIN 69871-ADB



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG		
50	C5	7	1	I50-QC-C5-095	M24	50.0	95.0	75.0	97.4	80	70.00	3.54		
	C6	7	1	I50-QC-C6-115	M24	63.0	115.0	95.0	97.4	80	90.00	4.43		
	C8	7	1	I50-QC-C8-135	M24	80.0	135.0	115.0	97.4	80	130.00	6.06		

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



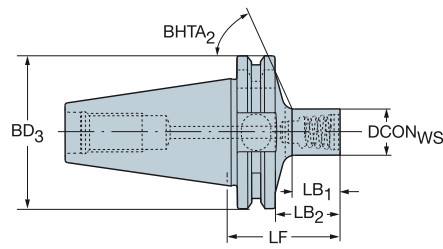
N23



N15

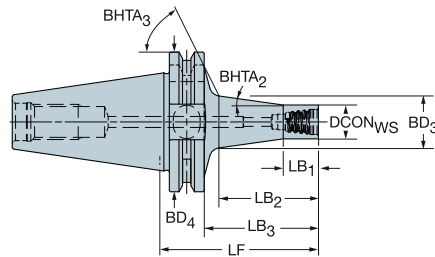
# ISO 7388-1 to Coromant EH adaptor

Machine side interface compatible with DIN 69871-AD



## Short design

					Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
40	E10	1	1	392.140EH-40 10 041	M16	9.6	41.0	12.7	21.9	63.5	65°	80	12.00	0.96	18000
	E12	1	1	392.140EH-40 12 044	M16	11.6	44.0	16.0	24.9	63.5	65°	80	15.00	0.97	18000
	E16	1	1	392.140EH-40 16 049	M16	15.4	49.0	21.5	29.9	63.5	65°	80	30.00	1.03	18000
	E20	1	1	392.140EH-40 20 046	M16	19.2	46.0	19.0	27.0	63.5	63°	80	50.00	1.05	18000
	E25	1	1	392.140EH-40 25 051	M16	24.1	51.0	24.6	31.9	63.5	61°	80	65.00	1.09	18000



## Long design

					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>2</sub>	BHTA <sub>3</sub>	BAR	NM	KG	RPMX
40	E10	1	1	392.140EH-40 10 055	M16	9.6	55.0	10.0	28.1	35.9	14.7	63.5	8°	65°	80	12.00	0.97	18000
	E12	1	1	392.140EH-40 12 060	M16	11.6	60.0	12.0	33.5	40.9	17.6	63.5	8°	65°	80	15.00	1.00	18000
	E16	1	1	392.140EH-40 16 071	M16	15.4	71.0	16.0	45.3	51.9	23.6	63.5	8°	63°	80	30.00	1.09	18000
	E20	1	1	392.140EH-40 20 084	M16	19.2	84.0	20.0	59.1	64.9	30.2	63.5	8°	61°	80	50.00	1.19	18000
	E25	1	1	392.140EH-40 25 100	M16	24.1	100.0	25.0	76.2	80.9	38.5	63.5	8°	51°	80	65.00	1.40	18000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



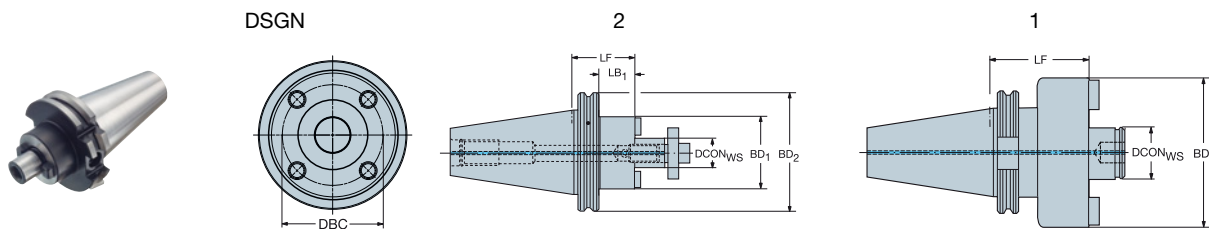
N15



N3

# ISO 7388-1 to arbor adaptor

Machine side interface compatible with DIN 69871-ADB



					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DBC	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX	
40	16	7	1	2	A1B05-40 16 035	M16	16.0	35.0	15.9	35.0	36.0	63.5	80	22.00	1.04	18000		
	16	7	1	2	A1B05-40 16 100	M16	16.0	100.0	78.9	100.0	36.0	63.5	80	22.00	1.47	18000		
	22	7	1	2	A1B05-40 22 035	M16	22.0	35.0	13.9	35.0	48.0	63.5	80	45.00	1.15	18000		
	22	7	1	2	A1B05-40 22 100	M16	22.0	100.0	78.9	100.0	48.0	63.5	80	45.00	2.02	18000		
	27	7	1	2	A1B05-40 27 035	M16	27.0	35.0	15.0	35.0	48.0	63.5	80	80.00	1.08	18000		
	27	7	1	2	A1B05-40 27 100	M16	27.0	100.0	80.9	100.0	60.0	63.5	80	80.00	2.59	18000		
50	32	7	1	1	A1B05-40 32 050	M16	32.0	50.0	50.0			78.0		80	180.00	1.82	18000	
	22	7	1	2	A1B05-50 22 035	M24	22.0	35.0	15.9	35.0	48.0	97.5	80	45.00	3.00	12000		
	22	7	1	2	A1B05-50 22 100	M24	22.0	100.0	77.9	100.0	48.0	97.5	80	45.00	4.03	12000		
	27	7	1	2	A1B05-50 27 035	M24	27.0	35.0	12.9	35.0	60.0	97.5	80	80.00	3.26	12000		
	27	7	1	2	A1B05-50 27 100	M24	27.0	100.0	77.9	100.0	60.0	97.5	80	80.00	4.68	12000		
	32	7	1	2	A1B05-50 32 035	M24	32.0	35.0	12.9	35.0	78.0	97.5	80	180.00	3.54	12000		
	32	7	1	2	A1B05-50 32 100	M24	32.0	100.0	77.9	100.0	78.0	97.5	80	180.00	5.78	12000		
	40S	7	1	2	A1B05-50 40 050	66.7	M24	40.0	50.0	30.9	50.0	89.0	97.5	80	300.00	4.48	12000	
	60	7	1	1	A1F05-50 60 070	101.6	M24	60.0	70.0	70.0			127.0		80	180.00	7.76	

All holders are delivered with a standard screw without hole for coolant.

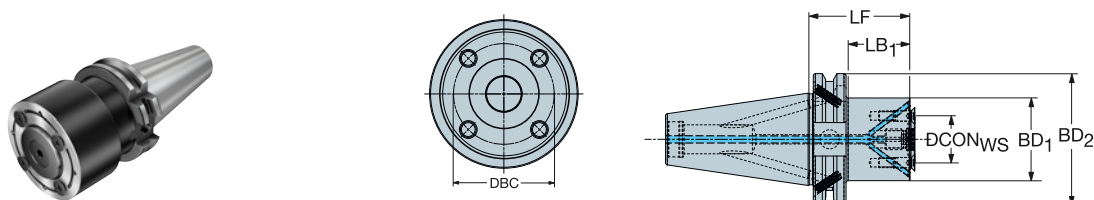
For cutters with coolant channels a new screw with radial coolant holes is necessary and can be ordered separately.

See page M13

# ISO 7388-1 to arbor with driving screws adaptor

Machine side interface compatible with DIN 69871-ADB

For CoroMill® QD with internal coolant supply



					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DBC	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX	
40	X10	7	3	I40-X10-032-045	22.0	M16	10.0	2	45.0	24.5	32.0	63.5	80	6.40	1.00	12000	
	X22	7	3	I40-X22-040-050	32.0	M16	22.0	2	50.0	29.5	40.0	63.5	80	3.90	1.14	11000	
	X32	7	3	I40-X32-063-070	45.0	M16	32.0	2	70.0	50.5	63.0	63.5	80	6.40	1.89	10000	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



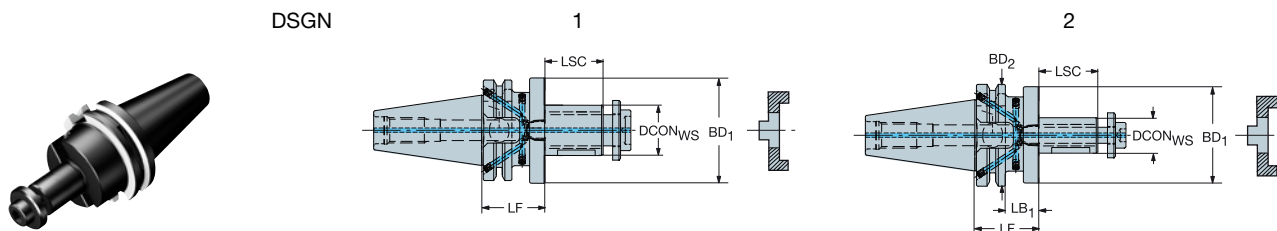
N23



N15

# ISO 7388-1 to side and face mill arbor adaptor

Machine side interface compatible with DIN 69871-ADB



					Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG
40	22	7	1	2	A1B08-40 22 055	M16	22.0	31	43.0	19.9	43.0	40.0	63.5	80	45.00	1.26
	27	7	1	2	A1B08-40 27 055	M16	27.0	33	43.0	22.9	43.0	48.0	63.5	80	80.00	1.45
	32	7	1	2	A1B08-40 32 060	M16	32.0	37	46.0	26.9	46.0	58.0	63.5	80	180.00	1.76
	40	7	1	1	A1B08-40 40 060	M16	40.0	41	46.0	60.0		70.0	80	300.00	2.38	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



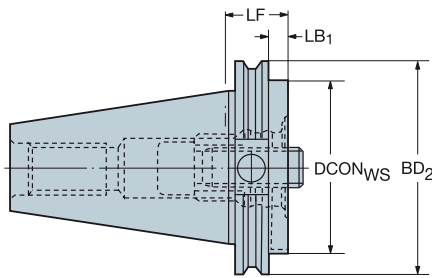
N23



N15

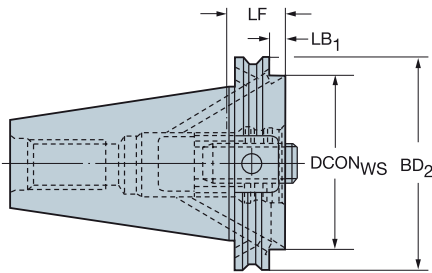


## ISO 7388-1 to VL adaptor



## Machine side interface compatible with DIN 69871-AD

					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>VS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG
50	80	1	1	390.140-50 80 027	M24	80.0	27.0	7.9	97.5	20	180.00	2.88



## Machine side interface compatible with DIN 69871-B

					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>VS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG
50	80	6	1	390.272-50 80 027	M24	80.0	27.0	7.9	97.5	20	180.00	2.86

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N15

# ISO 7388-1 to Weldon adaptor

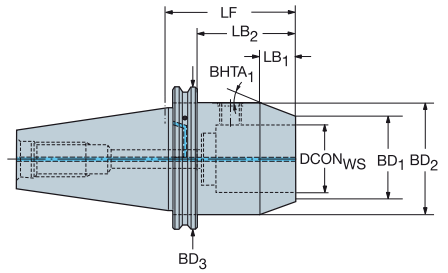
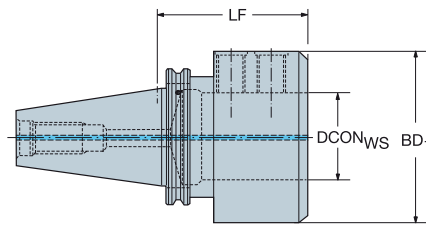
Machine side interface compatible with DIN 69871-ADB

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN

3

6



						Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	
40	6	7	1	6	A1B20-40 06 050	M16	6.0	50.0	11.0	28.9	50.0	12.3	25.0	63.5	30°	20	3.00	0.91	
	6	7	1	6	A1B20-40 06 100	M16	6.0	100.0	11.0	78.9	100.0	12.3	25.0	63.5	30°	20	3.00	1.06	
	8	7	1	6	A1B20-40 08 050	M16	8.0	50.0	11.0	28.9	50.0	15.3	28.0	63.5	30°	20	7.00	0.82	
	8	7	1	6	A1B20-40 08 100	M16	8.0	100.0	11.0	78.9	100.0	15.3	28.0	63.5	30°	20	7.00	1.14	
	10	7	1	6	A1B20-40 10 050	M16	10.0	50.0	13.0	28.9	50.0	20.0	35.0	63.5	30°	20	10.00	0.92	
	10	7	1	6	A1B20-40 10 100	M16	10.0	100.0	13.0	78.9	100.0	20.0	35.0	63.5	30°	20	10.00	1.34	
	12	7	1	6	A1B20-40 12 050	M16	12.0	50.0	13.0	28.9	50.0	27.0	42.0	63.5	30°	20	12.00	1.07	
	12	7	1	6	A1B20-40 12 100	M16	12.0	100.0	13.0	78.9	100.0	27.0	42.0	63.5	30°	20	12.00	1.57	
	16	7	1	6	A1B20-40 16 063	M16	16.0	63.0	13.0	41.9	63.0	33.0	48.0	63.5	30°	20	15.00	1.30	
	16	7	1	6	A1B20-40 16 100	M16	16.0	100.0	13.0	78.9	100.0	33.0	48.0	63.5	30°	20	15.00	1.79	
	20	7	1	6	A1B20-40 20 063	M16	20.0	63.0	13.0	41.9	63.0	37.0	52.0	63.5	30°	20	20.00	1.26	
	20	7	1	6	A1B20-40 20 100	M16	20.0	100.0	13.0	78.9	100.0	37.0	52.0	63.5	30°	20	20.00	1.89	
	25	7	1	3	A1B20-40 25 100	M16	25.0	100.0	13.0	100.0		50.0	65.0		30°	20	25.00	2.24	
32	7	1	3	A1B20-40 32 100	M16	32.0	100.0	12.0	100.0		58.1	72.0		30°	20	45.00	2.54		
50	12	7	1	6	A1B20-50 12 063	M24	12.0	63.0	13.0	40.9	63.0	27.0	42.0	97.4	30°	20	12.00	3.00	
	16	7	1	6	A1B20-50 16 063	M24	16.0	63.0	13.0	40.9	63.0	33.0	48.0	97.4	30°	20	15.00	3.20	
	20	7	1	6	A1B20-50 20 063	M24	20.0	63.0	13.0	40.9	63.0	37.0	52.0	97.4	30°	20	20.00	3.26	
	20	7	1	6	A1B20-50 20 100	M24	20.0	100.0	13.0	77.9	100.0	37.0	52.0	97.4	30°	20	20.00	3.87	
	25	7	1	6	A1B20-50 25 080	M24	25.0	80.0	13.0	57.9	80.0	50.0	65.0	97.4	30°	20	25.00	3.92	
	25	7	1	6	A1B20-50 25 100	M24	25.0	100.0	13.0	77.9	100.0	50.0	65.0	97.4	30°	20	25.00	4.45	
	32	7	1	6	A1B20-50 32 100	M24	32.0	100.0	12.0	77.9	100.0	58.1	72.0	97.4	30°	20	45.00	4.60	
	32	7	1	6	A1B20-50 32 160	M24	32.0	160.0	12.0	137.9	160.0	58.1	72.0	97.4	30°	20	45.00	6.60	
40	7	1	6	A1B20-50 40 120	M24	40.0	120.0	15.0	97.9	120.0	60.7	78.0	97.4	30°	20	45.00	5.50		

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



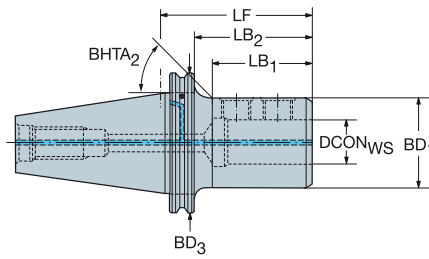
N23



N15

# ISO 7388-1 to ISO 9766 adaptor

Machine side interface compatible with DIN 69871-ADB



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG
40	16	7	1	A1B27-40 16 080	M16	16.0	49	80.0	55.9	36.0	63.5	20	10.00	1.21
	20	7	1	A1B27-40 20 080	M16	20.0	51	80.0	55.9	40.0	63.5	20	12.00	1.27
	25	7	1	A1B27-40 25 085	M16	25.0	57	85.0	64.9	45.0	63.5	20	20.00	1.38
	32	7	1	A1B27-40 32 090	M16	32.0	61	90.0	69.9	52.0	63.5	20	30.00	1.50
50	16	7	1	A1B27-50 16 080	M24	16.0	49	80.0	59.9	36.0	97.5	20	10.00	3.16
	20	7	1	A1B27-50 20 080	M24	20.0	51	80.0	59.9	40.0	97.5	20	12.00	3.20
	25	7	1	A1B27-50 25 085	M24	25.0	57	85.0	64.9	45.0	97.5	20	20.00	3.36
	32	7	1	A1B27-50 32 090	M24	32.0	61	90.0	69.9	52.0	97.5	20	30.00	3.52
	40	7	1	A1B27-50 40 090	M24	40.0	71	90.0	69.9	75.0	97.5	20	40.00	4.40
	50	7	1	A1B27-50 50 100	M24	50.0	81	100.0	79.9	75.0	97.5	20	45.00	4.22

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



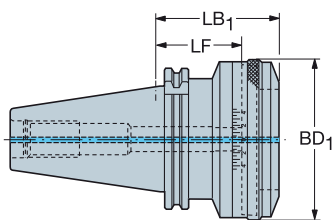
N23



N15

# ISO 7388-1 to ISO 9766 adjustable adaptor

Machine side interface compatible with DIN 69871-AD



				Dimensions, mm								
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>1</sub>	BAR	KG	RPMX
40	1	1	1	392.140277-40 01 055A	M16	78.0	55.0	79.6	86.0	20	2.26	12000
50	2	1	1	392.140277-50 02 055A	M24	98.0	55.0	79.6	106.0	20	5.16	9000
	3	1	1	392.140277-50 03 075A	M24	136.0	75.0	85.0	140.0	20	7.03	6000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



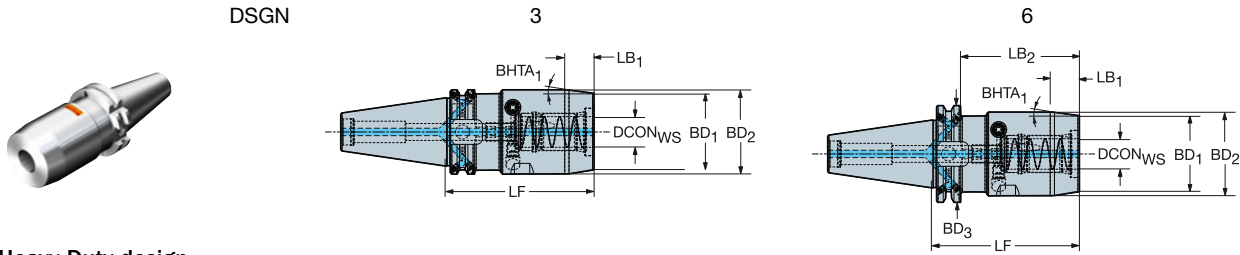
M1



N23

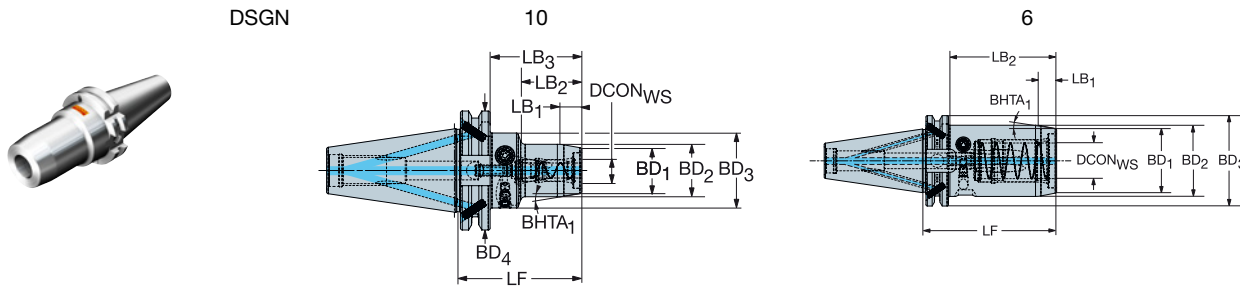
# ISO 7388-1 to CoroChuck™ 930

Machine side interface compatible with DIN 69871-ADB



## Heavy Duty design

						Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX			
40	20	7	1	6	930-140-HD-20-097	M16	20.0	51	97.0	17.8	77.9	97.0	50.0	55.0	63.5	8°	80	10.00	2.03	18000			
	25	7	1	3	930-140-HD-25-103	M16	25.0	57	103.0	18.8	103.0		57.0	65.0		12°	80	10.00	2.48	18000			
50	20	7	1	6	930-150-HD-20-083	M24	20.0	51	83.0	17.8	63.9	83.0	50.0	55.0	97.4	8°	80	10.00	3.68	12000			
	25	7	1	6	930-150-HD-25-087	M24	25.0	57	87.0	18.8	67.9	87.0	57.0	65.0	97.4	12°	80	10.00	4.13	12000			
	32	7	1	6	930-150-HD-32-077	M24	32.0	61	77.0	18.8	57.9	77.0	68.0	76.0	97.4	12°	80	10.00	4.24	12000			
	32	7	1	6	930-150-HD-32-170	M24	32.0	61	170.0	18.8	150.9	170.0	68.0	76.0	97.4	12°	80	10.00	7.43	12000			



## Slender design

						Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>1</sub>	BHTA <sub>3</sub>	BAR	NM	KG	RPMX	
40	6	7	1	10	930-140-S-06-068	M16	6.0	37	68.0	11.3	30.2	48.9	22.0	26.0	40.0	63.5	10°	0°	80	8.00	1.06	18000	
	8	7	1	10	930-140-S-08-068	M16	8.0	37	68.0	11.3	30.2	48.9	24.0	28.0	40.0	63.5	10°	0°	80	8.00	1.07	18000	
	10	7	1	10	930-140-S-10-072	M16	10.0	41	72.0	11.3	34.2	52.9	26.0	30.0	40.0	63.5	10°	0°	80	8.00	1.11	18000	
	12	7	1	10	930-140-S-12-080	M16	12.0	46	80.0	11.3	38.2	60.9	28.0	32.0	50.0	63.5	10°	0°	80	8.00	1.32	18000	
	20	7	1	10	930-140-S-20-090	M16	20.0	51	90.0	16.0	49.2	70.9	38.0	42.0	50.0	63.5	7°	0°	80	8.00	1.50	18000	
	25	7	1	6	930-140-S-25-095	M16	25.0	57	95.0	12.9	75.0	76.0	45.0	50.0	50.0	63.5	11°	82°	80	8.00	1.71	18000	
50	20	7	1	10	930-150-S-20-089	M24	20.0	51	89.0	16.0	49.2	69.9	38.0	42.0	50.0	97.4	7°	0°	80	8.00	3.34	12000	
	25	7	1	6	930-150-S-25-095	M24	25.0	57	95.0	12.9	73.5	76.0	45.0	50.0	50.0	97.4	11°	84°	80	8.00	3.57	12000	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

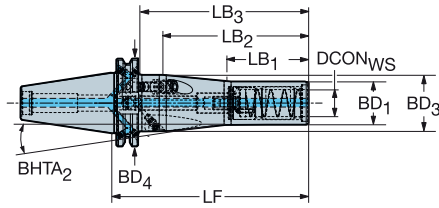


# ISO 7388-1 to CoroChuck™ 930

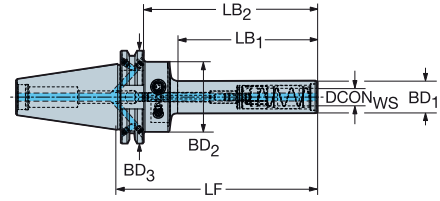
Machine side interface compatible with DIN 69871-ADB

DSGN

11



5



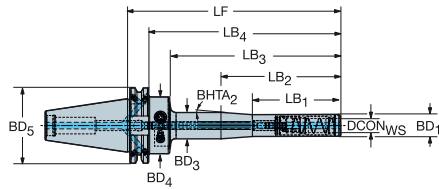
Pencil design

Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
40	8	7	1	5	930-140-P-08-088	M16	8.0	37	88.0	45.8	66.5	88.0		17.5	40.0	63.5		0°	80	8.00	1.04	18000
	10	7	1	5	930-140-P-10-098	M16	10.0	41	98.0	55.8	76.5	98.0		20.0	40.0	63.5		0°	80	8.00	1.09	18000
	10	7	1	5	930-140-P-10-138	M16	10.0	41	138.0	95.8	116.5	138.0		20.0	40.0	63.5		0°	80	8.00	1.18	18000
	12	7	1	5	930-140-P-12-103	M16	12.0	46	103.0	60.8	83.9	103.0		22.0	40.0	63.5		0°	80	8.00	1.17	18000
	12	7	1	5	930-140-P-12-138	M16	12.0	46	138.0	95.8	118.9	138.0		22.0	40.0	63.5		0°	80	8.00	1.27	18000
	20	7	1	11	930-140-P-20-145	M16	20.0	51	145.0	60.0	108.0	125.9	145.0	32.0	32.0	42.0	63.5	6°	80	8.00	1.68	18000

DSGN

17



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BD <sub>5</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
40	12	7	1	17	930-140-P-12-188	M16	12.0	46	188.0	50.0	75.0	145.8	168.9	22.0	26.0	40.0	63	4°	80	8.00	1.57	18000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N6



N15

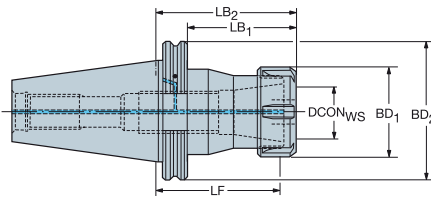


N4

# ISO 7388-1 to ER collet chuck

Machine side interface compatible with DIN 69871-ADB

Workpiece side interface DIN 6499-B



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	KG	RPMX
40	ER16	7	1	A1B14-40 16 070	M16	17.0	59.7	50.9	70.0	28.0	63.5	80	0.97	18000
				A1B14-40 16 100	M16	17.0	89.7	80.9	100.0	28.0	63.5	80	1.12	18000
	ER20	7	1	A1B14-40 20 070	M16	21.0	58.8	50.9	70.0	34.0	63.5	80	1.02	18000
				A1B14-40 20 100	M16	21.0	88.8	80.9	100.0	34.0	63.5	80	1.25	18000
	ER25	7	1	A1B14-40 25 070	M16	26.0	58.3	50.9	70.0	42.0	63.5	80	1.13	18000
				A1B14-40 25 100	M16	26.0	88.3	80.9	100.0	42.0	63.5	80	1.44	18000
	ER32	7	1	A1B14-40 32 070	M16	33.0	57.3	50.9	70.0	50.0	63.5	80	1.18	18000
				A1B14-40 40 070	M16	41.0	55.3	50.9	70.0	63.0	63.5	80	1.25	18000
50	ER20	7	1	A1B14-50 20 070	M24	21.0	58.8	50.9	70.0	34.0	97.5	80	2.96	12000
				A1B14-50 20 100	M24	21.0	88.8	80.9	100.0	34.0	97.5	80	3.23	12000
	ER25	7	1	A1B14-50 25 070	M24	26.0	58.3	50.9	70.0	42.0	97.5	80	3.02	12000
				A1B14-50 25 100	M24	26.0	88.3	80.9	100.0	42.0	97.5	80	3.45	12000
	ER32	7	1	A1B14-50 32 070	M24	33.0	57.3	50.9	70.0	50.0	97.5	80	3.08	12000
				A1B14-50 32 100	M24	33.0	87.3	80.9	100.0	50.0	97.5	80	3.58	12000
	ER40	7	1	A1B14-50 40 070	M24	41.0	55.3	50.9	70.0	63.0	97.5	80	3.20	12000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N15

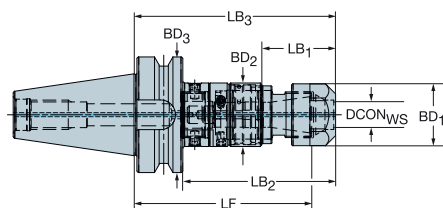
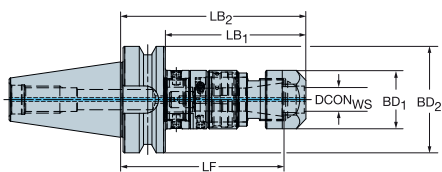
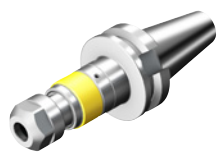
# ISO 7388-1 to CoroChuck™ 970

Workpiece side interface DIN 6499-B

DSGN

2

5



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BAR	KG	RPMX
40	ER20	M12	1	1	5	970-I40-20-102	M16	20.8	89.2	35.3	78.1	97.2	33.7	35.0	63.5	80	1.26	8000
	ER25	M20	1	1	5	970-I40-25-122	M16	25.8	108.1	37.1	97.5	116.6	42.0	44.0	63.5	80	1.63	8000
	ER32	M27	1	1	2	970-I40-32-125	M16	32.8	115.8	106.2	125.3		50.0	63.5		80	1.58	8000
50	ER20	M12	1	1	5	970-I50-20-106	M24	20.8	93.2	35.3	82.1	101.2	33.7	35.0	97.5	80	3.12	8000
	ER25	M20	1	1	5	970-I50-25-126	M24	25.8	112.1	37.1	101.5	120.6	42.0	44.0	97.5	80	3.75	8000
	ER32	M27	1	1	2	970-I50-32-129	M24	32.8	119.8	110.2	129.3		50.0	97.5		80	3.36	8000
	ER40	M30	1	1	2	970-I50-40-155	M24	40.8	138.2	130.6	149.6		63.0	97.5		80	4.94	8000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



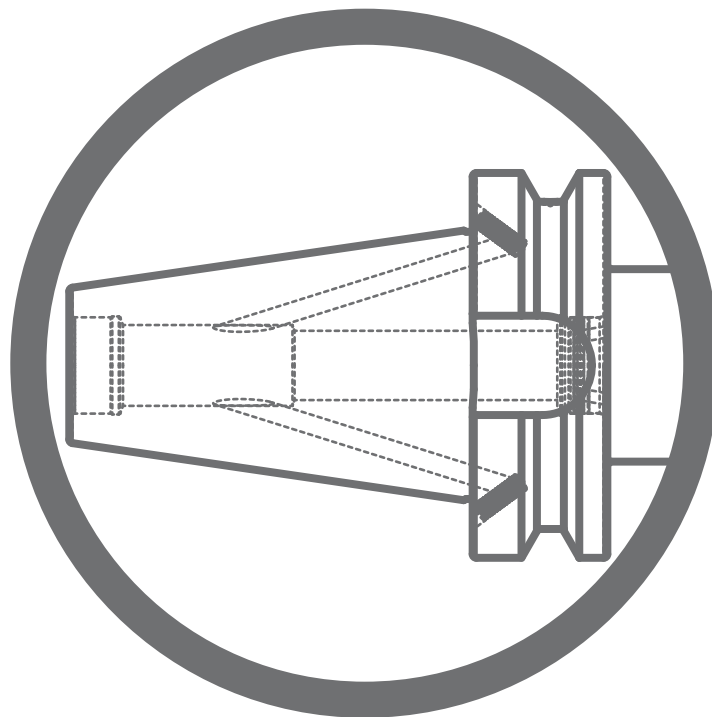
N15



N5

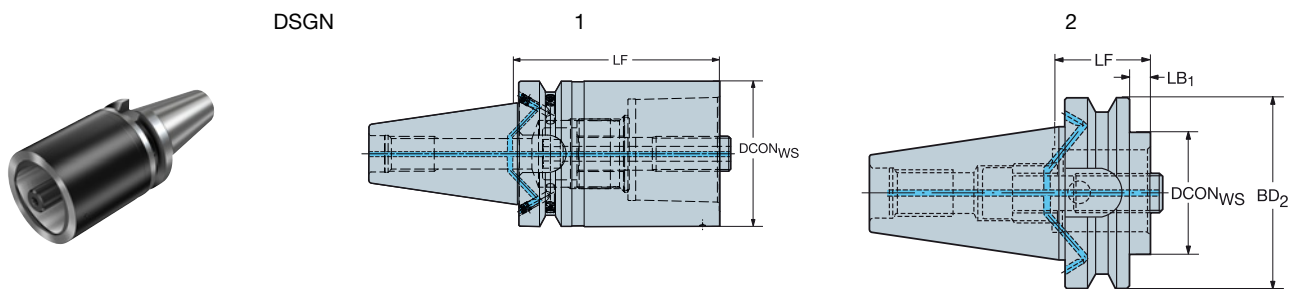


# Machine side interface MAS-BT



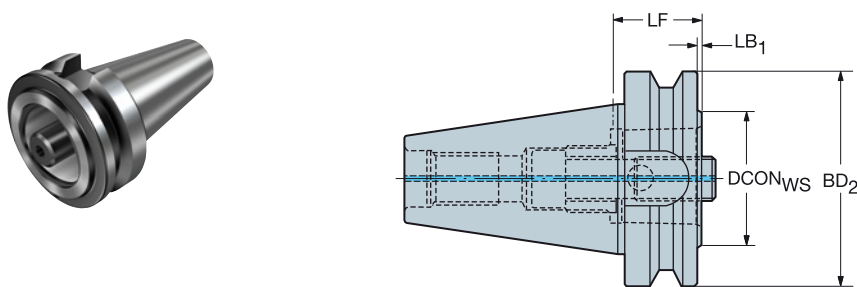
# MAS-BT 403 to Coromant Capto® adaptor

Machine side interface compatible with JIS B 6339



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>2</sub>	BAR	NM	KG
30	C3	1	1	2	C3-390.55-30 030	M12	32.0	30.0	8.0	30.0	46.0	80	45.00	0.42
	C3	1	1	2	C3-390.55-30 060	M12	32.0	60.0	38.0	60.0	46.0	80	45.00	0.58
	C4	1	1	2	C4-390.55-30 060	M12	40.0	60.0	38.0	60.0	46.0	80	55.00	0.67
	C5	1	1	1	C5-390.55-30 080	M12	50.0	80.0	80.0			80	95.00	1.07
40	C3	7	1	2	C3-390B.55-40 030	M16	32.0	30.0	3.0	30.0	63.0	80	45.00	0.99
	C3	7	1	2	C3-390B.55-40 060	M16	32.0	60.0	33.0	60.0	63.0	80	45.00	1.14
	C4	7	1	2	C4-390B.55-40 030	M16	40.0	30.0	3.0	30.0	63.0	80	55.00	0.95
	C4	7	1	2	C4-390B.55-40 060	M16	40.0	60.0	33.0	60.0	63.0	80	55.00	1.21
	C5	7	1	2	C5-390B.55-40 050	M16	50.0	50.0	23.0	50.0	63.0	80	95.00	1.15
	C5	7	1	2	C5-390B.55-40 090	M16	50.0	90.0	63.0	90.0	63.0	80	95.00	1.72
	C6	7	1	1	C6-390B.55-40 075	M16	63.0	75.0	75.0			80	170.00	1.74
50	C3	7	1	2	C3-390B.58-50 040	M24	32.0	40.0	2.0	40.0	100.0	80	45.00	3.68
	C3	7	1	2	C3-390B.58-50 070	M24	32.0	70.0	32.0	70.0	100.0	80	45.00	3.80
	C4	7	1	2	C4-390B.58-50 040	M24	40.0	40.0	2.0	40.0	100.0	80	55.00	3.65
	C4	7	1	2	C4-390B.58-50 070	M24	40.0	70.0	32.0	70.0	100.0	80	55.00	3.88
	C5	7	1	2	C5-390B.58-50 040	M24	50.0	40.0	2.0	40.0	100.0	80	95.00	3.56
	C5	7	1	2	C5-390B.58-50 080	M24	50.0	80.0	42.0	80.0	100.0	80	95.00	4.09
	C6	7	1	2	C6-390B.58-50 050	M24	63.0	50.0	12.0	50.0	100.0	80	170.00	3.61
	C6	7	1	2	C6-390B.58-50 100	M24	63.0	100.0	62.0	100.0	100.0	80	170.00	4.71
	C8	7	1	2	C8-390B.58-50 070	M24	80.0	70.0	32.0	70.0	100.0	80	170.00	4.12
	C8	7	1	2	C8-390B.58-50 120	M24	80.0	120.0	72.0	120.0	100.0	80	170.00	5.98
C10	7	1	1	C10-390B.58-50 140	M24	100.0	140.0	140.0			80	380.00	8.00	
60	C8	1	1	2	C8-390.58-60 120	M30	80.0	120.0	72.0	120.0	155.0	80	170.00	15.14
	C10	1	1	2	C10-390.58-60 080	M30	100.0	80.0	32.0	80.0	155.0	80	380.00	13.30

## 90° rotated polygon for precision tool tip control Designed for Mazak™ e-machine and Mori Seiki NT™ -Series



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG		
40	C5	1	1	C5-390.605-40 030	M16	50.0	30.0	3.0	63.0	80	95.00	0.88		
50	C6	1	1	C6-390.605-50 040	M24	63.0	40.0	2.0	100.0	80	170.00	3.26		
	C8	1	1	C8-390.605-50 070	M24	80.0	70.0	32.0	100.0	80	170.00	4.14		

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



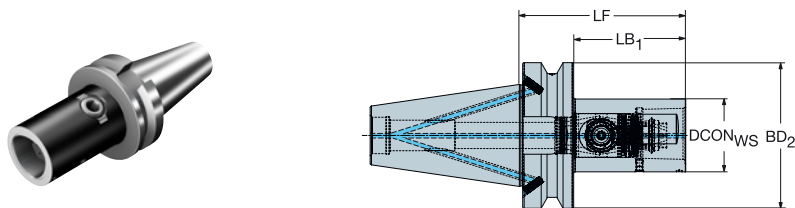
N23



N15

## MAS-BT 403 to Coromant Capto® adaptor with Quick change

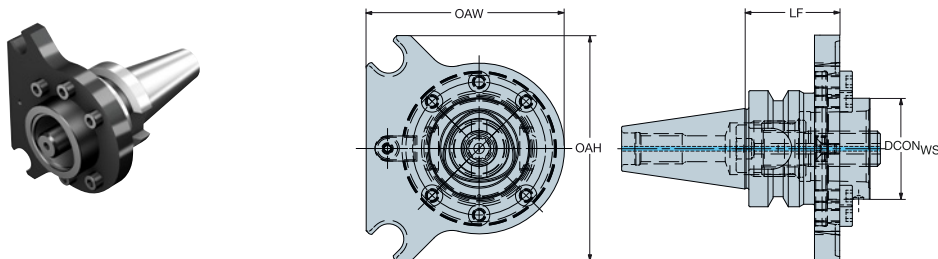
Machine side interface compatible with JIS B 6339



					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG
50	C5	7	1	B50-QC-C5-115	M24	50.0	115.0	76.0	100.0	80	70.00	4.55
	C6	7	1	B50-QC-C6-135	M24	63.0	135.0	96.0	100.0	80	90.00	5.49
	C8	7	1	B50-QC-C8-150	M24	80.0	150.0	111.0	100.0	80	130.00	6.91

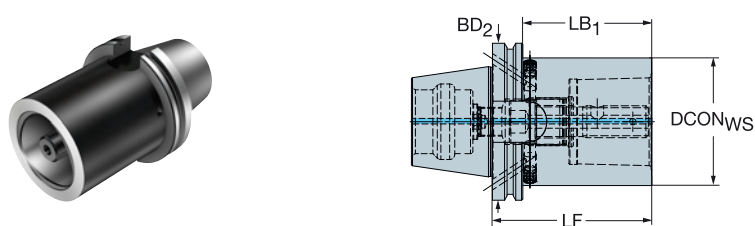
## MAS-BT 403 to Coromant Capto® turning adaptor

For Brother Speedio mill-turn



					Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>WS</sub>	LF	OAW	OAH	BAR	NM	KG
30	C4	1	1	C4-390.680-30 050Y	40.0	50.0	77.0	90.0	80	55	1.0

## MAS-BT short cone to Coromant Capto® adaptor



					Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG
50	C8	6	1	C8-390.670-50 100	80.0	100.0	62.0	100.0	150	170.00	4.43

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23



N23



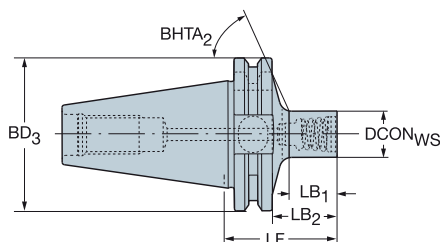
N15

# MAS-BT 403 to Coromant EH adaptor

Machine side interface compatible with JIS B 6339

DSGN

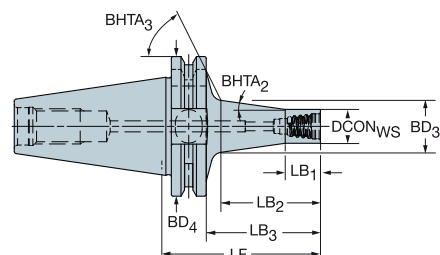
7



					Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
30	E10	1	1	7	392.55EH-30 10 044	M12	9.6	44.0	13.3	22.0	46.0	65°	80	12.00	0.51	25000
	E12	1	1	7	392.55EH-30 12 046	M12	11.6	46.0	15.6	24.0	46.0	64°	80	15.00	0.52	25000
	E16	1	1	7	392.55EH-30 16 041	M12	15.4	41.3	8.0	19.3	46.0	49°	80	30.00	0.57	25000
	E16	1	1	7	392.55EH-30 16 052	M12	15.4	52.0	22.1	30.0	46.0	63°	80	30.00	0.58	25000
	E16	1	1	7	392.55EH-30 16 056	M12	15.4	56.3	16.0	34.3	46.0	35°	80	30.00	0.61	25000
40	E20	1	1	7	392.55EH-30 20 049	M12	19.2	49.0	19.6	27.0	46.0	61°	80	50.00	0.59	25000
	E20	1	1	7	392.55EH-30 20 069	M12	19.2	68.7	25.0	34.7	46.0	27°	80	50.00	0.66	25000
	E25	1	1	7	392.55EH-30 25 054	M12	24.1	54.0	25.2	32.0	46.0	58°	80	65.00	0.65	25000
	E10	1	1	7	392.55EH-40 10 051	M16	9.6	51.0	13.0	24.0	63.0	67°	80	12.00	1.16	18000
	E12	1	1	7	392.55EH-40 12 054	M16	11.6	54.0	16.3	27.0	63.0	67°	80	15.00	1.18	18000
40	E16	1	1	7	392.55EH-40 16 060	M16	15.4	60.0	22.8	33.0	63.0	66°	80	30.00	1.23	18000
	E20	1	1	7	392.55EH-40 20 056	M16	19.2	56.0	19.3	29.0	63.0	66°	80	50.00	1.25	18000
	E25	1	1	7	392.55EH-40 25 062	M16	24.1	62.0	26.0	35.0	63.0	65°	80	65.00	1.30	18000

DSGN

15



					Dimensions, mm														
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>2</sub>	BHTA <sub>3</sub>	BAR	NM	KG	RPMX
30	E10	1	1	15	392.55EH-30 10 057	M12	9.6	57.0	10.0	27.6	35.0	14.6	46.0	7°	65°	80	12.00	0.51	25000
	E12	1	1	15	392.55EH-30 12 063	M12	11.6	63.0	12.0	34.1	41.0	17.8	46.0	8°	64°	80	15.00	0.54	25000
	E16	1	1	15	392.55EH-30 16 074	M12	15.4	74.0	16.0	45.9	52.0	23.8	46.0	8°	61°	80	30.00	0.64	25000
	E20	1	1	15	392.55EH-30 20 086	M12	19.2	86.0	20.0	58.7	64.0	30.1	46.0	8°	56°	80	50.00	0.73	25000
	E25	1	1	15	392.55EH-30 25 077	M12	24.1	77.0	25.0	49.9	55.0	31.1	46.0	8°	55°	80	65.00	0.75	25000
40	E10	1	1	15	392.55EH-40 10 065	M16	9.6	65.0	10.0	28.4	38.0	14.8	63.0	8°	68°	80	12.00	1.18	18000
	E12	1	1	15	392.55EH-40 12 070	M16	11.6	70.0	12.0	33.8	43.0	17.7	63.0	8°	67°	80	15.00	1.20	18000
	E16	1	1	15	392.55EH-40 16 081	M16	15.4	81.0	16.0	45.6	54.0	23.7	63.0	8°	66°	80	30.00	1.29	18000
	E20	1	1	15	392.55EH-40 20 094	M16	19.2	94.0	20.0	59.5	67.0	30.3	63.0	8°	65°	80	50.00	1.39	18000
	E25	1	1	15	392.55EH-40 25 108	M16	24.1	108.0	25.0	74.5	81.0	38.0	63.0	8°	62°	80	65.00	1.59	18000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



N23



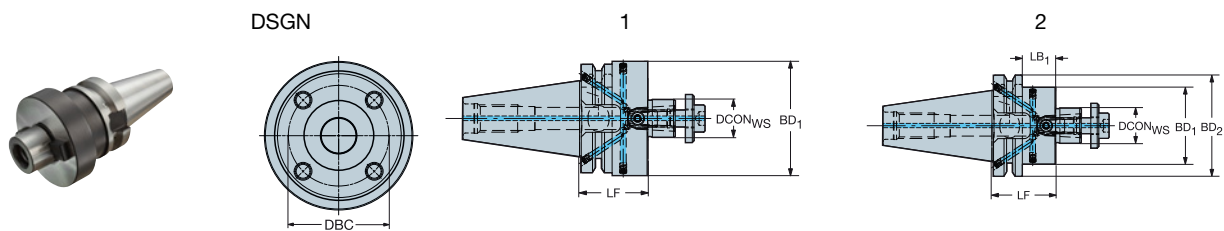
N15



N3

# MAS-BT 403 to arbor adaptor

Machine side interface compatible with JIS B 6339



					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DBC	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
30	16	1	1	2	A205-30 16 035		M12	16.0	35.0	13.0	35.0	36.0	46.0	80	22.00	0.54	25000
	22	1	1	2	A205-30 22 035		M12	22.0	35.0	11.9	35.0	42.0	46.0	80	45.00	0.63	25000
	27	1	1	2	A205-30 27 035		M12	27.0	35.0	13.0	35.0	42.0	46.0	80	80.00	0.67	25000
	32	1	1	1	A205-30 32 050		M12	32.0	50.0	50.0		78.0		80	180.00	1.40	25000
40	16	7	1	2	A2B05-40 16 035		M16	16.0	35.0	8.0	35.0	36.0	63.0	80	22.00	0.96	18000
	16	7	1	2	A2B05-40 16 100		M16	16.0	100.0	71.0	100.0	36.0	63.0	80	22.00	1.58	18000
	22	7	1	2	A2B05-40 22 035		M16	22.0	35.0	6.0	35.0	48.0	63.0	80	45.00	1.20	18000
	22	7	1	2	A2B05-40 22 100		M16	22.0	100.0	71.0	100.0	48.0	63.0	80	45.00	2.07	18000
	27	7	1	2	A2B05-40 27 035		M16	27.0	35.0	6.0	35.0	48.0	63.0	80	80.00	1.26	18000
	27	7	1	2	A2B05-40 27 100		M16	27.0	100.0	71.0	100.0	59.0	63.0	80	80.00	2.66	18000
	32	7	1	1	A2B05-40 32 065		M16	32.0	65.0	65.0		78.0		80	180.00	2.35	18000
	40S	7	1	1	A2B05-40 40 070	66.7	M16	40.0	70.0	70.0		87.0		80	300.00	3.08	18000
50	22	7	4	2	A2B05-50 22 055		M24	22.0	55.0	14.0	55.0	48.0	100.0	80	45.00	4.06	12000
	22	7	1	2	A2B05-50 22 100		M24	22.0	100.0	59.0	100.0	48.0	100.0	80	45.00	4.79	12000
	27	7	1	2	A2B05-50 27 055		M24	27.0	55.0	14.0	55.0	60.0	100.0	80	80.00	4.26	12000
	27	7	1	2	A2B05-50 27 100		M24	27.0	100.0	59.0	100.0	60.0	100.0	80	80.00	5.28	12000
	32	7	1	2	A2B05-50 32 055		M24	32.0	55.0	14.0	55.0	78.0	100.0	80	180.00	4.62	12000
	32	7	1	2	A2B05-50 32 100		M24	32.0	100.0	59.0	100.0	78.0	100.0	80	180.00	6.31	12000
	40S	7	1	2	A2B05-50 40 055	66.7	M24	40.0	55.0	14.0	55.0	89.0	100.0	80	300.00	5.04	12000
	60	7	1	1	A2F05-50 60 080	101.6	M24	60.0	80.0	80.0		127.0		80	180.00	7.78	12000

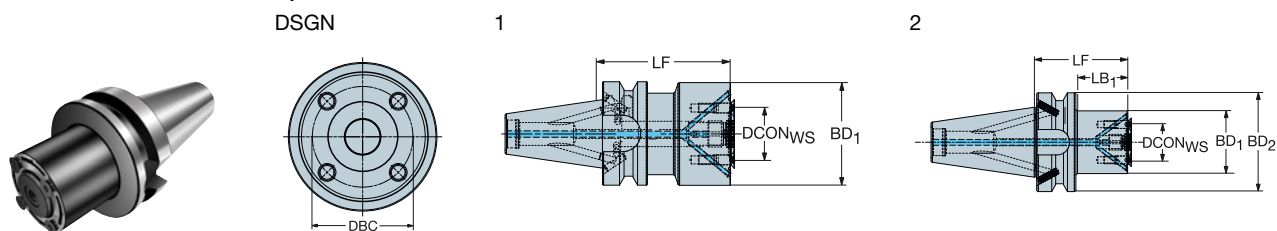
All holders are delivered with a standard screw without hole for coolant.

For cutters with coolant channels a new screw with radial coolant holes is necessary and can be ordered separately.

See page M13

# MAS-BT to arbor with driving screws adaptor

Machine side interface compatible with JIS B 6339



					Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DBC	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
30	X10	1	3	2	B30-X10-032-050	22.0	M12	10.0	2	50.0	27.0	50.0	32.0	46.0	80	6.40	0.60	12000
	X22	1	3	2	B30-X22-040-055	32.0	M12	22.0	2	55.0	32.0	55.0	40.0	46.0	80	3.90	0.73	11000
40	X10	7	3	2	B40-X10-032-055	22.0	M16	10.0	2	55.0	27.0	55.0	32.0	63.0	80	6.40	1.18	12000
	X22	7	3	2	B40-X22-040-060	32.0	M16	22.0	2	60.0	32.0	60.0	40.0	63.0	80	3.90	1.33	11000
	X32	7	3	1	B40-X32-063-080	45.0	M16	32.0	2	80.0	80.0		63.0		80	6.40	2.28	10000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



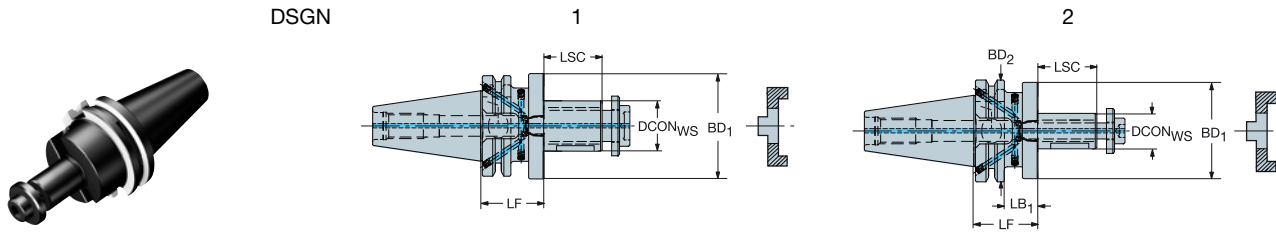
N23



N15

# MAS-BT 403 to side and face mill arbor adaptor

Machine side interface compatible with JIS B 6339



		Dimensions, mm															
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
30	22	1	1	2	A208-30 22 047	M12	22.0	31	35.0	13.0	35.0	40.0	46.0	80	45.00	0.71	25000
	27	1	1	1	A208-30 27 050	M12	27.0	33	38.0	38.0		48.0		80	80.00	0.87	25000
40	22	7	1	2	A2B08-40 22 055	M16	22.0	31	43.0	12.0	43.0	40.0	63.0	80	45.00	1.35	18000
	27	7	1	2	A2B08-40 27 055	M16	27.0	33	43.0	15.0	43.0	48.0	63.0	80	80.00	1.51	18000
	32	7	1	2	A2B08-40 32 060	M16	32.0	38	46.0	18.0	46.0	58.0	63.0	80	180.00	1.86	18000
	40	7	1	1	A2B08-40 40 070	M16	40.0	41	56.0	56.0		70.0		80	300.00	2.70	18000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N15

# MAS-BT 403 to Weldon adaptor

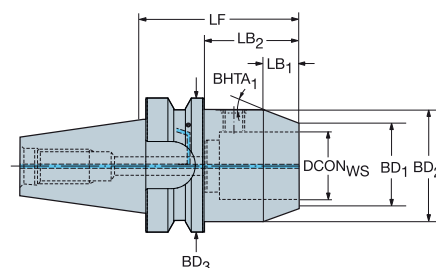
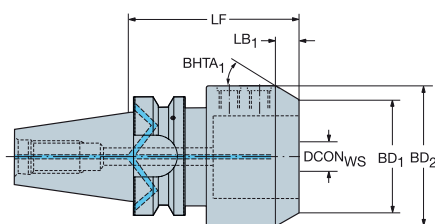
Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN

3

6



						Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BAR	NM	KG
30	12	1	1	6	A2B20-30 12 052	M12	12.0	52.0	12.6	28.9	52.0	27.0	41.5	46.0	30°	20	12.00	0.63
	16	1	1	3	A2B20-30 16 063	M12	16.0	63.0	12.6	63.0		33.0	47.5		30°	20	15.00	0.83
	20	1	1	3	A2B20-30 20 063	M12	20.0	63.0	12.6	63.0		37.0	51.5		30°	20	20.00	0.87
40	6	7	1	6	A2B20-40 06 100	M16	6.0	100.0	11.0	71.0	100.0	12.3	25.0	63.0	30°	20	3.00	1.21
	8	7	1	6	A2B20-40 08 100	M16	8.0	100.0	11.0	71.0	100.0	15.3	28.0	63.0	30°	20	7.00	1.27
	10	7	1	6	A2B20-40 10 100	M16	10.0	100.0	13.0	71.0	100.0	20.0	35.0	63.0	30°	20	10.00	1.44
	12	7	1	6	A2B20-40 12 063	M16	12.0	63.0	13.0	34.0	63.0	27.0	42.0	63.0	30°	20	12.00	1.12
	12	7	1	6	A2B20-40 12 100	M16	12.0	100.0	13.0	71.0	100.0	27.0	42.0	63.0	30°	20	12.00	1.66
	16	7	1	6	A2B20-40 16 063	M16	16.0	63.0	13.0	34.0	63.0	33.0	48.0	63.0	30°	20	15.00	1.35
	16	7	1	6	A2B20-40 16 100	M16	16.0	100.0	13.0	71.0	100.0	33.0	48.0	63.0	30°	20	15.00	1.84
	20	7	1	6	A2B20-40 20 063	M16	20.0	63.0	13.0	34.0	63.0	37.0	52.0	63.0	30°	20	20.00	1.37
	20	7	1	6	A2B20-40 20 100	M16	20.0	100.0	13.0	71.0	100.0	37.0	52.0	63.0	30°	20	20.00	1.96
	25	7	1	6	A2B20-40 25 090	M16	25.0	90.0	13.0	61.0	90.0	44.0	59.0	63.0	30°	20	25.00	1.73
	32	7	1	3	A2B20-40 32 100	M16	32.0	100.0	13.0	100.0		57.0	72.0		30°	20	45.00	2.40
50	6	7	1	6	A2B20-50 06 063	M24	6.0	63.0	11.0	22.0	63.0	12.3	25.0	100.0	30°	20	3.00	3.81
	8	7	1	6	A2B20-50 08 063	M24	8.0	63.0	11.0	22.0	63.0	15.3	28.0	100.0	30°	20	7.00	3.84
	10	7	1	6	A2B20-50 10 070	M24	10.0	70.0	13.0	29.0	70.0	20.0	35.0	100.0	30°	20	10.00	3.90
	12	7	1	6	A2B20-50 12 080	M24	12.0	80.0	13.0	36.0	80.0	26.8	42.0	100.0	30°	20	12.00	4.04
	16	7	1	6	A2B20-50 16 080	M24	16.0	80.0	13.0	39.0	80.0	33.0	48.0	100.0	30°	20	15.00	4.16
	20	7	1	6	A2B20-50 20 080	M24	20.0	80.0	13.0	39.0	80.0	37.0	52.0	100.0	30°	20	20.00	4.18
	20	7	1	6	A2B20-50 20 100	M24	20.0	100.0	13.0	59.0	100.0	37.0	52.0	100.0	30°	20	20.00	4.58
	25	7	1	6	A2B20-50 25 100	M24	25.0	100.0	13.0	59.0	100.0	50.0	65.0	100.0	30°	20	25.00	4.90
	25	7	1	6	A2B20-50 25 160	M24	25.0	160.0	13.0	119.0	160.0	50.0	65.0	100.0	30°	20	25.00	6.62
	32	7	1	6	A2B20-50 32 105	M24	32.0	105.0	12.0	64.0	105.0	58.1	72.0	100.0	30°	20	45.00	5.30
32	7	1	6	A2B20-50 32 160	M24	32.0	160.0	12.0	119.0	160.0	58.1	72.0	100.0	30°	20	45.00	7.20	
40	7	1	6	A2B20-50 40 115	M24	40.0	115.0	15.0	74.0	115.0	60.7	78.0	100.0	30°	20	45.00	5.60	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



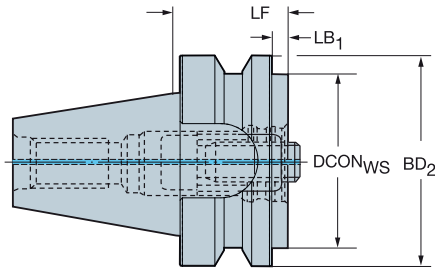
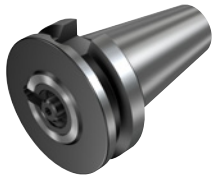
N23



N15

# MAS-BT 403 to VL adaptor

Machine side interface compatible with JIS B 6339



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG
50	80	1	1	390.58-50 80 040	M24	80.0	40.0	2.0	100.0	20	180.00	3.63

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N15

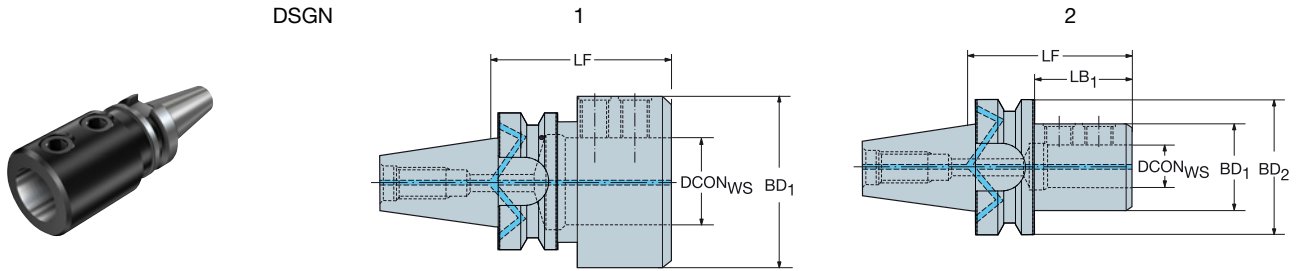
L 80





# MAS-BT 403 to ISO 9766 adaptor

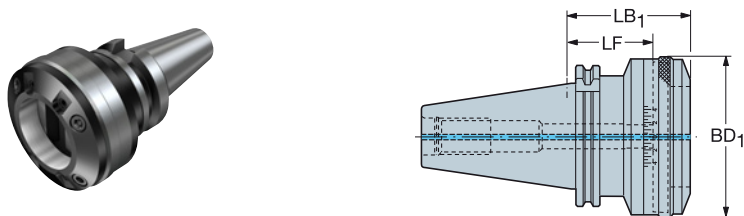
Machine side interface compatible with JIS B 6339



					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
30	16	1	1	2	A227-30 16 080	M12	16.0	49	80.0	58.0	80.0	36.0	46.0	20	10.00	0.76	25000
	20	1	1	2	A227-30 20 080	M12	20.0	51	80.0	56.9	80.0	40.0	46.0	20	12.00	0.82	25000
	25	1	1	2	A227-30 25 085	M12	25.0	57	85.0	62.9	85.0	45.0	46.0	20	20.00	0.92	25000
	32	1	1	1	A227-30 32 090	M12	32.0	61	90.0	90.0		52.0		20	30.00	1.03	25000
40	16	7	1	2	A2B27-40 16 070	M16	16.0	49	70.0	42.0	70.0	36.0	63.0	20	10.00	1.24	18000
	20	7	1	2	A2B27-40 20 075	M16	20.0	51	75.0	48.0	75.0	40.0	63.0	20	12.00	1.32	18000
	25	7	1	2	A2B27-40 25 080	M16	25.0	57	80.0	52.0	80.0	45.0	63.0	20	20.00	1.40	18000
	32	7	1	2	A2B27-40 32 085	M16	32.0	61	85.0	57.0	85.0	52.0	63.0	20	30.00	1.51	18000
50	16	7	1	2	A2B27-50 16 080	M24	16.0	49	80.0	41.5	80.0	36.0	100.0	20	10.00	3.98	12000
	20	7	1	2	A2B27-50 20 085	M24	20.0	51	85.0	46.0	85.0	40.0	100.0	20	12.00	3.98	12000
	25	7	1	2	A2B27-50 25 090	M24	25.0	57	90.0	51.0	90.0	45.0	100.0	20	20.00	4.08	12000
	32	7	1	2	A2B27-50 32 095	M24	32.0	61	95.0	56.0	95.0	52.0	100.0	20	30.00	4.24	12000
	40	7	1	2	A2B27-50 40 105	M24	40.0	71	105.0	66.0	105.0	75.0	100.0	20	40.00	5.32	12000
50	7	1	2	A2B27-50 50 113	M24	50.0	81	113.0	74.0	113.0	75.0	100.0	20	45.00	4.96	12000	

# MAS-BT 403 to ISO 9766 adjustable adaptor

Machine side interface compatible with JIS B 6339



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>1</sub>	BAR	KG	RPMX		
40	1	1	1	392.55277-40 01 055A	M16	78.0	55.0	79.6	86.0	20	2.38	12000		
50	2	1	1	392.58277-50 02 063A	M24	98.0	63.0	87.6	106.0	20	5.79	9000		
	3	1	1	392.58277-50 03 080B	M24	136.0	80.0	90.0	140.0	20	7.36	6000		

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23



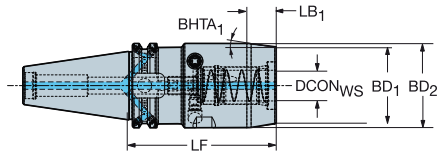
N15

# MAS-BT 403 to CoroChuck™ 930

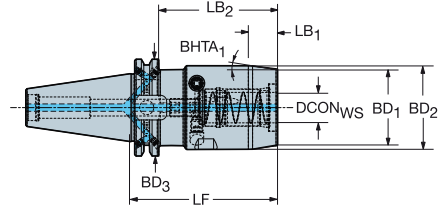
Machine side interface compatible with JIS B 6339

DSGN

3



6

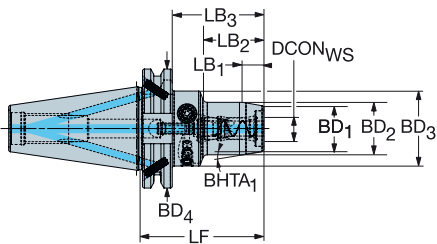


## Heavy Duty design

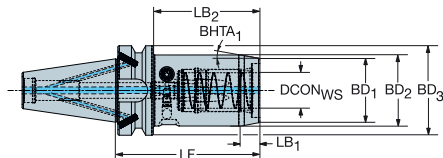
						Dimensions, mm																
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	(BAR)	(NM)	(KG)	RPMX		
40	20	7	1	6	930-B40-HD-20-088	M16	20.0	51	88.0	17.8	61.0	88.0	50.0	55.0	63.0	8°	80	10.00	1.93	18000		
	25	7	1	3	930-B40-HD-25-094	M16	25.0	57	94.0	18.8	94.0		57.0	65.0		12°	80	10.00	2.39	18000		
50	20	7	1	6	930-B50-HD-20-102	M24	20.0	51	102.0	17.8	64.0	102.0	50.0	55.0	100.0	8°	80	10.00	4.68	12000		
	25	7	1	6	930-B50-HD-25-106	M24	25.0	57	106.0	18.8	68.0	106.0	57.0	65.0	100.0	12°	80	10.00	5.15	12000		
	32	7	1	6	930-B50-HD-32-096	M24	32.0	61	96.0	18.8	58.0	96.0	68.0	76.0	100.0	12°	80	10.00	5.23	12000		
	32	7	1	6	930-B50-HD-32-185	M24	32.0	61	185.0	18.8	147.0	185.0	68.0	76.0	100.0	12°	80	10.00	8.34	12000		

DSGN

10



6



## Slender design

						Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>1</sub>	(BAR)	(NM)	(KG)	RPMX	
30	6	1	1	6	930-B30-S-06-048	M12	6.0	37	48.0	9.3	12.8	48.0		22.0	26.0	46.0		12°	80	8.00	0.55	25000	
	8	1	1	6	930-B30-S-08-048	M12	8.0	37	48.0	9.3	12.8	48.0		24.0	28.0	46.0		12°	80	8.00	0.56	25000	
	10	1	1	6	930-B30-S-10-048	M12	10.0	41	48.0	9.3	13.8	48.0		26.0	30.0	46.0		12°	80	8.00	0.55	25000	
	12	1	1	10	930-B30-S-12-082	M12	12.0	46	82.0	11.3	38.2	60.0	82.0	28.0	32.0	40.0	46.0	10°	80	8.00	0.75	25000	
40	20	1	1	6	930-B30-S-20-088	M12	20.0	51	88.0	16.0	66.0	88.0		38.0	42.0	46.0		7°	80	8.00	0.93	25000	
	6	7	1	10	930-B40-S-06-075	M16	6.0	37	75.0	11.3	30.2	48.0	75.0	22.0	26.0	40.0	63.0	10°	80	8.00	1.21	18000	
	8	7	1	10	930-B40-S-08-075	M16	8.0	37	75.0	11.3	30.2	48.0	75.0	24.0	28.0	40.0	63.0	10°	80	8.00	1.23	18000	
	10	7	1	10	930-B40-S-10-080	M16	10.0	41	80.0	11.3	34.2	53.0	80.0	26.0	30.0	40.0	63.0	10°	80	8.00	1.27	18000	
	12	7	1	10	930-B40-S-12-085	M16	12.0	46	85.0	11.3	38.2	58.0	85.0	27.9	32.0	50.0	63.0	10°	80	8.00	1.45	18000	
	20	7	1	10	930-B40-S-20-094	M16	20.0	51	94.0	16.0	49.2	67.0	94.0	37.9	42.0	50.0	63.0	7°	80	8.00	1.62	18000	
	25	7	1	6	930-B40-S-25-102	M16	25.0	57	102.0	12.9	74.0		102.0	45.0	50.0		63.0	11°	80	8.00	1.86	18000	
	50	20	7	1	10	930-B50-S-20-108	M24	20.0	51	108.0	16.0	49.2	70.0	108.0	37.9	42.0	50.0	100.0	7°	80	8.00	4.35	12000
		25	7	1	6	930-B50-S-25-114	M24	25.0	57	114.0	12.9	73.5		114.0	45.0	50.0		100.0	11°	80	8.00	4.59	12000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



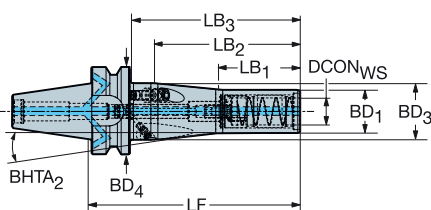
# MAS-BT 403 to CoroChuck™ 930

Machine side interface compatible with JIS B 6339

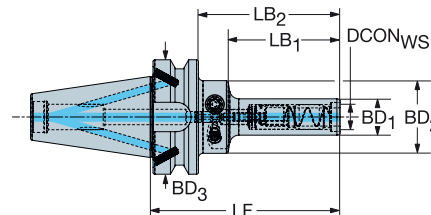
Pencil design

DSGN

11



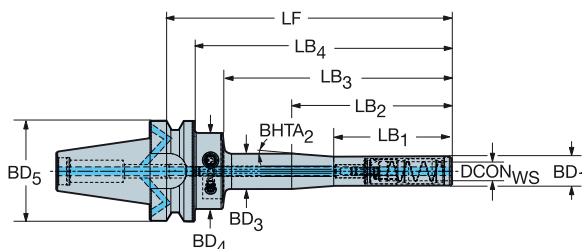
5



					Dimensions, mm																				
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX			
30	6	1	1	11	930-B30-P-08-088	M12	6.0	37	88.0	45.8	52.1	66.0	88.0	14.5	14.5	40.0	46.0	0°	80	8.00	0.62	25000			
	8	1	1	5	930-B30-P-08-088	M12	8.0	37	88.0	45.8	66.0	88.0		17.5	40.0	46.0		0°	80	8.00	0.59	25000			
	10	1	1	5	930-B30-P-10-098	M12	10.0	41	98.0	55.8	76.0	98.0		20.0	40.0	46.0		0°	80	8.00	0.63	25000			
	10	1	1	5	930-B30-P-10-138	M12	10.0	41	138.0	95.8	116.0	138.0		20.0	40.0	46.0		0°	80	8.00	0.73	25000			
	12	1	1	11	930-B30-P-12-103	M12	12.0	46	103.0	60.8	66.4	81.0	103.0	22.0	22.0	40.0	46.0	0°	80	8.00	0.71	25000			
	12	1	1	11	930-B30-P-12-138	M12	12.0	46	138.0	95.8	101.4	116.0	138.0	22.0	22.0	40.0	46.0	0°	80	8.00	0.81	25000			
40	8	7	1	5	930-B40-P-08-095	M16	8.0	37	95.0	45.8	65.5	95.0		17.5	40.0	63.0		0°	80	8.00	1.20	18000			
	10	7	1	5	930-B40-P-10-105	M16	10.0	41	105.0	55.8	75.5	105.0		20.0	40.0	63.0		0°	80	8.00	1.24	18000			
	10	7	1	5	930-B40-P-10-145	M16	10.0	41	145.0	95.8	115.5	145.0		20.0	40.0	63.0		0°	80	8.00	1.34	18000			
	12	7	1	11	930-B40-P-12-110	M16	12.0	46	110.0	60.8	66.4	83.0	110.0	22.0	22.0	40.0	63.0	0°	80	8.00	1.32	18000			
	12	7	1	11	930-B40-P-12-145	M16	12.0	46	145.0	95.8	101.4	118.0	145.0	22.0	22.0	40.0	63.0	0°	80	8.00	1.47	18000			
	20	7	1	11	930-B40-P-20-153	M16	20.0	51	153.0	60.0	108.0	126.0	153.0	32.0	32.0	42.0	63.0	6°	80	8.00	1.84	18000			

DSGN

17



					Dimensions, mm																				
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BD <sub>5</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX			
30	12	1	1	17	930-B30-P-12-188	M12	12.0	46	188.0	50.0	75.0	151.1	166.0	22.0	26.0	40.0	46	4°	80	8.00	1.10	25000			
40	12	7	1	17	930-B40-P-12-195	M16	12.0	46	195.0	50.0	75.0	151.1	168.0	22.0	26.0	40.0	46	4°	80	8.00	1.72	18000			

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N6



N15



N4

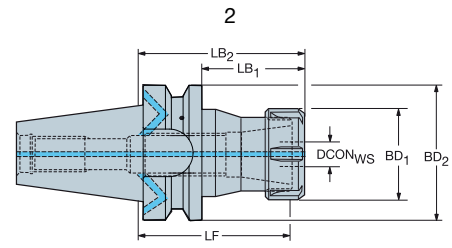
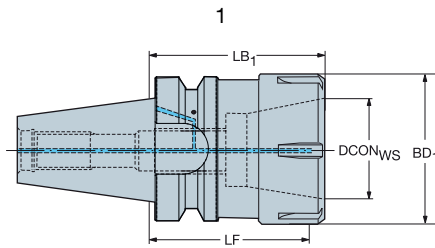


# MAS-BT 403 to ER collet chuck

Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6499-B

DSGN



					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	KG	RPMX		
30	ER11	1	1	2	A2B14-30 11 050	M12	11.4	43.7	26.9	50.0	19.0	46.0	80	0.43	25000		
	ER16	1	1	2	A214-30 16 080	M12	17.0	69.7	56.9	80.0	28.0	46.0	80	0.59	25000		
	ER16	1	1	2	A214-30 16 100	M12	17.0	89.7	76.9	100.0	28.0	46.0	80	0.68	25000		
	ER16	1	1	2	A214-30 16 130	M12	17.0	119.7	106.9	130.0	28.0	46.0	80	0.81	25000		
	ER16	1	1	2	A2B14-30 16 050	M12	17.0	39.7	26.9	50.0	27.7	46.0	80	0.46	25000		
	ER20	1	1	2	A214-30 20 090	M12	21.0	78.8	66.9	90.0	34.0	46.0	80	0.73	25000		
	ER20	1	1	2	A214-30 20 130	M12	21.0	118.8	106.9	130.0	34.0	46.0	80	0.99	25000		
	ER20	1	1	2	A2B14-30 20 050	M12	21.0	38.8	26.9	50.0	34.0	46.0	80	0.48	25000		
	ER25	1	1	2	A214-30 25 100	M12	26.0	88.3	76.9	100.0	42.0	46.0	80	0.99	25000		
	ER25	1	1	2	A214-30 25 130	M12	26.0	118.3	108.0	130.0	42.0	46.0	80	1.30	25000		
	ER25	1	1	2	A2B14-30 25 062	M12	26.0	50.3	38.9	62.0	42.0	46.0	80	0.58	25000		
	ER32	1	1	1	A214-30 32 070	M12	33.0	57.3	70.0		50.0		80	0.70	25000		
	ER32	1	1	1	A214-30 32 130	M12	33.0	117.3	130.0		50.0		80	1.25	25000		
	40	ER16	7	1	2	A2B14-40 16 070	M16	17.0	59.7	41.0	70.0	28.0	63.0	80	1.10	18000	
ER16		7	1	2	A2B14-40 16 100	M16	17.0	89.7	71.0	100.0	28.0	63.0	80	1.25	18000		
ER20		7	1	2	A2B14-40 20 070	M16	21.0	58.8	41.0	70.0	34.0	63.0	80	1.15	18000		
ER20		7	1	2	A2B14-40 20 100	M16	21.0	88.8	71.0	100.0	34.0	63.0	80	1.33	18000		
ER25		7	1	2	A2B14-40 25 070	M16	26.0	58.3	41.0	70.0	42.0	63.0	80	1.22	18000		
ER25		7	1	2	A2B14-40 25 100	M16	26.0	88.3	71.0	100.0	42.0	63.0	80	1.50	18000		
ER32		7	1	2	A2B14-40 32 070	M16	33.0	57.3	41.0	70.0	50.0	63.0	80	1.24	18000		
ER40		7	1	1	A2B14-40 40 070	M16	41.0	55.3	70.0		63.0		80	1.35	18000		
50	ER20	7	1	2	A2B14-50 20 070	M24	21.0	58.8	29.0	70.0	34.0	100.0	80	3.80	12000		
	ER20	7	1	2	A2B14-50 20 100	M24	21.0	88.8	59.0	100.0	34.0	100.0	80	4.11	12000		
	ER25	7	1	2	A2B14-50 25 070	M24	26.0	58.3	29.0	70.0	42.0	100.0	80	3.88	12000		
	ER25	7	1	2	A2B14-50 25 100	M24	26.0	88.3	59.0	100.0	42.0	100.0	80	4.26	12000		
	ER32	7	1	2	A2B14-50 32 070	M24	33.0	57.3	28.6	70.0	50.0	100.0	80	3.84	12000		
	ER32	7	1	2	A2B14-50 32 100	M24	33.0	87.3	59.0	100.0	50.0	100.0	80	4.26	12000		
	ER40	7	1	2	A2B14-50 40 080	M24	41.0	65.3	39.0	80.0	63.0	100.0	80	4.04	12000		

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23

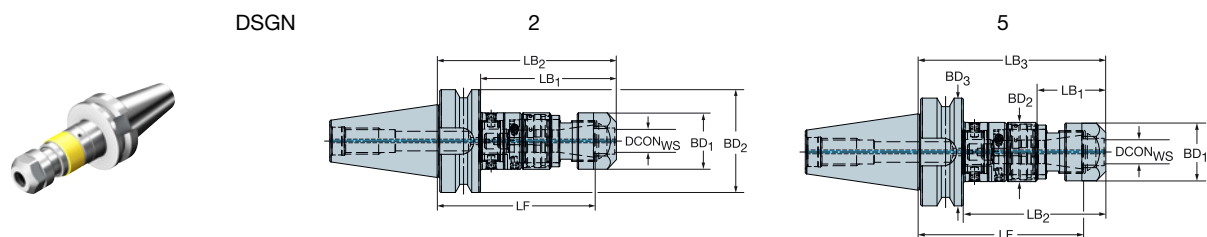


N15

# MAS-BT 403 to CoroChuck™ 970

Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6499-B



							Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">BAR</span>	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">KG</span>	RPMX	
30	ER11	M5	1	1	5	970-B30-11-082	M12	11.3	78.2	24.1	60.0	82.0	18.7	23.5	46.0	80	0.55	8000	
	ER20	M12	1	1	5	970-B30-20-105	M12	20.8	92.2	35.3	78.1	100.2	33.7	35.0	46.0	80	0.83	8000	
	ER25	M20	1	1	5	970-B30-25-125	M12	25.8	111.1	37.1	97.6	119.6	42.0	44.0	46.0	80	1.19	8000	
40	ER20	M12	1	1	5	970-B40-20-110	M16	20.8	97.2	35.3	78.1	105.2	33.7	35.0	63.0	80	1.42	8000	
	ER25	M20	1	1	5	970-B40-25-130	M16	25.8	116.1	37.1	97.6	124.6	42.0	44.0	63.0	80	1.78	8000	
	ER32	M27	1	1	2	970-B40-32-133	M16	32.8	123.8	106.3	133.3		50.0	63.0		80	1.74	8000	
50	ER20	M12	1	1	5	970-B50-20-125	M24	20.8	112.2	35.3	82.1	120.2	33.7	35.0	100.0	80	4.09	8000	
	ER25	M20	1	1	5	970-B50-25-145	M24	25.8	131.1	37.1	101.6	139.6	42.0	44.0	100.0	80	4.47	8000	
	ER32	M27	1	1	2	970-B50-32-148	M24	32.8	138.8	110.3	148.3		50.0	100.0		80	4.33	8000	
	ER40	M30	1	1	2	970-B50-40-174	M24	40.8	157.2	130.6	168.6		63.0	100.0		80	5.90	8000	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1



N23

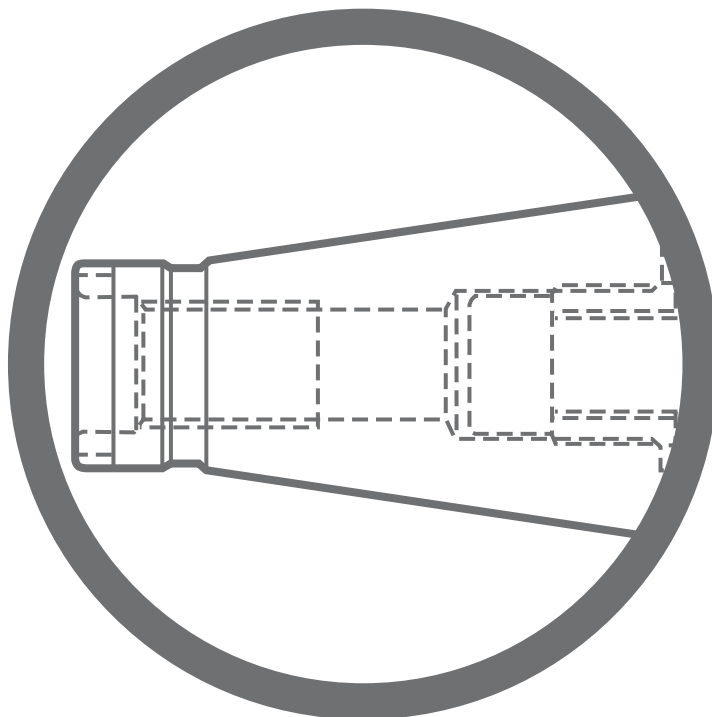


N15

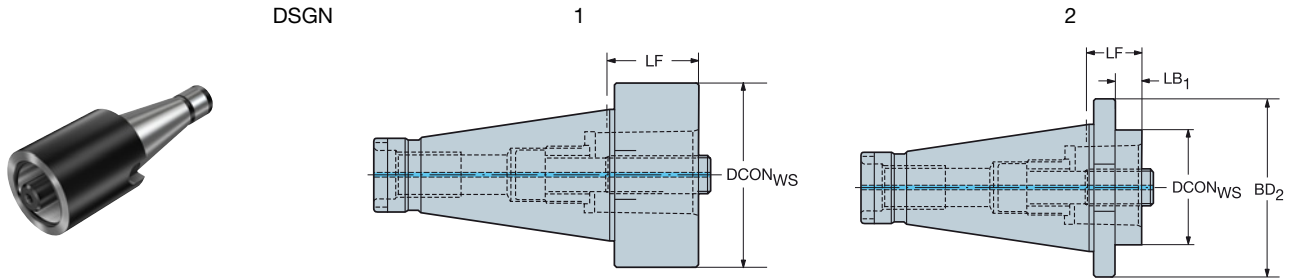


N5

# Machine side interface DIN 2080



## DIN 2080 to Coromant Capto® adaptor



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>2</sub>	BAR	NM	KG
40	C3	1	1	2	C3-390.00-40 030	M16	32.0	30.0	18.4	30.0	63.0	80	45.00	0.86
	C4	1	1	2	C4-390.00-40 030	M16	40.0	30.0	18.4	30.0	63.0	80	55.00	0.09
	C4	1	1	2	C4-390.00-40 060	M16	40.0	60.0	48.4	60.0	63.0	80	55.00	1.13
	C5	1	1	2	C5-390.00-40 030	M16	50.0	30.0	18.4	30.0	63.0	80	95.00	0.90
	C6	1	1	1	C6-390.00-40 075	M16	63.0	75.0	75.0			80	170.00	1.87
	50	C3	1	1	2	C3-390.00-50 030	M24	32.0	30.0	14.8	30.0	97.5	80	45.00
C3		1	1	2	C3-390.00-50 060	M24	32.0	60.0	44.8	60.0	97.5	80	45.00	2.89
C4		1	1	2	C4-390.00-50 030	M24	40.0	30.0	14.8	30.0	97.5	80	55.00	2.79
C4		1	1	2	C4-390.00-50 060	M24	40.0	60.0	44.8	60.0	97.5	80	55.00	3.01
C5		1	1	2	C5-390.00-50 030	M24	50.0	30.0	14.8	30.0	97.5	80	95.00	2.76
C5		1	1	2	C5-390.00-50 070	M24	50.0	70.0	54.8	70.0	97.5	80	95.00	3.28
C6		1	1	2	C6-390.00-50 030	M24	63.0	30.0	14.8	30.0	97.5	80	170.00	2.72
C6		1	1	2	C6-390.00-50 080	M24	63.0	80.0	64.8	80.0	97.5	80	170.00	3.82
C8		1	1	2	C8-390.00-50 070	M24	80.0	70.0	54.8	70.0	97.5	80	170.00	3.98
C8		1	1	2	C8-390.00-50 120	M24	80.0	120.0	104.8	120.0	97.5	80	170.00	5.84

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

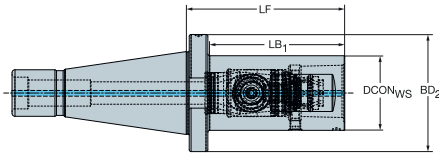
N23



N15

# DIN 2080 to Coromant Capto® adaptor with Quick change

ENG



					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	CRKS	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG
40	C5	1	1	DN40-QC-C5-095	M16	50.0	95.0	83.4	62.8	80	70.00	1.70
50	C8	1	1	DN50-QC-C8-140	M24	80.0	140.0	124.8	97.3	80	130.00	6.30

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

J

K

L

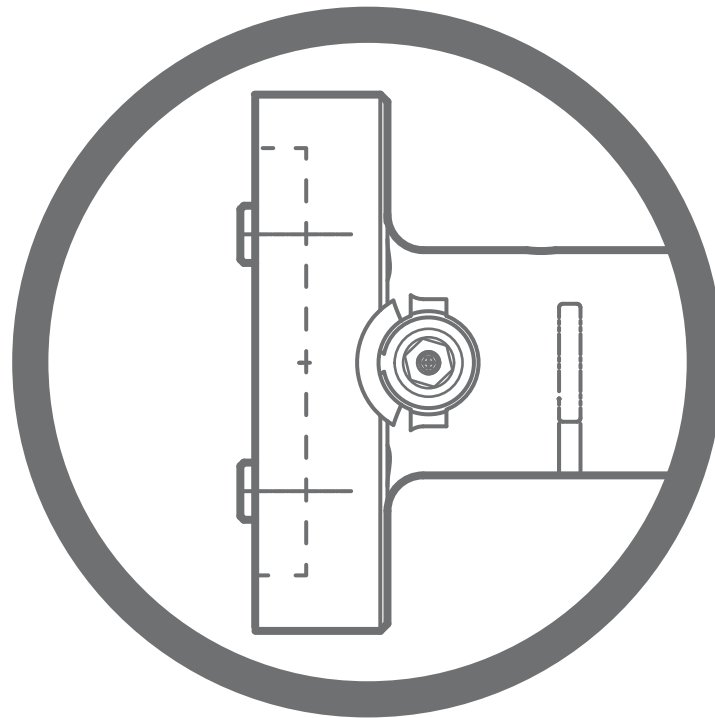
M

N

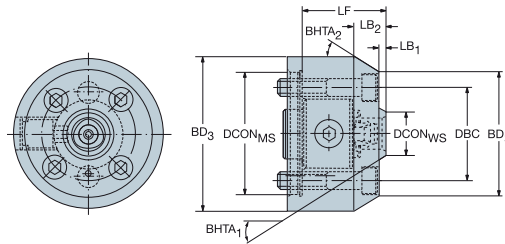




# Machine side interface DIN 2079

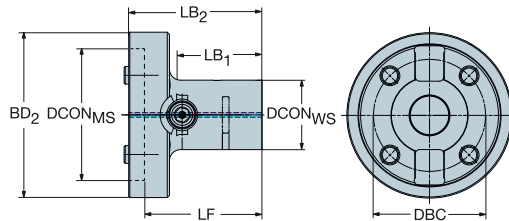


# DIN 2079 to Coromant Capto® adaptor



		Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BHTA <sub>1</sub>	BHTA <sub>2</sub>	NM	KG
40	C3	C3-390.34705-40 060	88.8	66.7	32.0	60.0	5.0	22.3	90.0	110.0	30°	30°	35.00	3.99
	C4	C4-390.34705-40 070	88.8	66.7	40.0	70.0	5.0	22.3	90.0	110.0	30°	30°	15.00	5.00

# DIN 2079 to Coromant Capto® adaptor with Quick change

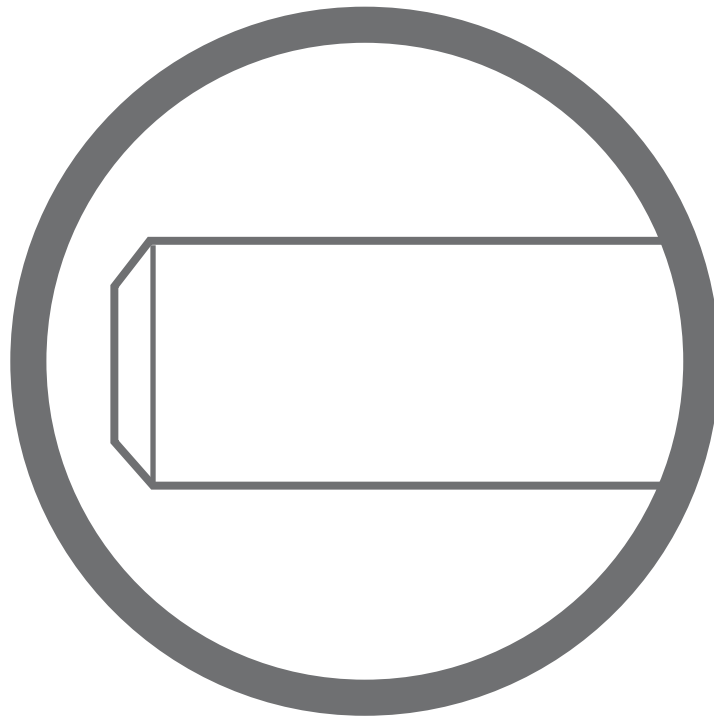


		Dimensions, mm													
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>2</sub>	BAR	NM	KG	
40	C5	1	1	SI40-QC-C5-090	88.8	66.7	50.0	90.0	70.0	102.0	110.0	80	70.00	2.30	
50	C6	1	1	SI50-QC-C6-105	128.5	101.6	63.0	105.0	74.0	121.0	150.0	80	90.00	5.00	
	C8	3	1	SI50-QC-C8-135	128.5	101.6	80.0	135.0	104.0	151.0	150.0	80	130.00	6.89	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

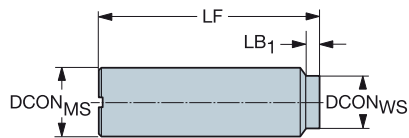


# Machine side interface Cylindrical shank



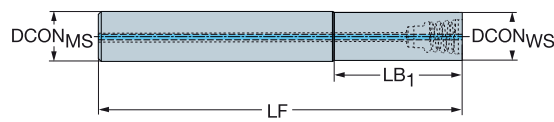
# Cylindrical shank to Coromant EH adaptor

Straight design



## Steel shank

					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BAR	NM	KG	RPMX	
10	E10	1	1	E10-A10-SS-075	10.0	9.6	54	75.0	20.0	80	12.00	0.09	40000	
12	E12	1	1	E12-A12-SS-100	12.0	11.6	77	100.0	22.0	80	15.00	0.14	31000	
16	E10	1	1	E10-A16-SS-065	16.0	9.6	57	65.0	5.0	80	12.00	0.14	40000	
	E12	1	1	E12-A16-SS-065	16.0	11.6	58	65.0	5.0	80	15.00	0.15	40000	
20	E16	1	1	E16-A20-SS-070	20.0	15.4	63	70.0	5.0	80	30.00	0.26	40000	
	E16	1	1	E16-A20-SS-110	20.0	15.4	83	110.0	25.0	80	30.00	0.33	40000	
	E20	1	1	E20-A20-SS-120	20.0	19.2	89	120.0	30.0	80	50.00	0.38	34000	
25	E20	1	1	E20-A25-SS-080	25.0	19.2	73	80.0	5.0	80	50.00	0.39	40000	
	E25	1	1	E25-A25-SS-140	25.0	24.1	99	140.0	40.0	80	65.00	0.63	25000	
32	E25	1	1	E25-A32-SS-080	32.0	24.1	73	80.0	5.0	80	65.00	0.62	40000	



## Heavy metal shank

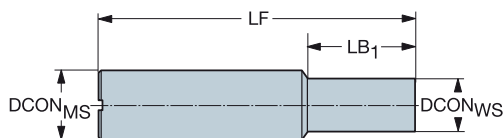
					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BAR	KG	RPMX		
10	E10	1	1	EH10-A10-SH-100	10.0	9.6	79	100.0	20.0	80	0.18	26000		
12	E12	1	1	EH12-A12-SH-110	12.0	11.6	84	110.0	25.0	80	0.26	25000		
16	E16	1	1	EH16-A16-SH-130	16.0	15.4	94	130.0	35.0	80	0.52	22000		
20	E20	1	1	EH20-A20-SH-160	20.0	19.2	114	160.0	45.0	80	0.92	17000		
25	E25	1	1	EH25-A25-SH-185	25.0	24.1	119	185.0	65.0	80	1.58	16000		

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# Cylindrical shank to Coromant EH adaptor

Straight design



## Cemented carbide shank

				Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BAR	NM	KG	RPMX
10	E10	1	1	E10-A10-SE-100	10.0	9.6	49	100.0	50.0	80	12.00	0.15	35000
12	E12	1	1	E12-A12-SE-100	12.0	11.6	51	100.0	48.0	80	15.00	0.20	40000
16	E16	1	1	E16-A16-SE-135	16.0	15.4	54	135.0	80.0	80	30.00	0.44	27000
20	E20	1	1	E20-A20-SE-095	20.0	19.2	56	95.0	38.0	80	50.00	0.46	40000
	E20	1	1	E20-A20-SE-180	20.0	19.2	69	180.0	110.0	80	50.00	0.82	20000
25	E25	1	1	E25-A25-SE-200	25.0	24.1	79	200.0	120.0	80	65.00	1.36	19000

### Note!

Cemented carbide shank to be used for Finishing/Semi finishing only

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



N23



N6



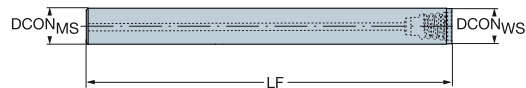
N15



N3

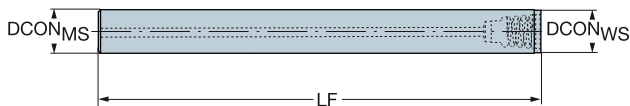
# Cylindrical shank to Coromant EH adaptor

Straight design



## G-undersized steel shank

					Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	BAR	KG	RPMX
9	E10	1	1	EH10-A09.7-SS-080	9.7	9.6	78	80.0	80	0.10	40000
11	E12	1	1	EH12-A11.7-SS-085	11.7	11.6	83	85.0	80	0.12	40000
15	E16	1	1	EH16-A15.7-SS-100	15.7	15.4	97	100.0	80	0.24	40000
19	E20	1	1	EH20-A19.7-SS-120	19.7	19.2	117	120.0	80	0.38	40000
24	E25	1	1	EH25-A24.7-SS-135	24.7	24.1	132	135.0	80	0.56	40000



## G-undersized heavy metal shank

					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	BAR	NM	KG	RPMX
9	E10	1	1	EH10-A09.7-SH-120	9.7	9.6	117	120.0	80	0.20	19000	
	E10	1	1	EH10-A09.7-SH-100	9.7	9.6	97	100.0	80	12.00	0.17	23000
11	E12	1	1	EH12-A11.7-SH-135	11.7	11.6	132	135.0	80	0.29	17000	
	E12	1	1	EH12-A11.7-SH-110	11.7	11.6	107	110.0	80	15.00	0.25	23000
15	E16	1	1	EH16-A15.7-SH-160	15.7	15.4	156	160.0	80	0.61	15000	
	E16	1	1	EH16-A15.7-SH-130	15.7	15.4	126	130.0	80	30.00	0.51	19000
19	E20	1	1	EH20-A19.7-SH-200	19.7	19.2	196	200.0	80	1.15	12000	
	E20	1	1	EH20-A19.7-SH-160	19.7	19.2	156	160.0	80	50.00	0.91	19000
24	E25	1	1	EH25-A24.7-SH-235	24.7	24.1	231	235.0	80	1.99	10500	
	E25	1	1	EH25-A24.7-SH-185	24.7	24.1	181	185.0	80	65.00	1.58	14000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



N23



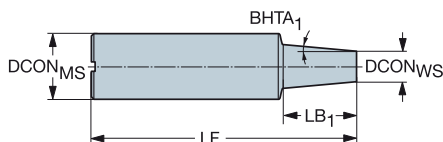
N15



N3

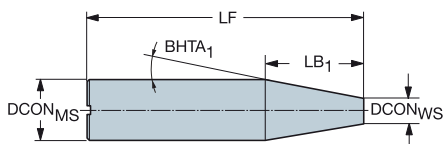
# Cylindrical shank to Coromant EH adaptor

## Conical design



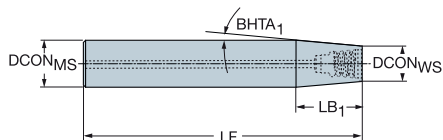
## Steel shank

		Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX
16	E10	1	1	E10-A16-CS-140	16.0	9.6	103	140.0	36.6	5°	80	12.00	0.24	16000
	E10	1	1	E10-A16-CS-160	16.0	9.6	108	160.0	50.0	1°	80	12.00	0.24	12000
	E12	1	1	E12-A16-CS-140	16.0	11.6	115	140.0	25.1	5°	80	15.00	0.25	16000
20	E16	1	1	E16-A16-CS-170	16.0	11.6	108	170.0	60.0	1°	80	15.00	0.30	12000
	E16	1	1	E16-A20-CS-190	20.0	15.4	112	190.0	75.0	1°	80	30.00	0.49	13000
25	E16	1	1	E16-A25-CS-170	25.0	15.4	115	170.0	54.9	5°	80	30.00	0.66	18000
32	E10	1	1	E10-A32-CS-250	32.0	9.6	186	250.0	63.5	10°	80	12.00	1.39	10000
	E12	1	1	E12-A32-CS-250	32.0	11.6	192	250.0	57.8	10°	80	15.00	1.50	10000
	E20	1	1	E20-A32-CS-180	32.0	19.2	107	180.0	73.2	5°	80	50.00	1.06	20000
E25	1	1	E25-A32-CS-200	32.0	24.1	154	200.0	45.1	5°	80	65.00	1.29	15000	



## Steel shank

		Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BHTA <sub>1</sub>	BAR	KG	RPMX
20	E16	1	1	EH16-A20-CS-165	20.0	15.4	138	165.0	26.3	5°	80	0.44	27000
25	E20	1	1	EH20-A25-CS-200	25.0	19.2	120	200.0	80.0	1°	80	0.70	19000



## Cemented carbide shank

		Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BHTA <sub>1</sub>	BAR	NM	KG	RPMX
16	E10	1	1	EH10-A16-CE-140	16.0	9.6	103	140.0	36.6	5°	80		0.41	36000
	E12	1	1	EH12-A16-CE-165	16.0	11.6	139	165.0	25.1	5°	80		0.50	23000
	E10	1	1	E10-A16-CE-155	16.0	9.6	52	155.0	100.0	1°	80	12.00	0.34	22000
20	E12	1	1	E12-A16-CE-150	16.0	11.6	58	150.0	90.0	1°	80	15.00	0.39	23000
	E16	1	1	EH16-A20-CE-165	20.0	15.4	138	165.0	26.3	5°	80		0.78	27000
25	E16	1	1	E16-A20-CE-175	20.0	15.4	55	175.0	118.0	1°	80	30.00	0.72	22000
	E20	1	1	EH20-A25-CE-150	25.0	19.2	116	150.0	33.1	5°	80	50.00	1.05	23000
32	E20	1	1	EH20-A25-CE-200	25.0	19.2	117	200.0	83.0	2°	80	50.00	1.08	19000
	E20	1	1	EH20-A32-CE-175	32.0	19.2	101	175.0	73.2	5°	80	50.00	1.78	21000
	E25	1	1	EH25-A32-CE-190	32.0	24.1	144	190.0	45.1	5°	80	65.00	2.07	20000
E25	1	1	EH25-A32-CE-215	32.0	24.1	169	215.0	45.1	5°	80	65.00	2.41	18000	

### Note!

Cemented carbide shank to be used for Finishing/Semi finishing only

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



N23



N6



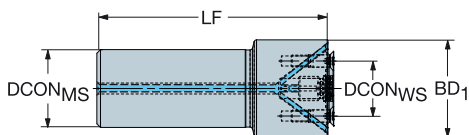
N15



N3

# Cylindrical shank to arbor with driving screws adaptor

For CoroMill® QD with internal coolant supply



				Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LSC	LF	BD <sub>1</sub>	BAR	NM	KG	RPMX
25	X10	1	3	CY25-X10-032-090	25.0	22.0	10.0	57	90.0	32.0	80	6.40	0.42	12000
	X22	1	3	CY25-X22-040-090	25.0	32.0	22.0	57	90.0	40.0	80	3.90	0.53	11000
32	X22	1	3	CY32-X22-040-095	32.0	32.0	22.0	61	95.0	40.0	80	3.90	0.71	11000



N23

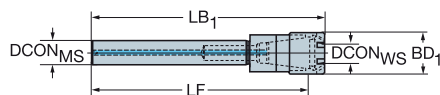


N15



# Cylindrical shank to ER collet chuck

Workpiece side interface DIN 6499-B



					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BD <sub>1</sub>	BAR	KG
8	ER11	1	1	393.14-08 11 056	8.0	11.4	52	75.0	82.5	16.0	20	0.05
12	ER16	1	1	393.14-12 16 080	12.0	17.0	77	107.0	118.5	22.0	20	0.13
16	ER11	1	1	393.14-16 11 150	16.0	11.4	149	163.5	171.0	16.0	20	0.21
20	ER16	1	1	393.14-20 16 155	20.0	17.0	155	170.0	181.5	22.0	20	0.31
25	ER20	1	1	393.14-25 20 170A	25.0	21.0	141	170.5	182.0	28.0	20	0.51

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



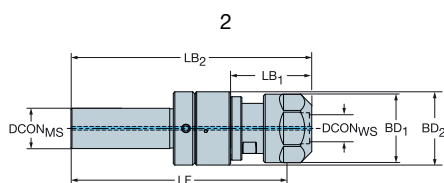
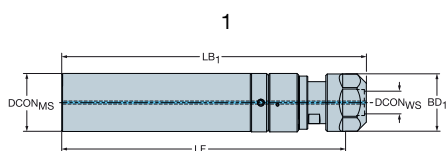
N15

# Cylindrical shank to CoroChuck™ 970

Workpiece side interface DIN 6499-B



DSGN



						Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	(BAR)	(KG)	RPMX	
12	ER8	M3	1	1	1	970-CY12-8-052	12.0	8.5	70	94.0	100.0		12.0		60	0.12	8000	
16	ER11	M5	1	1	2	970-CY16-11-052	16.0	11.3	44	91.5	25.2	96.4	18.7	23.5	80	0.16	8000	
20	ER20	M12	1	1	2	970-CY20-20-069	20.0	20.8	50	106.5	40.2	119.5	34.0	34.6	80	0.44	8000	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23

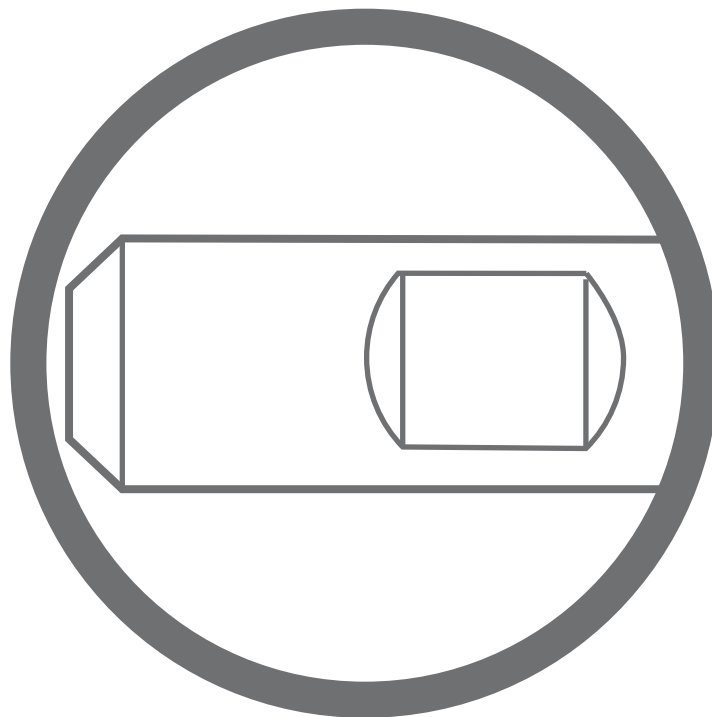


N15

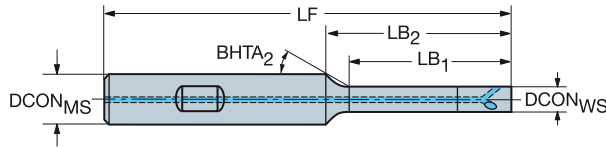


N5

## Machine side interface Weldon shank



# Weldon to CoroMill® 327 adaptor



		Dimensions, mm														
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BHTA <sub>2</sub>	BAR	NM	KG	RPMX
12	06	1	1	327-12B15SC-06	12.0	6.0	46	70.5	11.5	17.2	6.0	30°	20	1.80	0.07	40000
	06	1	1	327-12B21EC-06	12.0	6.0	46	76.5	17.5	23.2	6.0	30°	20	1.80	0.13	40000
	06	1	1	327-12B30EC-06	12.0	6.0	46	86.5	26.5	32.2	6.0	30°	20	1.80	0.13	40000
	06	1	1	327-12B42EC-06	12.0	6.0	46	96.5	38.5	44.2	6.0	30°	20	1.80	0.13	40000
16	09	1	1	327-16B18SC-09	16.0	9.0	49	74.3	12.2	18.8	9.0	30°	20	4.30	0.19	40000
	12	1	1	327-16B24SC-12	16.0	12.0	49	74.3	18.3	22.3	12.0	30°	20	6.50	0.10	40000
	09	1	1	327-16B32EC-09	16.0	9.0	49	94.3	26.2	32.8	9.0	30°	20	4.30	0.27	40000
	09	1	1	327-16B45EC-09	16.0	9.0	49	104.3	39.2	45.8	9.0	30°	20	4.30	0.20	40000
	09	1	1	327-16B64EC-09	16.0	9.0	49	124.3	58.2	64.8	9.0	30°	20	4.30	0.30	40000
	12	1	1	327-16B42EC-12	16.0	12.0	49	94.3	36.3	40.3	12.0	30°	20	6.50	0.28	40000
	12	1	1	327-16B60EC-12	16.0	12.0	49	124.3	54.3	58.3	12.0	30°	20	6.50	0.34	35000
	12	1	1	327-16B85EC-12	16.0	12.0	49	154.3	79.3	83.3	12.0	30°	20	6.50	0.39	30000
	14	1	1	327-16B42EC-14	16.0	14.3	49	93.5	35.5	37.5	14.3	30°	20	6.50	0.30	40000
	14	1	1	327-16B60EC-14	16.0	14.3	49	123.5	53.5	55.5	14.3	30°	20	6.50	0.37	35000
	14	1	1	327-16B85EC-14	16.0	14.3	49	153.5	78.5	80.5	14.3	30°	20	6.50	0.47	27000
	20	14	1	327-20B35SC-14	20.0	14.3	51	93.5	28.5	33.2	14.0	30°	20	6.50	0.28	40000

S = Steel shank

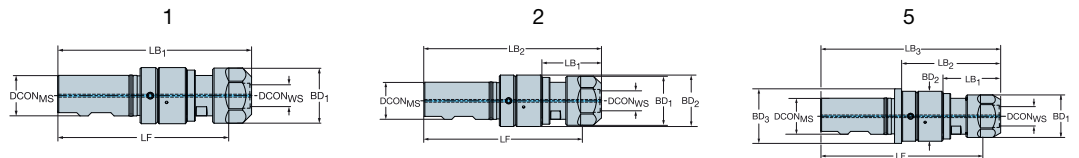
E = Cemented carbide shank

# Weldon to CoroChuck™ 970

Workpiece side interface DIN 6499-B



DSGN

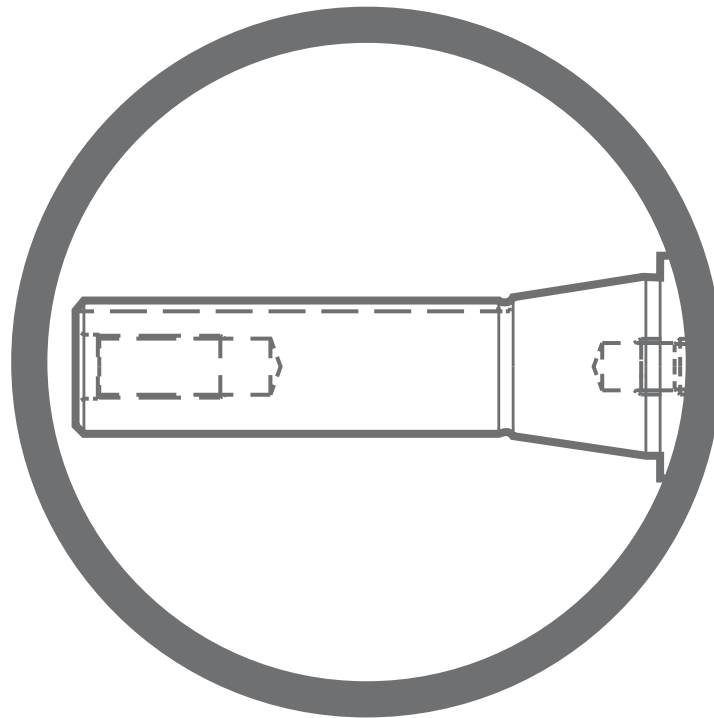


		Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BAR	KG	RPMX
16	ER11	M5	1	1	2	970-WE16-11-052	16.0	11.3	44	91.5	25.2	96.4		18.7	23.5		80	0.18	8000
20	ER11	M5	1	1	5	970-WE20-11-052	20.0	11.3	50	97.8	25.2	48.6	102.7	18.7	23.5	28.5	80	0.22	8000
	ER20	M12	1	1	2	970-WE20-20-069	20.0	20.8	50	106.5	40.3	119.5		33.7	34.6		80	0.44	8000
25	ER11	M5	1	1	5	970-WE25-11-052	25.0	11.3	50	97.8	25.2	48.6	102.7	18.7	23.5	28.5	80	0.30	8000
	ER20	M12	1	1	2	970-WE25-20-069	25.0	20.8	50	106.5	40.1	119.5		33.7	34.6		80	0.47	8000
	ER25	M20	1	1	2	970-WE25-25-088	25.0	25.8	50	125.4	42.2	138.9		41.7	44.0		80	0.84	8000
	ER40	M30	1	1	1	970-WE25-40-117	25.0	40.8	50	151.4	167.9			63.0			80	2.10	8000
40	ER50	M48	1	1	5	970-WE40-50-164	40.0	52.0	70	211.8	78.5	134.8	234.3	78.0	80.0	86.0	80	5.20	8000

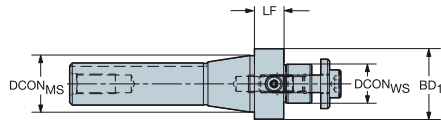
For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# Machine side interface Bridgeport



# R8 (Bridgeport) to arbor adaptor



		Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>WS</sub>	Ordering code	DCON <sub>WS</sub>	LF	BD <sub>1</sub>	NM	KG	RPMX
R8	22	392.R8.05-22 020	22.0	20.0	40.0	45.00	0.67	10000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1

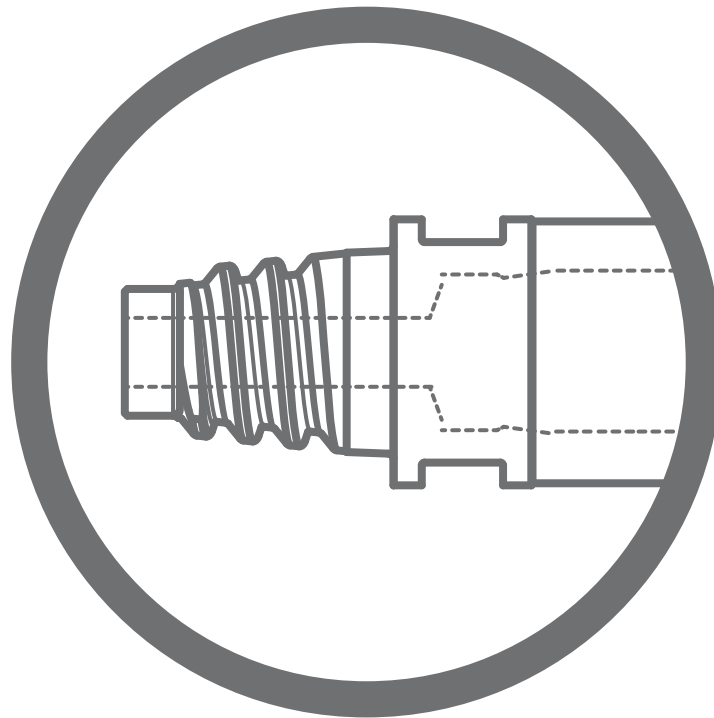


N23

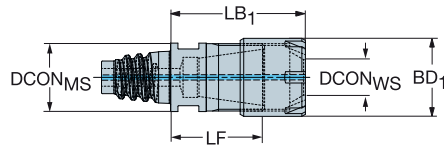


N15

## Machine side interface Coromant EH

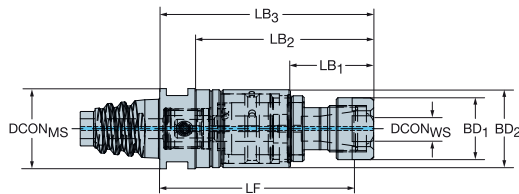
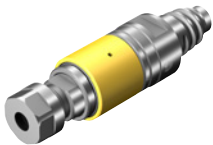


### Coromant EH to ER adaptor



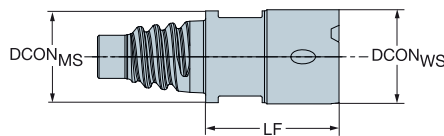
					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>1</sub>	BAR	KG	RPMX
E12	ER8	1	1	ER-EH12-08-024	11.7	8.5	18.0	24.0	12.0	80	0.03	40000
E16	ER11	1	1	ER-EH16-11-028	15.5	11.4	20.5	28.0	16.0	80	0.04	40000
E20	ER16	1	1	ER-EH20-16-038	19.3	17.0	26.5	38.0	22.0	80	0.08	40000
E25	ER20	1	1	ER-EH25-20-042	24.2	21.0	30.5	42.0	28.0	80	0.12	32000

### Coromant EH to CoroChuck™ 970



					Dimensions, mm											
CZC <sub>MS</sub>	CZC <sub>WS</sub>	TRMAX	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	KG	RPMX
E25	ER11	M5	1	1	970-EH25-11-065	24.2	11.3	59.8	25.1	53.6	64.6	18.7	23.5	80	0.16	8000

### Coromant EH to CoroMill® 327 adaptor



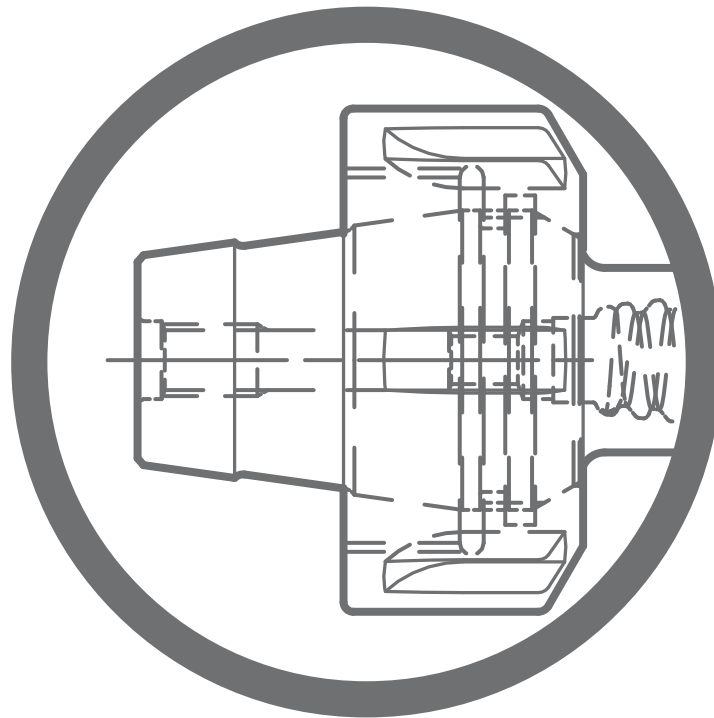
					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	BD <sub>1</sub>	BAR	NM	KG	RPMX
E10	09	1	3	327-EH10-09-015	9.7	9.0	15.0	10.0	20	4.30	0.02	40000
E12	12	1	3	327-EH12-12-017	11.7	12.0	17.0	12.0	20	6.50	0.02	40000
	14	1	3	327-EH12-14-017	11.7	14.3	17.0	14.3	20	6.50	0.01	40000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



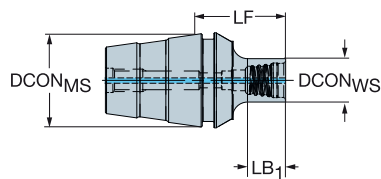


# Machine side interface ER

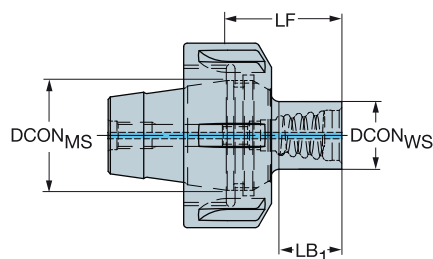


# ER to Coromant EH adaptor

Machine side interface DIN 6499-B



					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BAR	NM	KG	RPMX
ER16	E10	1	1	EH-ER16-10-008	17.0	9.6	14.9	7.2	80	12.00	0.09	40000
ER20	E10	1	1	EH-ER20-10-008	21.0	9.6	15.8	7.2	80	12.00	0.11	40000
	E12	1	1	EH-ER20-12-010	21.0	11.6	17.8	9.2	80	15.00	0.13	40000
ER25	E10	1	1	EH-ER25-10-012	26.0	9.6	20.3	7.2	80	12.00	0.16	32000
	E12	1	1	EH-ER25-12-014	26.0	11.6	22.3	10.2	80	15.00	0.17	32000
	E16	1	1	EH-ER25-16-016	26.0	15.4	24.3	14.2	80	30.00	0.22	32000
ER32	E10	1	1	EH-ER32-10-012	33.0	9.6	21.5	7.4	80	12.00	0.25	25000
	E12	1	1	EH-ER32-12-014	33.0	11.6	23.5	9.4	80	15.00	0.27	25000
	E16	1	1	EH-ER32-16-018	33.0	15.4	27.5	13.4	80	30.00	0.35	25000
	E20	1	1	EH-ER32-20-022	33.0	19.2	31.5	18.9	80	50.00	0.34	25000
	E25	1	1	EH-ER32-25-025	33.0	24.1	34.5	25.0	80	65.00	0.41	25000
ER40	E16	1	1	EH-ER40-16-022	41.0	15.4	33.1	15.0	20		0.51	20000
	E20	1	1	EH-ER40-20-025	41.0	19.2	36.1	19.0	20		0.53	20000
	E25	1	1	EH-ER40-25-028	41.0	24.1	39.1	24.0	20		0.58	20000



					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BAR	NM	KG	RPMX
ER11	E10	1	1	392.EREH-11 10 008	11.4	9.6	16.8	8.0	80	12.00	0.09	40000
ER16	E12	1	1	392.EREH-16 12 010	17.0	11.6	20.5	10.0	80	15.00	0.16	40000
ER20	E16	1	1	392.EREH-20 16 014	21.0	15.4	24.1	14.0	80	30.00	0.27	40000
ER25	E20	1	1	392.EREH-25 20 019	26.0	19.2	29.1	19.0	80	50.00	0.36	40000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



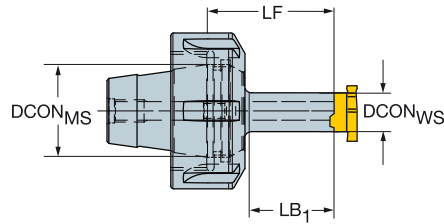
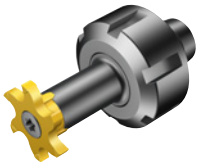
N15



N3

## ER to CoroMill® 327 adaptor

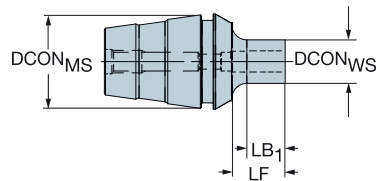
Machine side interface DIN 6499-B



		Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>1</sub>	$\text{NM}$	$\text{KG}$	RPMX	
ER11	09	392.ER327-11 09 022	11.4	9.0	25.0	16.0	9.0	4.30	0.07	40000	
ER16	09	392.ER327-16 09 022	17.0	9.0	26.8	16.2	9.0	4.30	0.15	40000	
	12	392.ER327-16 12 030	17.0	12.0	34.8	24.3	12.0	6.50	0.22	40000	
ER20	12	392.ER327-20 12 030	21.0	12.0	34.7	24.8	12.0	6.50	0.25	40000	
	14	392.ER327-20 14 035	21.0	14.3	38.9	28.8	14.0	6.50	0.27	40000	
ER32	14	392.ER327-32 14 035	33.0	14.3	41.3	28.8	14.0	6.50	0.50	25000	

**Note!**

The nut is not a standard ER nut and therefore not exchangeable with the spare part series 5533 050-0X. The nut is always included in the package!



		Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>1</sub>	$\text{NM}$	$\text{KG}$	RPMX	
ER11	06	327-ER11-06-016	11.4	6.0	17.5	12.8	6.0	1.80	0.03	40000	
ER20	09	327-ER20-09-022	21.0	9.0	24.7	16.5	9.0	4.30	0.09	40000	
ER25	09	327-ER25-09-022	26.0	9.0	25.2	16.5	9.0	4.30	0.13	32000	
	12	327-ER25-12-030	26.0	12.0	33.2	24.6	12.0	6.50	0.22	32000	
	14	327-ER25-14-019	26.0	14.3	22.9	14.3	14.0	6.50	0.21	32000	
ER32	14	327-ER25-14-035	26.0	14.3	37.4	28.8	14.0	6.50	0.23	32000	
	12	327-ER32-12-030	33.0	12.0	34.2	24.6	12.0	6.50	0.31	25000	
	14	327-ER32-14-019	33.0	14.3	23.9	14.3	14.0	6.50	0.30	25000	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



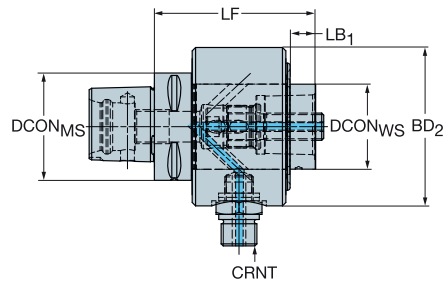
M1



N23

# Coromant Capto® reduction adaptor

Coolant inducer

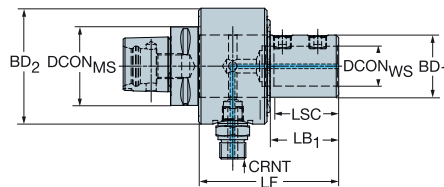


Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	BD <sub>2</sub>	CRNT	BAR	NM	KG	RPMX
C5	C4	2	1	C5-391.02CCH-40 090	50.0	40.0	90.0	16.5	78.0	G 3/8"	18	55.00	1.96	6300
C6	C5	2	1	C6-391.02CCH-50 095	63.0	50.0	95.0	15.0	93.0	G 1/2"	18	95.00	1.60	4300
C8	C6	2	1	C8-391.02CCH-63 110	80.0	63.0	110.0	15.0	108.0	G 1/2"	18	170.00	4.77	3300

# Coromant Capto® to ISO 9766 adaptor

Coolant inducer



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BD <sub>1</sub>	BD <sub>2</sub>	CRNT	BAR	NM	KG	RPMX
C5	20	2	1	C5-391.27CCH-20 120	50.0	20.0	51	120.0	46.5	40.0	78.0	G 3/8"	18	12.00	2.27	6300
	25	2	1	C5-391.27CCH-25 135	50.0	25.0	57	135.0	49.7	45.0	93.0	G 1/2"	18	20	3.16	5300
C6	32	2	1	C6-391.27CCH-32 135	63.0	32.0	61	135.0	55.0	50.0	93.0	G 1/2"	18	30	3.41	5300
C8	40	2	1	C8-391.27CCH-40 155	80.0	40.0	71	155.0	63.5	65.0	108.0	G 1/2"	18	40	5.75	4000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N15

# Silent Tools®

## Adaptors with a dampening mechanism

### Application

- In operations with long overhangs
- Productivity increases and surface quality improvements in short overhangs

### Minimizing vibration at long overhangs over 3×D

Silent Tools adaptors minimize vibration through a dampener inside the tool maintaining good productivity and close tolerances even at long overhangs



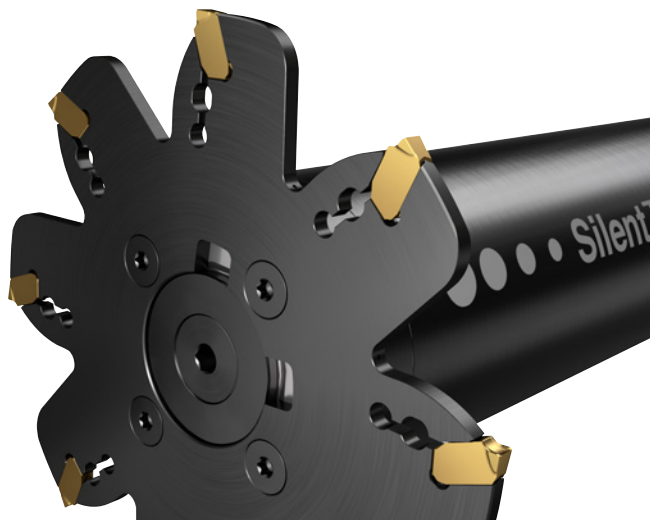
● ● ● ● SilentTools®

### Boring

Problems that originate from vibrations are frequently encountered in boring and other operations, especially when machining with long overhangs. The vibrations may cause bad surface texture, insufficient accuracy and loss of productivity, increased insert and machine tool wear, as well as noise. Solving vibration problems will therefore always give you a productivity boost.

### Milling

In many machining centers, the components and machine tools require long tool assemblies to reach down in large components. Vibration risk is high, and the typical remedy is either slow machining or damped tools. With Silent Tools milling adapters, chatter and vibrations are eliminated, allowing the machining rate to be increased and improving process security. Silent Tools for milling are productivity boosters.



[www.sandvik.coromant.com/silenttools](http://www.sandvik.coromant.com/silenttools)



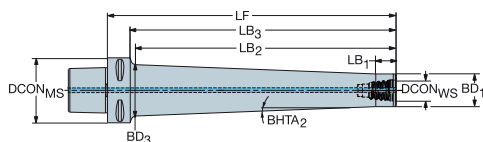
The dampening system consists of a heavy mass, supported on rubber spring elements

# Coromant Capto® to Coromant EH damped adaptor

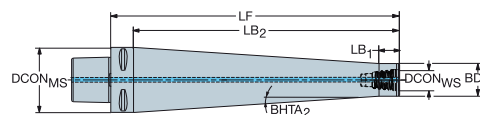


DSGN

12



7



●●● SilentTools®

					Dimensions, mm																	
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	LB <sub>4</sub>	BD <sub>1</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BHTA <sub>2</sub>	BHTA <sub>3</sub>	(BAR)	(NM)	(KG)	RPMX	
C4	E16	3	1	12	C4-EH16D-175	40.0	15.4	175.0	3.0	150.0	155.0	175.0	19.5	29.7	40.0	2°	45°	70	30.00	1.05	15000	
C5	E20	3	1	12	C5-EH20D-185	50.0	19.2	185.0	3.0	159.0	165.0	185.0	24.0	33.8	50.0	1°	53°	70	50.00	1.53	15000	
					C5-EH25D-280	50.0	24.1	280.0	20.0	260.0	280.0	31.7	50.0	2°	0°	70	65.00	5.29	10000			
C6	E25	3	1	12	C6-EH25D-280	63.0	24.1	280.0	20.0	252.0	258.0	280.0	31.7	49.7	63.0	2°	67°	70	65.00	5.68	10000	
					C6-EH25D-340	63.0	24.1	340.0	20.0	313.0	317.8	340.0	31.7	54.7	63.0	2°	61°	70	65.00	7.00	8000	
C8	E25	3	1	12	C8-EH25D-420	80.0	24.1	420.0	8.0	384.0	390.0	420.0	31.7	61.7	80.0	2°	71°	70	65.00	10.61	6000	

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



N23



N15

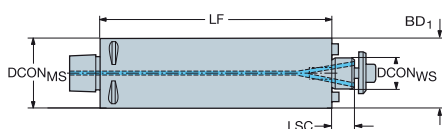


N3

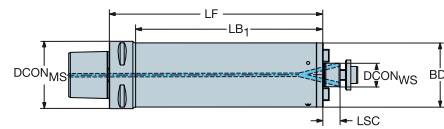
## Coromant Capto® to arbor damped adaptor



DSGN 1



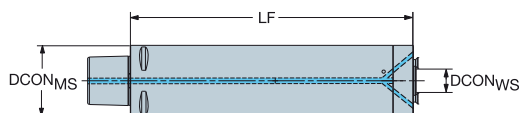
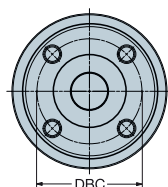
2



●●●● SilentTools®

					Dimensions, mm												
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	DSGN	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	LB <sub>2</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BAR	NM	KG	RPMX
C4	16	3	4	2	C4-Q16D-038-130	40.0	16.0	11	130.0	107.8	130.0	38.0	40.0	70	22.00	1.62	16000
	16	3	4	2	C4-Q16D-038-200	40.0	16.0	11	200.0	177.8	200.0	38.0	40.0	70	22.00	2.32	8000
C5	22	3	4	2	C5-Q22D-048-180	50.0	22.0	16	180.0	157.6	180.0	47.5	50.0	70	45.00	3.22	14000
	22	3	4	2	C5-Q22D-048-220	50.0	22.0	16	220.0	197.6	220.0	47.5	50.0	70	45.00	6.04	11000
	22	3	4	2	C5-Q22D-048-270	50.0	22.0	16	270.0	247.6	270.0	47.5	50.0	70	45.00	6.85	7000
C6	22	3	4	2	C6-Q22D-060-200	63.0	22.0	16	200.0	175.4	200.0	60.0	63.0	70	45.00	8.05	15000
	22	3	4	2	C6-Q22D-060-260	63.0	22.0	16	260.0	235.4	260.0	60.0	63.0	70	45.00	9.29	11000
	22	3	4	2	C6-Q22D-060-310	63.0	22.0	16	310.0	285.4	310.0	60.0	63.0	70	45.00	10.86	6000
	27	3	4	1	C6-Q27D-063-200	63.0	27.0	18	200.0	200.0		63.0	70	80.00	8.54	11000	
	27	3	4	1	C6-Q27D-063-260	63.0	27.0	18	260.0	260.0		63.0	70	80.00	9.88	8000	
C8	27	3	4	1	C6-Q27D-063-310	63.0	27.0	18	310.0	310.0		63.0	70	80.00	11.57	5000	
	27	3	4	2	C8-Q27D-076-220	80.0	27.0	18	220.0	187.2	220.0	76.0	80.0	70	80.00	12.92	12000
	27	3	4	2	C8-Q27D-076-320	80.0	27.0	18	320.0	287.2	320.0	76.0	80.0	70	80.00	13.40	8000
	27	3	4	2	C8-Q27D-076-360	80.0	27.0	18	360.0	327.2	360.0	76.0	80.0	70	80.00	18.20	6000
	32	3	4	1	C8-Q32D-080-220	80.0	32.0	20	220.0	220.0		80.0	70	180.00	13.73	10000	
	32	3	4	1	C8-Q32D-080-320	80.0	32.0	20	320.0	320.0		80.0	70	180.00	18.00	6000	
C10	32	3	4	2	C8-Q32D-080-360	80.0	32.0	20	360.0	360.0		80.0	70	180.00	19.60	4000	
	40	3	4	1	C10-Q40D-100-400	100.0	40.0	23	400.0	400.0		100.0	70	300.00	28.30	5000	

## Coromant Capto® to arbor with driving screws damped adaptor



●●●● SilentTools®

For CoroMill® QD with internal coolant supply

					Dimensions, mm							
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DBC	DCON <sub>WS</sub>	LSC	LF	BAR	NM	KG
C3	X10	3	4	C3-X10D-032-128	32.0	22.0	10.0	2	128.0	70	6.40	1.10
C4	X22	3	3	C4-X22D-040-160	40.0	32.0	22.0	2	160.0	70	3.90	1.92
C6	X32	3	3	C6-X32D-063-252	63.0	45.0	32.0	2	252.0	70	6.40	9.30
C8	X40	3	3	C8-X40D-080-320	80.0	63.0	40.0	2	320.0	70	70.00	17.45

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

M1

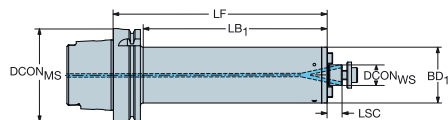


N23



N15

# HSK to arbor damped adaptor



●●● SilentTools®

					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	LB <sub>1</sub>	BD <sub>1</sub>	BAR	NM	KG	RPMX
63	16	1	4	HA06-Q16D-038-160	63.0	16.0	11	160.0	131.0	38.0	70	22.00	4.35	16000
16	1	4		HA06-Q16D-038-230	63.0	16.0	11	230.0	201.0	38.0	70	22.00	5.06	8000
22	1	4		HA06-Q22D-048-210	63.0	22.0	16	210.0	181.0	47.5	70	45.00	6.10	8000
22	1	4		HA06-Q22D-048-260	63.0	22.0	16	260.0	231.0	47.5	70	45.00	6.89	5000
100	22	1	4	HA10-Q22D-048-213	100.0	22.0	16	213.0	181.0	47.5	70	45.00	7.68	14000
22	1	4		HA10-Q22D-048-263	100.0	22.0	16	263.0	231.0	47.5	70	45.00	8.55	9000
22	1	4		HA10-Q22D-060-230	100.0	22.0	16	230.0	198.0	60.0	70	45.00	9.78	14000
22	1	4		HA10-Q22D-060-340	100.0	22.0	16	340.0	308.0	60.0	70	45.00	12.96	7000
27	1	4		HA10-Q27D-076-250	100.0	27.0	18	250.0	218.0	76.0	70	80.00	14.13	10000
27	1	4		HA10-Q27D-076-390	100.0	27.0	18	390.0	358.0	76.0	70	80.00	20.00	5000
32	1	4		HA10-Q32D-080-250	100.0	32.0	20	250.0	218.0	80.0	70	180.00	15.30	10000
32	1	4		HA10-Q32D-080-390	100.0	32.0	20	390.0	358.0	80.0	70	180.00	21.07	5000

For spare parts, visit [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



M1



N23



N15



# Accessories

Coromant Capto® M2

Assembly fixture M3  
Tool wagon for Coromant Capto® M4  
Cassettes (polygon seating) M5  
Locking mechanism for cassettes M6  
Assembly item M7-M9  
Torque value M10

## HSK

Assembly item M11

## Accessory item for CoroBore®

Corobore® XL pre measuring unit M12  
Shim set M12

## Arbor

Arbor mounting screws with coolant hole M13  
Spacing rings M14

## Sleeves and collets

Cylindrical sleeves M15-M18  
Extractor for cylindrical sleeves M18  
Cylindrical sleeve with mechanical locking interface M19  
Eccentric sleeve M20  
ER collet M21  
ER Collet for tap shank M24  
ER collet sealing discs M25  
Sleeve for fine boring head M26  
Assembly item M27

## Adaptors

Slide to adjustable drill adaptor M28  
VL M28

## Keys and torque wrenches

Assembly tools M29  
Torx Plus® torque wrench M32

Pull studs M33-M34

# Coromant Capto®

## Three systems in one

### Application

- Coromant Capto works in all machine types:
- Turning centers – quick-change and high pressure coolant delivery.
- Multi-task machines and machining centers - rotating spindle interface, modular tooling, and quick change.
- Available in six sizes, there is a flexible Coromant Capto solution for every need: C3-C10



### Benefits and features

- Flexible with extensive modularity
- High basic stability and accuracy
- Minimized tool inventory
- Reduced set-up time
- High torque transmission
- High bending strength
- Quick-change and automated tool change
- Advanced nozzle technology for process security even at low pressures
- Through-tool delivery of high-pressure coolant, from machine to cutting edge
- Balanced and concentric
- Self-centering

[www.sandvik.coromant.com/coromantcapto](http://www.sandvik.coromant.com/coromantcapto)

### Quick change

- Turning centres
- Vertical lathes

Coromant Capto clamping units and driven tool holders reduce set-up and tool change time for high machine utilization.

### Integrated spindle

- Multi-task machines
- Vertical lathes
- Machining centres with turning option

Coromant Capto integrated in the spindle adds stability and versatility.

### Modular system

- Machining centres
- Multi-task machines
- Vertical lathes

Coromant Capto machine interface adaptors in combination with extension and reduction adaptors enable assembling of tools with different lengths and design regardless of the machine interface.

### Coromant Capto® range

Coromant Capto programme includes machine interface adaptors, clamping units, tool holders, integrated cutting tools, adaptors and chucks.

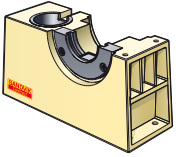


## Assembly fixture

### Fixture body

Ordering code:

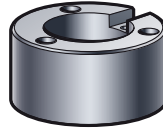
391.500



### Fixture body for sleeves

Ordering code:

391.501



#### Ordering code



Sleeve	For holder type, size
391.540-C3	Coromant Capto Size C3
391.540-C4	Coromant Capto Size C4
391.540-C5	Coromant Capto Size C5
391.540-C6	Coromant Capto Size C6
391.540-C8	Coromant Capto Size C8
391.540-C10	Coromant Capto Size C10
391.540-HA04	HSK 40 Form A/C
391.540-HA05	HSK 50 Form A/C
391.540-HA06	HSK 63 Form A/C
391.540-HA08	HSK 80 Form A/C
391.540-HA10	HSK 100 Form A/C
391.540-30	MAS-BT/CAT/ISO 30
391.540-40	MAS-BT/CAT/ISO 40
391.540-50	MAS-BT/CAT/ISO 50

#### Ordering code

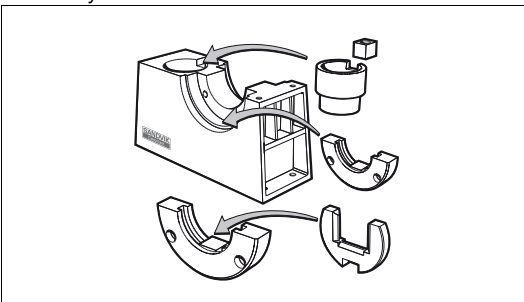


Flange	Collar	For holder type, size
391.510-140 50	391.530-C3	Coromant Capto Size C3
391.510-140 50	391.530-C4	Coromant Capto Size C4
391.510-140 50	391.530-C5	Coromant Capto Size C5
391.510-140 50	391.530-C6	Coromant Capto Size C6
391.510-140 50	391.530-C8	Coromant Capto Size C8
391.510-140 50	391.530-C10*	Coromant Capto Size C10
391.510-HA04		HSK 40 Form A
391.510-HA05		HSK 50 Form A
391.510-HA06		HSK 63 Form A
391.510-HA08		HSK 80 Form A
391.510-HA10		HSK 100 Form A
391.510-HA12		HSK 125 Form A
391.510-55 30		MAS-BT 30
391.510-55 40		MAS-BT 40
391.510-55 50		MAS-BT 50
391.510-562-40		BIG-PLUS, MAS-BT 40
391.510-562-50		BIG-PLUS, MAS-BT 50
391.510-140 40		DIN 69871/40, ANSIB 5.50-40. ISO7388/1-40, CAT 40
391.510-140 50		DIN 69871/50, ANSIB 5.50-40. ISO7388/1-50, CAT 50
391.510-540 40		BIG-PLUS DIN69871/1-40, BIG-PLUS 7388/1-40, CAT 40
391.510-540 50		BIG-PLUS DIN69871/1-50, BIG-PLUS 7388/1-50, CAT 50
391.510-00 40		DIN 2080-40/NMTB 40
391.510-00 50		DIN 2080-50/NMTB 50
A391.510-45 40		ANSIB 5.50-2009, CAT-V 40-2009
A391.510-45 50		ANSIB 5.50-2009, CAT-V 50-2009
A391.510-545 40		BIG-PLUS ANSIB 5.50-2009, CAT-V 40-2009
A391.510-545 50		BIG-PLUS ANSIB 5.50-2009, CAT-V 50-2009
391.510-140 50	391.530-970-11	CoroChuck 970, ER11
391.510-140 50	391.530-970-20	CoroChuck 970, ER20
391.510-140 50	391.530-970-25	CoroChuck 970, ER25
391.510-140 50	391.530-970-32	CoroChuck 970, ER32
391.510-140 50	391.530-970-40	CoroChuck 970, ER40

Note: Key is delivered with the sleeve.

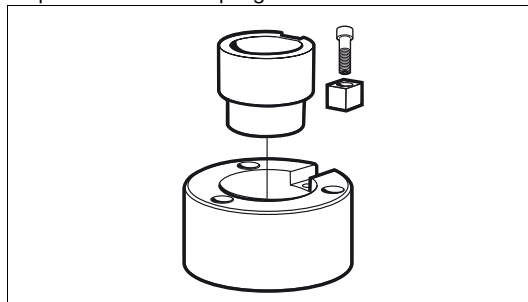
\* Combined collar and flange

#### Assembly fixture 391.500



Choose flange, collar and sleeve to suit tool to be assembled.

#### Fixture 391.501 for maintenance of tools with Coromant Capto® and HSK couplings



Choose sleeve to suit coupling.  
The fixture should be fastened to the bench with three socket head screws (not delivered with fixture)

## Tool wagon for Coromant Capto®

Quick change tooling



1. Cradle carrier
2. Tool cradles
3. Molded tool holders (To be ordered separately)

Ordering code	Kit consist of:		
CCW-KIT	TC-0	4 pieces	Tool cradles
	TCC-2	4 pairs	Frame carriers for tool cradle

To order a complete wagon 1 pcs CCW-KIT + Molded tool holders

Tool cradles and cradle carriers could be bought extra as accessories.

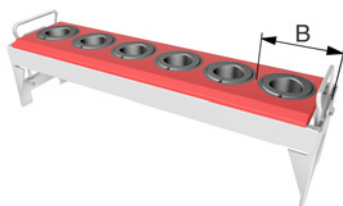
## Bench stand



Ordering code
BS-KIT

No accessory codes for bench stand.

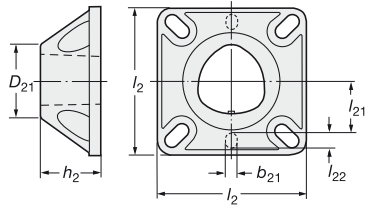
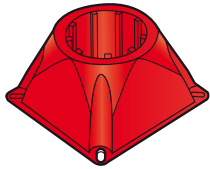
## Molded tool holders - to be ordered separately



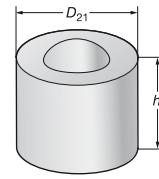
Ordering code	Width (B), mm	Max. number of tool holders in a cradle
C3-IC-1	58	C3 = 9
C4-IC-1	58	C4 = 9
C5-IC-1	65.5	C5 = 8
C6-IC-1	81.5	C6 = 6
C8-IC-1	105	C8 = 5
C10-IC-1	120	C10 = 4

# Cassettes (polygon seating)

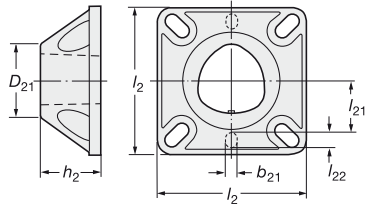
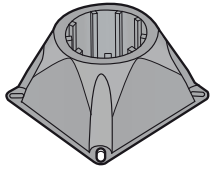
Coromant Capto®



**-4000**  
Plastic storage cassettes (red)

**-6000-B**

**Aluminium cassette blanks**

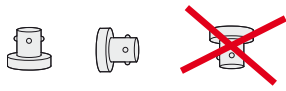
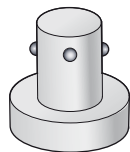


**-5000**  
High grade plastic in-machine tool storage (black)

Coupling size	Ordering code	Dimensions, mm						
			$b_{21}$	$D_{21}$	$h_2$	$l_2$	$l_{21}$	
C3	C3-C-4000	-	32	26	65	-	-	All plastic cassettes conforming to hole pattern 17 mm, 20 mm, 25 mm.  High grade plastic. Red colour. To be used: – alone for upright storage – with mechanism type PL-01 for horizontal or upright position.
C4	C4-C-4000	6	50	39	74	26	8	
C5	C5-C-4000	6	50	39	74	26	8	
C6	C6-C-4000	8	80	63	116	41	10	
C8	C8-C-4000	8	80	63	116	41	10	High grade re-inforced black plastic. For in-machine tool storage with mechanism AL-01.
C4	C4-C-5000	6	50	39	74	26	8	
C5	C5-C-5000	6	50	39	74	26	8	
C6	C6-C-5000	8	80	63	116	41	10	
C8	C8-C-5000	8	80	63	116	41	10	
C10	C10-C-5000	8	100	80	150	60	68	Aluminium cassette blanks for individual adaptation. To be used with AL-01.
C6	C6-C-6000-B	-	120	63	-	-	-	
C8	C8-C-6000-B	-	120	63	-	-	-	
C10	C10-C-6000-B	-	138	80	-	-	-	

## Locking mechanism for cassettes

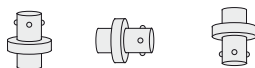
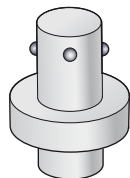
-PL



**Passive locking mechanism**

For vertical upwards and horizontal storage. NEVER upside down storage.

-AL



**Active locking mechanism**

For storage at all angles: vertical upwards and downwards or horizontal.

K

CZC	Ordering code	Pull action force, N	
C4	C4-PL-01	55	Central passive locking mechanism. Spring loaded clamping. Fits directly into all cassettes type 4000.
C5	C5-PL-01	120	
C6	C6-PL-01	150	
C8	C8-PL-01	240	

CZC	Ordering code	Rec. max. tool weight, kg	
C4	C4-AL-01	40	Active locking mechanism – mechanical push action. Fits directly into all cassettes type 5000/6000.
C5	C5-AL-01	60	
C6	C6-AL-01	75	
C8	C8-AL-01	110	
C10	C10-AL-01	150	

L

CZC	Ordering code	Rec. max. tool weight, kg	
C6	C6-AL-02	75	Active locking mechanism – mechanical push action. Fits directly into all cassettes type 5000/6000.
C8	C8-AL-02	110	

M

N

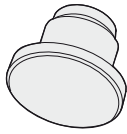
## Assembly item

### Cover plug

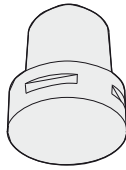
CP-11



CP-01



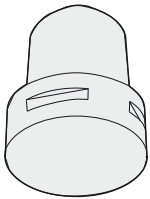
CPA-01



Coupling size	Ordering code		
	Manual unit	Automatic unit	Type 3000
C3	C3-CP-01	-	C3-CP-11
C4	C4-CP-01	C4-CPA-01	C4-CP-11
C5	C5-CP-01	C5-CPA-01	C5-CP-11
C6	C6-CP-01	C6-CPA-01	-
C8	C8-CP-01	C8-CPA-01	-
C10	-	C10-CPA-01	-

### Balancing tool

Cx-BAT-01

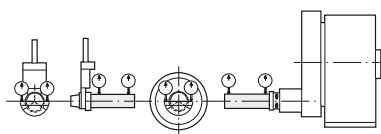


Coupling size	Ordering code
C3	C3-BAT-01
C4	C4-BAT-01
C5	C5-BAT-01
C6	C6-BAT-01
C8	C8-BAT-01
C10	C10-BAT-01

# Assembly item

## Master setting gauges

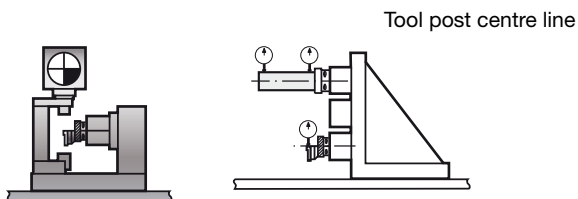
Checking position for grippers Spindle orientation



The Coromant Capto system guarantees exceptional, repeatable accuracy but this is of little use unless the various other components in the total machining process are correctly and accurately positioned.

Coromant offers a range of axial and centre height master setting gauges for the various coupling sizes which are strongly recommended for setting important parameters such as:

- The centre line of the tool post
- Spindle orientation
- The position of the tool for grippers
- Tool centre height and cutting edge position ( $f_1$  and  $l_1$  dimensions). Gauges can be used in a pre-measuring fixture
- Component fixtures

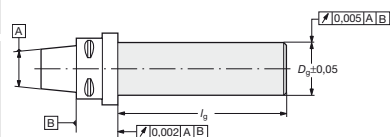


Tool presetting

Component fixture geometric control

## Axial gauge

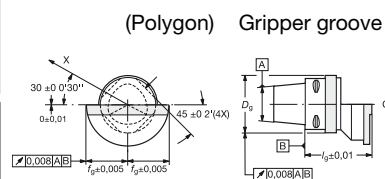
### Master setting gauges MAS-11



		Dimensions, mm	
Coupling size	Ordering code	$D_g$	$l_g$
C3	C3-MAS-11	25	160
C4	C4-MAS-11	25	160
C5	C5-MAS-11	32	210
C6	C6-MAS-11	40	315
C8	C8-MAS-11	40	315
C10	C10-MAS-11	60	420

## Centre height gauge

### Master setting gauges MAS-01



		Dimensions, mm		
Coupling size	Ordering code	$f_g$	$l_g$	$D_g$
C3	C3-MAS-01	22	40	34
C4	C4-MAS-01	27	50	42
C5	C5-MAS-01	35	60	52
C6	C6-MAS-01	45	65	65
C8	C8-MAS-01	55	80	82
C10	C10-MAS-01	65	100	102

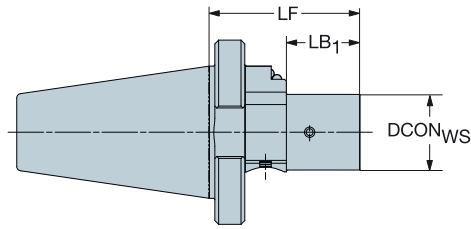
## Centre height gauge

		Dimensions, mm	
Coupling size	Ordering code	$l_g$	$D_g$
C4	C4-MAS-25 140	140	25
C5	C5-MAS-32 145	145	32
C6	C6-MAS-40 180	180	40
C8	C8-MAS-40 240	240	40



## Assembly item

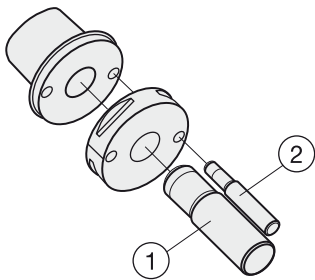
### Pre-measuring unit



				Dimensions, mm			
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>WS</sub>	LF	LB <sub>1</sub>
50	C3	0	0	C3-PMU-I50	32	75	36
	C4	0	0	C4-PMU-I50	40	80	39
	C5	0	0	C5-PMU-I50	50	90	45
	C6	0	0	C6-PMU-I50	63	107	56
	C8	0	0	C8-PMU-I50	80	127	60

## Alignment tool

This tool is used to check the Automatic Tool Change positioning tolerance between the gripper arm and magazine and the clamping unit/spindle. If the tolerance is not achieved the result can be abnormal wear on cutting tool or Coromant Capto interface, wrong clamping, dropped tools, personal injuries etc. Instructions and tolerances are available in the box together with the tool.



Coupling size	Ordering code Tool	Spare parts	
		1 Gauge pin	2 Gauge pin
C4	C4-AMT-01	5552 069-03	5552 069-01
C5	C5-AMT-01	5552 069-04	5552 069-01
C6	C6-AMT-01	5552 069-05	5552 069-02
C8	C8-AMT-01	5552 069-05	5552 069-02
C10	C10-AMT-01	5552 069-09	5552 069-08

## Torque value

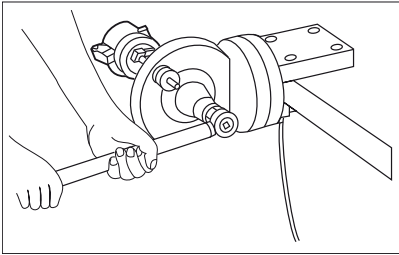
Tightening torque recommendations

Coromant Capto® tightening torque:

Manual clamping units and driven tool holders with camshaft mechanism

CZC	Torque Nm
C3	35
C4	50
C5	70
C6	90
C8	130
C10	285

Coromant Capto® basic holders



Centre bolt clamping

CZC	Torque Nm
C3	45
C4	55
C5	95
C6	170
C8	170
C10	380

# Assembly item

Coolant tube for solid HSK assortment



HSK size	Ordering code	Dimensions, mm				Key	
		BD	THL	OAL	KG	Ordering code	Torque Nm
40	5692 022-02	8	7.5	29.5	0.01	5680 094-02	10
50	5692 022-03	10	9.5	32.8	0.02	5680 094-03	15
63	5692 022-04	12	11.5	46.5	0.03	5680 094-04	20
100	5692 022-06	16	15.5	44.5	0.05	5680 094-06	30
100	5692 022-16	16.0	16.0	44	0.06	5680 094-06	30
125	5692 022-07	18	17.5	48	0.08	5680 094-07	30

## Shrink fit MQL screws

Fig. 1

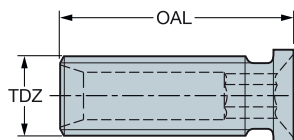
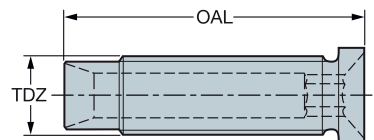


Fig. 2



Ordering code	Size	Fig.	Dimensions		
			OAL	TDZ	Key size
5692 039-01	6 mm	2	34	M5	SW 2,5
5692 039-02	6 mm	1	17	M5	SW 2,5
5692 039-03	8 mm	2	34	M6	SW 3
5692 039-04	8 mm	1	18	M6	SW 3
5692 039-05	10 mm	2	35	M8x1	SW 4
5692 039-06	10 mm	1	18	M8x1	SW 4
5692 039-07	12 mm	2	35	M10x1	SW 5
5692 039-08	12 mm	1	18	M10x1	SW 5
5692 039-09	16 mm	2	37	M10x1	SW 5
5692 039-10	16 mm	1	22	M10x1	SW 5
5692 039-11	20 mm	2	40	M10x1	SW 5
5692 039-12	20 mm	1	23,5	M10x1	SW 5
5692 039-13	25 mm	1	27,5	M10x1	SW 5
5692 039-14	25 mm	1	30,5	M10x1	SW 5

## Balancing screws



Ordering code
5514 100-01

## Adjustment screws for MQL tap holder CoroChuck 970-HAxxQ-xx-xxx

Taps with external center

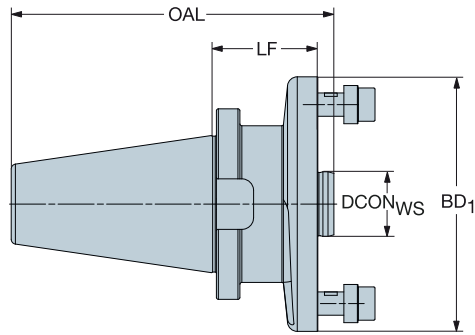
Tap shank diameter, mm	ER20	ER25
6, 7	5692 037-01	
8, 9	5692 037-02	5692 037-04
10	5692 037-03	5692 037-03
11-16		5692 037-05



N23

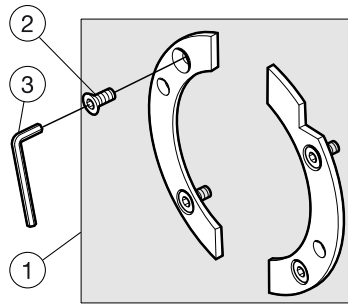
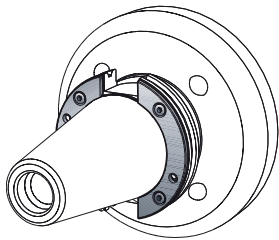


# Corobore® XL pre measuring unit



				Dimensions, mm				
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	Ordering code	DCON	OAL	LF	BD <sub>1</sub>	KG
50	33	0	I50-PMU-A33	33	178.30	50.0	130.0	5.59

## Shim set

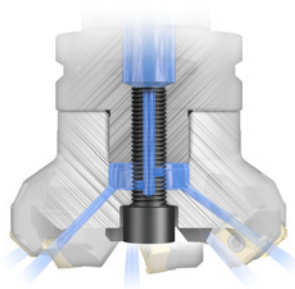


1 Shim set 5549 128-50	2 Screw 3213 011-256	3 Key 3021 010-025 (2.5)
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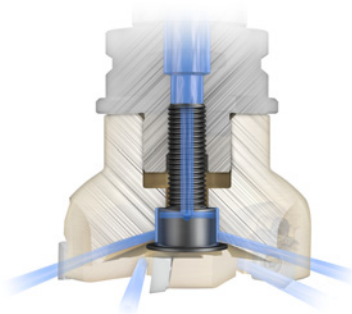


## Arbor mounting screws with coolant hole

### ISO A



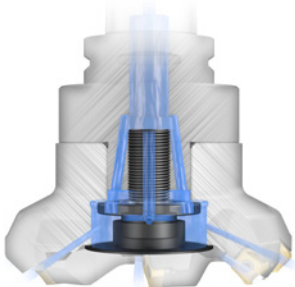
Arbor size	Screw		Key
16	5512 073-03	(M8)	3021 010-060 (6.0)
22	5512 073-01	(M10)	3021 010-080 (8.0)
22	5512 073-04	(M10)	3021 010-080 (8.0)
27	5512 073-02	(M12)	3021 010-100 (10.0)
32	5512 073-05	(M16)	3021 010-140 (12.0)



Arbor size	Screw		Key
22	5512 087-01	(M10)	5680 043-17 (30IP)
27	5512 087-02	(M12)	5680 043-18 (50IP)
27	5512 098-05*	(M12)	5680 043-13 (15IP)
			5680 043-18 (50IP)
32	5512 087-03	(M16)	5680 043-19 (55IP)

\* Screw set have an adjustable cap

### ISO B

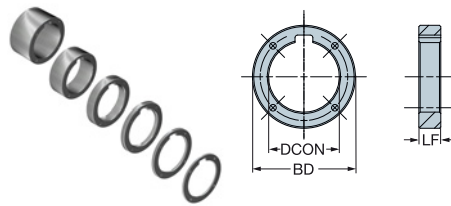


Arbor size	Screw		Key
32	5512 098-04	(M16)	3021 010-060 (6.0)
			3021 010-120 (12.0)
40	5512 098-03	(M20)	3021 010-060 (6.0)
			3021 010-120 (12.0)

## Spacing rings

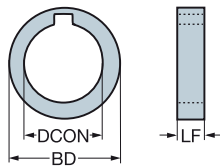
Assembly items for CoroMill® 331

Set with hole



Metric, mm	LF	0.5	1	1.5	2	3	4	5	6	10	20	30
Set code	DCON	BD	BD	BD	BD	BD	BD	BD	BD	BD	BD	BD
5549 091-032	27	39	39	39	41	41	41	41	41	41	41	41
5549 091-042	32	45	45	45	47	47	47	47	47	47	47	47
5549 091-052	40	54	54	54	55	55	55	55	55	55	55	55

Set without hole



Ordering code	For adaptor	Dimensions, mm											
		LF	0.5	1.0	1.5	2.0	3.0	4.0	5.0	6.0	10.0	20.0	30.0
		DCON	BD	BD	BD	BD	BD	BD	BD	BD	BD	BD	BD
5549 091-011	391.10-16...	16	25	25	25	27	27	27	27	27	27	27	—
5549 091-021	391.10-22...	22	33	33	33	34	34	34	34	34	34	34	34
5549 091-061	391.10-50...	50	67	67	—	68	68	68	68	68	68	68	68
5549 091-071	391.10-60...	60	84	84	—	84	84	84	84	84	84	84	84

Coolant screw and washer to CoroMill® 331

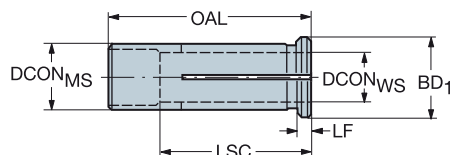


Metric

Set code	Screw code	Washer code	Arbor size
5512 076-101	5512 076-01	5549 210-01	27
5512 076-102	5512 076-02	5549 210-02	32
5512 076-103	5512 076-03	5549 210-03	40

# Cylindrical sleeves

Metallic sealed for coolant through tool



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	BD	LSC	OAL	LF	BAR	KG		
6	3	1	1	393.CGS-06 03 27	6	3	9	27.0	30	3	80	0.012		
12	3	1	1	393.CGS-12 03 40	12	3	16	40.0	44	4	80	0.036		
	4	1	1	393.CGS-12 04 40	12	4	16	40.0	44	4	80	0.035		
	5	1	1	393.CGS-12 05 40	12	5	16	40.0	44	4	80	0.030		
	6	1	1	393.CGS-12 06 40	12	6	16	40.0	44	4	80	0.035		
	7	1	1	393.CGS-12 07 40	12	7	16	40.0	44	4	80	0.032		
	8	1	1	393.CGS-12 08 40	12	8	16	40.0	44	4	80	0.029		
	9	1	1	393.CGS-12 09 40	12	9	16	40.0	44	4	80	0.024		
	10	1	1	393.CGS-12 10 40	12	10	16	40.0	44	4	80	0.020		
20	3	1	1	393.CGS-20 03 52	20	3	25	50.0	54	4	80	0.118		
	4	1	1	393.CGS-20 04 52	20	4	25	50.0	54	4	80	0.104		
	5	1	1	393.CGS-20 05 52	20	5	25	50.0	54	4	80	0.100		
	6	1	1	393.CGS-20 06 52	20	6	25	50.0	54	4	80	0.110		
	7	1	1	393.CGS-20 07 52	20	7	25	50.0	54	4	80	0.110		
	8	1	1	393.CGS-20 08 52	20	8	25	50.0	54	4	80	0.108		
	9	1	1	393.CGS-20 09 52	20	9	25	50.0	54	4	80	0.106		
	9.7	1	1	393.CGS-20 09.7 50	20	9	25	50.0	54	4	80	0.102		
	10	1	1	393.CGS-20 10 52	20	10	25	50.0	54	4	80	0.102		
	11.7	1	1	393.CGS-20 11.7 50	20	11	25	50.0	54	4	80	0.094		
	12	1	1	393.CGS-20 12 52	20	12	25	50.0	54	4	80	0.094		
	14	1	1	393.CGS-20 14 52	20	14	25	50.0	54	4	80	0.081		
	15.7	1	1	393.CGS-20 15.7 50	20	15	25	50.0	54	4	80	0.067		
	16	1	1	393.CGS-20 16 52	20	16	25	50.0	54	4	80	0.065		
	18	1	1	393.CGS-20 18 52	20	18	25	50.0	54	4	80	0.045		
25	3	1	1	393.CGS-25 03 56	25	3	30	56.0	60	4	80	0.212		
	4	1	1	393.CGS-25 04 56	25	4	30	56.0	60	4	80	0.191		
	5	1	1	393.CGS-25 05 56	25	5	30	56.0	60	4	80	0.208		
	6	1	1	393.CGS-25 06 56	25	6	30	56.0	60	4	80	0.192		
	7	1	1	393.CGS-25 07 56	25	7	30	56.0	60	4	80	0.204		
	8	1	1	393.CGS-25 08 56	25	8	30	56.0	60	4	80	0.200		
	9	1	1	393.CGS-25 09 56	25	9	30	56.0	60	4	80	0.197		
	9.7	1	1	393.CGS-25 09.7 56	25	9	30	56.0	60	4	80	0.185		
	10	1	1	393.CGS-25 10 56	25	10	30	56.0	60	4	80	0.186		
	11.7	1	1	393.CGS-25 11.7 56	25	11	30	56.0	60	4	80	0.161		
	12	1	1	393.CGS-25 12 56	25	12	30	56.0	60	4	80	0.167		
	14	1	1	393.CGS-25 14 56	25	14	30	56.0	60	4	80	0.156		
	15.7	1	1	393.CGS-25 15.7 56	25	15	30	56.0	60	4	80	0.151		
	16	1	1	393.CGS-25 16 56	25	16	30	56.0	60	4	80	0.150		
	18	1	1	393.CGS-25 18 56	25	18	30	56.0	60	4	80	0.121		
	19.7	1	1	393.CGS-25 19.7 56	25	19	30	56.0	60	4	80	0.102		
	20	1	1	393.CGS-25 20 56	25	20	30	56.0	60	4	80	0.100		
32	8	1	1	393.CGS-32 08 60	32	8	36	60.0	64	4	80	0.329		
	10	1	1	393.CGS-32 10 60	32	10	36	60.0	64	4	80	0.300		
	12	1	1	393.CGS-32 12 60	32	12	36	60.0	64	4	80	0.312		
	14	1	1	393.CGS-32 14 60	32	14	36	60.0	64	4	80	0.300		
	15.7	1	1	393.CGS-32 15.7 60	32	15	36	60.0	64	4	80	0.287		
	16	1	1	393.CGS-32 16 60	32	16	36	60.0	64	4	80	0.288		
	18	1	1	393.CGS-32 18 60	32	18	36	60.0	64	4	80	0.268		
	19.7	1	1	393.CGS-32 19.7 60	32	19	36	60.0	64	4	80	0.248		
	20	1	1	393.CGS-32 20 60	32	20	36	60.0	64	4	80	0.248		
	24.7	1	1	393.CGS-32 24.7 60	32	24	36	60.0	64	4	80	0.184		
	25	1	1	393.CGS-32 25 60	32	25	36	60.0	64	4	80	0.181		

LSC Clamping length required to achieve sealing effect.

For extractors for cylindrical collets, see page M18



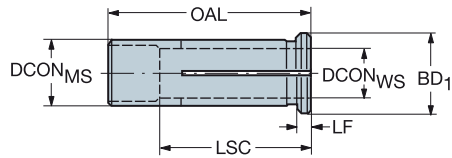
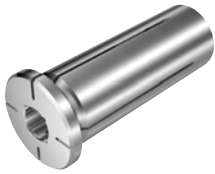
N23



N15

## Cylindrical sleeves

## Precision coolant supply



				Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	OAL	LF	BAR	KG			
12	2.90	1	4	393.CF-12 02.9 40	12.00	2.90	40.00	44.00	4	80	0.03			
	3.00	1	4	393.CF-12 03 40	12.00	3.00	40.00	44.00	4	80	0.03			
	3.80	1	4	393.CF-12 03.8 40	12.00	3.80	29.00	44.00	4	80	0.03			
	4.00	1	4	393.CF-12 04 40	12.00	4.00	40.00	44.00	4	80	0.03			
	4.80	1	4	393.CF-12 04.8 40	12.00	4.80	30.00	44.00	4	80	0.03			
	5.00	1	4	393.CF-12 05 40	12.00	5.00	36.00	44.00	4	80	0.03			
	5.80	1	4	393.CF-12 05.8 40	12.00	5.80	36.00	44.00	4	80	0.03			
	6.00	1	4	393.CF-12 06 40	12.00	6.00	36.00	44.00	4	80	0.03			
	7.80	1	4	393.CF-12 07.8 40	12.00	7.80	37.00	44.00	4	80	0.02			
	8.00	1	4	393.CF-12 08 40	12.00	8.00	40.00	44.00	4	80	0.02			
20	6.00	1	4	393.CF-20 06 50	20.00	6.00	50.00	54.00	4	80	0.11			
	8.00	1	4	393.CF-20 08 50	20.00	8.00	37.00	54.00	4	80	0.10			
	9.70	1	4	393.CF-20 09.7 50	20.00	9.70	40.00	54.00	4	80	0.10			
	10.00	1	4	393.CF-20 10 50	20.00	10.00	45.00	54.00	4	80	0.09			
	11.70	1	4	393.CF-20 11.7 50	20.00	11.70	45.00	54.00	4	80	0.09			
	12.00	1	4	393.CF-20 12 50	20.00	12.00	45.00	54.00	4	80	0.09			
	15.70	1	4	393.CF-20 15.7 50	20.00	15.70	50.00	54.00	4	80	0.06			
	16.00	1	4	393.CF-20 16 50	20.00	16.00	48.00	54.00	4	80	0.06			
25	9.70	1	4	393.CF-25 09.7 56	25.00	9.70	56.00	60.00	4	80	0.18			
	10.00	1	4	393.CF-25 10 56	25.00	10.00	56.00	60.00	4	80	0.16			
	11.70	1	4	393.CF-25 11.7 56	25.00	11.70	41.00	60.00	4	80	0.16			
	12.00	1	4	393.CF-25 12 56	25.00	12.00	46.00	60.00	4	80	0.16			
	15.70	1	4	393.CF-25 15.7 56	25.00	15.70	56.00	60.00	4	80	0.15			
	16.00	1	4	393.CF-25 16 56	25.00	16.00	56.00	60.00	4	80	0.15			
	19.70	1	4	393.CF-25 19.7 56	25.00	19.70	56.00	60.00	4	80	0.10			
20.00	1	4	393.CF-25 20 56	25.00	20.00	50.00	60.00	4	80	0.10				
32	15.70	1	4	393.CF-32 15.7 60	32.00	15.70	60.00	64.00	4	80	0.28			
	19.70	1	4	393.CF-32 19.7 60	32.00	19.70	60.00	64.00	4	80	0.24			
	20.00	1	4	393.CF-32 20 60	32.00	20.00	60.00	64.00	4	80	0.24			
	24.70	1	4	393.CF-32 24.7 60	32.00	24.70	56.00	64.00	4	80	0.18			
	25.00	1	4	393.CF-32 25 60	32.00	25.00	57.00	64.00	4	80	0.18			

For extractors for cylindrical collets, see page M18



N23

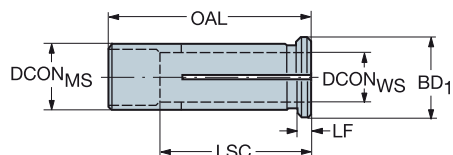


N15



# Cylindrical sleeves

Coolant through sleeve



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	BD	LSC	OAL	LF	BAR	KG		
12	6	1	4	393.CG-12 06 40	12	6	16	40.0	44	4	80	0.034		
	7	1	4	393.CG-12 07 40	12	7	16	40.0	44	4	80	0.030		
	8	1	4	393.CG-12 08 40	12	8	16	40.0	44	4	80	0.029		
	9	1	4	393.CG-12 09 40	12	9	16	40.0	44	4	80	0.025		
	10	1	4	393.CG-12 10 40	12	10	16	40.0	44	4	80	0.020		
20	3	1	4	393.CG-20 03 52	20	3	25	50.0	54	4	80	0.120		
	4	1	4	393.CG-20 04 52	20	4	25	50.0	54	4	80	0.114		
	5	1	4	393.CG-20 05 52	20	5	25	50.0	54	4	80	0.100		
	6	1	4	393.CG-20 06 52	20	6	25	50.0	54	4	80	0.113		
	7	1	4	393.CG-20 07 52	20	7	25	50.0	54	4	80	0.100		
	8	1	4	393.CG-20 08 52	20	8	25	50.0	54	4	80	0.109		
	9	1	4	393.CG-20 09 52	20	9	25	50.0	54	4	80	0.103		
	10	1	4	393.CG-20 10 52	20	10	25	50.0	54	4	80	0.101		
	12	1	4	393.CG-20 12 52	20	12	25	50.0	54	4	80	0.095		
	14	1	4	393.CG-20 14 52	20	14	25	50.0	54	4	80	0.080		
25	6	1	4	393.CG-25 06 56	25	6	30	56.0	60	4	80	0.192		
	8	1	4	393.CG-25 08 56	25	8	30	56.0	60	4	80	0.200		
	10	1	4	393.CG-25 10 56	25	10	30	56.0	60	4	80	0.171		
	12	1	4	393.CG-25 12 56	25	12	30	56.0	60	4	80	0.168		
	14	1	4	393.CG-25 14 56	25	14	30	56.0	60	4	80	0.154		
	16	1	4	393.CG-25 16 56	25	16	30	56.0	60	4	80	0.139		
	18	1	4	393.CG-25 18 56	25	18	30	56.0	60	4	80	0.120		
	20	1	4	393.CG-25 20 56	25	20	30	56.0	60	4	80	0.100		
32	6	1	4	393.CG-32 06 60	32	6	36	60.0	64	4	80	0.306		
	8	1	4	393.CG-32 08 60	32	8	36	60.0	64	4	80	0.328		
	10	1	4	393.CG-32 10 60	32	10	36	60.0	64	4	80	0.324		
	12	1	4	393.CG-32 12 60	32	12	36	60.0	64	4	80	0.314		
	14	1	4	393.CG-32 14 60	32	14	36	60.0	64	4	80	0.300		
	16	1	4	393.CG-32 16 60	32	16	36	60.0	64	4	80	0.282		
	18	1	4	393.CG-32 18 60	32	18	36	60.0	64	4	80	0.267		
	20	1	4	393.CG-32 20 60	32	20	36	60.0	64	4	80	0.246		
	25	1	4	393.CG-32 25 60	32	25	36	60.0	64	4	80	0.181		

For extractors for cylindrical collets, see page M18



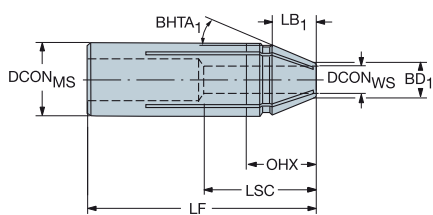
N23



N15

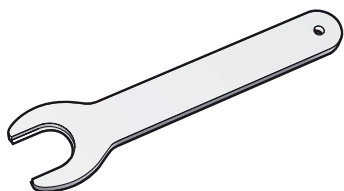
# Cylindrical sleeves

Pencil type



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	BD	LB	BHTA	LSC	LF	BAR	KG	
20	3	1	4	393.CGP-20 03 72	20	3	7	14	20°	55.0	72	80	0.134	
	6	1	4	393.CGP-20 06 72	20	6	9	14	20°	55.0	72	80	0.139	
	8	1	4	393.CGP-20 08 72	20	8	11	13	17°	55.0	72	80	0.127	
	10	1	4	393.CGP-20 10 72	20	10	13	13	15°	55.0	72	80	0.123	
	12	1	4	393.CGP-20 12 72	20	12	15	13	13°	55.0	72	80	0.112	

## Extractor for cylindrical sleeves



Ordering code	For collet size
5680 061-01	12
5680 061-02	16
5680 061-03	20
5680 061-04	25
5680 061-05	32



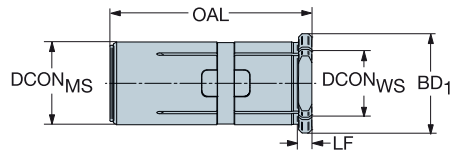
N23



N15

## Cylindrical sleeve with mechanical locking interface

393.CLF



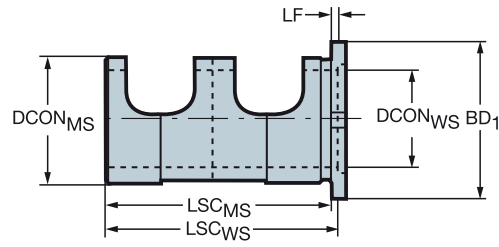
Application	Ordering code	Dimensions, mm					Accessories	
		DCON <sub>WS</sub>	DCON <sub>MS</sub>	BD <sub>1</sub>	LF	OAL	Anchor screw	Assembly tool
CoroChuck™ 930 HD32	393.CLF-321660	16	32	36	4	65	5519 140-02	5680 140-02
	393.CLF-322060	20	32	36	4	65		
	393.CLF-322560	25	32	36	4	65		
CoroChuck™ 930 HD/S25	393.CLF-251256	12	25	30	4	61	5519 140-02	5680 140-02
	393.CLF-251656	16	25	30	4	61		
	393.CLF-252056	20	25	30	4	61		
CoroChuck™ 930 HD/S20	393.CLF-201052	10	20	25	4	55	5519 140-01	5680 140-01
	393.CLF-201252	12	20	25	4	55		
	393.CLF-201652	16	20	25	4	55		

Anchor screw and assembly tool to be ordered separately.

For assembly instructions, please see [www.sandvik.coromant.com/corochuck930/instructions](http://www.sandvik.coromant.com/corochuck930/instructions)

# Eccentric sleeve

For CoroDrill® 880



Dimensions, mm

GZC <sub>MS</sub>	GZC <sub>WS</sub>	ADJLN	ADJLX	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	BD <sub>1</sub>	LB <sub>1</sub>	OAL	LF	KG
25	20	-0.30	0.30	416.2-L20-25	25	20	33	5	60	2	0.084
32	25	-0.30	0.30	416.2-L25-32	32	25	40	5	65	3	0.153
40	32	-0.30	0.30	416.2-L32-40	40	32	50	5	75	2	0.238
50	40	-0.30	0.30	416.2-L40-50	50	40	60	5	85	2	0.419



N23

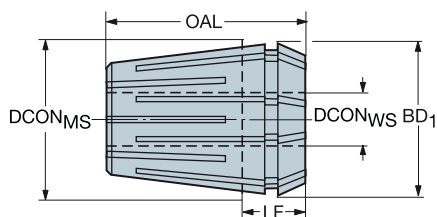


N15

# ER collet

Metallic sealed for coolant through tool

Compatible with DIN 6499-B



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	DCON <sub>NWS</sub>	DCON <sub>XWS</sub>	BD <sub>1</sub>	OAL	LF	BAR	KG	
ER16	3 (h9)	1	1	393.15-16 03	17	3			17	27	10	300	0.026	
	4 (h9)	1	1	393.15-16 04	17	4			17	27	10	300	0.025	
	5.0 - 4.5	1	1	393.15-16 05	17		4.5	5.0	17	27	10	300	0.026	
	6.0 - 5.5	1	1	393.15-16 06	17		5.5	6.0	17	27	10	300	0.024	
	8.0 - 7.5	1	1	393.15-16 08	17		7.5	8.0	17	27	10	300	0.021	
	10.0 - 9.5	1	1	393.15-16 10	17		9.5	10.0	17	27	10	300	0.017	
ER20	3 (h9)	1	1	393.15-20 03	21	3			21	31	11	300	0.047	
	4 (h9)	1	1	393.15-20 04	21	4			21	31	11	300	0.046	
	5 (h9)	1	1	393.15-20 05	21	5			21	31	11	300	0.045	
	6 (h9)	1	1	393.15-20 06	21	6			21	31	11	300	0.044	
	8.0 - 7.5	1	1	393.15-20 08	21		7.5	8.0	21	31	11	300	0.041	
	10.0 - 9.5	1	1	393.15-20 10	21		9.5	10.0	21	31	11	300	0.036	
	12.0 - 11.5	1	1	393.15-20 12	21		11.5	12.0	21	31	11	300	0.030	
	ER25	6 (h9)	1	1	393.15-25 06	26	6			26	34	11	300	0.080
8.0 - 7.5		1	1	393.15-25 08	26		7.5	8.0	26	34	11	300	0.078	
10.0 - 9.5		1	1	393.15-25 10	26		9.5	10.0	26	34	11	300	0.074	
12.0 - 11.5		1	1	393.15-25 12	26		11.5	12.0	26	34	11	300	0.066	
14.0 - 13.5		1	1	393.15-25 14	26		13.5	14.0	26	34	11	300	0.060	
16.0 - 15.5		1	1	393.15-25 16	26		15.5	16.0	26	34	11	300	0.049	
ER32	6 (h9)	1	1	393.15-32 06	33	6			33	40	12	300	0.163	
	8.0 - 7.5	1	1	393.15-32 08	33		7.5	8.0	33	40	12	300	0.167	
	10.0 - 9.5	1	1	393.15-32 10	33		9.5	10.0	33	40	12	300	0.158	
	12.0 - 11.5	1	1	393.15-32 12	33		11.5	12.0	33	40	12	300	0.154	
	14.0 - 13.5	1	1	393.15-32 14	33		13.5	14.0	33	40	12	300	0.135	
	16.0 - 15.5	1	1	393.15-32 16	33		15.5	16.0	33	40	12	300	0.124	
	18.0 - 17.5	1	1	393.15-32 18	33		17.5	18.0	33	40	12	300	0.112	
	20.0 - 19.5	1	1	393.15-32 20	33		19.5	20.0	33	40	12	300	0.098	
ER40	6 (h9)	1	1	393.15-40 06	41	6			41	46	14	300	0.291	
	8 (h9)	1	1	393.15-40 08	41	8			41	46	14	300	0.289	
	10.0 - 9.5	1	1	393.15-40 10	41		9.5	10.0	41	46	14	300	0.293	
	12.0 - 11.5	1	1	393.15-40 12	41		11.5	12.0	41	46	14	300	0.286	
	14.0 - 13.5	1	1	393.15-40 14	41		13.5	14.0	41	46	14	300	0.276	
	16.0 - 15.5	1	1	393.15-40 16	41		15.5	16.0	41	46	14	300	0.265	
	18.0 - 17.5	1	1	393.15-40 18	41		17.5	18.0	41	46	14	300	0.250	
	20.0 - 19.5	1	1	393.15-40 20	41		19.5	20.0	41	46	14	300	0.232	
25.0 - 24.5	1	1	393.15-40 25	41		24.5	25.0	41	46	14	300	0.181		



N23

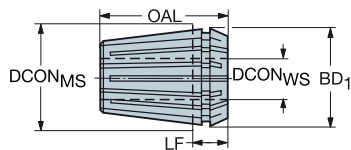


N15

# ER collet

Coolant through collet

Compatible with DIN 6499-B



					Dimensions, mm									
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	DCON <sub>XWS</sub>	BD <sub>1</sub>	OAL	LF	BAR	KG		
ER8	3.00 - 2.50	1	4	393.14-08 0300	8	2.5	3.0	8	13	4	300	0.005		
	3.50 - 3.00	1	4	393.14-08 0350	8	3.0	3.5	8	13	4	300	0.005		
	4.00 - 3.50	1	4	393.14-08 0400	8	3.5	4.0	11	13	4	300	0.005		
ER11	1.00 - 0.75	1	4	393.14-11 0100	11	0.8	1.0	11	18	6	300	0.009		
	1.25 - 1.00	1	4	393.14-11 0125	11	1.0	1.3	11	18	6	300	0.009		
	1.50 - 1.25	1	4	393.14-11 0150	11	1.3	1.5	11	18	6	300	0.009		
	1.75 - 1.50	1	4	393.14-11 0175	11	1.5	1.8	11	18	6	300	0.009		
	2.00 - 1.75	1	4	393.14-11 0200	11	1.8	2.0	11	18	6	300	0.009		
	2.25 - 2.00	1	4	393.14-11 0225	11	2.0	2.3	11	18	6	300	0.009		
	2.50 - 2.25	1	4	393.14-11 0250	11	2.3	2.5	11	18	6	300	0.009		
	3.00 - 2.50	1	4	393.14-11 0300	11	2.5	3.0	11	18	6	300	0.009		
	3.50 - 3.00	1	4	393.14-11 0350	11	3.0	3.5	11	18	6	300	0.009		
	4.00 - 3.50	1	4	393.14-11 0400	11	3.5	4.0	11	18	6	300	0.009		
	4.50 - 4.00	1	4	393.14-11 0450	11	4.0	4.5	11	18	6	300	0.009		
	5.00 - 4.50	1	4	393.14-11 0500	11	4.5	5.0	11	18	6	300	0.009		
	5.50 - 5.00	1	4	393.14-11 0550	11	5.0	5.5	11	18	6	300	0.008		
	6.00 - 5.50	1	4	393.14-11 0600	11	5.5	6.0	11	18	6	300	0.007		
	6.50 - 6.00	1	4	393.14-11 0650	11	6.0	6.5	11	18	6	300	0.007		
7.00 - 6.50	1	4	393.14-11 0700	11	6.5	7.0	11	18	6	300	0.006			
ER16	1.0 - 0.5	1	4	393.14-16 0100	17	0.5	1.0	17	27	10	300	0.027		
	1.5 - 1.0	1	4	393.14-16 0150	17	1.0	1.5	17	27	10	300	0.027		
	2.0 - 1.0	1	4	393.14-16 0200	17	1.0	2.0	17	27	10	300	0.027		
	2.5 - 1.5	1	4	393.14-16 0250	17	1.5	2.5	17	27	10	300	0.027		
	3.0 - 2.0	1	4	393.14-16 0300	17	2.0	3.0	17	27	10	300	0.024		
	4.0 - 3.0	1	4	393.14-16 0400	17	3.0	4.0	17	27	10	300	0.003		
	5.0 - 4.0	1	4	393.14-16 0500	17	4.0	5.0	17	27	10	300	0.025		
	6.0 - 5.0	1	4	393.14-16 0600	17	5.0	6.0	17	27	10	300	0.023		
	7.0 - 6.0	1	4	393.14-16 0700	17	6.0	7.0	17	27	10	300	0.021		
	8.0 - 7.0	1	4	393.14-16 0800	17	7.0	8.0	17	27	10	300	0.020		
	9.0 - 8.0	1	4	393.14-16 0900	17	8.0	9.0	17	27	10	300	0.018		
10.0 - 9.0	1	4	393.14-16 1000	17	9.0	10.0	17	27	10	300	0.016			
ER20	1.5 - 1.0	1	4	393.14-20 015	21	1.0	1.5	21	31	11	300	0.047		
	2.0 - 1.5	1	4	393.14-20 020	21	1.5	2.0	21	31	11	300	0.049		
	2.5 - 2.0	1	4	393.14-20 025	21	2.0	2.5	21	31	11	300	0.048		
	3.0 - 2.5	1	4	393.14-20 030	21	2.5	3.0	21	31	11	300	0.046		
	4.0 - 3.0	1	4	393.14-20 040	21	3.0	4.0	21	31	11	300	0.045		
	5.0 - 4.0	1	4	393.14-20 050	21	4.0	5.0	21	31	11	300	0.044		
	6.0 - 5.0	1	4	393.14-20 060	21	5.0	6.0	21	31	11	300	0.043		
	7.0 - 6.0	1	4	393.14-20 070	21	6.0	7.0	21	31	11	300	0.041		
	8.0 - 7.0	1	4	393.14-20 080	21	7.0	8.0	21	31	11	300	0.037		
	9.0 - 8.0	1	4	393.14-20 090	21	8.0	9.0	21	31	11	300	0.037		
	10.0 - 9.0	1	4	393.14-20 100	21	9.0	10.0	21	31	11	300	0.034		
	11.0 - 10.0	1	4	393.14-20 110	21	10.0	11.0	21	31	11	300	0.033		
	12.0 - 11.0	1	4	393.14-20 120	21	11.0	12.0	21	31	11	300	0.031		
13.0 - 12.0	1	4	393.14-20 130	21	12.0	13.0	21	31	11	300	0.026			
ER25	2.0 - 1.5	1	4	393.14-25 020	26	1.5	2.0	26	34	11	300	0.079		
	2.5 - 2.0	1	4	393.14-25 025	26	2.0	2.5	26	34	11	300	0.079		
	3.0 - 2.5	1	4	393.14-25 030	26	2.5	3.0	26	34	11	300	0.078		
	4.0 - 3.0	1	4	393.14-25 040	26	3.0	4.0	26	34	11	300	0.079		
	5.0 - 4.0	1	4	393.14-25 050	26	4.0	5.0	26	34	11	300	0.078		
	6.0 - 5.0	1	4	393.14-25 060	26	5.0	6.0	26	34	11	300	0.076		
	7.0 - 6.0	1	4	393.14-25 070	26	6.0	7.0	26	34	11	300	0.076		
	8.0 - 7.0	1	4	393.14-25 080	26	7.0	8.0	26	34	11	300	0.073		
	9.0 - 8.0	1	4	393.14-25 090	26	8.0	9.0	26	34	11	300	0.078		
	10.0 - 9.0	1	4	393.14-25 100	26	9.0	10.0	26	34	11	300	0.070		
	11.0 - 10.0	1	4	393.14-25 110	26	10.0	11.0	26	34	11	300	0.067		
	12.0 - 11.0	1	4	393.14-25 120	26	11.0	12.0	26	34	11	300	0.064		
	13.0 - 12.0	1	4	393.14-25 130	26	12.0	13.0	26	34	11	300	0.063		
	14.0 - 13.0	1	4	393.14-25 140	26	13.0	14.0	26	34	11	300	0.057		
15.0 - 14.0	1	4	393.14-25 150	26	14.0	15.0	26	34	11	300	0.054			
16.0 - 15.0	1	4	393.14-25 160	26	15.0	16.0	26	34	11	300	0.047			



N23

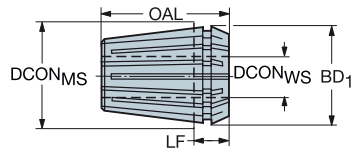


N15

## ER collet

Coolant through collet

Compatible with DIN 6499-B



					Dimensions, mm									
CZG <sub>MS</sub>	CZG <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	DCON <sub>WS</sub>	BD <sub>1</sub>	OAL	LF	BAR	KG		
ER32	2.5 - 2.0	1	4	393.14-32 025	33	2.0	2.5	33	40	12	300	0.155		
	3.0 - 2.5	1	4	393.14-32 030	33	2.5	3.0	33	40	12	300	0.161		
	4.0 - 3.0	1	4	393.14-32 040	33	3.0	4.0	33	40	12	300	0.154		
	5.0 - 4.0	1	4	393.14-32 050	33	4.0	5.0	33	40	12	300	0.151		
	6.0 - 5.0	1	4	393.14-32 060	33	5.0	6.0	33	40	12	300	0.157		
	7.0 - 6.0	1	4	393.14-32 070	33	6.0	7.0	33	40	12	300	0.161		
	8.0 - 7.0	1	4	393.14-32 080	33	7.0	8.0	33	40	12	300	0.158		
	9.0 - 8.0	1	4	393.14-32 090	33	8.0	9.0	33	40	12	300	0.157		
	10.0 - 9.0	1	4	393.14-32 100	33	9.0	10.0	33	40	12	300	0.144		
	11.0 - 10.0	1	4	393.14-32 110	33	10.0	11.0	33	40	12	300	0.151		
	12.0 - 11.0	1	4	393.14-32 120	33	11.0	12.0	33	40	12	300	0.147		
	13.0 - 12.0	1	4	393.14-32 130	33	12.0	13.0	33	40	12	300	0.143		
	14.0 - 13.0	1	4	393.14-32 140	33	13.0	14.0	33	40	12	300	0.142		
	15.0 - 14.0	1	4	393.14-32 150	33	14.0	15.0	33	40	12	300	0.124		
	16.0 - 15.0	1	4	393.14-32 160	33	15.0	16.0	33	40	12	300	0.126		
	17.0 - 16.0	1	4	393.14-32 170	33	16.0	17.0	33	40	12	300	0.114		
18.0 - 17.0	1	4	393.14-32 180	33	17.0	18.0	33	40	12	300	0.108			
19.0 - 18.0	1	4	393.14-32 190	33	18.0	19.0	33	40	12	300	0.109			
20.0 - 19.0	1	4	393.14-32 200	33	19.0	20.0	33	40	12	300	0.095			
ER40	4.0 - 3.0	1	4	393.14-40 040	41	3.0	4.0	41	46	14	300	0.302		
	5.0 - 4.0	1	4	393.14-40 050	41	4.0	5.0	41	46	14	300	0.316		
	6.0 - 5.0	1	4	393.14-40 060	41	5.0	6.0	41	46	14	300	0.304		
	7.0 - 6.0	1	4	393.14-40 070	41	6.0	7.0	41	46	14	300	0.282		
	8.0 - 7.0	1	4	393.14-40 080	41	7.0	8.0	41	46	14	300	0.305		
	9.0 - 8.0	1	4	393.14-40 090	41	8.0	9.0	41	46	14	300	0.302		
	10.0 - 9.0	1	4	393.14-40 100	41	9.0	10.0	41	46	14	300	0.299		
	11.0 - 10.0	1	4	393.14-40 110	41	10.0	11.0	41	46	14	300	0.295		
	12.0 - 11.0	1	4	393.14-40 120	41	11.0	12.0	41	46	14	300	0.292		
	13.0 - 12.0	1	4	393.14-40 130	41	12.0	13.0	41	46	14	300	0.286		
	14.0 - 13.0	1	4	393.14-40 140	41	13.0	14.0	41	46	14	300	0.281		
	15.0 - 14.0	1	4	393.14-40 150	41	14.0	15.0	41	46	14	300	0.275		
	16.0 - 15.0	1	4	393.14-40 160	41	15.0	16.0	41	46	14	300	0.269		
	17.0 - 16.0	1	4	393.14-40 170	41	16.0	17.0	41	46	14	300	0.261		
	18.0 - 17.0	1	4	393.14-40 180	41	17.0	18.0	41	46	14	300	0.253		
	19.0 - 18.0	1	4	393.14-40 190	41	18.0	19.0	41	46	14	300	0.250		
20.0 - 19.0	1	4	393.14-40 200	41	19.0	20.0	41	46	14	300	0.228			
21.0 - 20.0	1	4	393.14-40 210	41	20.0	21.0	41	46	14	300	0.217			
22.0 - 21.0	1	4	393.14-40 220	41	21.0	22.0	41	46	14	300	0.220			
23.0 - 22.0	1	4	393.14-40 230	41	22.0	23.0	41	46	14	300	0.210			
24.0 - 23.0	1	4	393.14-40 240	41	23.0	24.0	41	46	14	300	0.198			
25.0 - 24.0	1	4	393.14-40 250	41	24.0	25.0	41	46	14	300	0.187			
26.0 - 25.0	1	4	393.14-40 260	41	25.0	26.0	41	46	14	300	0.174			
ER50	26.0 - 24.0	1	4	393.14-50 260	52	24.0	26.0	52	60	21	300	0.478		
	28.0 - 26.0	1	4	393.14-50 280	52	26.0	28.0	52	60	21	300	0.461		
	30.0 - 28.0	1	4	393.14-50 300	52	28.0	30.0	52	60	21	300	0.413		
	32.0 - 30.0	1	4	393.14-50 320	52	30.0	32.0	52	60	21	300	0.371		
	34.0 - 32.0	1	4	393.14-50 340	52	32.0	34.0	52	60	21	300	0.332		
	36.0 - 34.0	1	4	393.14-50 360	52	34.0	36.0	52	60	21	300	0.279		



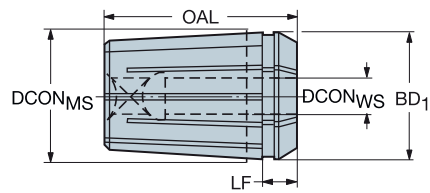
N23



N15

## ER Collet for tap shank

Compatible with DIN 6499-B



					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>	OAL	LF	BAR	KG		
ER11	4.00 x 3.15	1	4	393.14-11 D040X0315	11	4	11	18	4	300	0.009		
	2.50 x 2.00	1	4	393.14-11 D025X021	11	2	11	18	4	300	0.009		
	2.80 x 2.10	1	4	393.14-11 D028X021	11	2	11	18	4	300	0.010		
	5.00 x 4.00	1	4	393.14-11 D050X040	11	5	11	18	4	300	0.008		
	3.50 x 2.70	1	4	393.14-11 D035X027	11	3	11	18	4	300	0.010		
	4.00 x 3.00	1	4	393.14-11 D040X030	11	4	11	18	4	300	0.009		
	4.50 x 3.40	1	4	393.14-11 D045X034	11	4	11	18	4	300	0.008		
6.00 x 4.90	1	4	393.14-11 D060X049	11	6	11	18	4	300	0.007			
ER20	4.00 x 3.15	1	4	393.14-20 D040X0315	20	4	21	31	7	300	0.047		
	5.00 x 4.00	1	4	393.14-20 D050X040	20	5	21	31	7	300	0.044		
	3.50 x 2.70	1	4	393.14-20 D035X027	20	3	21	31	7	300	0.045		
	6.30 x 5.00	1	4	393.14-20 D063X050	20	6	21	31	7	300	0.042		
	7.10 x 5.60	1	4	393.14-20 D071X056	20	7	21	31	7	300	0.043		
	4.50 x 3.40	1	4	393.14-20 D045X034	20	4	21	31	7	300	0.043		
	8.00 x 6.30	1	4	393.14-20 D080X063	20	8	21	31	7	300	0.039		
	5.50 x 4.30	1	4	393.14-20 D055X043	20	5	21	31	7	300	0.043		
	9.00 x 7.10	1	4	393.14-20 D090X071	20	9	21	31	7	300	0.039		
	6.00 x 4.90	1	4	393.14-20 D060X049	20	6	21	31	7	300	0.042		
	10.00 x 8.00	1	4	393.14-20 D100X080	20	10	21	31	7	300	0.035		
	7.00 x 5.50	1	4	393.14-20 D070X055	20	7	21	31	7	300	0.041		
	ER25	8.00 x 6.30	1	4	393.14-25 D080X063	25	8	26	34	8	300	0.077	
9.00 x 7.10		1	4	393.14-25 D090X071	25	9	26	34	8	300	0.077		
6.00 x 4.90		1	4	393.14-25 D060X049	25	6	26	34	8	300	0.077		
10.00 x 8.00		1	4	393.14-25 D100X080	25	10	26	34	8	300	0.074		
7.00 x 5.50		1	4	393.14-25 D070X055	25	7	26	34	8	300	0.076		
11.20 x 9.00		1	4	393.14-25 D112X090	25	11	26	34	8	300	0.071		
12.50 x 10.00		1	4	393.14-25 D125X100	25	12	26	34	8	300	0.065		
14.00 x 11.20		1	4	393.14-25 D140X112	25	14	26	34	8	300	0.057		
11.00 x 9.00		1	4	393.14-25 D110X090	25	11	26	34	8	300	0.071		
12.00 x 9.00		1	4	393.14-25 D120X090	25	12	26	34	8	300	0.067		
16.00 x 12.00	1	4	393.14-25 D160X120	25	16	26	34	8	300	0.047			
ER40	12.50 x 10.00	1	4	393.14-40 D125X100	40	12	41	46	11	300	0.283		
	14.00 x 11.20	1	4	393.14-40 D140X112	40	14	41	46	11	300	0.275		
	16.00 x 12.50	1	4	393.14-40 D160X125	40	16	41	46	11	300	0.265		
	12.00 x 9.00	1	4	393.14-40 D120X090	40	12	41	46	11	300	0.281		
	18.00 x 14.50	1	4	393.14-40 D180X145	40	18	41	46	11	300	0.248		
	20.00 x 16.00	1	4	393.14-40 D200X160	40	20	41	46	11	300	0.234		
	22.00 x 18.00	1	4	393.14-40 D220X180	40	22	41	46	11	300	0.213		
ER50	22.00 x 18.00	1	4	393.14-50 D220X180	52	22	52	60	17	300	0.543		
	25.00 x 20.00	1	4	393.14-50 D250X200	52	25	52	60	17	300	0.500		
	28.00 x 22.00	1	4	393.14-50 D280X220	52	28	52	60	17	300	0.449		
	32.00 x 24.00	1	4	393.14-50 D320X240	52	32	52	60	17	300	0.380		



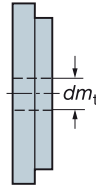
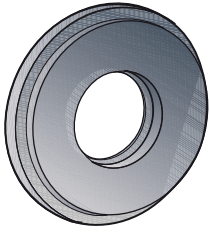
N23



N15



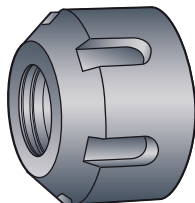
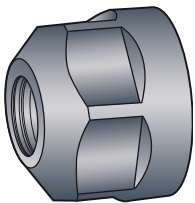
## ER collet sealing discs



Size 16		Size 25		Size 32		Size 40	
Range, mm $dm_t$	Ordering code	Range, mm $dm_t$	Ordering code	Range, mm $dm_t$	Ordering code	Range, mm $dm_t$	Ordering code
3.0-2.5	3916.00300	6.0-5.5	3925.00600	3.0-2.5	3932.00300	6.0-5.5	3940.00600
4.0-3.5	3916.00400	7.0-6.5	3925.00700	4.0-3.5	3932.00400	7.0-6.5	3940.00700
5.0-4.5	3916.00500	8.0-7.5	3925.00800	5.0-4.5	3932.00500	8.0-7.5	3940.00800
6.0-5.5	3916.00600	9.0-8.5	3925.00900	6.0-5.5	3932.00600	9.0-8.5	3940.00900
7.0-6.5	3916.00700	10.0-9.5	3925.01000	7.0-6.5	3932.00700	10.0-9.5	3940.01000
8.0-7.5	3916.00800	11.0-10.5	3925.01100	8.0-7.5	3932.00800	11.0-10.5	3940.01100
9.0-8.5	3916.00900	12.0-11.5	3925.01200	9.0-8.5	3932.00900	12.0-11.5	3940.01200
10.0-9.5	3916.01000	13.0-12.5	3925.01300	10.0-9.5	3932.01000	13.0-12.5	3940.01300
		14.0-13.5	3925.01400	11.0-10.5	3932.01100	14.0-13.5	3940.01400
		15.0-14.5	3925.01500	12.0-11.5	3932.01200	15.0-14.5	3940.01500
		16.0-15.5	3925.01600	13.0-12.5	3932.01300	16.0-15.5	3940.01600
				14.0-13.5	3932.01400	17.0-16.5	3940.01700
				15.0-14.5	3932.01500	18.0-17.5	3940.01800
				16.0-15.5	3932.01600	19.0-18.5	3940.01900
				17.0-16.5	3932.01700	20.0-19.5	3940.02000
				18.0-17.5	3932.01800	21.0-20.5	3940.02100
				19.0-18.5	3932.01900	22.0-21.5	3940.02200
				20.0-19.5	3932.02000	25.0-24.5	3940.02500
						26.0-25.5	3940.02600
Size 20							
Range, mm $dm_t$	Ordering code						
3.0-2.5	3920.00300						
4.0-3.5	3920.00400						
5.0-4.5	3920.00500						
6.0-5.5	3920.00600						
7.0-6.5	3920.00700						
8.0-7.5	3920.00800						
9.0-8.5	3920.00900						
10.0-9.5	3920.01000						
11.0-10.5	3920.01100						
12.0-11.5	3920.01200						
13.0-12.5	3920.01300						

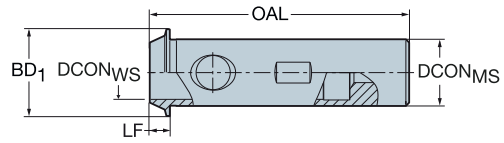
0.5 mm capacity per disc. Max 150 bar coolant pressure.

## ER collet nuts for through-coolant with sealing disc



CZC	Ordering code	TDZ	Wrench
ER16	5533 051-01	M22 x 1.5	5680 091-01
ER20	5533 051-02	M25 x 1.5	5680 091-02
ER25	5533 051-03	M32 x 1.5	5680 096-02
ER32	5533 051-04	M40 x 1.5	5680 096-03
ER40	5533 051-05	M50 x 1.5	5680 096-04

# Sleeve for fine boring head



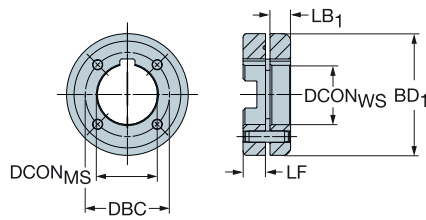
					Dimensions, mm						
CZC <sub>MS</sub>	CZC <sub>MS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	BD <sub>1</sub>	OAL	LF	BAR	KG
20	16	1	1	393.37A-20 16 072	20	16	26	78	6	20	0.114

To be used with R429U/R429.90 boring bars

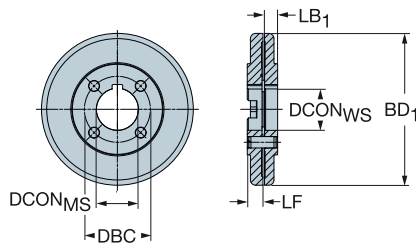


# Assembly item

Driving collar for CoroMill® QD



				Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	OAL	LF	LB <sub>1</sub>	BD <sub>1</sub>	(BAR)	(KG)	
32	X32	4	4	5549 201-011	32.00	32.00	2.40	25.40	12	11.00	65.00	80	0.46	
40	X40	4	4	5549 201-021	40.00	40.00	2.40	29.00	15	11.60	87.00	80	0.98	



				Dimensions, mm										
CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	OAL	LF	LB <sub>1</sub>	BD <sub>1</sub>	(BAR)	(KG)	
40	X40	4	4	5549 201-041	40.00	40.00	2.40	29.00	15	12.50	145.00	80	2.75	
	X40	4	4	5549 201-081	40.00	40.00	2.40	29.00	15	11.60	185.00	80	4.62	

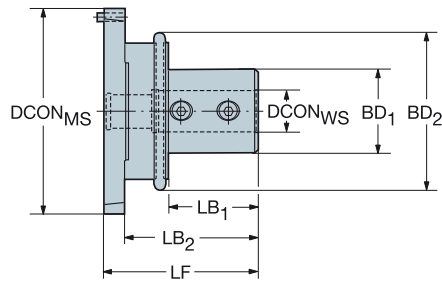


N23



N15

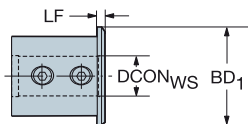
# Slide to adjustable drill adaptor



Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LF	LB <sub>1</sub>	LB <sub>2</sub>	LB <sub>3</sub>	BD <sub>1</sub>	BD <sub>2</sub>	BD <sub>3</sub>	BAR	KG
01	20	1	1	393.277-20 01 075A	78.0	20.0	75.0	44.0	65.0	75.0	40.0	55.2	78.0	20	0.85
	25	1	1	393.277-25 01 080A	78.0	25.0	80.0	50.0	70.0	80.0	45.0	55.2	78.0	20	0.94
02	20	1	1	393.277-20 02 075A	98.0	20.0	75.0	44.0	65.0	75.0	40.0	75.2	98.0	20	1.26
	25	1	1	393.277-25 02 085A	98.0	25.0	85.0	54.0	75.0	85.0	45.0	75.2	98.0	20	1.39
	32	1	1	393.277-32 02 085A	98.0	32.0	85.0	54.0	75.0	85.0	52.0	75.2	98.0	20	1.47
03	40	1	1	393.277-40 03 090A	136.0	40.0	90.0	65.0	90.0		65.0	136.0		20	3.52
	50	1	1	393.277-50 03 100A	136.0	50.0	100.0	75.0	110.0		75.0	163.0		20	3.90

## Sleeve

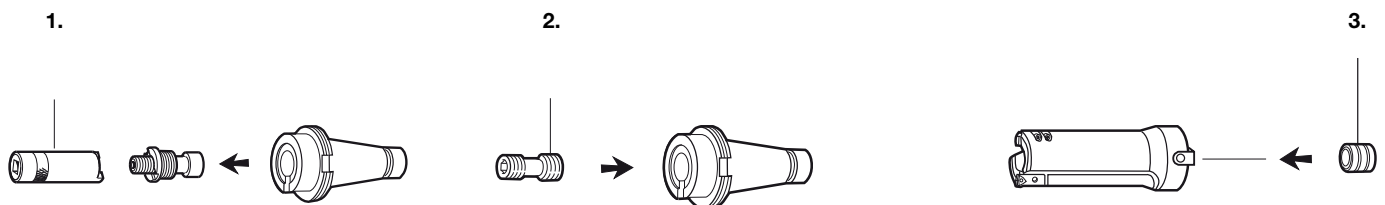


Dimensions, mm

CZC <sub>MS</sub>	CZC <sub>WS</sub>	CNSC	CXSC	Ordering code	DCON <sub>MS</sub>	DCON <sub>WS</sub>	LSC	LF	BD <sub>1</sub>	BAR	KG
40	32	1	1	393.277-40 32 074A	40.0	32.0	70	4.0	48.0	80	0.30

## VL

### Trepanning tool



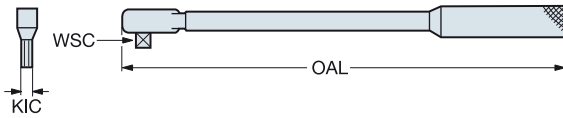
1. Ordering code Key	2. Ordering code Screw	3. Ordering code Centering sleeve
5680 065-02	5516 030-01	5638 030-01



## Assembly tools

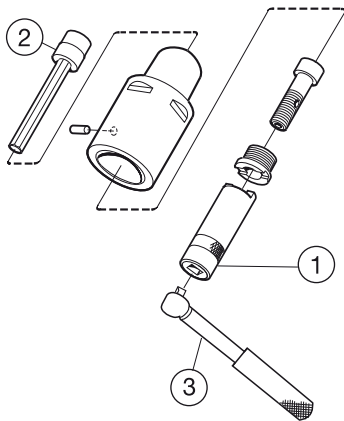
Coromant Capto®

### Torque wrench for manual clamping units, Quick change



Coupling size	Torque wrench				Key adaptor		
	Ordering code	Dimensions, mm	Torque range, Nm	WSC	OAL	Ordering code	KIC
C3	C-TK-01M	20-100	20-100	1/2"	345	5680 035-14	8
C4	C-TK-01M	20-100	20-100	1/2"	345	5680 035-06	10
C5	C-TK-01M	20-100	20-100	1/2"	345	5680 035-07	12
C6	C-TK-01M	20-100	20-100	1/2"	345	5680 035-07	12
C8	C-TK-02	40-200	40-200	1/2"	440	5680 035-07	12
C10	C-TK-03	60-300	60-300	1/2"	548	5680 035-10	17

### Torque wrench for modular assemblies, centre bolt clamping



Coupling size	3. Torque wrench				2. Extension key		1. Retaining nut spanner	
	Ordering code	Dimensions, mm	Torque range, Nm	WSC	OAL	Ordering code	KIC	Ordering code
C3	C-TK-02	40-200	40-200	1/2"	345	5680 015-05	8	5680 065-13
C4	C-TK-02	40-200	40-200	1/2"	345	5680 015-05	8	5680 065-10
C5	C-TK-02	40-200	40-200	1/2"	345	5680 015-01	10	5680 065-11
C6	C-TK-02	40-200	40-200	1/2"	345	5680 015-02	14	5680 065-12
C8	C-TK-02	40-200	40-200	1/2"	440	5680 015-02	14	5680 065-12
C10	C-TK-04	80-400	80-400	3/4"	683	5680 015-06	17	5680 065-14

To be calibrated according to ISO 6789, accuracy within 4%

## Assembly tools

### Torque wrench



Ordering code      Torque range      Bits interface

ER-TK-01M	10-50 Nm	16
ER-TK-02M	50-300 Nm	16

### Bits



Ordering code      ER size      Bits interface

5680 103-01	ER 11	16
5680 103-02	ER 16	16
5680 103-03	ER 20	16



Ordering code      ER size      MDI size      Bits interface

5680 103-04	ER 25		16
5680 103-05	ER 32	20	16
5680 103-06	ER 40	25	16
5680 103-07		32	16
5680 103-08		40	16
5680 103-09		50	16

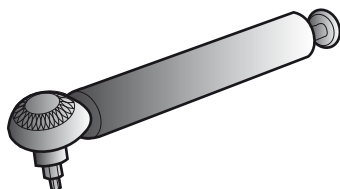
## Assembly tools

### Key for integrated collet

CZC	Ordering code	
ER11	5680 091-03	
ER16	5680 096-06	
ER20	5680 096-01	
ER25	5680 096-02	
ER32	5680 096-03	

### CoroChuck™ 930

Torque wrench



Ordering code

5680 099-01

### Coromant EH

Main spare parts

Coupling size	Key	Torque wrench head <sup>1)</sup>	Torque wrench head for 2-edge end mill <sup>1)</sup>	Torque value Nm	Torque range	
					Torque wrench <sup>1)</sup>	Nm
E10	5680 093-01	5680 089-01	5680 089-06	12	5680 088-01	10-20
E12	5680 093-02	5680 089-02	5680 089-07	15	5680 088-01	10-20
E16	5680 093-03	5680 089-03	5680 089-08	30	5680 088-02	25-65
E20	5680 093-04	5680 089-04		50	5680 088-02	25-65
E25	5680 093-05	5680 089-05		65	5680 088-02	25-65

<sup>1)</sup> Accessories, must be ordered separately

# Torx Plus® torque wrench

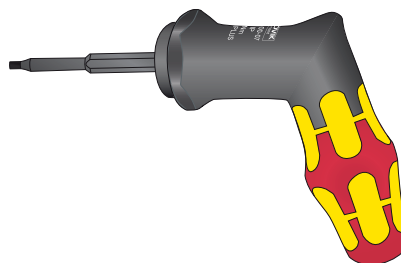
Correct torque when mounting of inserts in milling cutters is a prerequisite for a well functioning tool. Together with the Torx Plus screws the new wrench is a guarantee for improved and secure insert clamping.

The wrenches, available in several sizes and tested to withstand 10 000 insert tightenings, are each calibrated for the torque needed for correct insert clamping of Sandvik Coromant milling cutters.

A torque wrench is always recommended for cutters with Torx plus screw. The new wrench must be ordered separately.

**Note!** Torx Plus is a registered trademark of Camcar Textron (USA).

**Note!** We want to point out to all our customers that the new Torx Plus keys and screw-drivers do NOT fit into the standard Torx screws.



5680 100-07 (20IP) and 5680 100-08 (25IP)

## Torx Plus® torque wrench

Torque wrench	Size	Torque Nm
5680 100-01	6IP	0.6
5680 100-02	7IP	0.9
5680 100-03	8IP	1.2
5680 100-04	9IP	1.4
5680 100-05	10IP	2.0
5680 100-06	15IP	3.0
5680 100-07	20IP	5.0
5680 100-08	25IP	7.5
5680 100-09	HEX 5	6.0
5680 100-10	20IP	6.0

## Torque wrench and bits

5680 105-01  
5680 105-02



5680 105-05  
5680 105-06



Torque wrench	Torque range		Handle
	Nm		
5680 105-01	0.3 - 1.2		Straight
5680 105-02	1.2 - 3.0		Straight
5680 105-05	3.0 - 6.0		Angled
5680 105-06	4.0 - 8.8		Angled

Bit	OAL	N <sub>T</sub>
	mm	
5680 084-01	50	8IP
5680 084-02	50	15IP
5680 084-03	89	15IP
5680 084-04	50	7IP
5680 084-05	50	9IP
5680 084-06	50	10IP
5680 084-07	50	20IP
5680 084-08	89	20IP
5680 084-09	89	25IP
5680 084-10	89	30IP
5680 084-11	50	6IP
5680 084-12	80	27IP
5680 084-13	35	50IP

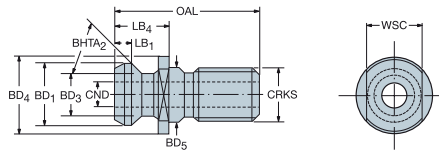
Bit	OAL	N <sub>T</sub>
	mm	
5680 084-14	50	30IP
5680 084-15	25	15IP
5680 084-16	25	30IP
5680 084-17	25	6IP
5680 084-18	25	7IP
5680 084-19	25	8IP
5680 084-20	25	9IP
5680 084-21	25	10IP
5680 084-22	25	20IP
5680 084-23	25	25IP
5680 083-01	25	HEX3
5680 083-04	50	HEX2,5



# Pull studs



PS-VxxC

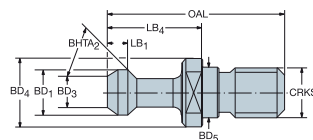


## CAT-V

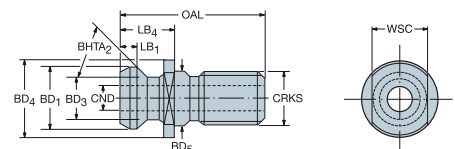
					Dimensions, mm												
CZC	CRKS	CNSC	CXSC	Ordering code	WSC	LB <sub>1</sub>	LB <sub>4</sub>	CND	BD <sub>1</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BD <sub>5</sub>	BHTA <sub>2</sub>	OAL	(KG)	Machine	
40	M16	1	1	PS-V40C-45-001	18	5.4	16.4	7	19.0	12.9	22.5		45°	38	0.04		
	M16	1	1	PS-V40C-45-006	19	5.1	19.1	6	18.8	12.4	22.1	17	45°	47	0.06	Fadal	
50	M24	1	1	PS-V50C-45-001	30	7.7	25.5	11	29.1	19.6	37.0		45°	59	0.15		
	1-8 UNC	1	1	PS-V50C-45-005	31	7.6	25.4	11	29.0	20.8	36.3	26	45°	58	0.17	Mazak	
	1-8 UNC	1	1	PS-V50C-45-008	29	9.9	45.2	9	22.9	16.9	38.1	24	45°	79	0.20	Makino	
	1-8 UNC	1	1	PS-V50C-60-001	29	9.9	44.9	6	23.0	17.0	38.1	25	60°	82	0.29	Okuma	



PS-Ixx



PS-IxxC



## ISO

					Dimensions, mm												
CZC	CRKS	CNSC	CXSC	Ordering code	WSC	LB <sub>1</sub>	LB <sub>4</sub>	CND	BD <sub>1</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BD <sub>5</sub>	BHTA <sub>2</sub>	OAL	(KG)	BSG	Machine
30	M12	0	0	PS-I30-75-001	14	5.0	24.0		13.0	9.0	17.0	13	75°	44	0.04		
40	M16	0	0	PS-I40-75-001	19	6.0	26.0		19.0	14.0	23.0	17	75°	54	0.05	DIN 69872	
	M16	1	1	PS-I40C-45-001	18	5.3	16.4	7	19.0	12.9	22.5	17	45°	44	0.05	ISO 7388 B	
	M16	1	1	PS-I40C-45-002	19	5.0	16.2	7	18.8	12.4	21.8	17	45°	41	0.05		Mazak
	M16	1	1	PS-I40C-45-003	19	5.0	19.1	7	18.8	12.4	22.0	17	45°	44	0.05		Mazak
	M16	1	1	PS-I40C-75-001	19	6.0	26.0	7	19.0	14.0	23.0	17	75°	54	0.05	DIN 69872	
	M16	1	1	PS-I40C-75-002	19	6.0	26.0	7	19.0	14.0	23.0	17	75°	54	0.05	ISO 7388	
	M16	1	1	PS-I40C-75-003	19	6.0	29.0	7	19.0	14.1	23.0	17	75°	54	0.05		Mori Seiki
50	M24	0	0	PS-I50-45-001	30	7.6	25.5		29.1	19.6	37.0	25	45°	65	0.15	ISO 7388 B	
	M24	0	0	PS-I50-75-001	30	9.0	34.0		28.0	21.0	36.0	25	75°	74	0.15	DIN 69872	
	M24	0	0	PS-I50-75-002	30	9.0	34.0		28.0	21.0	36.0	20	75°	74	0.15		
	M24	0	0	PS-I50-75-003	30	9.0	34.0		28.0	21.1	36.0	25	75°	74	0.15		
	M24	0	0	PS-I50-90-001	30	10.0	46.6		22.0	16.0	39.0	32	90°	99	0.15		GSP
	M24	1	1	PS-I50C-45-001	30	7.6	25.5	11	29.1	19.6	37.0	25	45°	65	0.15	ISO 7388 B	
	M24	1	1	PS-I50C-45-002	26	5.2	16.4	7	19.0	12.9	30.0	25	45°	56	0.15		
	M24	1	1	PS-I50C-45-003	30	7.6	25.4	10	29.0	20.8	36.5	25	45°	65	0.15		Yamazaki
	M24	1	1	PS-I50C-45-004	30	7.6	25.4	10	29.0	20.8	36.5	25	45°	65	0.15		Yamazaki
	M24	1	1	PS-I50C-75-001	30	9.0	34.0	11	28.0	21.0	36.0	25	75°	74	0.15	DIN 69872	
	M24	1	1	PS-I50C-75-002	30	9.0	34.0	11	28.0	21.0	36.0	25	75°	74	0.15	ISO 7388	
	M24	1	1	PS-I50C-90-001	30	6.5	32.5	6	20.0	13.0	38.5		90°	70	0.15		Forest



N23



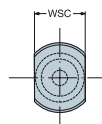
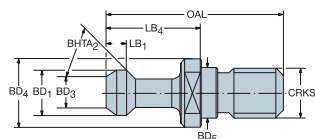
N15



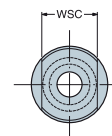
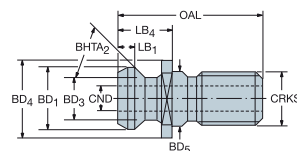
# Pull studs



PS-Bxx



PS-BxxC



## MAS-BT

					Dimensions, mm														
CZC	CRKS	CNSC	CXSC	Ordering code	WSC	LB <sub>1</sub>	LB <sub>4</sub>	CND	BD <sub>1</sub>	BD <sub>3</sub>	BD <sub>4</sub>	BD <sub>5</sub>	BHTA <sub>2</sub>	OAL	<sup>KG</sup>	BSG	Machine		
30	M12	0	0	PS-B30-45-001	13	5.0	23.0		11.0	7.0	16.0	12	45°	43	0.03				
	M12	0	0	PS-B30-60-001	13	7.0	35.0		11.0	7.0	16.0	12	60°	43	0.03				
	M12	1	1	PS-B30C-45-001	13	5.0	23.0	2	11.0	7.0	16.5	12	45°	43	0.03				
	M12	1	1	PS-B30C-45-002	13	5.0	23.0	2	11.0	7.0	16.5	12	45°	43	0.03		Mori Seiki		
	M12	1	1	PS-B30C-45-003	13	5.0	23.0	4	11.0	8.0	16.5	12	45°	43	0.03		Fanuc		
	M12	1	1	PS-B30C-60-001	13	5.0	23.0	2	11.0	7.0	16.5	12	60°	43	0.03				
	M12	1	1	PS-B30C-60-002	13	5.0	23.0	2	11.0	7.5	16.5	12	60°	43	0.03		Brother		
40	M16	0	0	PS-B40-45-001	19	7.0	35.0		15.0	10.0	23.0	17	45°	60	0.05				
	M16	0	0	PS-B40-60-001	19	7.0	35.0		15.0	10.0	23.0	17	60°	60	0.05				
	M16	0	0	PS-B40-90-001	19	7.0	35.0		15.0	10.0	23.0	17	90°	60	0.05				
	M16	1	1	PS-B40C-45-001	19	7.0	35.0	4	15.0	10.0	23.0	17	45°	60	0.05				
	M16	1	1	PS-B40C-60-001	19	7.0	35.0	3	15.0	10.0	23.0	17	60°	60	0.05				
	M16	1	1	PS-B40C-75-001	18	11.4	25.1	7	25.3	21.1	25.3	17	75°	53	0.05				
	M16	1	1	PS-B40C-75-002	19	6.0	29.0	7	19.0	14.0	23.0	17	75°	54	0.05		JIS 40		
	M16	1	1	PS-B40C-90-001	19	7.0	35.0	3	15.0	10.0	23.0	17	90°	60	0.05				
50	M24	0	0	PS-B50-45-001	30	10.0	45.0		23.0	17.0	38.0	25	45°	85	0.25				
	M24	0	0	PS-B50-60-001	30	10.0	45.0		23.0	17.0	38.0	25	60°	85	0.25				
	M24	0	0	PS-B50-90-001	30	10.0	45.0		23.0	17.0	38.0	25	90°	85	0.25		Okuma		
	M24	1	1	PS-B50C-45-001	30	10.0	45.0	7	23.0	17.0	38.0	25	45°	85	0.25				
	M24	1	1	PS-B50C-60-001	30	10.0	45.0	8	23.0	17.0	38.0	25	60°	85	0.25				
	M24	1	1	PS-B50C-75-001	30	9.0	34.0	11	28.0	21.0	36.0	25	75°	74	0.22		JIS 50		
	M24	1	1	PS-B50C-90-001	30	8.0	31.0	6	24.0	18.0	36.0	25	90°	71	0.20		Mitsui		
M24	1	1	PS-B50C-90-002	30	10.0	45.0	8	23.0	17.0	38.0	25	90°	85	0.25		Okuma			



N23



N15

# General information

# Wiper

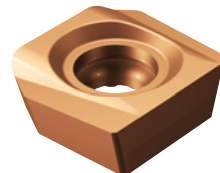
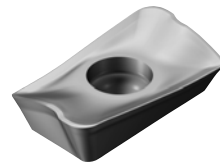
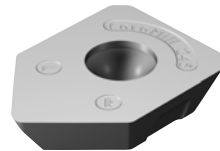
## Inserts for increased productivity

### Wiper

Excellent surface finishes can be achieved with standard inserts in combination with one or more wiper inserts. Wiper inserts work most usefully at a high feed per revolution,  $f_n$ , in larger diameter cutters with extra close pitch and setting facilities.

Feed per revolution can be increased approx. four times while still maintaining good surface quality. Wiper inserts can be used in milling in most materials to produce good surface textures – even under unfavorable conditions.

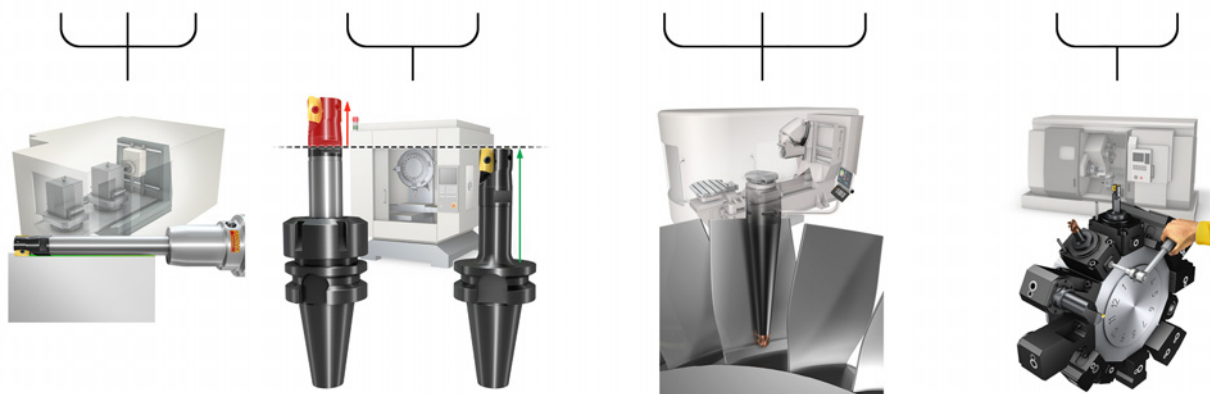
TECHNOLOGY  
**Wiper**



# Modular system - Coromant EH

Tooling flexibility for small diameters

CoroMill® 316    CoroMill® 495    CoroMill® 490    CoroMill® 390    CoroBore® 825 EH    CoroBore® 824 XS    CoroMill® 216    CoroMill® 300



**Large machining centres**  
Long overhang with stability and clearance.

**Small and medium machining centres**  
When gauge line is critical.

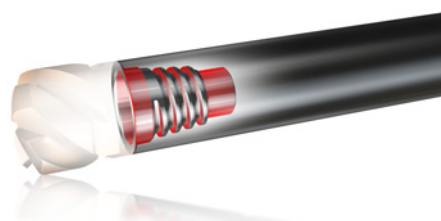
**Medium to large machining centres**  
Modularity with Coromant Capto® in different lengths.

**Turning centres with driven tool holders**  
Short gauge length and swing diameter.

For more information about Coromant EH system:  
[www.sandvik.coromant.com/coromanteh](http://www.sandvik.coromant.com/coromanteh)

## Coromant EH coupling

The Coromant EH coupling is based on a self-centering screw thread for secure mounting, rigidity and strength. The coupling has a physical stop which makes it easy to feel when the head is correctly tightened and helps to not overstress the clamping.



# CoroChuck™ 930

High-precision hydraulic chuck with high pull-out security and precision

## Application

- Suitable for milling and drilling operations where precision, easy handling and high pull-out security are required
- Covers all of the important machine interfaces

## Benefits and features

- High metal removal rate provides increased productivity
- Secure process and safe machining
- Quick tool change and set-up
- Enhanced surface finish and increased tool life
- Close hole tolerance
- Best pull-out security on the market due to the latest Fulcrum technology\* used for uppermost clamping performance with high clamping force. The clamping force repeats time after time
- Easy handling with torque wrench used for secure clamping
- The machine-side coupling is ground as last operation to guarantee the highest demands on precision
- High precision repetition
- Balancing according to DIN 69888
- Clamping length can be adjusted with an adjustment screw



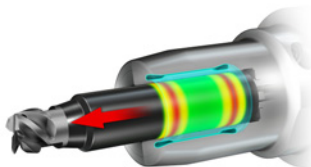
[www.sandvik.coromant.com/corochuck930](http://www.sandvik.coromant.com/corochuck930)

## Available coupling types

- Coromant Capto®
- HSK
- BIG-PLUS
- ISO
- CAT-V
- MAS-BT



CoroChuck™ 930 can be used with or without reduction collets. For internal coolant use 393.CGS collets and for external coolant use 393.CG.



Fulcrum technology\* gives best pull-out security on the market. It allows for secure clamping with two supports on each side (fulcrums).



Also available with BIG-PLUS interface for machining centers.

# CoroChuck™ 970

For a secure tapping process

## Application

- For elimination of oversized threading
- Suitable for all synchronized tapping operations

## Benefits and features

- Improves tapping tool life
- Secure machining process
- Reduces the risk of cutting oversized threads significantly
- Synchronized tapping reduces thrust force on tap flanks
- Accurate depth thanks to limited axial compensation
- New, improved design for internal coolant
- Suitable for high-pressure coolant up to 80 bar (1160 psi)
- More back-ends to fit your machine



[www.sandvik.coromant.com/corochuck970](http://www.sandvik.coromant.com/corochuck970)

## Available coupling types

- Coromant Capto®
- ISO-Cone (ISO, MAS-BT, CAT-V)
- HSK
- Cylindrical
- Weldon
- Coromant EH

## Product range

- ER sizes for CoroChuck 970: 8, 11, 20, 25, 32, 40 and 50.
- ER-size 50 has a square inside the adaptor and should be used with the largest tap (M48). The collet that will be used with this large tap will be a collet without a square.
- For HSK 63 and HSK 100 it is possible to use MQL on ER sizes 20 and 25.

## Product range

Design	Coromant Capto®	Coromant EH	ISO-Cone (ISO, MAS-BT, CAT-V)	BIG-PLUS (ISO, MAS-BT, CAT-V)	HSK	Cylindrical	Weldon
SynchroFlex®	C3, C4, C5, C6, C8, C10	25	30, 40, 50	30, 40, 50	63, 100	12, 16, 20	12, 16, 25, 25A, 40

# Tailor Made

Additional tool options designed for your specific requirements.



Apart from a comprehensive standard programme we can offer tools to your dimensions on standard tool terms. In our Tailor Made offer you are free to specify your own dimensions without paying the price of a special tool.

Even more possibilities thanks to tailored design!  
If you do not find what you need in our comprehensive standard programme, choose the tool shape you require and we will tailor it for you to your dimensions.

**CoroMill® 490**

**Cylindrical**

Size	D <sub>h</sub> (mm)	IC
16	16.00-21.4	08
20	19.00-26.8	08
25	19.00-32.2	08/14
32	21.75-37.6	08/14
40	21.75-43.0	08/14

**Weldon**

Size	D <sub>h</sub> (mm)	IC
16	16.00-21.4	08
20	19.00-26.8	08
25	19.00-32.2	08/14
32	21.75-37.6	08/14
40	21.75-43.0	08/14

**Coromant Capto®**

Size	D <sub>h</sub> (mm)	IC
C3	19.00-40	08
C4	19.00-45	08/14
C5	19.00-50	08/14
C6	19.00-55	08/14
C8	19.00-60	08/14
C8	19.00-65	08/14

**Standard insert, size 8 x 21, 4000 10 14**

**HSK type A**

Size	D <sub>h</sub> (mm)	IC
40	20-80	08/14
50	20-80	08/14

**Arbor mounting, TDA**

Size	D <sub>h</sub> (mm)	IC
16	37.5	08
20	38.1	08
22.225	38.1	08
25	40	08/14
27	44	08/14
31.75	100	14

**TDB**

Size	D <sub>h</sub> (mm)	IC
32	100-125	14
36.1	125-160	14
45	125-160	14
50.8	160-200	14

**TDC**

Size	D <sub>h</sub> (mm)	IC
40	100-200	14
47.625	200-254	14
60	200-254	14

**Options**

Insert size: 08 or 14  
D<sub>h</sub>: -08, Diameter - 16.00-44 mm  
-14, Diameter - 21.75-54 mm  
Pitch type: Even or Differential  
F<sub>z</sub>: -02, No. of inserts 2-08  
-14, No. of inserts 2-20  
Mounting: Cylindrical, Weldon, Coromant Capto®, HSK-A, Arbor mounting  
Type: CoroMill®  
Mounting size: see above

Reach length: -06, 21 mm = 3 × D<sub>h</sub>  
-14, 40 mm = 2 × D<sub>h</sub>  
Total length: -02, 74-200 mm  
-14, 99-250 mm  
Programming length: -02, 40-175.5 mm  
-14, 40-180.5 mm  
Coolant hole: -08, Yes -D<sub>h</sub> = 43 mm/No  
-14, Yes/No - all TDC and TDB size 50.8

**CoroMill® 490** Inquiry/ordering No.

Customer: \_\_\_\_\_ Customer No. (Coromant internal): \_\_\_\_\_ Date: \_\_\_\_\_  
Telephone: \_\_\_\_\_ Customer attention: \_\_\_\_\_  
Street: \_\_\_\_\_ Telephone: \_\_\_\_\_  
Post Code/City/State: \_\_\_\_\_ Telefax: \_\_\_\_\_ Issuer: \_\_\_\_\_  
Quantity: \_\_\_\_\_ Customer denomination: \_\_\_\_\_

main catalogue or supplement catalogue  
metric and imperial  
Your value / Your choice

above standard

14 Delivered with shank 38.1-254 (with exceptions)  
greater pitch not valid for every combination  
on insert size, cutter diameter and pitch

Coromant Capto HSK A  
Coromant Capto HSK A  
Size D<sub>h</sub> (mm) IC Size D<sub>h</sub> (mm) IC  
22 19.00-40 08 40 20-80 08/14  
24 19.00-45 08/14  
26 19.00-50 08/14  
28 19.00-55 08/14  
30 19.00-60 08/14

TDB HSK A  
Size D<sub>h</sub> (mm) IC Size D<sub>h</sub> (mm) IC  
32 100-125 14 40 100-200 14  
36.1 125-160 14 47.625 200-254 14  
45 125-160 14 60 200-254 14  
50.8 160-200 14

Coromant Capto HSK A Arbor mounting TDB TDC  
16 30-40 70-80 25.4 30 35 40  
20 30-40 70-80 25.4 30 35 40  
22 30-40 70-80 25.4 30 35 40  
25 30-40 70-80 25.4 30 35 40

Insert size 14  
D<sub>h</sub> 38.1-254  
F<sub>z</sub> max = 1.5 max  
F<sub>z</sub> 40-3 × D<sub>h</sub>  
F<sub>z</sub> \*

See 80.8  
The value choice must be given  
If no value choice is specified, it will be recommended by the system

### What you can expect from us

- Quick quotation
- Easy ordering
- Performance guarantee at given product and cutting data
- Competitive delivery times

[www.sandvik.coromant.com/tailormade](http://www.sandvik.coromant.com/tailormade)

The Tailor Made option is available in the following product families:

- |   |  |   |
|---|--|---|
| <p><b>Milling</b></p> <ul style="list-style-type: none"> <li>- CoroMill® 245</li> <li>- CoroMill® 300</li> <li>- CoroMill® 390</li> <li>- CoroMill® 419</li> <li>- CoroMill® 490</li> <li>- CoroMill® 790</li> <li>- CoroMill® Century</li> <li>- CoroMill® 331</li> <li>- CoroMill® QD</li> <li>- CoroMill® 415</li> <li>- CoroMill® 425</li> <li>- CoroMill® 345</li> <li>- CoroMill® 365</li> <li>- CoroMill® 745</li> </ul> | <p><b>Drilling</b></p> <ul style="list-style-type: none"> <li>- CoroDrill® 870</li> <li>- CoroDrill® 880</li> <li>- CoroDrill® DS20</li> </ul> | <p><b>Adaptors</b></p> <ul style="list-style-type: none"> <li>- Coromant EH</li> <li>- CoroChuck™ 930</li> <li>- Coromant Capto®</li> </ul> |
|---|--|---|

### Engineered solutions

When standard or Tailor Made solutions do not fulfill your needs you can depend on Sandvik Coromant's wide experience in engineered tool solutions to handle particularly demanding criteria. Access our Tailor Made forms at [www.sandvik.coromant.com](http://www.sandvik.coromant.com)



# 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

# Safety information

## 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.



## General code key for CoroMill cutter

<b>R</b>	<b>A</b>	<b>390</b>	<b>-</b>	<b>063</b>	<b>Q</b>	<b>22</b>	<b>L</b>	<b>-</b>	<b>11</b>	<b>M</b>	<b>050</b>
1	2	3		4	5	6	7		8	9	10

<p><b>1 Style</b></p> <p>R = Right hand rotating</p>	<p><b>2 Performance</b></p> <p>A = Inch</p>	<p><b>3 Main code</b></p> <p>E.g.: 390 = CoroMill® 390</p>		
<p><b>4 Cutting diameter</b></p> <p>E.g.: 063 = 63 mm</p>	<p><b>5 Type of coupling</b></p> <table border="0"> <tr> <td style="vertical-align: top;"> <p>A = Cylindrical, mm</p> <p>B = Weldon mm</p> <p>C = Coromant Capto®</p> <p>D = Cylindrical inch</p> <p>J = CIS arbor mounting</p> <p>M = Weldon, inch</p> <p>N = Whistle Notch inch</p> <p>Q = Arbor mounting mm</p> <p>O = Cylindrical inch</p> </td> <td style="vertical-align: top;"> <p>R = Arbor mounting inch</p> <p>T = Threaded coupling</p> <p>W = Whistle Notch mm</p> <p>HA= HSK form A</p> </td> </tr> </table>		<p>A = Cylindrical, mm</p> <p>B = Weldon mm</p> <p>C = Coromant Capto®</p> <p>D = Cylindrical inch</p> <p>J = CIS arbor mounting</p> <p>M = Weldon, inch</p> <p>N = Whistle Notch inch</p> <p>Q = Arbor mounting mm</p> <p>O = Cylindrical inch</p>	<p>R = Arbor mounting inch</p> <p>T = Threaded coupling</p> <p>W = Whistle Notch mm</p> <p>HA= HSK form A</p>
<p>A = Cylindrical, mm</p> <p>B = Weldon mm</p> <p>C = Coromant Capto®</p> <p>D = Cylindrical inch</p> <p>J = CIS arbor mounting</p> <p>M = Weldon, inch</p> <p>N = Whistle Notch inch</p> <p>Q = Arbor mounting mm</p> <p>O = Cylindrical inch</p>	<p>R = Arbor mounting inch</p> <p>T = Threaded coupling</p> <p>W = Whistle Notch mm</p> <p>HA= HSK form A</p>			
<p><b>6 Coupling size</b></p> <p>22 = 22 mm</p>	<p><b>9</b></p> <p>L = Coarse pitch</p> <p>M = Close pitch</p> <p>H = Extra close pitch</p>	<p><b>10 Length, LF</b></p> <p>E.g.: 050 = 50 mm</p>		
<p><b>7 Extra long</b></p> <p>L = Extra long</p>	<p><b>8 Insert size</b></p> <p>11 = 11 mm (LE)</p>			

## General code key for CoroMill inserts

<b>R</b>	<b>390</b>	-	<b>11</b>	<b>T3</b>	<b>12</b>	<b>M</b>	-	<b>P</b>	<b>L</b>	<b>W</b>
1	2		3	4	5	6		7	8	9

<p><b>1 Hand of insert</b></p> <p>R = Right hand L = Left hand</p>	<p><b>2 Main code</b></p> <p>E.g.: 390= CoroMill® 390</p>	<p><b>3 Insert width</b></p> <p>E.g.: 11 = 11 mm</p>
<p><b>4 Insert thickness, S mm</b></p> <p>E.g.: T3 S = 3.97 04 S = 4.76 06 S = 6.33</p>	<p><b>5 Corner radius</b></p> <p>E.g.: 12 = 1.2 mm</p>	<p><b>6 Edge performance</b></p> <p>M = Highest edge security E = Highest sharpness and precision H = High edge sharpness and high precision K = High cutting sharpness</p>
<p><b>7 Main ISO application area</b></p> <p><b>P</b> <b>M</b> <b>K</b> <b>N</b> <b>S</b> <b>H</b></p>	<p><b>8 Operation</b></p> <p>L = Light cutting M = Medium H = Heavy T = Turn milling</p>	<p><b>9 Wiper</b></p> <p>W = Wiper</p>

## Code key for CoroMill® 327

### CoroMill 327 insert

Grooving and chamfering

<b>327</b>	<b>R</b>	<b>12</b>	-	<b>22</b>	<b>130</b>	<b>45</b>	<b>08</b>	-	<b>GC</b>
1	2	3		4	5	9	12		7

Threading

<b>327</b>	<b>R</b>	<b>06</b>	-	<b>12</b>	<b>100</b>	<b>VM</b>	-	<b>TH</b>
1	2	3		4	10	11		7

Profiling

<b>327</b>	<b>R</b>	<b>06</b>	-	<b>12</b>	<b>220</b>	<b>11</b>	-	<b>RM</b>
1	2	3		4	5	6		7

Grooving

<b>327</b>	<b>R</b>	<b>12</b>	-	<b>28</b>	<b>150</b>	<b>01</b>	-	<b>GM</b>	<b>M</b>
1	2	3		4	5	6		7	8

- 1 Product name
- 2 Right-hand insert
- 3 Coupling size (interface)
- 4  $D_{min}$  (mm)
- 5 Insert width
- 6 Radius ex 02 = radius 0.2 mm
- 7 Type of insert

GM = Grooving  
 RM = Fullnose radius  
 CH = Chamfering  
 GC = Grooving and chamfering  
 TH = Threading

- 8 M = Close pitch
- 9 Chamfer 45°
- 10 Thread pitch           mm: pitch x 100
- 11 Type of thread        VM = V-Profile 60°  
                                   MM = Metric 60°  
                                   WH = Whitworth 55°
- 12 Max cutting depth, CDX in mm

### CoroMill® 327 holders

<b>327</b>	-	<b>12</b>	<b>B</b>	<b>15</b>	<b>S</b>	<b>C</b>	-	<b>06</b>
1		2	3	4	5	6		7

- 1 Product name
- 2 Shank diameter, DCON
- 3 Shank type                B = Weldon
- 4 Reach length
- 5 Shank materials         S = steel  
                                   E = solid carbide
- 6 Internal coolant
- 7 Coupling size (interface)

# Code key for CoroMill® 328

## CoroMill® 328 insert

Chamfering

<b>328</b>	<b>R</b>	<b>13</b>	-	<b>110</b>	<b>45</b>	-	<b>GC</b>
1	2	3		4	7		6

Threading

<b>328</b>	<b>R</b>	<b>13</b>	-	<b>150</b>	<b>VM</b>	-	<b>TH</b>
1	2	3		8	9		6

Grooving

<b>328</b>	<b>R</b>	<b>13</b>	-	<b>110</b>	<b>01</b>	-	<b>GM</b>
1	2	3		4	5		6

- |   |                              |   |                |                    |
|---|------------------------------|---|----------------|--------------------|
| 1 | Product name                 | 7 | Chamfer 45°    |                    |
| 2 | Right-hand insert            | 8 | Thread pitch   | mm: pitch x 100    |
| 3 | Insert size                  | 9 | Type of thread | VM = V-Profile 60° |
| 4 | Insert width                 |   |                |                    |
| 5 | Radius ex 02 = radius 0.2 mm |   |                |                    |
| 6 | Geometry                     |   |                |                    |
|   | GM = Grooving                |   |                |                    |
|   | GC = Grooving and chamfering |   |                |                    |
|   | TH = Threading               |   |                |                    |

## CoroMill® 328 cutters

<b>328</b>	-	<b>039</b>	<b>B</b>	<b>25</b>	-	<b>13</b>	<b>M</b>
1		2	3	4		5	6

- |   |                                 |
|---|---------------------------------|
| 1 | Product name                    |
| 2 | Cutting diameter, DC            |
| 3 | Shank type                      |
|   | B = Weldon                      |
|   | Q = Arbor                       |
|   | S = Bore with keyway            |
| 4 | Shank/couplings diameter (DCON) |
| 5 | Insert size                     |
| 6 | Pitch                           |

## Code key for tool holders

Cylindrical holder

<b>A</b>	<b>E12</b>	-	<b>A</b>	<b>20</b>	-	<b>S</b>	<b>S</b>	-	<b>140</b>
1	2		3	4		5	6		7

Coromant Capto® holder

<b>C3</b>	-	<b>A</b>	<b>391.EH</b>	-	<b>10</b>	<b>035</b>
8		1	9		10	7

Solid holder

<b>392.45EH</b>	-	<b>40</b>	-	<b>10</b>	-	<b>056</b>
9		11		10		7

<p><b>1 System of measurement</b></p> <p>A = Inch version</p>	<p><b>2 Size of interface</b></p> <p>E12= EH coupling size</p>	<p><b>3 Holder type</b></p> <p>A = Cylindrical</p>
<p><b>4 Holder diameter</b></p> <p>E.g.: DCON = 20 mm</p>	<p><b>5 Type of holder</b></p> <p>S = Straight C = Conical</p>	<p><b>6 Holder material</b></p> <p>S = Steel E = Solid carbide</p>
<p><b>8 Coupling size</b></p> <p>C = Coromant Capto®</p>	<p><b>9 Family/ holder type</b></p> <p>391.EH = Coromant Capto® EH holder 392.140EH = ISO 7388.1 392.55EH = MAS-BT 403 A392.45EH = CAT V 392.410EH = HSK holder Form A/C A392.R8EH = Bridgeport holder 392.EREH = ER integrated holder</p>	<p><b>10 Size of interface</b></p> <p>EH coupling size</p>
		<p><b>11 Taper size</b></p> <p>Taper size for Coromant solid holders</p>

## Code key for solid holding tools

<b>A</b>	<b>A</b>	<b>1</b>	<b>B</b>	<b>05</b>	-	<b>50</b>	<b>32</b>	<b>060</b>
1	2	3	4	5		6	7	8

**1 Inch version****2 Coolant through centre****3 Spindle type**

1=ISO 7388/1 (DIN 69871)  
 2= MAS-BT  
 3=CAT V-Flange

**4**

B= Coolant through flange  
 F= Flange mounting  
 X= Extra short

**5 Holder type**

05 = Face mill holder  
 14= ER Collet chuck  
 20=End mill holder Weldon type  
 27= Short hole drill holder-shank ISO 9766

**6 Taper size 30, 40, 50****7 Size bore or pilot, DCON<sub>ws</sub>**

mm		
09	19	38
13	25	51
16	32	63

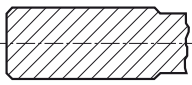
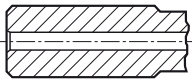
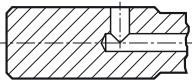
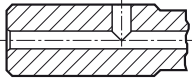
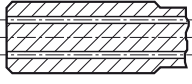
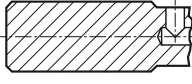
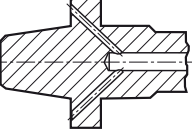
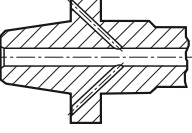

**8 Programming length, mm**

060 = 60 mm



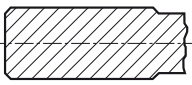
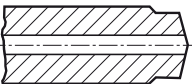
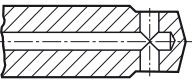
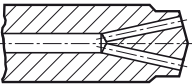
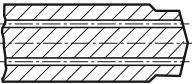
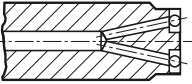
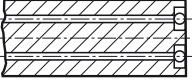
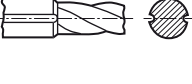
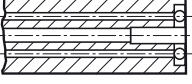
**CNSC**

## 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	

**Formulas and definitions:**

$v_c$ = cutting speed	m/min (meter/minute)
$n$ = spindle speed	rpm (revolution per minute)
$v_f$ = table feed	mm/min
$z_1$ = total number of cutting edges	
$z_c$ = number of effective cutting edges	
$f_z$ = feed per tooth	mm/z
$f_n$ = feed per revolution	mm/rev
$h_{ex}$ = maximum thickness	mm
$a_p$ = cutting depth	mm
$a_e/D_c$ % = Radial immersion	%
$T$ = machining time	min
$Q$ = metal removal rate	cm <sup>3</sup> /min
$n_{ap}$ = number of passes	
$k_c$ = specific cutting force	N/mm <sup>2</sup>
$R_a$ = surface roughness	μm

**Insert size**

 = cutting edge length in mm

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Material cross reference list

ISO	MC	CMC	Country										
			Europe	Germany	Great Britain	Sweden	USA	France	Italy	Spain	Japan		
			Standard DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS	
P	<b>Unalloyed steel</b>												
	P1.1.Z.AN	01.1	S235JR G2	1.0038	4360 40 C	-	1311	A570.36	E 24-2 Ne	-	-	STKM 12A;C	
	P1.1.Z.AN	01.1	S235J2 G3	1.0116	4360 40 B	-	1312	A573-81 65	E 24-U	Fe37-3	-	-	
	P1.1.Z.AN	01.1	C15	1.0401	080M15	-	1350	1015	CC12	C15C16	F.111	-	
	P1.1.Z.AN	01.1	C22	1.0402	050A20	2C/2D	1450	1020	CC20	C20C21	F.112	-	
	P1.1.Z.AN	01.1	C15E	1.1141	080M15	32C	1370	1015	XC12	C16	C15K	S15C	
	P1.1.Z.AN	01.1	C25E	1.1158	-	-	-	1025	-	-	-	S25C	
	P1.1.Z.AN	01.1	S380N	1.8900	4360 55 E	-	2145	A572-60	-	FeE390KG	-	-	
	P1.1.Z.AN	01.1	17MnV7	1.0870	4360 55 E	-	2142	A572-60	NFA 35-501 E 36	-	-	-	
	P1.1.Z.AN	02.1	55Si7	1.0904	250A53	45	2085	9255	55S7	55Si8	56Si7	-	
	P1.1.Z.AN	02.2	-	-	-	-	2090	9255	55S7	-	-	-	
	P1.2.Z.AN	01.2	C35	1.0501	060A35	-	1550	1035	CC35	C35	F.113	-	
	P1.2.Z.AN	01.2	C45	1.0503	080M46	-	1650	1045	CC45	C45	F.114	-	
	P1.2.Z.AN	01.2	40Mn4	1.1157	150M36	15	-	1039	35M5	-	-	-	
	P1.2.Z.AN	01.2	36Mn5	1.1167	-	-	2120	1335	40M5	-	36Mn5	SMn438(H)	
	P1.2.Z.AN	01.2	28Mn6	1.1170	150M28	14A	-	1330	20M5	C28Mn	-	SCMn1	
	P1.2.Z.AN	01.2	C35G	1.1183	060A35	-	1572	1035	XC38TS	C36	-	S35C	
	P1.2.Z.AN	01.2	C45E	1.1191	080M46	-	1672	1045	XC42	C45	C45K	S45C	
	P1.2.Z.AN	01.2	C53G	1.1213	060A52	-	1674	1050	XC48TS	C53	-	S50C	
	P1.2.Z.AN	01.3	C55	1.0535	070M55	-	1655	1055	-	C55	-	-	
	P1.2.Z.AN	01.3	C55E	1.1203	070M55	-	-	1055	XC55	C50	C55K	S55C	
	P1.2.Z.AN	02.1	S275J2G3	1.0144	4360 43C	-	1412	A573-81	E 28-3	-	-	SM 400A;B;C	
	P1.2.Z.AN	02.1	S355J2G3+C2	1.0570	4360 50B	-	2132	-	E36-3	Fe52BFN/Fe52CFN	-	SM490A;B;C;YA;YB	
	P1.2.Z.AN	02.1	S355J2G3	1.0841	150 M 19	-	2172	5120	20 MC 5	Fe52	F-431	-	
	P1.3.Z.AN	01.3	C60E	1.0601	080A62	43D	-	1060	CC55	C60	-	-	
	P1.3.Z.AN	01.3	C60E	1.1221	080A62	43D	1678	1060	XC60	C60	-	S58C	
	P1.3.Z.AN	01.4	C101E	1.1274	060 A 96	-	1870	1095	XC 100	-	F-5117	-	
	P1.3.Z.AN	01.4	C101u	1.1545	BW 1A	-	1880	W 1	Y105	C36KU	F-5118	SK 3	
	P1.3.Z.AN	01.4	C105W1	-	BW2	-	2900	W210	Y120	C120KU	F.515	SUP4	
	P1.3.Z.AN	02.1	S340 MGC	1.0961	-	-	-	9262	60SC7	60SiCr8	60SiCr8	-	
	P1.4.Z.AN	01.1	11SMn30	1.0715	230M07	-	1912	1213	S250	CF9SMn28	11SMn28	SUM22	
	P1.4.Z.AN	01.1	11SMnPb30	1.0718	-	-	1914	12L13	S250Pb	CF9SMnPb28	11SMnPb28	SUM22L	
	P1.4.Z.AN	01.1	10SPb20	1.0722	-	-	-	-	10PbF2	CF10SPb20	10SPb20	-	
	P1.4.Z.AN	01.1	11SMn37	1.0736	240M07	1B	-	1215	S 300	CF9SMn36	12SMn35	-	
	P1.4.Z.AN	01.1	11SMnPb37	1.0737	-	-	1926	12L14	S300Pb	CF9SMnPb36	12SMnP35	-	
	P1.4.Z.AN	01.2	35S20	1.0726	212M36	8M	1957	1140	35MF4	-	F210G	-	
	P1.5.C.UT	01.1	GC16E	1.1142	030A04	1A	1325	1115	-	-	-	-	
	Steel	<b>Low-alloy steel</b>											
		P2.1.Z.AN	02.1	16Mo3	1.5415	1501-240	-	2912	A204Gr.A	15D3	16Mo3KW	16Mo3	-
		P2.1.Z.AN	02.1	14Ni6	1.5622	-	-	-	A350LF5	16N6	14Ni6	15Ni6	-
		P2.1.Z.AN	02.1	21NiCrMo2	1.6523	805M20	362	2506	8620	20NCD2	20NiCrMo2	20NiCrMo2	SNCM220(H)
		P2.1.Z.AN	02.1	17CrNiMo6	1.6587	820A16	-	-	-	18NCD6	-	14NiCrMo13	-
		P2.1.Z.AN	02.1	15Cr3	1.7015	523M15	-	-	5015	12C3	-	-	SCR415(H)
		P2.1.Z.AN	02.1	55Cr3	1.7176	527A60	48	-	5155	55C3	-	-	SUP9(A)
		P2.1.Z.AN	02.1	15CrMo5	1.7262	-	-	2216	-	12CD4	-	12CrMo4	SCM415(H)
P2.1.Z.AN		02.1	13CrMo4-5	1.7335	1501-620Gr27	-	-	A182 F11;F12	15CD3.5	14CrMo4 5	14CrMo45	-	
P2.1.Z.AN		02.1	10CrMo9 10	1.7380	1501-622 Gr.31;45	-	2218	A182 F22	15CD4.5	-	-	-	
P2.1.Z.AN		02.1	14MoV6 3	1.7715	1503-660-440	-	-	-	12CD9, 10	12CrMo9, 10	TU.H	-	
P2.1.Z.AN		02.1	50CoMo4	1.7228	823M30	33	2512	-	-	-	13MoCrV6	-	
P2.1.Z.AN		02.2	14NiCr10	1.5732	-	-	-	3415	14NC11	16NiCr11	15NiCr11	SNC415(H)	
P2.1.Z.AN		02.2	14NiCr14	1.5752	655M13; A12	36A	-	3415;3310	12NC15	-	-	SNC815(H)	
P2.1.Z.AN		02.1/02.2	16MnCr5	1.7131	(527M20)	-	2511	5115	16MC5	16MnCr5	16MnCr5	-	
P2.1.Z.AN		02.1/02.2	34CrMo4	1.7220	708A37	19B	2234	4137;4135	35CD4	35CrMo4	34CrMo4	SCM432;SCCRM3	
P2.1.Z.AN		02.1/02.2	41CrMo4	1.7223	708M40	19A	2244	4140;4142	42CD4TS	41CrMo4	42CrMo4	SCM 440	
P2.1.Z.AN		02.1/02.2	42CrMo4	1.7225	708M40	19A	2244	4140	42CD4	42CrMo4	42CrMo4	SCM440(H)	
P2.1.Z.AN		03.11	14NiCrMo134	1.6657	832M13	36C	-	-	-	15NiCrMo13	14NiCrMo131	-	
P2.2.Z.AN		02.1	31CrMo12	1.8515	722 M 24	-	2240	-	30 CD 12	30CrMo12	F-1712	-	
P2.2.Z.AN		02.1	39CrMoV13 9	1.8523	897M39	40C	-	-	-	36CrMoV12	-	-	
P2.2.Z.AN		02.1	41CrS4	1.7039	524A14	-	2092	L1	-	105WCR 5	-	-	
P2.2.Z.AN		02.1	50NiCr13	1.2721	-	-	2550	L6	55NCV6	-	F-528	-	
P2.2.Z.AN		03.11	45WCrV7	1.2542	BS1	-	2710	S1	-	45WCrV8KU	45WCrS18	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	36CrNiMo4	1.6511	816M40	110	-	9840	40NCD3	38NiCrMo4(KB)	35NiCrMo4	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	34CrNiMo6	1.6582	817M40	24	2541	4340	35NCD6	35NiCrMo6(KB)	-	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	34Cr4	1.7033	530A32	18B	-	5132	32C4	34Cr4(KB)	35Cr4	SCR430(H)	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	41Cr4	1.7035	530A40	18	-	5140	42C4	41Cr4	42Cr4	SCR440(H)	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	32CrMo12	1.7361	722M24	40B	2240	-	30CD12	32CrMo12	F.124.A	-	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	51CrV4	1.8159	735A50	47	2230	6150	50CV4	50CrV4	51CrV4	SUP10	
P2.2.Z.AN/P2.5.Z.HT		02.1/02.2	41CrAlMo7	1.8509	905M39	41B	2940	-	40CAD6, 12	41CrAlMo7	41CrAlMo7	-	
P2.3.Z.AN		02.1	100Cr6	1.3505	534A99	31	2258	52100	100C6	100C6	F.131	SUJ2	

## Material cross reference list

ISO	MC	CMC	Country									
			Europe	Germany	Great Britain	Sweden	USA	France	Italy	Spain	Japan	
			Standard									
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
P	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	105WCr6	1.2419	-	-	2140	-	105WC13	10WCr6	105WCr5	SKS31
	P2.3.Z.AN/H1.2.Z.HA	-	-	-	-	-	-	-	-	107WCr5KU	-	SKS2, SKS3
	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	-	1.2714	-	-	-	L6	55NCDV7	-	F520.S	SKT4
	P2.3.Z.AN/H1.3.Z.HA	02.1/02.2	100Cr6	1.2067	BL3	-	-	L3	Y100C6	-	100Cr6	-
	P2.4.Z.AN	02.1	16MnCr5	1.7139	-	-	2127	-	-	-	-	-
	P2.5.Z.HT	02.1	16Mo5	1.5423	1503-245-420	-	-	4520	-	16Mo5	16Mo5	-
	P2.5.Z.HT	02.1	40NiCrMo8-4	1.6562	311-Type 7	-	-	8740	-	40NiCrMo2(KB)	40NiCrMo2	SNCM240
	P2.5.Z.HT	02.1	42Cr4	1.7045	-	-	2245	5140	-	-	42Cr4	SCR440
	P2.5.Z.HT	02.1	31NiCrMo14	1.5755	830 M 31	-	2534	-	-	-	F-1270	-
	P2.5.Z.HT	02.2	36NiCr6	1.5710	640A35	111A	-	3135	35NC6	-	-	SNC236
	P2.6.C.UT	02.1	22Mo4	1.5419	605A32	-	2108	8620	-	-	F520.S	-
	P2.6.C.UT	02.1/02.2	25CrMo4	1.7218	1717CDS110	-	2225	4130	25CD4	25CrMo4(KB)	AM26CrMo4	SCM420,SCM430
	P2.6.C.UT	06.2	-	-	-	-	2223	-	-	-	-	-
	<b>High-alloy steel</b>											
P3.0.Z.AN	03.11	X210Cr12	1.2080	BD3	-	-	D3	Z200C12	X210Cr13KU	X210Cr12	SKD1	
P3.0.Z.AN	03.11	X43Cr13	1.2083	-	-	2314	-	-	-	X250Cr12KU	-	
P3.0.Z.AN	03.11	X40CrMoV5 1	1.2344	BH13	-	2242	H13	Z40CDV5	X35CrMoV05KU	X40CrMoV5	SKD61	
P3.0.Z.AN	03.11	X100CrMoV5 1	1.2363	BA2	-	2260	A2	Z100CDV5	X40CrMoV511KU	X100CrMoV5	SKD12	
P3.0.Z.AN	03.11	X210CrW12	1.2436	-	-	2312	-	-	X100CrMoV51KU	X210CrW12	SKD2	
P3.0.Z.AN	03.11	X30WCrV9 3	1.2581	BH21	-	-	H21	Z30WCV9	X28W09KU	X30WCrV9	SKD5	
P3.0.Z.AN	03.11	X165CrMoV 12	1.2601	-	-	2310	-	-	X30WCrV9 3KU	X160CrMoV12	-	
P3.0.Z.AN	03.21	X155CrMoV12-1	1.2379	-	-	2736	HNV3	-	X165CrMoV12KU	-	-	
P3.0.Z.HT	03.11	X8Ni9	1.5662	1501-509;510	-	-	ASTM A353	-	X10Ni9	XBNI09	-	
P3.0.Z.HT	03.11	12Ni19	1.5680	-	-	-	2515	Z18N5	-	-	-	
P3.1.Z.AN	03.11	S6-5-2	1.3343	4959BA2	-	2715	D3	Z40CSD10	15NiCrMo13	-	SUH3	
P3.1.Z.AN	03.13	-	-	BM 2	-	2722	M 2	Z85WDCV	HS 6-5-2-2	F-5603.	SKH 51	
P3.1.Z.AN	03.13	HS 6-5-2-5	1.3243	BM 35	-	2723	M 35	6-5-2-5	HS 6-5-2-5	F-5613	SKH 55	
P3.1.Z.AN	03.13	HS 2-9-2	1.3348	HS 2-9-2	-	2782	M 7	-	HS 2-9-2	F-5607	-	
P3.2.C.AQ	06.33	G-X120Mn12	1.3401	Z120M12	-	2183	L3	Z120M12	XG120Mn12	X120Mn12	SCMnH/1	
<b>Ferritic/martensitic stainless steel</b>												
Steel	P5.0.Z.AN	05.11/15.11	X10CrAL13	1.4724	403S17	-	-	405	Z10C13	X10CrAl12	F.311	SUS405
	P5.0.Z.AN	05.11/15.11	X10CrAL18	1.4742	430S15	60	-	430	Z10CAS18	X8Cr17	F.3113	SUS430
	P5.0.Z.AN	05.11/15.11	X10CrAL2-4	1.4762	-	-	2322	446	Z10CAS24	X16Cr26	-	SUH446
	P5.0.Z.AN	05.11/15.11	X1CrMoTi18-2	1.4521	-	-	2326	S44400	-	-	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr13	1.4000	403S17	-	2301	403	Z6C13	X6Cr13	F.3110	SUS403
	P5.0.Z.AN/P5.0.Z.HT	-	X7Cr14	1.4001	-	-	-	-	-	-	F.8401	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X10Cr13	1.4006	410S21	56A	2302	410	Z10C14	X12Cr13	F.3401	SUS410
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr17	1.4016	430S15	960	2320	430	Z8C17	X8Cr17	F.3113	SUS430
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrAL13	1.4002	405S17	-	-	405	Z8CA12	X6CrAl13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X20Cr13	1.4021	420S37	-	2303	420	Z20C13	X20Cr13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrMo17-1	1.4113	434S17	-	2325	434	Z8CD17.01	X8CrMo17	-	SUS434
	P5.0.Z.HT	03.11	X45CrS9-3-1	1.4718	401S45	52	-	HW3	Z45CS9	X45CrSi8	F.322	SUH1
	P5.0.Z.HT	05.11/15.11	X85CrMoV18-2	1.4748	443S65	59	-	HNV6	Z80CSN20.02	X80CrSiNi20	F.320B	SUH4
	P5.0.Z.HT	05.11/15.11	X20CrMoV12-1	1.4922	-	-	2317	-	-	X20CrMoNi 12.01	-	-
	P5.0.Z.PH	05.11/15.11	X12CrS13	1.4005	416 S 21	-	2380	416	Z11CF13	X12 CrS 13	F-3411	SUS 416
	P5.0.Z.PH	05.11/15.11	X46Cr13	1.4034	420S45	56D	2304	-	Z40CM	X40Cr14	F.3405	SUS420J2
	P5.0.Z.PH	05.11/15.11	X19CrNi17-2	1.4057	431S29	57	2321	431	Z15CNI6.02	X16CrNi16	F.3427	SUS431
	P5.0.Z.PH	05.12/15.12	X5CrNiCuNb16-4	1.4542 1.4548	-	-	-	630	Z7CNU17-04	-	-	-
	P5.0.Z.PH	15.21	X4 CrNiMo16-5	1.4418	-	-	-	2387	-	Z6CND16-04-01	-	-
	P5.1.Z.AN/P5.0.Z.HT	05.11/15.11	X14CrMoS17	1.4104	-	-	2383	430F	Z10CF17	X10CrS17	F.3117	SUS430F
P2.1.Z.AN	02.1											
P2.2.Z.AN	02.1		1.0045									
P2.2.Z.AN	02.1											
P2.5.Z.HT	02.2											
P1.2.Z.AN												
P1.2.Z.AN												
P1.2.Z.AN												
P2.5.Z.HT												
P2.5.Z.HT	02.2											
P2.5.Z.HT	02.2											
P2.5.Z.HT												
P2.5.Z.HT												
P2.5.Z.HT												

Material cross reference list

ISO	MC	CMC	Country										
			Europe	Germany	Great Britain	Sweden	USA	France	Italy	Spain	Japan		
			Standard										
DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS				
M	<b>Austenitic stainless steel</b>												
	M1.0.Z.AQ	05.11/15.11	X3CrNiMo13-4	1.4313	425C11	-	2385	CA6-NM	Z4CND13.4M Z38C13M	(G)X6CrNi304	-	SCS5	
	M1.0.Z.AQ/M1.0.C.UT	05.11/15.11	X53CrMnNiN12-9	1.4871	349S54	-	-	EV8	Z52CMN21.09	X53CrMnNiN12 9	-	SUH35, SUH36	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiN18-10	1.4311	304S62	-	2371	304LN	Z2CN18.10	-	-	SUS304LN	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-13-3	1.4429	-	-	2375	316LN	Z2CND17.13	-	-	SUS316LN	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo17-12-2	1.4404	316S13	-	2348	316L	Z2CND17-12	X2CrNiMo1712	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-14-3	1.4435	316S13	-	2353	316L	Z2CND17.12	X2CrNiMo17 12	-	SCS16, SUS316L	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X3CrNiMo17-3-3	1.4436	316S33	-	2343, 2347	316	Z6CND18-12-03	X8CrNiMo1713	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-15-4	1.4438	317S12	-	2367	317L	Z2CND19.15	X2CrNiMo18 16	-	SUS317L	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiNb18-10	1.4550	347S17	58F	2338	347	Z6CND18.10	X6CrNiNb18 11	F.3552 F.3524	SUS347	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiMoTi17-12-2	1.4571	320S17	58J	2350	316Ti	Z6NDT17.12	X6CrNiMoTi17 12	F.3535	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X10CrNiMoNb 18-12	1.4583	-	-	-	318	Z6CNDNb17 13B	X6CrNiMoNb17 13	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X15CrNiSi20-12	1.4828	309S24	-	-	309	Z15CNS20.12	-	-	SUH309	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-11-2	1.4406	301S21	58C	2370	308	Z1NCDU25.20	-	F.8414	SCS17	
	M1.0.Z.AQ	05.21/15.21	X1CrNiMoCuN20-18-7	1.4547	-	-	2378	S31254	Z1CNDU20-18-06AZ	-	-	-	
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X9CrNi18-8	1.4310	-	-	2331	301	Z12CN17.07	X12CrNi17 07	F.3517	SUS301	
	M1.0.Z.PH	05.22/15.22	X7CrNiAl17-7	1.4568	1.4504	316S111	-	-	17-7PH	Z8CNA17-07	X2CrNiMo1712	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNi19-11	1.4306	304S11	-	2352	304L	Z2CN18-10	X2CrNi18 11	-	-	
	M1.1.Z.AQ	05.21/15.21	-	-	304S12	-	-	-	-	-	-	-	
	M1.1.Z.AQ	05.21/15.21	X5CrNi18-10	1.4301	304S31	58E	2332, 2333	304	Z6CN18.09	X5CrNi18 10	F.3504 F.3541	SUS304	
	M1.1.Z.AQ	05.21/15.21	X5CrNi18-10	1.4301	304S15	58E	2332	304	Z6CN18.09	X5CrNi18 10	F.3551	SUS304	
	M1.1.Z.AQ	05.21/15.21	X5CrNiMo17-2-2	1.4401	316S16	58J	2347	316	Z6CND17.11	X5CrNiMo17 12	F.3543	SUS316	
	M1.1.Z.AQ	05.21/15.21	X6CrNiTi18-10	1.4541	321S12	58B	2337	321	Z6CNT18.10	X6CrNiTi18 11	F.3553 F.3523	SUS321	
	M1.2.Z.AQ	05.21/15.21	X8CrNiSi18-9	1.4305	303S21	58M	2346	303	Z10CNF 18.09	X10CrNiSi 18.09	F.3508	SUS303	
	<b>Super austenitic (Ni&gt;20%) stainless steel</b>												
	M2.0.C.AQ	20.11	G-X40NiCrSi36-18	1.4865	330C11	-	-	-	-	XG50NiCr39 19	-	SCH15	
	M2.0.Z.AQ	05.21/15.21	X1NiCrMoCu25-20-5	1.4539	-	-	2562	UNS V 0890A	Z2 NCDU25-20	-	-	-	
	M2.0.Z.AQ	05.21/15.21	X8CrNi25-21	1.4845	310S24	-	2361	310S	Z12CN25 20	X6CrNi25 20	F.331	SUH310	
	M2.0.Z.AQ	20.11	X12NiCrSi36 16	1.4864	-	-	-	330	Z12NCS35.16	F-3313	-	SUH330	
	M2.0.Z.AQ	05.23/15.23	X1NiCrMoCu31-27-4	1.4563	-	-	2584	NO8028	Z1NCDU31-27-03	-	-	-	
	<b>Duplex (austenitic/ferritic) stainless steel</b>												
	M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X2CrNiN23-4	1.4362	-	-	2376	S31500	-	-	-	-	
	M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X8CrNiMo27-5	-	-	-	2324	S32900	-	-	-	-	
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiN23-4	-	-	-	2327	S32304	Z2CN23-04AZ	-	-	-	
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	-	-	-	-	2328	-	-	-	-	-	
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiMoN22-53	-	-	-	2377	S31803	Z2CND22-05-03	-	-	-	
	M1.1.Z.AQ	05.21/15.21											
	M1.1.Z.AQ	05.21/15.21		1.0045									
	M1.1.Z.AQ	05.21/15.21											
	M1.1.Z.AQ	05.21/15.21											
	M1.0.Z.AQ	05.23/15.23											
	M2.0.Z.AQ	05.23/15.23											
M3.2.Z.AQ	05.52/15.52												
M3.2.Z.AQ	05.52/15.52												

## Material cross reference list

ISO	MC	CMC	Country									
			Europe	Germany	Great Britain	Sweden	USA	France	Italy	Spain	Japan	
			Standard									
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
K	<b>Malleable cast iron</b>											
	K1.1.C.NS	07.1	-	-	8 290/6	-	0814	-	MN 32-8	-	-	FCMB310
	K1.1.C.NS	07.1	EN-GJMB350-10	0.8135	B 340/12	-	0815	32510	MN 35-10	-	-	FCMW330
	K1.1.C.NS	07.2	EN-GJMB450-6	0.8145	P 440/7	-	0852	40010	Mn 450	GMN 45	-	FCMW370
	K1.1.C.NS	07.2	EN-GJMB550-4	0.8155	P 510/4	-	0854	50005	MP 50-5	GMN 55	-	FCMP490
						P 570/3		0858	70003	MP 60-3		FCMP540
	K1.1.C.NS	07.2	EN-GJMB650-2	0.8165	P570/3	-	0856	A220-70003	Mn 650-3	GMN 65	-	FCMP590
	K1.1.C.NS	07.3	EN-GJMB700-2	0.8170	P690/2	-	0862	A220-80002	Mn700-2	GMN 70	-	FCMP690
	<b>Grey cast iron</b>											
	K2.1.C.UT	08.1	-	-	-	-	0100	-	-	-	-	-
	K2.1.C.UT	08.1	EN-GJL-100	0.6010	-	-	0110	No 20 B	Ft 10 D	-	-	FC100
	K2.1.C.UT	08.1	EN-GJL-150	0.6015	Grade 150	-	0115	No 25 B	Ft 15 D	G 15	FG 15	FC150
	K2.1.C.UT	08.1	EN-GJL-200	0.6020	Grade 220	-	0120	No 30 B	Ft 20 D	G 20	-	FC200
	K2.1.C.UT	08.2	EN-GJL-250	0.6025	Grade 260	-	0125	No 35 B	Ft 25 D	G 25	FG 25	FC250
	K2.1.C.UT	08.2	EN-JLZ	0.6040	Grade 400	-	0140	No 55 B	Ft 40 D	-	-	-
	K2.2.C.UT	08.2	EN-GJL-300	0.6030	Grade 300	-	0130	No 45 B	Ft 30 D	G 30	FG 30	FC300
	K2.2.C.UT	08.2	EN-GJL-350	0.6035	Grade 350	-	0135	No 50 B	Ft 35 D	G 35	FG 35	FC350
	K2.3.C.UT	08.3	GGL-NiCr20-2	0.6660	L-NiCuCr202	-	0523	A436 Type 2	L-NC 202	-	-	-
	<b>Nodular cast iron</b>											
	K3.1.C.UT	09.1	EN-GJS-400-15	0.7040	SNG 420/12	-	0717-02	60-40-18	FCS 400-12	GS 370-17	FGE 38-17	FCD400
	K3.1.C.UT	09.1	EN-GJS-400-18-LT	0.7043	SNG 370/17	-	0717-12	-	FGS 370-17	-	-	-
	K3.1.C.UT	09.1	EN-GJS-350-22-LT	0.7033	-	-	0717-15	-	-	-	-	-
	K3.1.C.UT	09.1	EN-GJS-800-7	0.7050	SNG 500/7	-	0727	80-55-06	FGS 500-7	GS 500	FGE 50-7	FCD500
	K3.2.C.UT	09.2	EN-GJS-600-3	0.7060	SNG 600/3	-	0732-03	-	FGS 600-3	-	-	FCD600
	K3.3.C.UT	09.2	EN-GJS-700-2	0.7070	SNG 700/2	-	0737-01	100-70-03	FGS 700-2	GS 700-2	FGS 70-2	FCD700
K3.5.C.UT	-	EN-GJSA-XNiCr20-2	0.7660	Grade S6	-	0776	A43D2	S-NC 202	-	-	-	
<b>Compacted graphite iron</b>												
K4.1.C.UT	-	EN-GJV-300										
K4.1.C.UT	-	EN-GJV-350										
K4.2.C.UT	-	EN-GJV-400										
K4.2.C.UT	-	EN-GJV-450										
K4.2.C.UT	-	EN-GJV-500										
<b>Austempered ductile iron</b>												
K5.1.C.NS	-	EN-GJS-800-8	-	-	-	-	ASTM A897 No. 1	-	-	-	-	
K5.1.C.NS	-	EN-GJS-1000-5	-	-	-	-	ASTM A897 No. 2	-	-	-	-	
K5.2.C.NS	-	EN-GJS-1200-2	-	-	-	-	ASTM A897 No. 3	-	-	-	-	
K5.2.C.NS	-	EN-GJS-1400-1	-	-	-	-	ASTM A897 No. 4	-	-	-	-	
K5.3.C.NS	-	-	-	-	-	-	ASTM A897 No. 5	-	-	-	-	



Material cross reference list

ISO	MC	CMC	Country											
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			Standard											
			DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS		
N	<b>Aluminium based alloys</b>													
	Non-ferrous metals	N1.3.C.AG	30.21	G-AISI9MGWA	3.2373	-	-	4251	SC64D	A-S7G	-	-	C4BS	
		N1.3.C.UT	30.21	G-ALMG5	-	LM5	-	4252	GD-AISI12	A-SU12	-	-	AC4A	
		N1.3.C.UT/N1.3.C.AG	30.21/30.22	-	-	LM25	-	4244	356.1	-	-	-	A5052	
		N1.3.C.UT	-	GD-AISI12	-	-	-	4247	A413.0	-	-	-	A6061	
		N1.3.C.AG	-	GD-AISI8Cu3	-	LM24	-	4250	A380.1	-	-	-	A7075	
		N1.3.C.UT	-	G-AISI12(Cu)	-	LM20	-	4260	A413.1	-	-	-	ADC12	
		N1.3.C.UT	-	G-AISI12	-	LM6	-	4261	A413.2	-	-	-	-	
		N1.3.C.AG	-	G-AISI10Mg(Cu)	-	LM9	-	4253	A360.2	-	-	-	-	
		S	<b>Nickel based alloys</b>											
Heat resistant super alloys			S2.0.Z.AG	20.22	S-NiCr13A16MoNb	LW2 4670	mar-46	-	-	5391	NC12AD	-	-	-
	S2.0.C.UT		20.24	NiCo15Cr10MoAlTi	LW2 4674	-	-	-	AMS 5397	-	-	-	-	
	S2.0.Z.AG		20.22	NiFe35Cr14MoTi	LW2.4662	-	-	-	5660	ZSNCDT42	-	-	-	
	S2.0.Z.AG		20.22	NiCr19Fe19NbMo	LW2.4668	HR8	-	-	5383	NC19eNB	-	-	-	
	S2.0.Z.AG		20.22	NiCr20TiAk	2.4631	HR401.601	-	-	-	NC20TA	-	-	-	
	S2.0.Z.AG		20.22	NiCr19Co11MoTi	2.4973	-	-	-	AMS 5399	NC19KDT	-	-	-	
	S2.0.Z.AG		20.22	NiCr19Fe19NbMo	LW2.4668	-	-	-	AMS 5544	NC20K14	-	-	-	
	S2.0.Z.AN		20.21	-	2.4603	-	-	-	5390A	NC22FeD	-	-	-	
	S2.0.Z.AN		20.21	NiCr22Mo9Nb	2.4856	-	-	-	5666	NC22FeDNB	-	-	-	
	S2.0.Z.AN		20.21	NiCr20Ti	2.4630	HR5.203-4	-	-	-	NC20T	-	-	-	
	S2.0.Z.AG		20.22	NiCu30AL3Ti	2.4375	3072-76	-	-	4676	-	-	-	-	
	<b>Cobalt alloys</b>													
	-		-	CoCr20W15Ni	-	-	-	-	5537C, AMS	KC20WN	-	-	-	-
	S3.0.Z.AG		20.32	CoCr22W14Ni	LW2.4964	-	-	-	5772	KC22WN	-	-	-	-
	<b>Titanium alloys</b>													
	S4.2.Z.AN		23.22	TiAl5Sn2.5	3.7115.1	TA14/17	-	-	UNS R54520	T-A5E	-	-	-	-
	S4.2.Z.AN		23.22	TiAl6V4	3.7165.1	TA10-13/TA28	-	-	UNS R56401	UNS R56400	-	-	-	-
	S4.3.Z.AN		23.22	TiAl5V5Mo5Cr3	-	-	-	-	-	T-A6V	-	-	-	-
	S4.2.Z.AN		23.22	TiAl4Mo4Sn4Si0.5	3.7185	-	-	-	-	-	-	-	-	-
	<b>Trade names</b>													
<b>Iron based alloys</b>														
S2.0.Z.UT/S2.0.Z.AN	20.11	Incoloy 800												
<b>Nickel based alloys</b>														
S2.0.Z.AN	20.2	Haynes 600												
S2.0.Z.AN	20.2	Nimocast PD16												
S2.0.Z.AG	20.2	Nimonic PE 13												
S2.0.Z.AG	20.2	Rene 95												
S2.0.Z.AN	20.21	Hastelloy C												
S2.0.Z.AN	20.21	Incoloy 825												
S2.0.Z.AN	20.21	Inconel 600												
S2.0.Z.AN	20.21	Monel 400												
S2.0.Z.AG	20.22	Inconel 700												
S2.0.Z.AG	S2.0.Z.AG	Inconel 718												
S2.0.Z.AG	20.22	Mar - M 432												
S2.0.Z.AG	20.22	Nimonic 901												
S2.0.Z.AG	20.22	Waspaloy												
S2.0.C.NS	20.24	Jessop G 64												
S3.0.Z.AG	20.3	<b>Cobalt alloys</b> Air Resist 213												
S3.0.Z.AG	20.3	Jetalloy 209												
H	<b>Hardened materials</b>													
	Hardened materials	H1.2.Z.HA	04.1	X100CrMo13	1.4108	-	-	2258 08	440A	-	-	-	C4BS	
		H1.3.Z.HA	04.1	X110CrMoV15	1.4111	-	-	2534 05	610	-	-	-	AC4A	
		H1.2.Z.HA	04.1	X65CrMo14	-	-	-	2541 06	0-2	-	-	-	AC4A	



**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>BALL</sub>	Cutting item count - Ball nose insert
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>SP</sub>	Cutting item count - Shank protection insert
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
DCONN <sub>WS</sub>	Connection diameter minimum workpiece side
DCONX <sub>WS</sub>	Connection diameter maximum 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
GB	Face land angle
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	Corner radius equivalent
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
STDNO	Standard number
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
ZADJ	Insert adjustable count
ZEFF	Face effective cutting edge count
ZEFP	Peripheral effective cutting edge count (ZEFP)
ZWX	Maximum number of Wiper inserts

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327..UN-TH	I150	393.37A	M26	826L..TC..-Cx	K59
327..VM-TH	I149	393.CF	M16	870..L	J6-J7
327..WH-TH	I150	393.CG	M17	870-GP	J8-J25
327-CH	I150	393.CGP	M18	870-KM	J8-J25
327-EHxx	L104	393.CGS	M15	870-MM	J8-J25
327-Erxx	L107	415..Axx	I38	870-PL	J11, J13-J14, J17, J20-J21, J23
327-GC	I147	415..EHxx	I39	870-PM	J8-J25
327-GM	I146	415..Txx	I40	880..C-GM	J42
327-RM	I147	415N..M-M30	I41	880..C-GR	J42
327-xxB	L100	416.2-L	M20	880..C-LM	J42
328..Bxx	I143	419..Axx	I30	880..Cx-03	J36-J37
328..MM-TH	I148	419..Cx	I29	880..L-02	J38-J40
328..Qxx	I143	419..Qxx	I29	880..L-03	J38-J40
328..Sxx	I143	419N/R..E-xx	I31	880..P-xx	J43
328..UN-TH	I148	419N/R..M-xx	I31	880-01..C-GR	J42
328..VM-TH	I148	425..P	I14	880-01..C-LM	J42
328-GC	I144	425..Qxx	I14	880-01..P-GR	J43
328-GM	I144	425N..E-KLW12	I15	880-01..P-LM	J43
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345..Cx	I5	490..Bxx	I52	880-D..Lxx-03	J41
345..Qxx	I6	490..Cx	I48-I49	880-D..Lxx-04	J41
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345R/L..M-xx	I8	495..Axx	I152	930-Bxx-HD	L82
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360R/L..M-KH	I22	495..EHxx	I153	930-Bxx-S	L82
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390.272	L65	5692	M11	930-Cx-T	L22
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390.540	L45	690..E-SL	I82	930-HAxx-P	L39
390.558	L55	690..HAxx	I81	930-HAxx-S	L38
390.58	L80	690..P-SL	I82	930-HF..HD	L37
390R..E-xx	I74-I76	690..Qxx	I81	930-IBxx-HD	L47
390R..M-xx	I75-I77	725..Cx	I43	930-IBxx-P	L48
392.140277	L68	725..Qxx	I44	930-IBxx-S	L47
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392.41005	L32	745..Qxx	I18	930-lxx-P	L70
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392.41014	L40	745R/L..E-M30	I19, I45	970-BBxx	L59
392.41020	L34	745R/L..E-M31	I19	970-Bxx	L85
392.41027	L36	745R/L..E-M50	I19, I45	970-Cx	L26
392.410277	L36	820..CN	K29, K31	970-Cyxx	L98
392.41037A..A	K40	820..CN-Cx	K25	970-EH	L104
392.41037A..B	K40	820..Cx-QC-Cx	K75	970-HAxx	L41
392.41037B..B	K40	820..SP	K28, K31	970-lbxx	L50
392.410EH	L31	820..SP..Y	K29-K30	970-lxx	L72
392.410XL	K76	820..SP..Y-Cx	K25	970-Wexx	L100
392.54005	L44	820..SP-Cx	K24	<b>A</b>	
392.54005C	L44	820..TC	K28, K30	A1B05	L63
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392.55277	L81	820..VC-XCx	K72	A1B20	L66
392.55505C	L54	820D..CC	K27	A1B27	L67
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392.55523	L55	820L..CC..F	K26	A205	L77
392.55805	L54	820L..SP..Y	K26	A208	L78
392.55805C	L54	825..SL	K70	A214	L84
392.55823	L55	825..SL-Cx	K69	A227	L81
392.55EH	L76	825..TC	K62, K64	A2B05	L77
392.58277	L81	825..TC..-EH	K47	A2B08	L78
392.644XL	K76	825..TC-Axx	K46	A2B14	L84
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392.647XL	K77	825D..TC	K60	A2B27	L81
392.ER327	L107	825D..TC..U-Cx	K52	A2F05	L77
392.EREH	L106	825L..TC	K56	APMT	I111
392.R8.05	L102	825L..TC..-Cx	K51, K58	<b>B</b>	
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393.14-xx	L97	826..TC-CxHP	K48-K50	BR10..CC..F-EHxx	K5
393.15	M21	826D..TC	K61	BR20..CC..F-Cx	K8

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BR20..SP..Y-Cx	K13	DS20..P-L6W	J33	R200..Axx	I102
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BR20D..SP..Y-CxS	K16	EHxx-Axx..CS	L95	R210..Txx	I35
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BR20D..TC..F-CxM	K15	EHxx-Axx.x-SH	L94	R216..Bxx	I108
BR20D..TC..F-CxS	K15	EHxx-Axx-SH	L92	R216..Cx	I106
BR30..CC..F-Cx	K18	EHxx-R824XS	K36	R216..EH	I109
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BR30..SN..Y-Cx	K21	Exx-Axx-CE	L95	R216..M-M	I111
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Cx-390.612	L29	LCMX-53	J47	R331.32C..Qxx	I116
Cx-390.670	L75	LCMX-58	J47	R331.32C..Qxx..MQ	I117
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Cx-390B.540	L43	N331.1A..E-xx	I130-I131	R331.52..Axx..R	I127
Cx-390B.55	L74	N331.1A..H-xx	I130-I131	R331.52..Qxx..L	I129
Cx-390B.555/558	L52	N331.1A..M-xx	I130-I131	R331.52..Qxx..R	I126
Cx-390B.58	L74	N331.1D..E-PM	I134	R390..Axx	I64-I65, I71
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Cx-391.01-Vxx	L13	N331.32..Sxx	I121	R390..Bxx	I66
Cx-391.02	L6-L7	N331.32..Sxx..MQ	I122	R390..Cx	I58-I59
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Cx-391.07C	L11	N365-KW4	I26	R390..EH	I67
Cx-391.10	L13	N365-KW8	I26	R390..E-xx	I74-I78
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SSYPR..CBX	K79				
SSYPR..CDX	K82				
STFCR..CBX	K78				
STFCR..CDX	K81				
<b>W</b>					
WCMX	J46-J47				