SANDVIK Coromant

2020

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

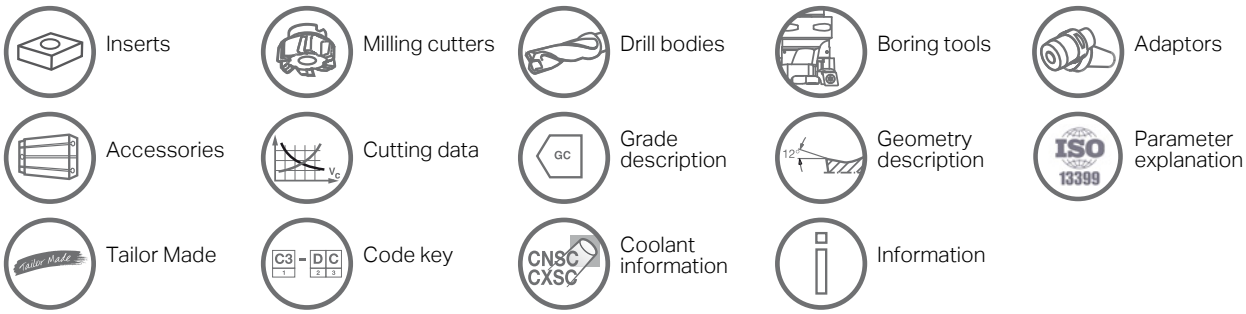
Solid Round Tools – Milling, Drilling, Tapping and Reaming

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**. 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 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:



★	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 I3

CoroMill® 345 I4-I8
CoroMill® 245 I9-I12
CoroMill® 425 I13-I15
CoroMill® 745 I16-I19
CoroMill® 360 I20-I22
CoroMill® 365 I23-I26

High-feed milling tools I27

CoroMill® 419 I28-I31
CoroMill® 210 I32-I36
CoroMill® 415 I37-I41
CoroMill® 745 I42-I45

Shoulder milling tools I46

CoroMill® 490 I47-I56
CoroMill® 390 I57-I78
CoroMill® 690 I79-I82
CoroMill® Century I83-I89

Profile milling tools I90

CoroMill® 300 I91-I99
CoroMill® 200 I100-I104
CoroMill® 216 I105-I111

Disc milling tools I112

CoroMill® 331 I113-I134

Groove milling tools I135

CoroMill® QD I136-I141
CoroMill® 328 I142-I144
CoroMill® 327 I145-I147

Thread milling tools I135

CoroMill® 328 I148
CoroMill® 327 I149-I150

Chamfer milling tools I135

CoroMill® 327 I150
CoroMill® 495 I151-I153

For complete assortment, see www.sandvik.coromant.com

How to choose your milling tool

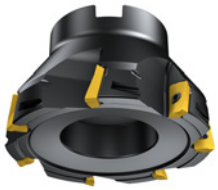
Cutter pitch

L

Coarse pitch

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

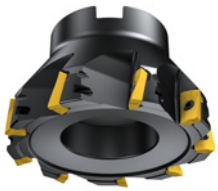
M



Close pitch

General purpose milling and mixed production. Always first choice.

H

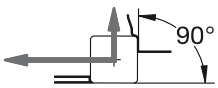


Extra close pitch

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

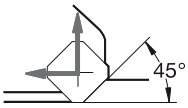
Entering angle

90° entering angle



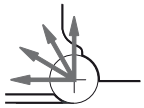
- Thin-walled components
- Weak fixtured components
- Where 90° form is required

45° entering angle



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

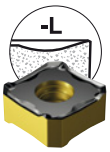
Round insert cutters



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

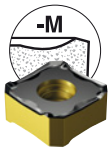
Insert geometries

Light



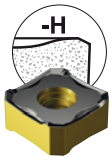
Extra positive, light machining, low cutting forces and for low feed rates.

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

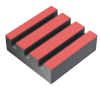
Ramping

Parting

Chamfering

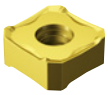
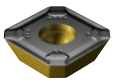
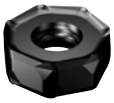
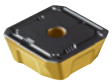
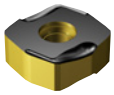
Grooving

Threading


Intermittent milling

Shoulder milling

Face milling tools

	CoroMill® 345	CoroMill® 245	CoroMill® 425	CoroMill® 745	CoroMill® 360	CoroMill® 365
Page	I5	I10	I14	I17	I21	I23
Material	P M K N S H	P M K N S H	K	P M K S	P M K	P M K N S H
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

J

Application

- Face milling
- Roughing to finishing

ISO application area:

P M K N S H

K

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

L

www.sandvik.coromant.com/coromill345

Couplings

- Coromant Capto®
- Arbor
- Cylindrical shank

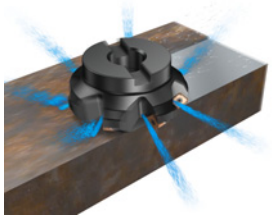
Inserts

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

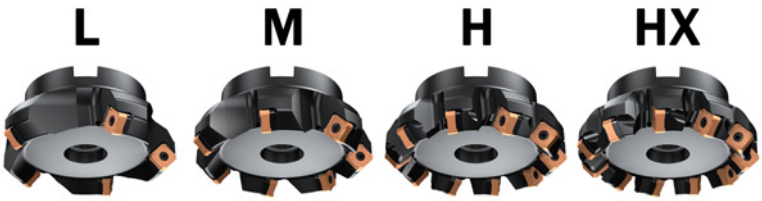
M

Internal coolant

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



N



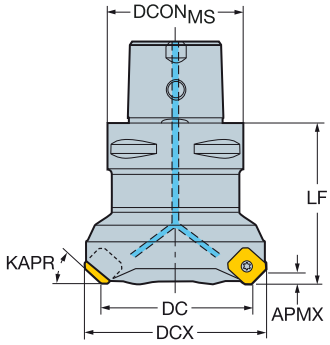
Coarse pitch | Close pitch | Extra close pitch | Extra close pitch plus

I5 I8

ENG

CoroMill® 345 face milling cutter

Coromant Capto® - Internal coolant supply



DC		CZCMS	APMXFFW	CNSC			Ordering code	Dimensions, mm DCONMS	DCX	LF	NM	KG	RPMX	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

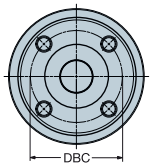
For complete list of spare parts, see www.sandvik.coromant.com

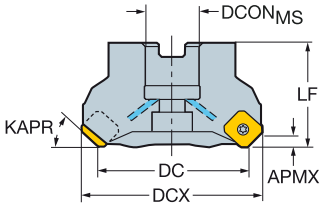
I8 L2 N23 N9 N15

CoroMill® 345 face milling cutter

Arbor - Internal coolant supply

STDNO ISO6462
KAPR 45°





DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	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

I8

L2

M1

N23

N9

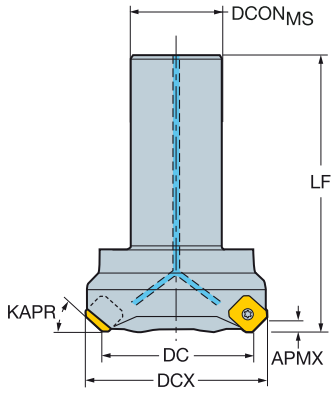
N15

ENG

CoroMill® 345 face milling cutter

Cylindrical shank - Internal coolant supply

KAPR 45°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	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

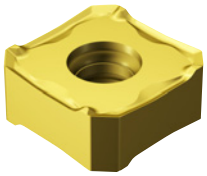
Spare parts		
Insert screw	Shim	Shim screw
416.1-834	5322 474-01	5512 090-11

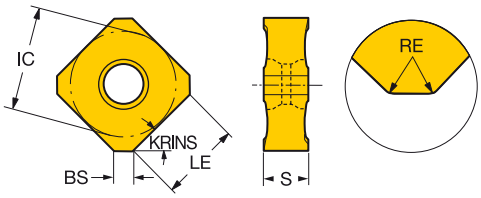
For complete list of spare parts, see www.sandvik.coromant.com

I8 L2 N23 N9 N15

CoroMill® 345 insert for milling

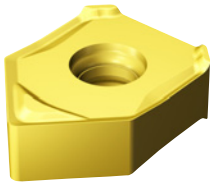
KRINS 45°

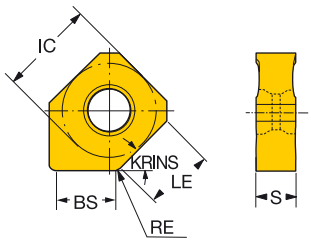




			RE	Ordering code	P 1010	P 1130	P 4220	P 4330	P 4340	P 530	P S40T	M 1040	M 2030	M 2040	M 530	M S30T	M S40T	K 1010	K 1020	K 3040	K 3220	K 3330	K 4220	K H13A	K K20W	N 1130	N 530	S 2030	S 2040	S 30T	S 40T	H 1010	H 1130	H 3040	H 4220	H 530	Dimensions, mm IC	LE	S	BS
Light	KL	13	0.80	345R-1305E-KL															★	☆	☆	☆		☆	☆									☆			13.0	8.8	5.60	2.0
			0.80	345R-1305M-KL			☆												★	☆		☆	☆		☆									☆	☆		13.0	8.8	5.60	2.0
	ML	13	0.80	345R-13T5E-ML		☆					☆	★	☆	☆		☆	☆									☆		☆	☆	★	☆		☆				13.0	8.8	5.95	2.0
	PL	13	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	13	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
	MM	13	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
	PM	13	0.80	345L-1305M-PM		☆		★	☆																								☆				13.0	8.8	5.60	2.0
			0.80	345R-1305M-PM	☆	☆	☆	★	☆	☆					☆			☆					☆									★	☆		★	☆	13.0	8.8	5.60	2.0
Heavy	KH	13	0.80	345R-1305M-KH				☆												☆	☆	★			☆									☆			13.0	8.8	5.60	2.0
	PH	13	0.80	345R-1305M-PH	☆	☆	☆	★	☆									☆		★			☆			☆						★	☆	☆	★		13.0	8.8	5.60	2.0

KRINS 45°





Wiper TECHNOLOGY

			RE	Ordering code	P 1010	P 1130	P 4330	P 530	M 1040	M 2030	M 2040	M 530	M S30T	M S40T	K 1010	K 1020	K 3220	K 3330	K 4330	K H13A	K K20W	N 1130	N 530	N H13A	S 2030	S 2040	S H13A	S 30T	S 40T	H 1010	H 1130	H 530	Dimensions, mm IC	LE	S	BS	BSR
Light	KW8	13	1.00	345N-1305E-KW8												☆	☆	☆		☆	☆			☆			☆							13.0	8.8	5.60	8.0	500.0
	MW8	13	1.00	345N-13T5E-MW8		☆			☆	☆	☆		☆	☆								☆			☆	☆		☆	☆		☆		13.0	8.8	5.95	8.0	500.0
	PW5	13	1.00	345N-1305E-PW5	☆	☆	☆								☆				☆			☆									☆	☆		13.0	8.8	5.60	5.0	500.0
	PW8	13	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

I5 I154 I175 N23 N10 N2

SANDVIK Coromant

CoroMill® 245

Light-cutting face mill for heavy roughing to mirror finishing

Application

- Face milling
- Roughing to finishing

ISO application area

P M K N S H

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

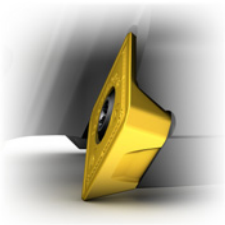
Couplings

- Arbor
- Cylindrical Shank

Inserts

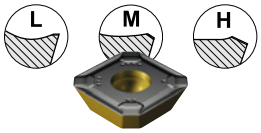
- Four cutting edges
- Wide range of grades and geometries including ceramic and CBN grades
- Wiper inserts for high feed finishing

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.

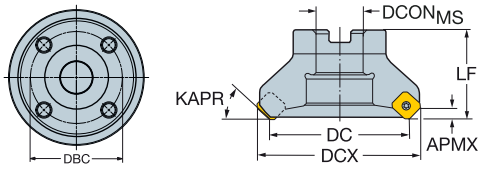


I10 I12 N6

CoroMill® 245 face milling cutter

Arbor

STDNO ISO6462
KAPR 45°



DC		CZC$_{MS}$	APMX$_{FFW}$			Ordering code	Dimensions, mm DCON$_{MS}$	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..
	18	32	10.00		5	R245-080Q32-18H	32.0	B		98.8	50.0	5.0	1.60	6100	5	R245-18T6..
100.0	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..
	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..
125.0	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..
	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..
160.0	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..
	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..
200.0	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..
	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..
250.0	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

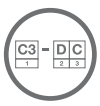
I12

L2

M1

N23

N6



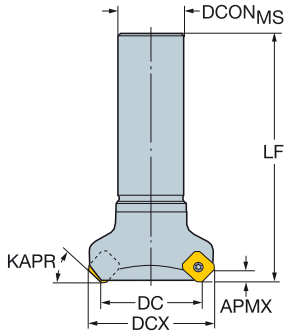
N9

ENG

CoroMill® 245 face milling cutter

Cylindrical shank

KAPR 45°



DC		CZC$_{MS}$	APMX$_{FFW}$			Ordering code	Dimensions, mm DCON$_{MS}$	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..

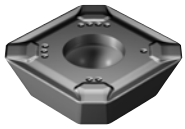
		Spare parts		
DC		Insert screw	Shim	Shim screw
32.00	12	5513 020-01		
40.00-80.00	12	5513 020-01	5322 472-01	5512 090-09

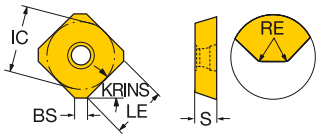
For complete list of spare parts, see www.sandvik.coromant.com

I12 L2 N23 N6 N9

CoroMill® 245 insert for milling

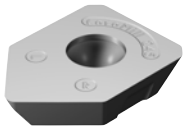
KRINS 45°

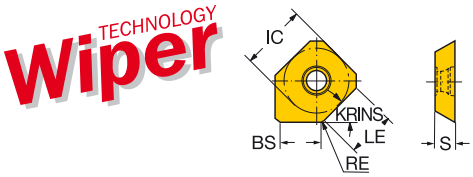




			RE	Ordering code	P 1010	P 1025	P 1030	P 4220	P 4330	P 4340	P 530	P S40T	M 1040	M 2030	M 2040	M 530	M S30T	M S40T	K 1010	K 1020	K 3040	K 3220	K 3330	K 4220	K H13A	K K15W	K K20W	N 1025	N 1030	N 530	N H10	N H13A	S 1025	S 1030	S 2030	S 2040	S H13A	S S30T	S S40T	H 1010	H 1025	H 1030	H 3040	H 4220	H 530	Dimensions, mm IC	LE	S	BS
Light	AL	12	1.50	R245-12 T3 E-AL																											★																13.4	10.0	3.97	2.3
Light	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
Light	ML	12	1.50	R245-12 T3 E-ML		☆	☆						★															☆	☆				☆	★							☆	☆					13.4	10.0	3.97	2.1
Light	PL	12	1.50	R245-12 T3 E-PL	☆	☆	☆		★		☆	☆				☆	☆	☆	☆									☆	☆	☆			☆	☆				★	☆	★	☆	☆				☆	13.4	10.0	3.97	2.1
			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
Medium	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
Medium	PM	12	1.50	R245-12 T3 M-PM	☆		☆	☆	★	☆	☆					☆			☆					☆					☆	☆				☆						★		☆		☆	☆	13.4	10.0	3.97	2.1
		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
Heavy	PH	12	1.60	R245-12 T3 M-PH				☆	★	☆														☆																				★		13.4	9.8	3.97	1.5

KRINS 45°

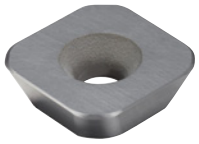


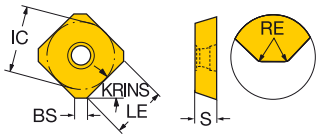


			RE	Ordering code	P 1010	P 1025	P 1030	P 530	M 530	K 1010	K 1020	K 1025	K 3220	K 3330	K CB50	K H13A	K K15W	N 1025	N H10	N 1030	N 530	N H13A	S 1025	S 1030	S H13A	H 1010	H 1025	H 1030	H 530	H CB50	Dimensions, mm IC	LE	S	BS	BSR
Light	W	12	2.50	R245-12 T3 E-W	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	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 6190	K CB50	N CD10	H 6190	H CB50	Dimensions, mm IC	LE	S	BS
Light	12	1.50	R245-12 T3 E		☆	★		☆	13.4	3.5	3.97	1.4
Light		2.50	R245-12 T3 E1	☆			☆		13.4	10.0	3.97	0.4

I10

I154

I175

N23

N10

N2

ENG

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

Couplings

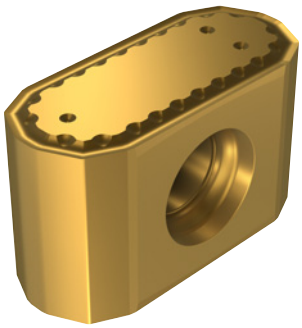
- Arbor
- Cap mounting

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.

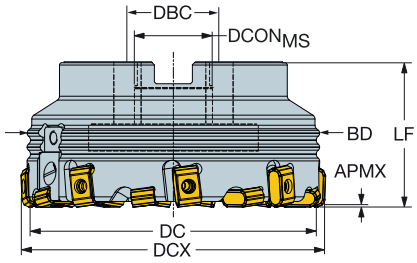


I14 I15

CoroMill® 425 face milling cutter

Arbor

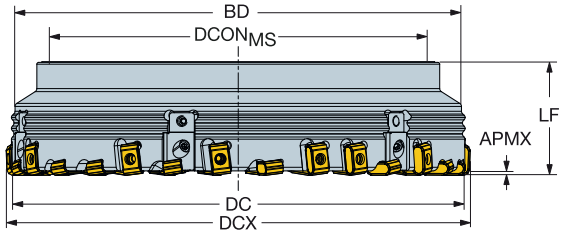
STDNO ISO6462
KAPR 25°



DC		CZC$_{MS}$	APMX	ZADJ		Ordering code	Dimensions, mm DCON$_{MS}$	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°



DC		CZC$_{MS}$	APMX	ZADJ		Ordering code	Dimensions, mm DCON$_{MS}$	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

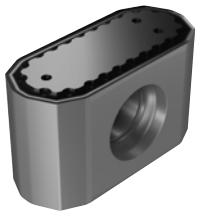
Spare parts					
Clamping screw	Wedge	Screw	Screw	Insert screw	Cassette
3212 012-260	5332 010-09	5516 035-09	5513 014-75	5513 020-13	R425-CA-17-2

For complete list of spare parts, see www.sandvik.coromant.com

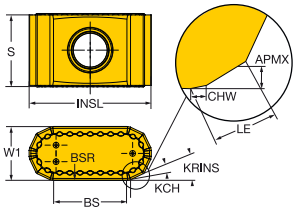
I41 L2 M1 N23 N9

ENG

CoroMill® 425 insert for milling



KRINS 25°



			KCH	CHW	Ordering code	K 1010	K 1020	K 3220	K 3330	K K20W	Dimensions, mm W1	LE	S	BS	BSR
Light	KLW	17	14°	0.4	425N-1707E-KLW12	★	☆	☆	☆	☆	7.5	2.1	10.00	10.4	1250.0

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:

P M K S

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

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.

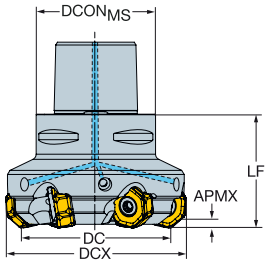
I17 I19

ENG

CoroMill® 745 face milling cutter

Coromant Capto® - Internal coolant supply

KAPR 42°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	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

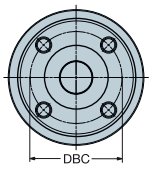
For complete list of spare parts, see www.sandvik.coromant.com

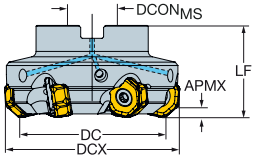
I19 L2 N23 N9 N15

CoroMill® 745 face milling cutter

Arbor - Internal coolant supply

STDNO ISO6462
KAPR 42°





DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	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

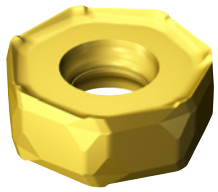
	Spare parts	
DC	Shower screw	Insert screw
63.00	5512 073-01	5513 020-80
80.00	5512 073-02	5513 020-80
100.00	5512 073-05	5513 020-80
125.00-160.00	5512 098-03	5513 020-80
250.00	-	5513 020-80

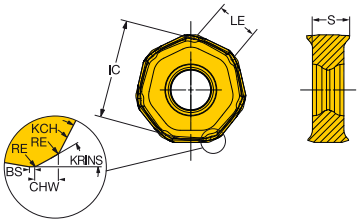
For complete list of spare parts, see www.sandvik.coromant.com

I45 L2 M1 N23 N9 N15

CoroMill® 745 insert for milling

KRINS 42°





			RE	KCH	CHW	Ordering code	P 1040	P 1130	P 2030	P 2040	P 3040	P 4220	P 4230	P 4240	P S40T	M 1040	M 2030	M 2040	M 4240	M S30T	M S40T	K 1020	K 3040	K 4220	K 4230	K 4240	K K20D	K K20W	S 2030	S 2040	S S30T	S S40T	Dimensions, mm 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
Medium	M31	21	1.00			745R-2109E-M31	☆	★	☆	☆	☆	☆	★	☆	☆	★	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	21.0	7.1	9.00	1.9	150.0
Roughing	M50	21	1.00	17°	1.3	745R-2109E-M50		☆			☆	☆	★	☆									★	☆	☆	☆	☆	☆					21.0	8.9	9.00	0.3	25.0
			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.

I17 I154 I175 N23 N10

CoroMill® 360

Heavy duty face mill

J

ISO application area:

P M K

K

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

L

M

H

M

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.

N

I21 I22

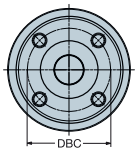
SANDVIK Coromant

ENG

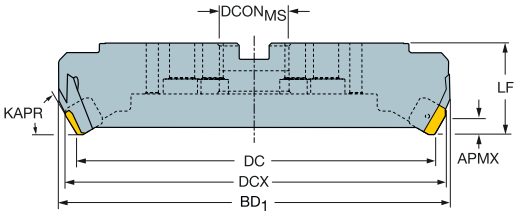
CoroMill® 360 face milling cutter

Arbor

STDNO
KAPR



ISO6462
60°



DC		CZC$_{MS}$	APMX	ZADJ			Ordering code	DCON$_{MS}$	ISO	DBC	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID
								Dimensions, mm											
160.0	19	40	13.0	6		6	360-160Q40-Z6D19	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	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	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	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	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	18.0	80.0	16.0	58.00	320	15	360R-2807

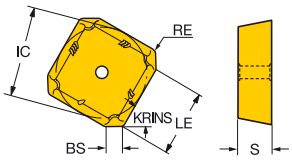
		Spare parts				
DC		Cassette	Insert wedge	Insert wedge screw	Cassette wedge	Cassette wedge screw
160.00-315.00	19	360R-CA-19	360R-IW-19	267.21-830	5431 105-08	5516 010-06
200.00-400.00	28	360R-CA-28	360R-IW-28	267.21-830	5431 105-08	5516 010-06

For complete list of spare parts, see www.sandvik.coromant.com

I22 L2 M1 N23 N9

CoroMill® 360 insert for milling

KRINS 60°



		SSC	RE	Ordering code	P 2030	P 2040	P 3040	P 4220	P 4330	P 4340	M 2030	M 2040	M 4340	K 3040	K 3330	K 4220	K 4330	K 4340	Dimensions, mm 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
			1.70	360R-28 07M-MH		☆						★							28.5	20.0	7.94	4.6	200.0
	PH	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

SANDVIK Coromant

CoroMill® 365

Secure face milling in cast iron and steel

ISO application area

P M K N S H

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.

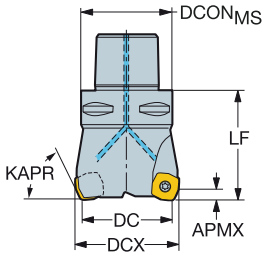
I24 I26

CoroMill® 365 face milling cutter

Coromant Capto®

Screw clamp design

KAPR 65°

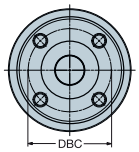


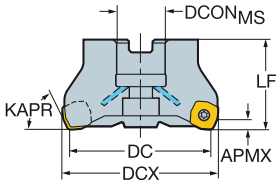
DC		CZCMS	APMX	CNSC		Ordering code	Dimensions, mm DCONMS	DCX	LF	NM	KG	RPMX	CICT	MIID
60.0	15	C6	6.0	3	5	R365-063C6-S15M	63.0	69.7	60.0	3.0	1.88	13600	5	R365-1505ZNE

Arbor

Screw clamp design

STDNO ISO6462
KAPR 65°





DC		CZCMS	APMX	CNSC			Ordering code	Dimensions, mm DCONMS	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

I26 L2 N23 N15 N9

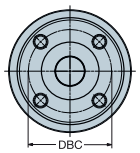
SANDVIK Coromant

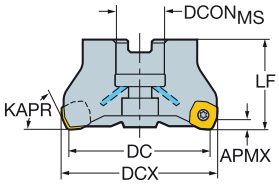
CoroMill® 365 face milling cutter

Arbor

Wedge clamp design

STDNO ISO6462
KAPR 65°





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

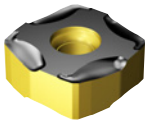
Spare parts	
Wedge screw	Wedge
339-831	5431 058-01

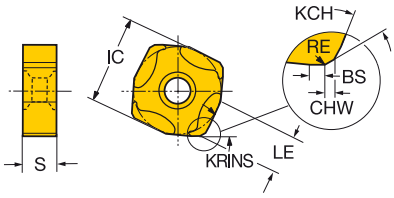
For complete list of spare parts, see www.sandvik.coromant.com

I26 L2 N23 N15 N9

CoroMill® 365 insert for milling

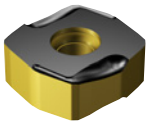
KRINS 65°

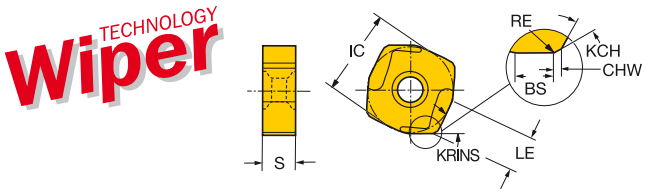




			RE	KCH	CHW	Ordering code	P 1130	P 4220	P 4330	M 1130	K 1010	K 1020	K 3330	K 4220	K 4330	K 20D	K 20W	N 1130	S 1130	H 1010	H 1130	H 4220	Dimensions, mm IC	LE	S	BS	BSR
Light	KL	15		30°	0.7	L365-1505ZNE-KL						★	☆										15.0	6.4	5.66	1.5	
			0.30	35°	0.7	R365-1505ZNE-KL						★	☆			☆	☆						15.0	6.4	5.66	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	
			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°

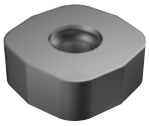


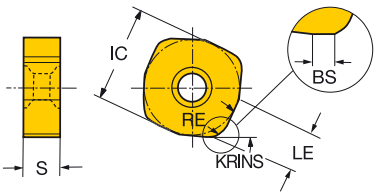


			RE	KCH	CHW	Ordering code	P 1030	P 1130	M 1030	M 1130	K 1020	K 20W	K 3220	K 3330	H 1030	H 1130	Dimensions, mm IC	LE	S	BS	BSR
Light	KW4	15	0.55	35°	0.8	N365-1505ZNE-KW4					☆	☆	☆	☆			15.0	6.4	5.66	4.0	200.0
	KW8	15	0.20	35°	0.8	N365-1505ZNE-KW8					☆	☆	☆	☆			15.0	6.4	5.66	8.0	431.0
	PW4	15	0.55	35°	0.8	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°



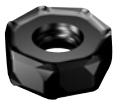
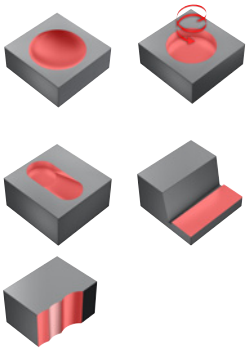
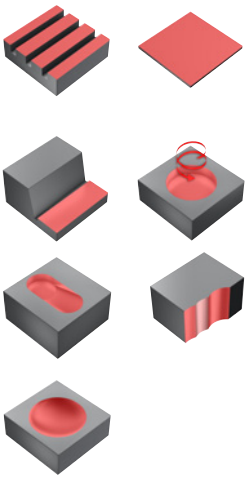
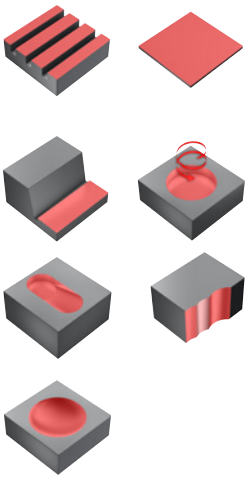


		RE	Ordering code	K 6190	H 6190	Dimensions, mm IC	LE	S	BS	BSR
Light	15	3.60	N365-1505ZNE	☆	☆	15.0	6.4	5.66	1.2	150.0
Medium	15	3.60	N365-150536E	☆	☆	15.0	6.4	5.66		

I24 I154 I175 N23 N10

SANDVIK Coromant

High-feed milling tools

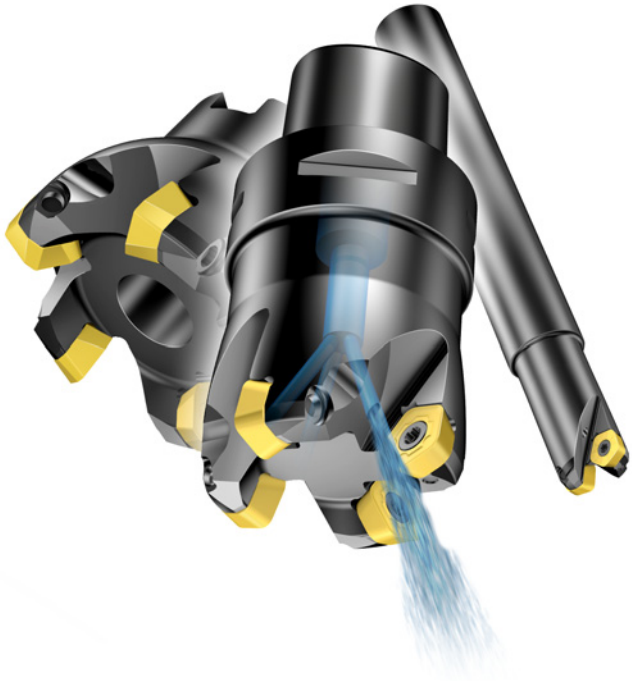
	CoroMill® 419	CoroMill® 210	CoroMill® 415	CoroMill® 745
Page	I29	I33	I38	I43
Material	P M K S H	P M K S H	P M S H	P K
Main operation				
KAPR	19°	10°	15°	25°
DC mm	17.4 - 85.3	10.9 - 136	4.6 - 23.6	63 - 160
DCX mm	32.0 - 100.0	25 - 160	13 - 32	86.4 - 183.4
APMX mm	2	1.2 - 2	0.85 - 1.2	2.80
Insert				
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:

P M K N S H

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

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

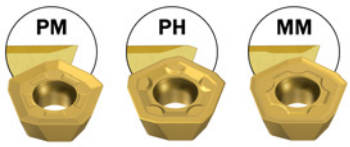
M

Close pitch

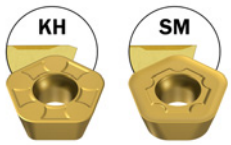
H

Extra close pitch

Face milling



Face and Profile Milling



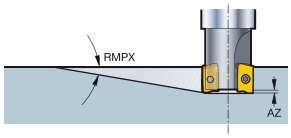
I29 I31 N6

ENG

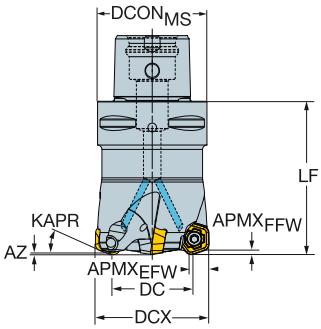
CoroMill® 419 face milling cutter

Coromant Capto® - Internal coolant supply

High-feed milling cutter

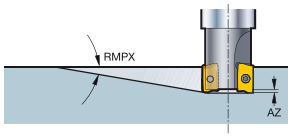


KAPR 19°

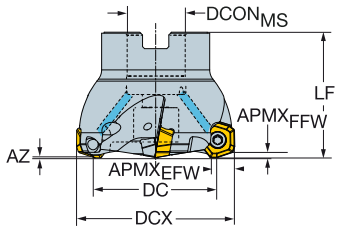


DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	DCX	LF	NM	KG	RPMX	CICT	MIID
21.4	14	C3	8.0	2.00	9°	2.0	3	2		419-036C3-14L	32.0	36.0	50.0	5.0	0.36	22400	2	419R-1405
27.4	14	C4	8.0	2.00	8°	2.0	3		3	419-042C4-14M	40.0	42.0	70.0	5.0	0.62	19900	3	419R-1405
37.4	14	C5	8.0	2.00	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 ISO 6462
KAPR 19°



DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	ISO	DCX	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

I31

L2

M1

N23

N6

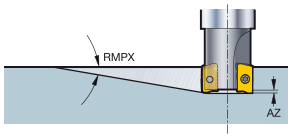
N9

N15

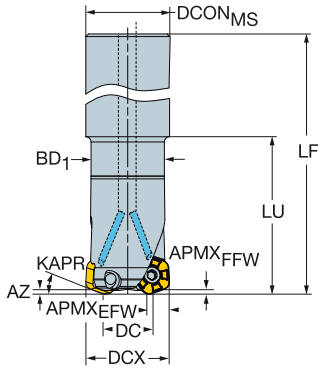
CoroMill® 419 face milling cutter

Cylindrical shank - Internal coolant supply

High-feed milling cutter



KAPR 19°



DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	DCX	BD	LB	LF	LU	NM	KG	RPMX	CICT	MIID
17.4	14	32	8.0	2.00	10°	2.0	1	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°	2.0	1		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

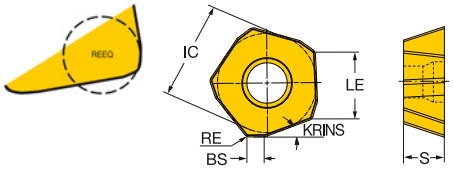
For complete list of spare parts, see www.sandvik.coromant.com

I31 L2 N23 N6 N9 N15

SANDVIK Coromant

CoroMill® 419 insert for milling

KRINS 19°



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

J

Application

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

ISO application area:

P M K N S H

K

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

L

www.sandvik.coromant.com/coromill210

Couplings

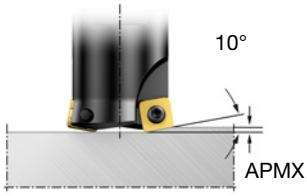
- Coromant Capto®
- Arbor
- Cylindrical shank
- Threaded coupling

Inserts

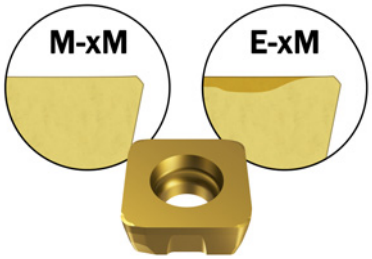
- Four cutting edges
- Insert geometries and grades for all materials apart from ISO N
- E-xM geometry for excellent performance in titanium

M

Close pitch Extra close pitch



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.

N

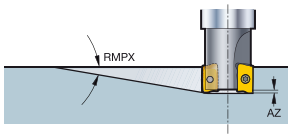
I33 I36

ENG

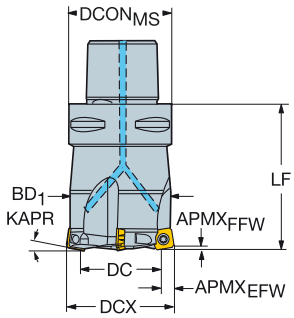
CoroMill® 210 face milling cutter

Coromant Capto® - Internal coolant supply

High-feed milling cutter



KAPR 10°



DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	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

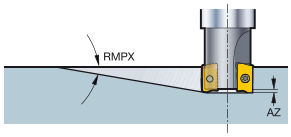
For complete list of spare parts, see www.sandvik.coromant.com

I36 L2 N23 N9 N15

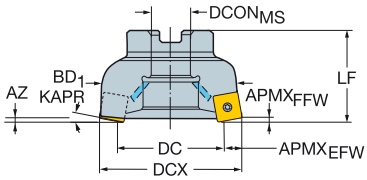
CoroMill® 210 face milling cutter

Arbor - Internal coolant supply

High-feed milling cutter



STDNO ISO6462
KAPR 10°



DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	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

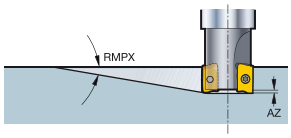
I36 L2 M1 N23 N9 N15

ENG

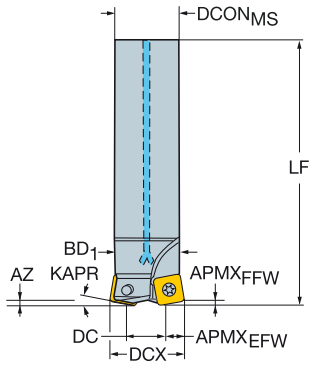
CoroMill® 210 face milling cutter

Cylindrical shank - Internal coolant supply

High-feed milling cutter

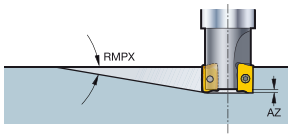


KAPR 10°

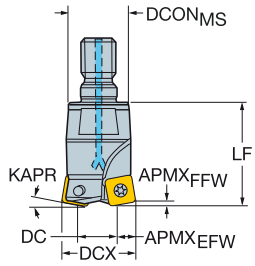


DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID
10.9	09	20	8.0	1.20	14°	1.8	1	2		R210-025A20-09M	20.0	25.0	22.0	35.0	180.0	3.0	0.54	17200	2	R210-090412M-
17.9	09	25	8.0	1.20	8°	1.8	1	2		R210-032A25-09M	25.0	32.0	29.0	45.0	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°



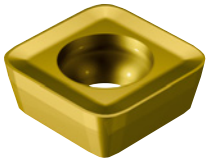
DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	DCX	BD	LF	NM	KG	RPMX	CICT	MIID
10.9	09	M12	8.0	1.20	14°	1.8	1	2	R210-025T12-09M	20.8	25.0	22.0	35.0	3.0	0.24	15000	2	R210-090412M-
17.9	09	M16	8.0	1.20	8°	1.8	1	2	R210-032T16-09M	28.8	32.0	29.0	45.0	3.0	0.36	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

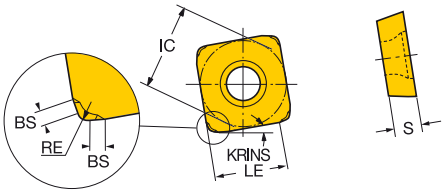
I36 L2 N23 N9 N15

CoroMill® 210 insert for milling

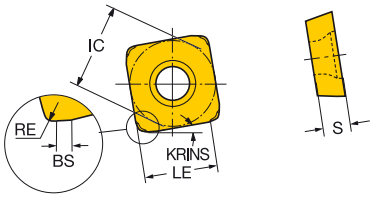


KRINS

10°
R210..E-KM



10°
R210..M-PM



			RE	Ordering code	P								M							K							N	S						H				Dimensions, mm					
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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
	MM	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
		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
	PM	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

SANDVIK Coromant

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:

P M S H

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

Couplings

- Cylindrical shank
- Coromant EH
- Threaded coupling

Inserts

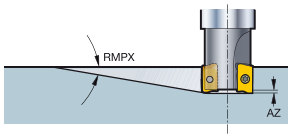
- Four cutting edges
- The unique iLock™ solution provides easy and accurate insert indexing, increased reliability and considerably improved tool life

I38 I41

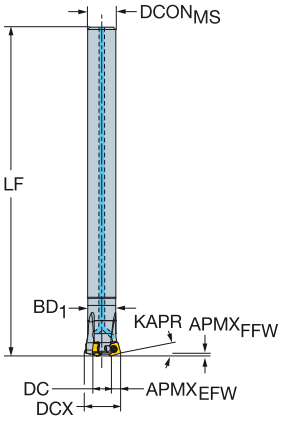
CoroMill® 415 face milling cutter

Cylindrical shank - Internal coolant supply

High-feed milling cutter



KAPR 15°



DC		CZCMS	APMXEFW	APMXFFW	RMPX	CNSC		Ordering code	Dimensions, mm DCONMS	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

I41 L2 N23 N9 N15

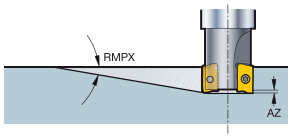
SANDVIK Coromant

ENG

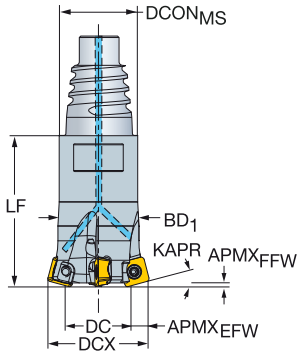
CoroMill® 415 face milling cutter

Coromant EH - Internal coolant supply

High-feed milling cutter



KAPR 15°



DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	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

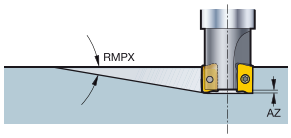
For complete list of spare parts, see www.sandvik.coromant.com

I41 L2 N23 N9 N15 N3

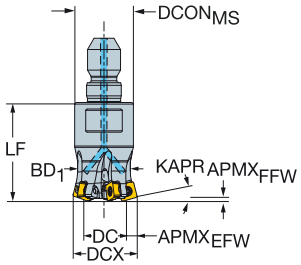
CoroMill® 415 face milling cutter

Threaded coupling - Internal coolant supply

High-feed milling cutter



KAPR 15°



DC		CZCMS	APMXEFW	APMXFFW	RMPX	CNSC		Ordering code	Dimensions, mm DCONMS	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

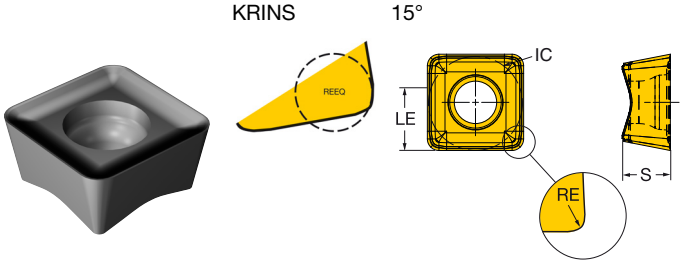
	Spare parts
	Insert screw
05	5513 020-28
07	5513 020-56

For complete list of spare parts, see www.sandvik.coromant.com

I41 N23 N9 N15

ENG

CoroMill® 415 insert for milling



			RE	Ordering code	P			M					S				H		Dimensions, mm			
					1040	1130	4340	1040	1130	4340	S30T	S40T	1130	H13A	S30T	S40T	1010	1130	IC	LE	S	REEQ
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)

I38 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:

P K

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

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

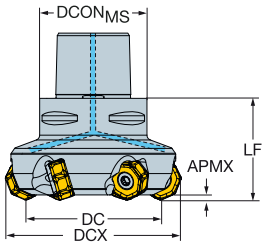
ENG

CoroMill® 745 face milling cutter

Coromant Capto® - Internal coolant supply

High-feed milling cutter

KAPR 25°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	DCX	LF	NM	KG	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

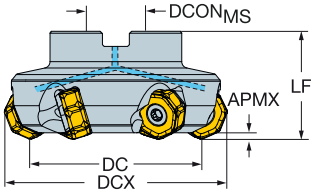
I45 L2 N23 N9 N15

CoroMill® 745 face milling cutter

Arbor - Internal coolant supply

High-feed milling cutter

STDNO ISO 6462
KAPR 25°



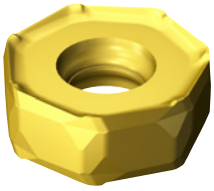
DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	ISO	DCX	LF	NM	KG	RPMX	CICT	MIID
63.0	21	22	2.80	3	5	725-063Q22-21M	22.0	A	86.4	50.0	12.0	0.90	5894	5	745R-2109
	21	22	2.80	3	7	725-063Q22-21H	22.0	A	86.4	50.0	12.0	0.81	5894	7	745R-2109
80.0	21	27	2.80	3	6	725-080Q27-21M	27.0	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

	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

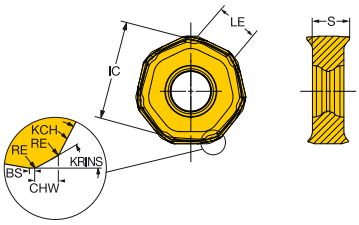
For complete list of spare parts, see www.sandvik.coromant.com

ENG

CoroMill® 745 insert for milling



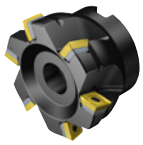
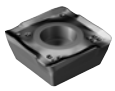
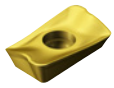
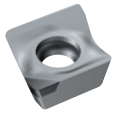
KRINS 42°



			RE	KCH	CHW	Ordering code	P 1130	P 3040	P 4220	P 4230	P 4240	K 1020	K 3040	K 4220	K 4230	K 4240	K K20D	K K20W	Dimensions, mm 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
Medium	M50	21	1.00	17°	1.3	745L-2109E-M50				★					☆		☆	☆	21.0	8.5	9.00	0.3	25.0
Medium	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

I43 I154 I175 N23 N10

Shoulder milling tools

	CoroMill® 490	CoroMill® 390	CoroMill® 690	CoroMill® Century
				
Page	I47	I57	I79	I83
Material	P M K N S H	P M K N S H	S	P M K N S H
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	 	 	 	

ENG

CoroMill® 490

Face and shoulder mill for precise profiles

Application

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

ISO application area:

P M K N S H

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

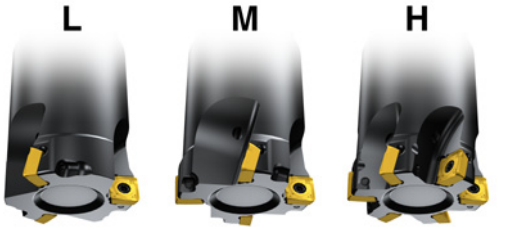
www.sandvik.coromant.com/coromill490

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

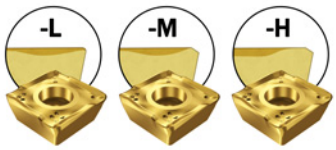
- Four cutting edges
- Cemented carbide, CBN and ceramic grades



Coarse pitch Close pitch Extra close pitch

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.

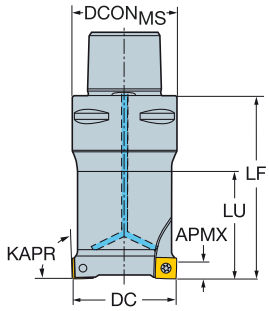


I48 I55 N6

CoroMill® 490 square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	LB	LF	LU	NM	KG	RPMX	CICT	MIID
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

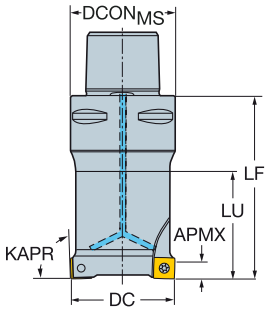
SANDVIK Coromant

ENG

CoroMill® 490 square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	LB	LF	LU	NM	KG	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

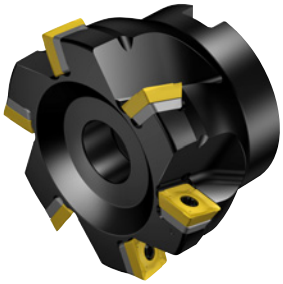
	Spare parts		
	Insert screw	Shim	Shim screw
08	5513 020-35		
14	5513 020-72	5322 471-01	5512 090-01

For complete list of spare parts, see www.sandvik.coromant.com

I55 L2 N23 N6 N9 N15

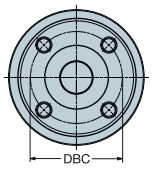
CoroMill® 490 square shoulder milling cutter

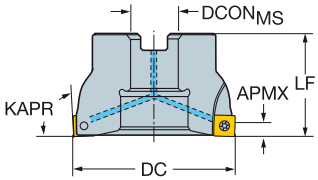
Arbor - Internal coolant supply



STDNO
KAPR

ISO6462
90°





DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	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
	14	22	10.00	1	5		490-050Q22-14H	22.0	A		40.0	3.0	0.36	22400	5	490R-1404
54.0	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
63.0	08	22	5.50	1		5	490-063Q22-08L	22.0	A		40.0	1.2	0.77	22200	5	490R-08T308
	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
80.0	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
	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
84.0	08	27	5.50	1		8	490-084Q27-08M	27.0	A		50.0	1.2	1.78	18900	8	490R-08T308
	14	27	10.00	1		6	490-084Q27-14M	27.0	A		50.0	3.0	1.61	9800	6	490R-1404
100.0	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
	14	32	10.00	1	10		490-100Q32-14H	32.0	B		50.0	3.0	2.00	8900	10	490R-1404
125.0	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
	14	40	10.00	1	12		490-125Q40-14H	40.0	B		63.0	3.0	3.29	7800	12	490R-1404
160.0	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

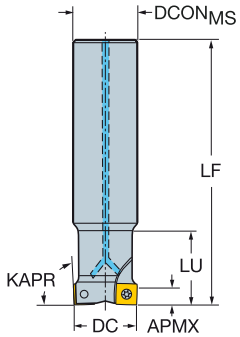
I55 L2 M1 N23 N6 N9 N15

ENG

CoroMill® 490 square shoulder milling cutter

Cylindrical shank - Internal coolant supply

KAPR 90°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	LF	LU	NM	KG	RPMX	CICT	MIID
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

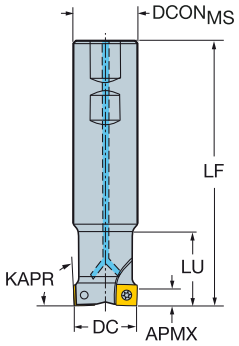
For complete list of spare parts, see www.sandvik.coromant.com

I55 L2 N23 N6 N9 N15

CoroMill® 490 square shoulder milling cutter

Weldon - Internal coolant supply

KAPR 90°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	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		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

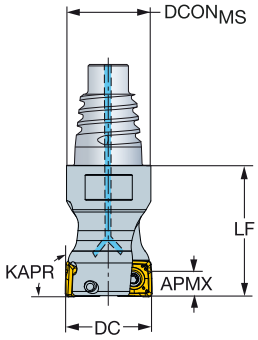
I55 L2 N23 N6 N9 N15

ENG

CoroMill® 490 square shoulder milling cutter

Coromant EH - Internal coolant supply

KAPR 90°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	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
	08	E25	5.50	1	3		490-025EH25-08M	24.2	35.0	1.2	0.19	40400	3	490R-08T308
32.0	08	E25	5.50	1		3	490-032EH25-08L	24.2	35.0	1.2	0.21	33900	3	490R-08T308
	08	E25	5.50	1	4		490-032EH25-08M	24.2	35.0	1.2	0.18	33900	4	490R-08T308

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

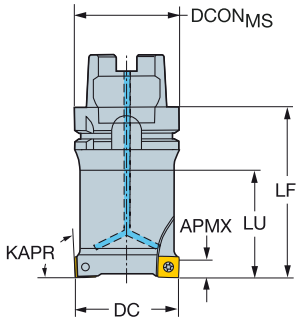
For complete list of spare parts, see www.sandvik.coromant.com

J K L M N

CoroMill® 490 square shoulder milling cutter

HSK - Internal coolant supply

KAPR 90°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	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
	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
	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

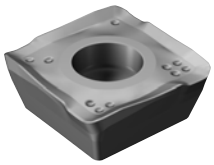
For complete list of spare parts, see www.sandvik.coromant.com

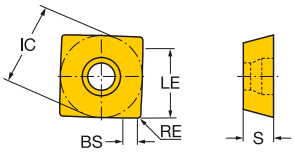
I55 L2 N23 N6 N9 N15

ENG

CoroMill® 490 insert for milling

KRINS 90°



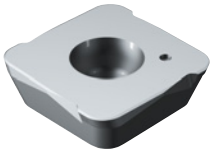


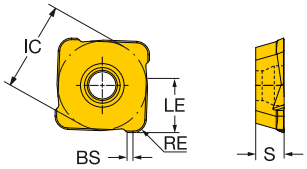
			RE	Ordering code	P									M							K									N		S							H					Dimensions, mm			
					1040	1130	2030	2040	3040	4220	4330	4340	530	1040	1130	2030	2040	4340	530	S30T	S40T	1010	1020	3040	3220	3330	4220	4330	4340	H13A	1130	H13A	1130	2030	2040	H13A	S30T	S40T	1010	1130	3040	4220	530	IC	LE	S	BS
Light	KL	08	0.40	490R-08T304M-KL					☆														★	☆		☆														☆			8.5	5.6	3.30	1.5
			0.80	490R-08T308M-KL					☆														★	☆		☆														☆			8.5	5.6	3.30	1.2
	ML	08	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
		14	0.80	490R-140408E-ML	☆			☆						★			☆			☆	☆									☆		★			☆	☆	★	☆						13.8	10.3	3.90	2.0
	PL	08	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
			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	1.2
			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
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

CoroMill® 490 insert for milling

Advanced cutting materials

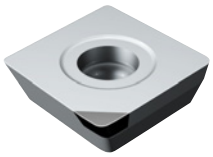
KRINS 90°

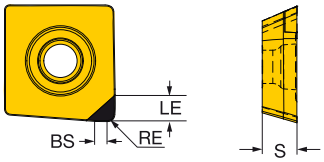




			RE	Ordering code	K 6190	H 6190	Dimensions, mm IC	LE	S	BS
Medium	PO	14	2.00	490R-140420E	★	☆	13.8	5.0	3.90	0.8
			2.00	490R-140408E	★		13.8	5.0	3.90	0.8

KRINS 90°





			RE	Ordering code	K CB50	H CB50	Dimensions, mm 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:

P M K N S H

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

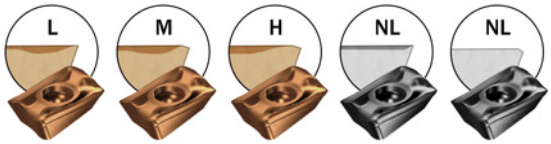
www.sandvik.coromant.com/coromill390

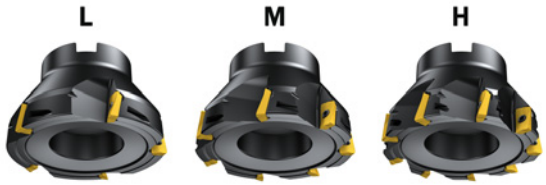
Cutter bodies

- 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

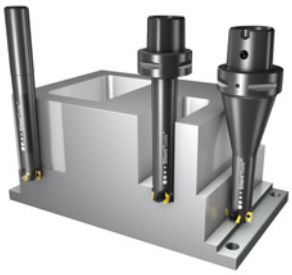
- Two cutting edges
- Cemented carbide and PCD grades
- The light-cutting insert geometries and high-performance grades of are designed for low cutting forces and vibration-free machining for secure milling in all materials.





Coarse pitch Close pitch Extra close pitch

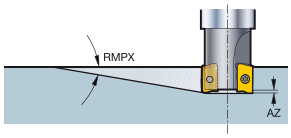
Silent Tools damped cutter bodies boost productivity at long overhangs



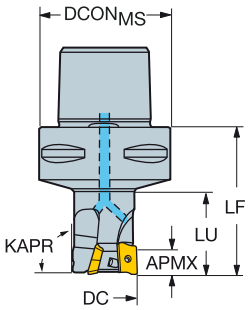
I58 I74 N6

CoroMill® 390 square shoulder milling cutter

Coromant Capto® - Internal coolant supply



KAPR 90°



DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	LF	LU	NM	KG	RPMX	CICT	MIID
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..
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	45.0	1.2	1.60	36500	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	C3	5.5	10.00	3°	1.0	3		3	R390-032C3-11M050	32.0	50.0	35.0	1.2	0.38	31000	3	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..
	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..
44.0	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..
	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..
50.0	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..
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		R390-054C5-18M080	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..

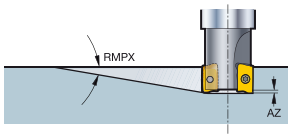
I74 L2 N23 N6 N9 N15

SANDVIK Coromant

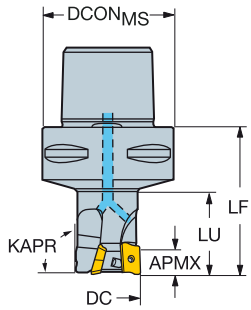
ENG

CoroMill® 390 square shoulder milling cutter

Coromant Capto® - Internal coolant supply



KAPR 90°



DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	LF	LU	NM	KG	RPMX	CICT	MIID
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..
	18	C6	1.1	15.40	3°	0.0	3	5	R390-066C6-18M080	63.0	80.0		3.0	2.25	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

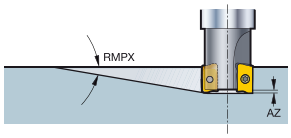
For complete list of spare parts, see www.sandvik.coromant.com

I74 L2 N23 N6 N9 N15

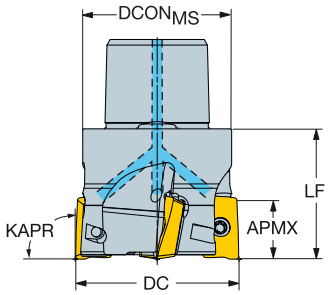
CoroMill® 390 square shoulder milling cutter

Coromant Capto® - Internal coolant supply

Short version without gripper grooves



KAPR 90°



DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	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

I74 L2 N23 N6 N9 N15

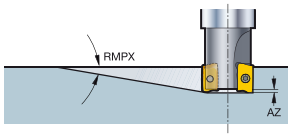
ENG

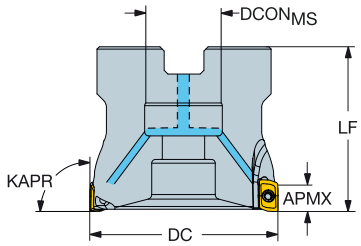
CoroMill® 390 square shoulder milling cutter

Arbor - Internal coolant supply

Lightweight shoulder milling cutter

STDNO ISO6462
KAPR 90°





DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCONMS	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..

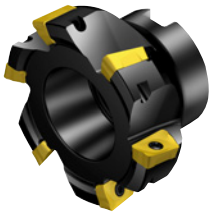
		Spare parts	
DC		Insert screw	Screw
40.00	11	5513 020-35	3213 010-412
50.00	11	5513 020-35	3213 010-461

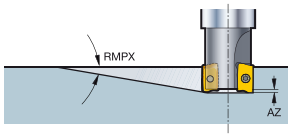
For complete list of spare parts, see www.sandvik.coromant.com

I74 L2 M1 N23 N6 N9 N15

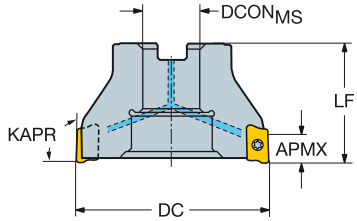
CoroMill® 390 square shoulder milling cutter

Arbor - Internal coolant supply





STDNO ISO 6462
KAPR 90°



DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	ISO	LF	NM	KG	RPMX	CICT	MIID
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..

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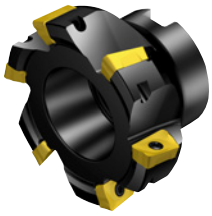
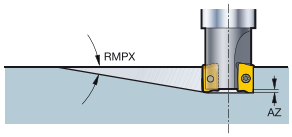
CoroMill® 390 square shoulder milling cutter

Arbor





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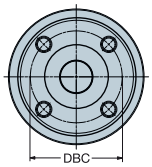

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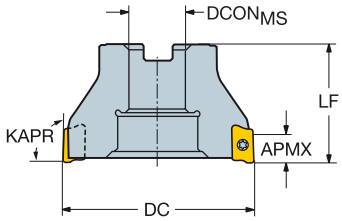

DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCONMS	ISO	DBC	LF	NM	KG	RPMX	CICT	MIID
160.0	18	40S	1.1	15.40	1°	0.0	0	8	R390-160Q40-18L	40.0	C	66.7	63.0	3.0	3.33	4000	8	R390-18..
	18	40S	1.1	15.40	1°	0.0	0	12	R390-160Q40-18M	40.0	C	66.7	63.0	3.0	4.00	4000	12	R390-18..
200.0	18	60	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

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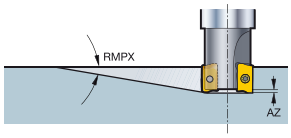
CoroMill® 390 square shoulder milling cutter

Cylindrical shank - Internal coolant supply



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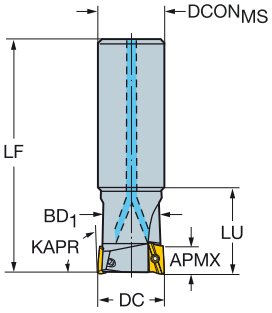

DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	BD1	LF	LU	NM	KG	RPMX	CICT	MIID
9.7	07	10	2.0	5.80	7°	0.5	1	2		R390-0097A10-07L	10.0	9.2	60.0	15.0	0.5	0.07	55600	2	390R-07..
10.0	07	9	2.0	5.80	7°	0.5	1	2		R390-010A09L-07L	9.0	9.3	100.0		0.5	0.08	54100	2	390R-07..
	07	10	2.0	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		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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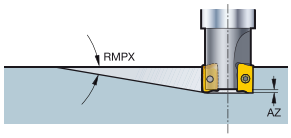
CoroMill® 390 square shoulder milling cutter

Cylindrical shank - Internal coolant supply



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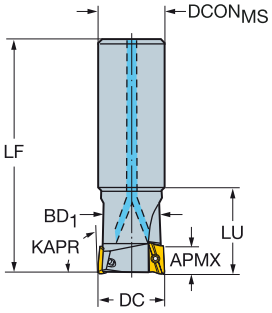


DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	BD$_1$	LF	LU	NM	KG	RPMX	CICT	MIID
40.0	11	32	5.5	10.00	2°	1.0	1	2		R390-040A32-11L	32.0		170.0		1.2	1.19	27000	2	R390-11..
	11	32	5.5	10.00	2°	1.0	1	2		R390-040A32L-11L	32.0		250.0		1.2	1.82	7600	2	R390-11..
	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..

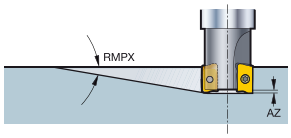
		Spare parts
DC		Insert screw
10.00-25.00	07	5513 020-82
12.00-22.00	11	5513 020-36
25.00-40.00	11	5513 020-35
25.00	17	5513 020-37
32.00-40.00	17	5513 020-39

For complete list of spare parts, see www.sandvik.coromant.com

I74 L2 N23 N6 N9 N15

CoroMill® 390 square shoulder milling cutter

Weldon - Internal coolant supply



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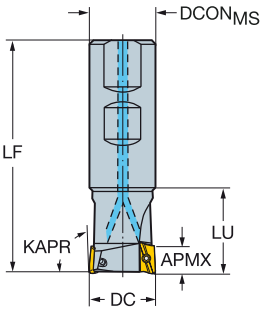


DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	ISO	LF	LU	NM	KG	RPMX	CICT	MIID
12.0	11	16	5.5	10.00	6°	1.0	1	1		R390-012B16-11L	16.0	WE	68.0	17.2	1.2	0.18	68600	1	R390-11..
16.0	11	16	5.5	10.00	10°	1.0	1	2		R390-016B16-11L	16.0	WE	73.0	25.0	1.2	0.11	41500	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

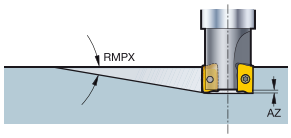
For complete list of spare parts, see www.sandvik.coromant.com

I74 L2 N23 N6 N9 N15

ENG

CoroMill® 390 square shoulder milling cutter

Coromant EH - Internal coolant supply



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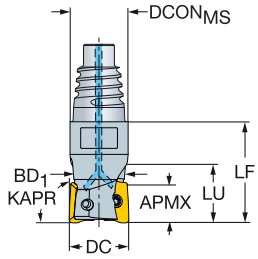


DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	BD	LB	LF	LU	NM	KG	RPMX	CICT	MIID
9.7	07	E10	2.0	5.80	7°	0.5	1	2		R390-0097EH10-07L	9.7	9.2	12.5	20.0	12.5	0.5	0.12	55600	2	390R-07..
10.0	07	E10	2.0	5.80	7°	0.5	1	2		R390-010EH10-07L	9.7	9.3	12.5	20.0	12.5	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..

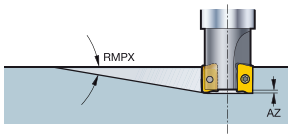
		Spare parts
DC		Insert screw
10.00-32.00	07	5513 020-82
16.00-22.00	11	5513 020-36
25.00-32.00	11	5513 020-35
25.00	17	5513 020-37
32.00	17	5513 020-39

For complete list of spare parts, see www.sandvik.coromant.com

I74 L2 N23 N6 N9 N15 N3

CoroMill® 390 square shoulder milling cutter

Threaded coupling - Internal coolant supply



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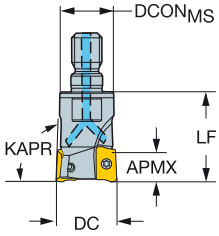


DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	LF	NM	KG	RPMX	CICT	MIID
16.0	11	M8	5.5	10.00	10°	1.0	0	2	**R390-16T08-11L**	12.8	25.0	1.2	0.13	10900	2	R390-11..
20.0	11	M10	5.5	10.00	5°	1.0	1	2	**R390-20T10-11L**	17.8	30.0	1.2	0.16	9900	2	R390-11..
	11	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

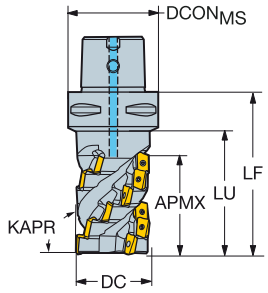
I74 N23 N6 N9 N15 N3

ENG

CoroMill® 390 long edge square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



DC		CZCMS	APMXFFW	CNSC			Ordering code	Dimensions, mm DCONMS	LF	LU	NM	KG	RPMX	CICT	MIID
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..
40.0	11	C5	54.00	3		3	R390-040C5-54M	50.0	89.4	63.0	1.2	0.80	18900	18	R390-11..
	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..
44.0	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..
	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..
50.0	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..
	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	R390-11..
	18	C5	43.00	3		3	R390-054C5-43M	50.0	78.6		3.0	1.00	7500	9	R390-18..
63.0	18	C6	43.00	3		4	R390-063C6-43M	63.0	80.6	53.0	3.0	2.09	6800	12	R390-18..
	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..
66.0	11	C6	45.00	3		4	R390-066C6-45M	63.0	82.5		1.2	2.00	13900	20	R390-11..
	18	C6	57.00	3		3	R390-066C6-57L	63.0	94.6		3.0	2.47	6700	12	R390-18..
80.0	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..

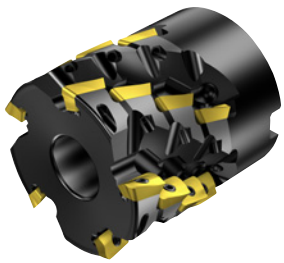
	Spare parts
	Insert screw
11	5513 024-01
18	5513 036-01

For complete list of spare parts, see www.sandvik.coromant.com

I74 L2 N23 N6 N9 N15

CoroMill® 390 long edge square shoulder milling cutter

Arbor



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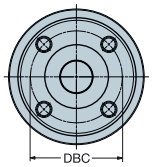
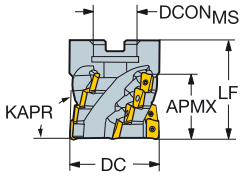


ISO6462
90°



DC		CZCMS	APMXFFW			Ordering code	Dimensions, mm DCONMS	ISO	DBC	LF	NM	KG	RPMX	CICT	MIID
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

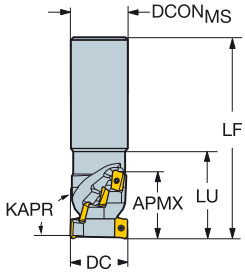
I74 L2 M1 N23 N6 N9

ENG

CoroMill® 390 long edge square shoulder milling cutter

Cylindrical shank

KAPR 90°



DC		CZC$_{MS}$	APMX$_{FFW}$			Ordering code	Dimensions, mm DCON$_{MS}$	LF	LU	NM	KG	RPMX	CICT	MIID
32.0	11	25	36.00	2		R390-032A25-36L	25.0	108.7		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..

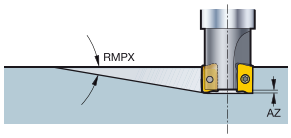
Spare parts
Insert screw
5513 024-01

For complete list of spare parts, see www.sandvik.coromant.com

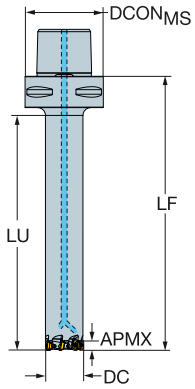
I74 L2 N23 N6 N9

CoroMill® 390 damped square shoulder milling cutter

Coromant Capto® - Internal coolant supply



KAPR 90°



DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCONMS	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

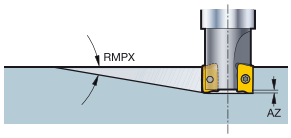
For complete list of spare parts, see www.sandvik.coromant.com

I74 L2 N23 N6 N9 N15 L109

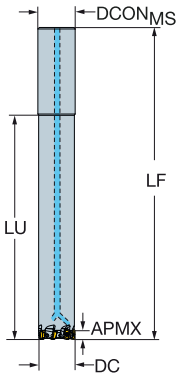
ENG

CoroMill® 390 damped square shoulder milling cutter

Cylindrical shank - Internal coolant supply



KAPR 90°



DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	LF	LU	NM	KG	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..

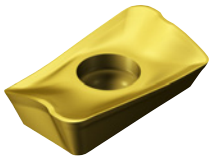
		Spare parts
DC		Insert screw
20.00-32.00	07	5513 020-82
20.00	11	5513 020-36
25.00-32.00	11	5513 020-35

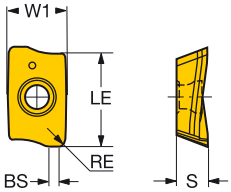
For complete list of spare parts, see www.sandvik.coromant.com

I74 L2 N23 N6 N9 N15 L109

CoroMill® 390 insert for milling

KRINS 90°





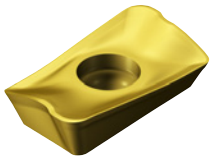
			RE	Ordering code	P 1025	P 1040	P 1130	P 2030	P 2040	P 3040	P 4220	P 4330	P 4340	P 530	M 1025	M 1040	M 1130	M 2030	M 2040	M 4340	M 530	M S30T	M S40T	K 1010	K 1020	K 1025	K 3040	K 3330	K 4220	K 4330	K 4340	K H13A	N 1025	N 1130	N 530	N H13A	S 1025	S 1130	S 2030	S 2040	S H13A	S S30T	S S40T	H 1010	H 1025	H 1130	H 3040	H 4220	H 530	Dimensions, mm W1	LE	S	BS
Light	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	

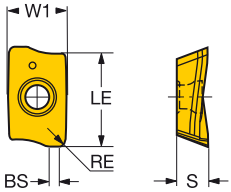
I58 I154 I175 N23 N10

SANDVIK Coromant

CoroMill® 390 insert for milling

KRINS 90°





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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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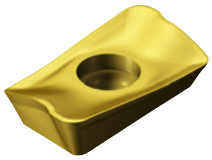
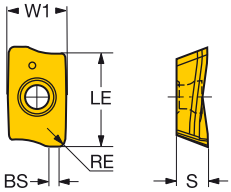
CoroMill® 390 insert for milling

KRINS 90°





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Medium	MM	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
		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	
		17	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	
		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
	MMR	18	1.20	R390-18 06 12M-MMR		☆			☆						★			☆																				★												11.0	15.4	6.33	0.3

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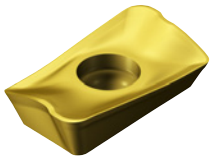
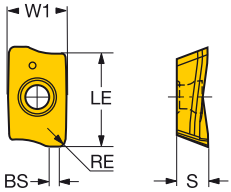
SANDVIK Coromant

CoroMill® 390 insert for milling

KRINS 90°





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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
		11	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
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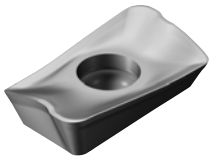
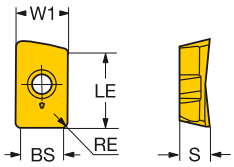
			2.40	R390-11 T3 24E-PM	☆		★						★		☆		☆			☆						☆					☆		☆	☆			☆	☆							☆	☆				6.8	10.0	3.59	
			3.10	R390-11 T3 31E-PM	☆		★						★		☆		☆			☆				☆		☆					☆		☆	☆			☆	☆						★	☆	☆				6.8	10.0	3.59	
			3.10	R390-11 T3 31M-PM	☆		★				☆		★		☆		☆			☆		☆	☆	☆		☆			☆		☆		☆	☆			☆	☆				★	☆	★	☆	☆		☆		6.8	10.0	3.59	
		17	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	
		18	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
	PMR	18	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
		17	0.80	R390-17 04 08M-KH						☆														☆			☆	★																				☆				9.6	15.7	4.76	1.5
	MH	11	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
		17	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

I58 I154 I175 N23 N10

CoroMill® 390 insert for milling

KRINS 90°

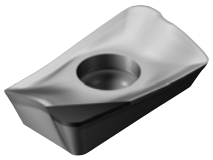


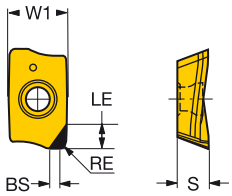


Wiper TECHNOLOGY

			RE	Ordering code	P 1025	P 1130	M 1025	M 1130	K 1020	K 1025	N 1025	N 1130	S 1025	S 1130	H 1025	H 1130	Dimensions, mm W1	LE	S	BS
Light	KTW	18	1.60	R390-18 06 16H-KTW					★								11.0	15.4	6.33	8.6
Light	PLW	11	0.80	R390-11 T3 08E-PLW	☆	★	☆	☆		☆	☆	☆	☆	☆	☆	☆	6.8	10.0	3.59	5.0
Light	PTW	18	1.60	R390-18 06 16H-PTW		★		☆						☆		☆	11.0	15.4	6.33	8.6

KRINS 90°





Advanced cutting materials

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

I58 I154 I175 N23 N10 N2

SANDVIK Coromant

ENG

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

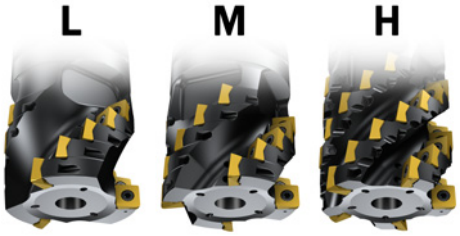
Couplings

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

Inserts

- Four cutting edges
- SL geometry optimized for titanium

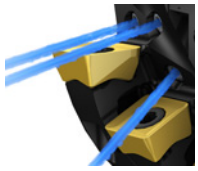
P-SL = Side (or Periphery) insert
E-SL = End insert



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.

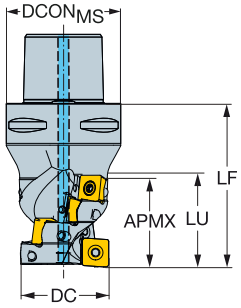


I80 I82

CoroMill® 690 long edge square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



DC	APMX$_{FFW}$			CZC$_{MS}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	DCX	LF	LU	NM	KG	RPMX	CICT	MIID$_E$	MIID$_P$
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

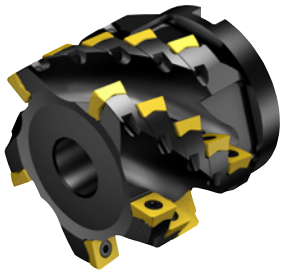
		Spare parts	
DC		Insert screw	Plug screw
40.00	10	5513 020-68	3214 010-202
44.00	10	5513 020-68	3214 010-202
50.00-66.00	10	5513 020-68	3214 010-253
54.00-100.00	14	5513 020-55	3214 010-253

For complete list of spare parts, see www.sandvik.coromant.com

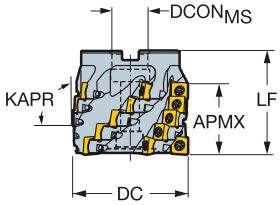
I82 L2 N23 N9 N15

CoroMill® 690 long edge square shoulder milling cutter

Arbor



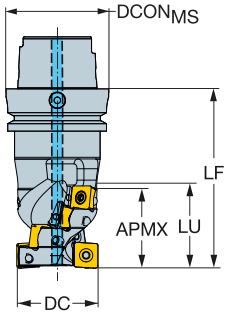
STDNO ISO6462
KAPR 90°



DC	APMXFFW			CZCMS			Ordering code	DCONMS	ISO	DCX	LF	NM	KG	RPMX	CICT	MIIDE	MIIDP
								Dimensions, mm									
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°



DC	APMXFFW			CZCMS	CNSC		Ordering code	DCONMS	DCX	LF	LU	NM	KG	RPMX	CICT	MIIDE	MIIDP
								Dimensions, mm									
63.0	105.0	10E	10P	125	1	4	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

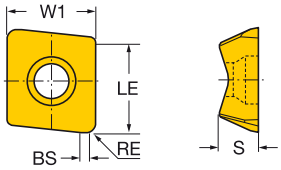
		Spare parts	
DC		Insert screw	Plug screw
50.00-63.00	10	5513 020-68	3214 010-253
63.00-100.00	14	5513 020-55	3214 010-253

For complete list of spare parts, see www.sandvik.coromant.com

I82 L2 M1 N23 N9

CoroMill® 690 insert for milling

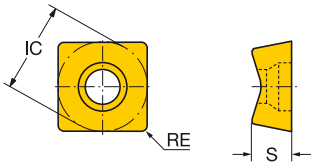
KRINS 90°



End insert

			RE	Ordering code	S 1030	S 2040	S 30T	S 40T	Dimensions, mm 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 1030	S 2040	S 30T	S 40T	Dimensions, mm 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

I80 I154 I175 N23 N10

SANDVIK Coromant

ENG

CoroMill® Century

Light cutting face mill for high speed finishing

Application

- Square shoulder milling
- Face milling

ISO application area:

P M K N S H

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

Couplings

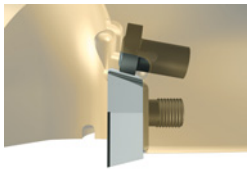
- Coromant Capto®
- Arbor
- HSK

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.

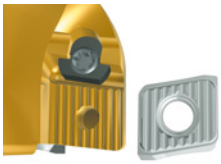


Macro setting

Macro setting of insert within 1 mm setting range.

Insert setting

Serrated insert location gives very high security against insert movement.

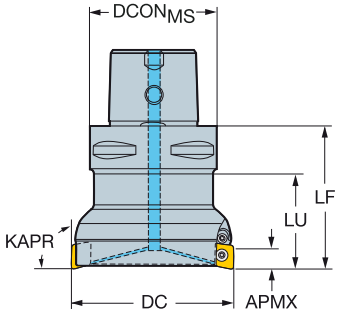


I84 I87 N6

CoroMill® Century square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC	ZADJ		Ordering code	Dimensions, mm DCON$_{MS}$	LF	LU	NM	KG	RPMX	CICT	MIID
40.0	11	C3	11.00	3	3	3	R590-040C3-11M	32.0	55.0	40.0	3.0	0.65	48000	3	R590-1105..
	11	C4	11.00	3	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	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	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	6	R590-080C6-11M	63.0	71.0		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

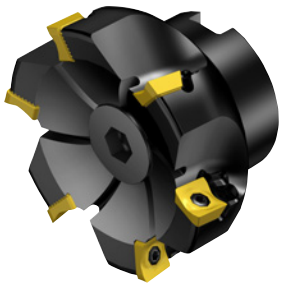
For complete list of spare parts, see www.sandvik.coromant.com

I87 L2 N23 N9 N15

ENG

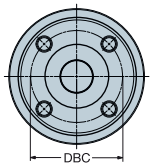
CoroMill® Century square shoulder milling cutter

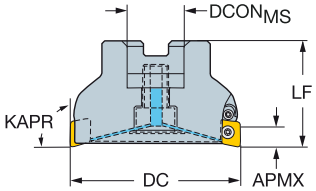
Arbor - Internal coolant supply



STDNO
KAPR

ISO6462
90°





DC		CZCMS	APMXFFW	CNSC	ZADJ		Ordering code	Dimensions, mm DCONMS	ISO	DBC	LF	NM	KG	RPMX	CICT	MIID
50.0	11	22	11.00	1	4	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	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	6	R590-080Q27A-11M	27.0	A		50.0	3.0	1.04	27500	6	R590-1105..
	11	27	11.00	1	6	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	6	R590-100Q32A-11M	32.0	A		50.0	3.0	1.37	23800	6	R590-1105..
	11	32	11.00	1	6	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	8	R590-125Q40A-11M	40.0	B		63.0	3.0	1.84	20700	8	R590-1105..
	11	40	11.00	1	8	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	10	R590-160Q40A-11M	40.0	B		63.0	3.0	2.74	17900	10	R590-1105..
	11	40	11.00	1	10	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	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	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

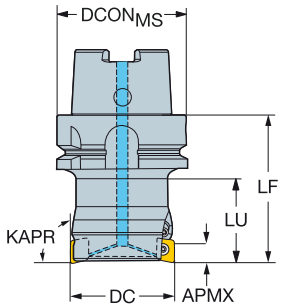
For complete list of spare parts, see www.sandvik.coromant.com

I87 L2 M1 N23 N9 N15

CoroMill® Century square shoulder milling cutter

HSK - Internal coolant supply

KAPR 90°



DC		CZCMS	APMXFFW	CNSC	ZADJ		Ordering code	Dimensions, mm DCONMS	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

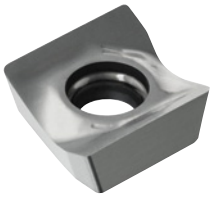
For complete list of spare parts, see www.sandvik.coromant.com

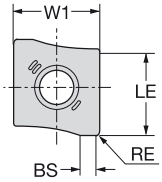
I87 L2 N23 N9 N15

ENG

CoroMill® Century insert for milling

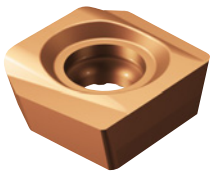
KRINS 90°

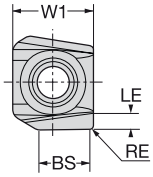




			RE	Ordering code	K 1020	K H10	N H10	H 1130	Dimensions, mm W1	LE	S	BS
Light	KL	11	0.80	R590-110508H-KL	★				11.5	11.0	5.00	1.7
	NL	11	0.40	R590-110504H-NL		☆	★		11.5	11.0	5.00	2.0
	PL	11	0.80	R590-110508H-PL				☆	11.5	11.0	5.00	1.7

KRINS 90°





Wiper TECHNOLOGY

			RE	Ordering code	P 1130	M 1130	K 1020	N 1130	N H10	S 1130	H 1130	Dimensions, mm 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

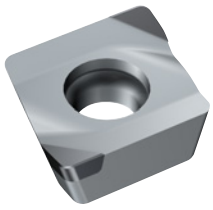
Make sure to choose working insert and wiper insert with the same RE/KCH values

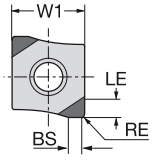
I84 I154 I175 N23 N6 N10 N2

CoroMill® Century insert for milling

Advanced cutting materials

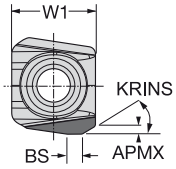
KRINS 90°



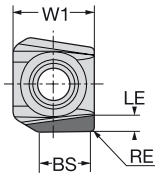


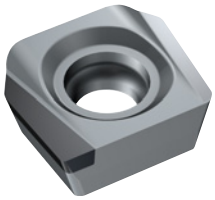
			RE	KCH	CHW	Ordering code	K CB50	H CB50	Dimensions, mm W1	LE	S	BS	BSR
Light	KL	11		30°	1.0	L590-1105H-ZC2-KL	☆	☆	11.5	3.0	5.00	2.3	200.0
				60°	1.5	R590-1105H-ZC2-KL	☆	☆	11.5	3.0	5.00	2.3	200.0
Medium	KM	11	0.80			R590-110508H-PR2-KM	☆	☆	11.5	2.0	5.00	1.5	25.0

KRINS 90°
R/L590..H-Z..-KW



90°
R590..PR2-KW





Wiper TECHNOLOGY

			RE	KCH	CHW	Ordering code	K CB50	H CB50	Dimensions, mm 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

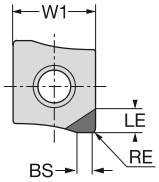
SANDVIK Coromant

ENG

CoroMill® Century insert for milling

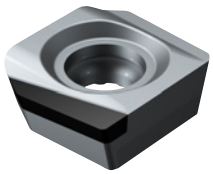
Advanced cutting materials

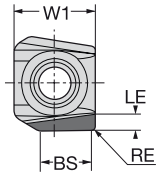
KRINS 90°



			RE	KCH	CHW	Ordering code	N CD10	Dimensions, mm W1	LE	S	BS	BSR
Light	NL	11		45°	1.0	R590-1105H-PC2-NL	★	11.5	3.0	5.00	1.5	200.0
				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°





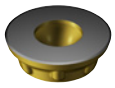
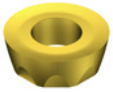
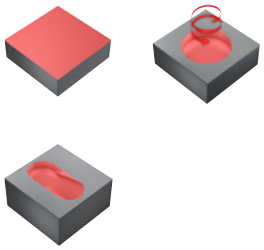
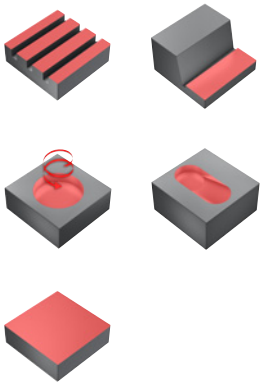
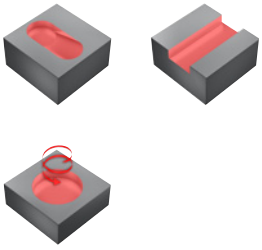
Wiper TECHNOLOGY

			RE	KCH	CHW	Ordering code	N CD10	Dimensions, mm W1	LE	S	BS	BSR
Light	NW	11		45°	1.2	R590-1105H-RC2-NW	☆	11.5	3.0	5.00	6.0	500.0
			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

I84 I154 I175 N23 N6 N10 N2

Profile milling tools

	CoroMill® 300	CoroMill® 200	CoroMill® 216
Page	I91	I100	I105
Material	P M K N S H	P M K N S H	P M K N S H
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			

ENG

CoroMill® 300

Light cutting face and profile milling cutters

Application

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

ISO application area:

P M K N S H

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

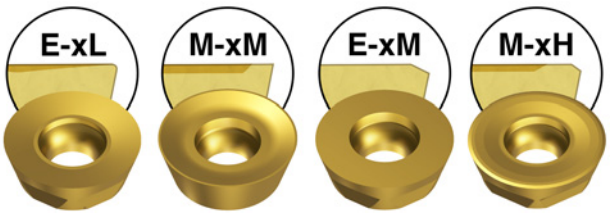
www.sandvik.coromant.com/coromill300

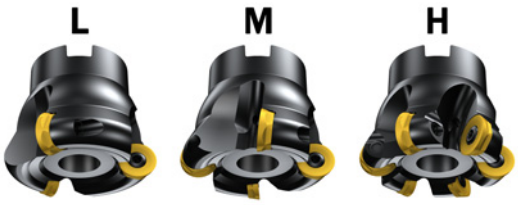
Couplings

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

Inserts

- Insert geometries and grades for all materials





Coarse pitch Close pitch Extra close pitch

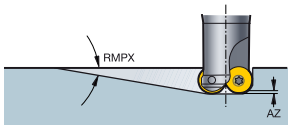
Specific insert indexing solution for size 20 inserts prevents insert movement and enables all cutting edges to be utilized.

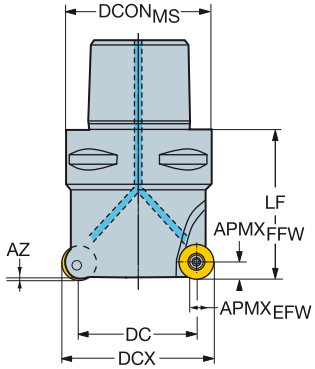
I92 I99 N6

CoroMill® 300 face milling cutter

Coromant Capto® - Internal coolant supply

Positive design





DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	DCX	BD	LF	NM	KG	RPMX	CICT	MIID
23.0	12	C3	9.0	6.00	10°	3.0	3		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	4		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	4		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		4	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	5		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		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	4		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	5		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	6		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		4	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	5		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		4	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	5		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	8		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		4	R300-066C6-20M	63.0	66.0		80.0	7.5	1.88	18478	4	R300-2060..
	20	C6	15.0	10.00	9°	6.0	3	5		R300-066C6-20H	63.0	66.0		80.0	7.5	1.83	18478	5	R300-2060..
50.0	16	C6	12.0	8.00	4°	3.8	3		5	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	6		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		5	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	7		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	10		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		5	R300-080C6-20M	63.0	80.0		80.0	7.5	2.24	15622	5	R300-2060..
	20	C6	15.0	10.00	6°	6.0	3	6		R300-080C6-20H	63.0	80.0		80.0	7.5	2.20	15622	6	R300-2060..
64.0	16	C6	12.0	8.00	3°	3.8	3		5	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	7		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		6	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	8		R300-080C6-12H	63.0	80.0	59.3	50.0	3.0	1.72	18900	8	R300-1240..
72.0	08	C6	6.0	4.00	1°	1.9	3	12		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		6	R300-100C8-20M	80.0	100.0		80.0	7.5	3.72	12843	6	R300-2060..
	20	C8	15.0	10.00	4°	6.0	3	7		R300-100C8-20H	80.0	100.0		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

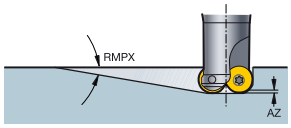
I99 L2 N23 N6 N9 N15

ENG

CoroMill® 300 face milling cutter

Arbor - Internal coolant supply

Positive design



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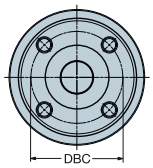

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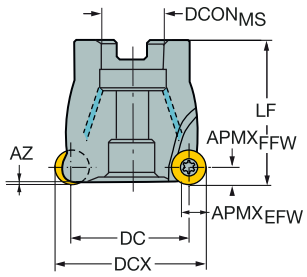


DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	ISO	DBC	DCX	LF	NM	KG	RPMX	CICT	MIID
32.0	08	16	6.0	4.00	3°	1.9	1		5	R300-040Q16-08M	16.0	A		40.0	40.0	1.2	0.44	30800	5	R300-0828..
	08	16	6.0	4.00	3°	1.9	1	6		R300-040Q16-08H	16.0	A		40.0	40.0	1.2	0.20	30800	6	R300-0828..
38.0	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

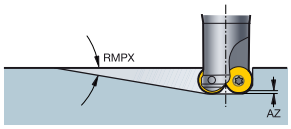
For complete list of spare parts, see www.sandvik.coromant.com

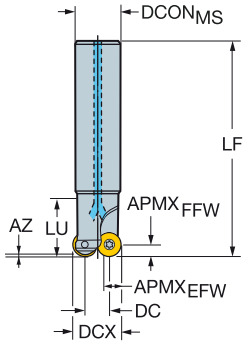
I99 L2 M1 N23 N6 N9 N15

CoroMill® 300 face milling cutter

Cylindrical shank - Internal coolant supply

Positive design





DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	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

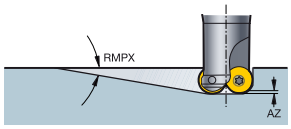
I99 L2 N23 N6 N9 N15

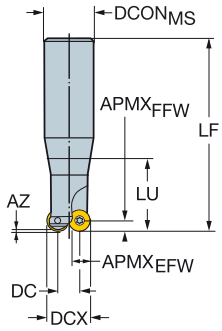
ENG

CoroMill® 300 face milling cutter

Cylindrical shank

Neutral design





DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ		Ordering code	Dimensions, mm DCONMS	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

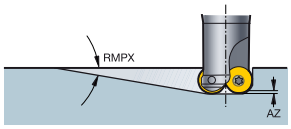
For complete list of spare parts, see www.sandvik.coromant.com

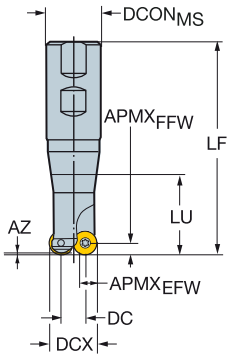
I99 L2 N23 N6 N9

CoroMill® 300 face milling cutter

Weldon

Neutral design





DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ		Ordering code	Dimensions, mm DCONMS	ISO	DCX	BD	LB	LF	LU	NM	KG	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

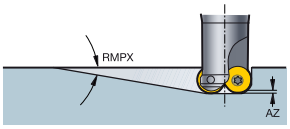
I99 L2 N23 N6 N9

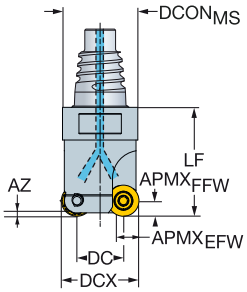
SANDVIK Coromant

ENG

CoroMill® 300 face milling cutter

Coromant EH - Internal coolant supply





Neutral design

DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	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

DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	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

DC		Spare parts 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

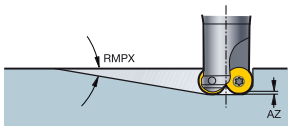
Spare parts Insert screw
5513 020-56

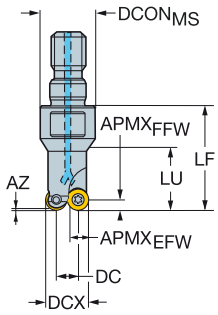
For complete list of spare parts, see www.sandvik.coromant.com

I99 L2 N23 N6 N9 N15 N3

CoroMill® 300 face milling cutter

Threaded coupling - Internal coolant supply





Neutral design

DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCONMS	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

DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	DCX	BD	LB	LF	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

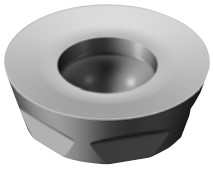
Spare parts
Insert screw
5513 020-56

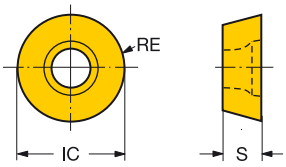
For complete list of spare parts, see www.sandvik.coromant.com

I99 N23 N6 N9 N15

ENG

CoroMill® 300 insert for milling





		RE	Ordering code	P									M								K									N			S									H					Dimensions, mm	
				1025	1040	1130	2030	2040	3040	4220	4330	4340	1025	1040	1130	2030	2040	4340	S30T	S40T	1010	1020	1025	3040	3330	4220	4330	4340	H13A	1025	1130	H13A	1025	1130	2030	2040	H13A	S30T	S40T	1010	1025	1130	3040	4220	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
	05	2.50	R300-0517E-PM			★						☆			☆													★			☆			☆								☆			5.0	1.70
Medium	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

I92 I154 I175 N23 N10

CoroMill® 200

Robust face milling and profile cutter

Application

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

ISO application area:

P M K N S H

Benefits and features

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

www.sandvik.coromant.com/coromill200

Couplings

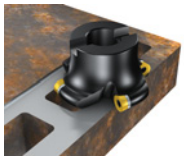
- Arbor
- Cylindrical shank

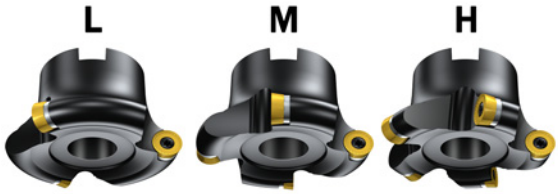
Inserts

- 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).





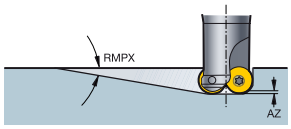
Coarse pitch Close pitch Extra close pitch

I101 I103

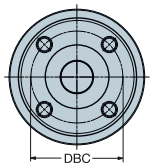
ENG

CoroMill® 200 face milling cutter

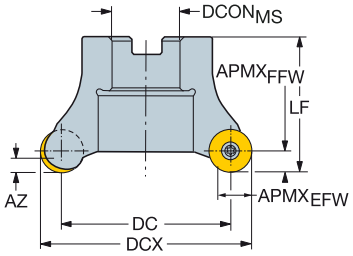
Arbor



STDNO



ISO6462



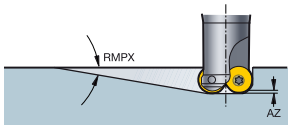
DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ			Ordering code	Dimensions, mm DCONMS	ISO	DBC	DCX	BD	LF	NM	KG	RPMX	CICT	MIID
38.0	12	22	9.0	6.00	6°	3.7		3	R200-038Q22-12L	22.0	A		50.0	50.0	50.0	3.0	0.65	18800	3	RCKT 12 04 M0
	12	22	9.0	6.00	6°	3.7		4	R200-038Q22-12M	22.0	A		50.0	50.0	50.0	3.0	0.66	18800	4	RCKT 12 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

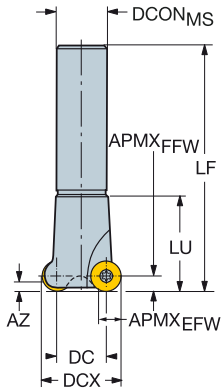
For spare parts, visit www.sandvik.coromant.com

I103 L2 M1 N23 N9

CoroMill® 200 face milling cutter

Cylindrical shank





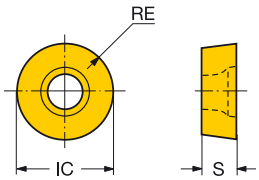
DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ			Ordering code	Dimensions, mm DCONMS	DCX	BD	LB	LF	NM	KG	RPMX	CICT	MIID
15.0	10	20	7.5	5.00	13°	2.9	2		R200-015A20-10M	20.0	25.0	25.0	25.0	150.0	3.0	0.54	37500	2	RCKT 10 T3 M0
	10	20	7.5	5.00	13°	2.9	3		R200-015A20-10H	20.0	25.0	25.0	25.0	150.0	3.0	0.49	37500	3	RCKT 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

I103 L2 N23 N9

CoroMill® 200 insert for milling



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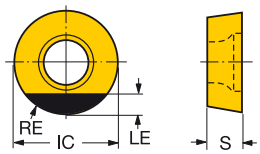
Light	KL	10	5.00	RCHT 10 T3 M0-KL																														☆					★						☆										10.0	3.97
		12	6.00	RCHT 12 04 M0-KL																														☆					★						☆										12.0	4.76
		16	8.00	RCHT 16 06 M0-KL																														☆					★						☆										16.0	6.35
		20	10.00	RCHT 20 06 M0-KL																														☆					★						☆										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
Heavy	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

I101 I154 I175 N23 N10

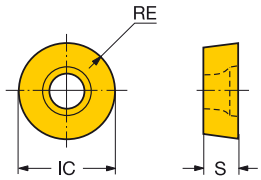
CoroMill® 200 insert for milling

Advanced cutting materials

RCHT



RCKT



			RE	Ordering code	K 6190	K CB50	H 6190	H CB50	Dimensions, mm IC	LE	S
Light	PO	12	6.00	RCHT 12 04 M0		☆		☆	12.0	3.0	4.76
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

SANDVIK Coromant

ENG

CoroMill® 216

A metal remover for rough and semi-finish profiling

Application

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

ISO application area:

P M K N S H

Benefits and features

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

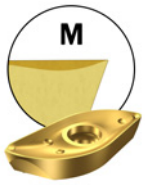
www.sandvik.coromant.com/coromill216

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

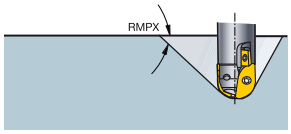
Insert location

Same inserts for both central and peripheral locations.

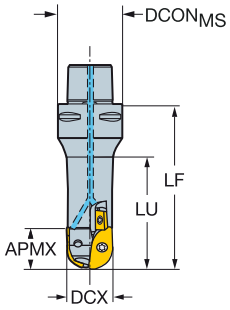
I106 I111

CoroMill® 216 ball nose milling cutter

Coromant Capto® - Internal coolant supply



KAPR 90°



DC	APMX$_{FFW}$	APMX$_{EFW}$			CZC$_{MS}$	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	DCX	BD$_1$	LF	LU	NM	KG	RPMX	CICT$_{BALL}$	MIID$_{BALL}$	CICT$_{SP}$	MIID$_{SP}$
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

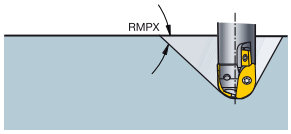
For complete list of spare parts, see www.sandvik.coromant.com

I111 L2 N23 N9 N15

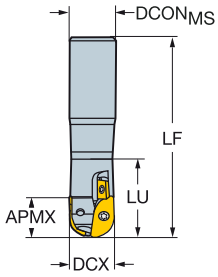
ENG

CoroMill® 216 ball nose milling cutter

Cylindrical shank - Internal coolant supply



KAPR 90°



DC	APMX$_{FFW}$	APMX$_{EFW}$			CZC$_{MS}$	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	DCX	BD$_1$	LF	LU	NM	KG	RPMX	CICT$_{BALL}$	MIID$_{BALL}$	CICT$_{SP}$	MIID$_{SP}$
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		

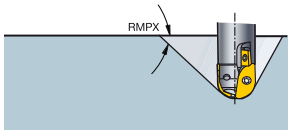
		Spare parts	
		Insert screw	Protection insert screw
10		5513 020-40	
12		5513 020-36	
16		5513 020-36	
20		5513 020-16	
25		5513 020-52	
30	16	5513 020-07	5513 020-09
32		5513 020-07	

For complete list of spare parts, see www.sandvik.coromant.com

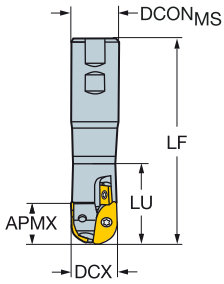
I111 L2 N23 N9 N15

CoroMill® 216 ball nose milling cutter

Weldon - Internal coolant supply



KAPR 90°



DC	APMXFFW	APMXEFW			CZCMS	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCONMS	ISO	DCX	BD1	LF	LU	NM	KG	RPMX	CICTBALL	MIIDBALL	CICTSP	MIIDSP
12.0	10.8	6.0	12		20	85°	6.0	0	2	R216-12B20-060	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	R216-12B20-040	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	R216-16B20-040	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	R216-16B20-060	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	R216-20B25-050	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	R216-20B25-070	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	R216-25B25-060	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	R216-25B25-080	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	R216-30B32-070	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	R216-30B32-100	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	R216-32B32-100	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	R216-32B32-070	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	R216-40B40-100	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	R216-40B40-150	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	R216-50B40-100	40.0	WE	50.0	47.0	171.0		10.0	1.88	7000	2	R216-50 07		
	44.6	25.0	50	16	50	85°	25.0	1	2	R216-50B50-125	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	R216-50B50-175	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	

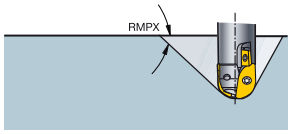
For complete list of spare parts, see www.sandvik.coromant.com

I111 L2 N23 N9 N15

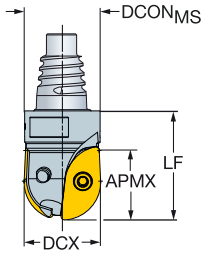
ENG

CoroMill® 216 ball nose milling cutter

Coromant EH - Internal coolant supply



KAPR 90°



DC		CZCMS	APMXFFW	RMPX	CNSC		Ordering code	Dimensions, mm DCONMS	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

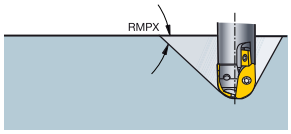
	Spare parts
	Insert screw
10	5513 020-40
12	5513 020-36
16	5513 020-36
20	5513 020-16
25	5513 020-52
30	5513 020-07
32	5513 020-07

For complete list of spare parts, see www.sandvik.coromant.com

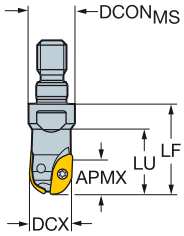
I111 L2 N23 N9 N15 N3

CoroMill® 216 ball nose milling cutter

Threaded coupling - Internal coolant supply



KAPR 90°



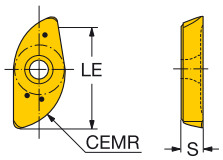
DC		CZC$_{MS}$	APMX$_{EFW}$	APMX$_{FFW}$	RMPX	AZ	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	BD$_1$	LF	LU	NM	KG	RPMX	CICT	MIID
10.0	10	M8	5.0	8.60	85°	5.0	0	2	R216-10T08	12.8	9.2	25.0	17.8	0.6	0.05	12700	2	R216-10 02
12.0	12	M8	6.0	10.80	85°	6.0	0	2	R216-12T08	12.8	10.8	25.0	18.3	1.2	0.09	12700	2	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

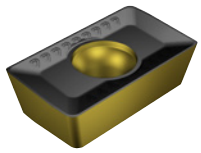
I111 N23 N9 N15 N3

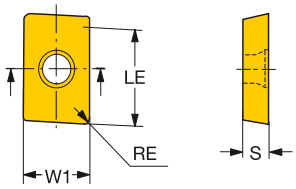
CoroMill® 216 ball nose insert



		CEMR	Ordering code	P 1025	P 1130	P 2040	P 4220	P 4340	M 1025	M 1130	M 2040	M 4340	M S30T	K 1010	K 1025	K 4220	K 4340	K H13A	N 1025	N 1130	N H13A	S 1025	S 1130	S 2040	S H13A	S S30T	H 1010	H 1025	H 1130	H 4220	Dimensions, mm LE	Dimensions, mm S
Medium	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

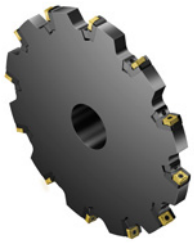
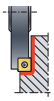
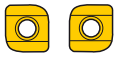
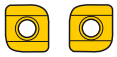
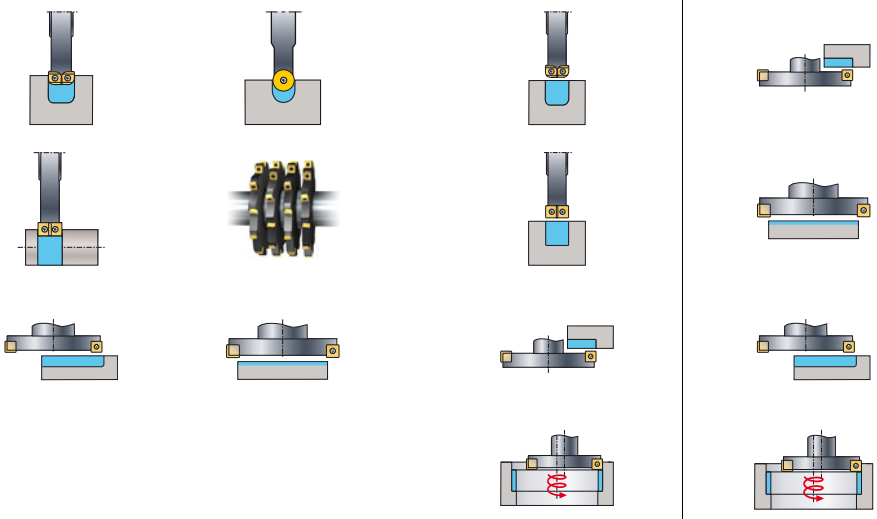




			RE	Ordering code	P 4340	M 4340	K 4340	Dimensions, mm W1	Dimensions, mm LE	Dimensions, mm S
Medium	WHX	16	0.80	APMT 16 04 08-M	☆	☆	☆	9.2	16.0	4.76

I106 I154 I175 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	P M K N S H					
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

SANDVIK Coromant

ENG

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:

P M K N S H

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

www.sandvik.coromant.com/coromill331

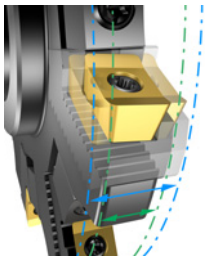
Couplings

- 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.

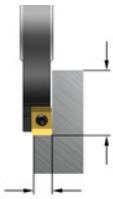


Wide setting range

Adjustable pockets for flexibility.

I116 I130 N6

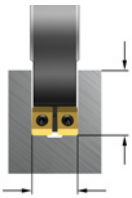
Half side



CDX ≤ 114.5 mm

a_p ≤ 10.6 mm

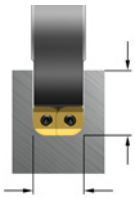
Double half side



CDX ≤ 114.5 mm

a_p ≤ 27.2 - 33.8 mm

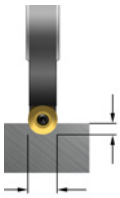
Full slot with radius



CDX ≤ 114.5 mm

a_p ≤ 6 - 26.5 mm

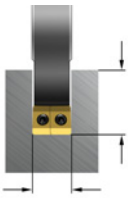
Full radius



CDX ≤ 114.5 mm

a_p ≤ 10 - 16 mm

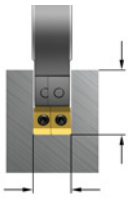
Full slot fixed pocket



CDX ≤ 34.0 mm

a_p ≤ 6 - 10 mm

Full slot cassette



CDX ≤ 114.5 mm

a_p ≤ 6 - 26.5 mm

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			Neutral inserts		Right and left hand inserts				
Groove width range mm	Cutter versions (end of code)	Insert size	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							

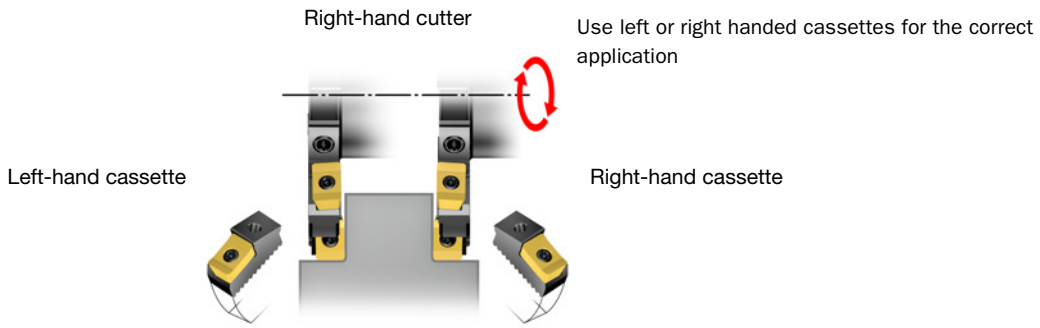
Tailor Made

Other insert radii available as Tailor Made.

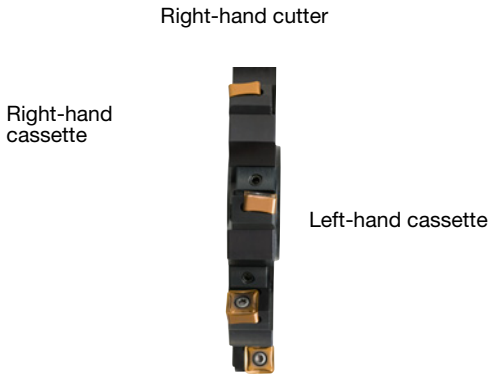
SANDVIK Coromant

Cutter bodies, cassettes and inserts to combine for all applications

Half side and face mill



Full side and face mill

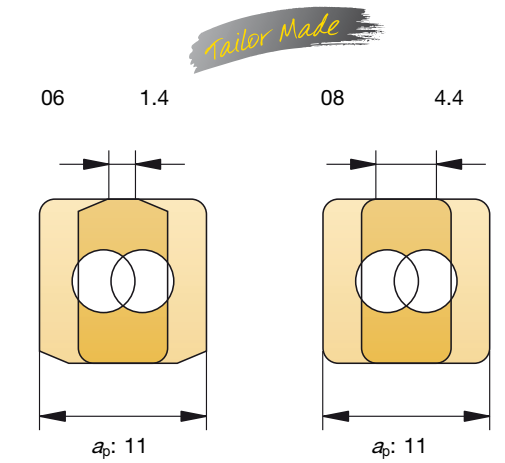


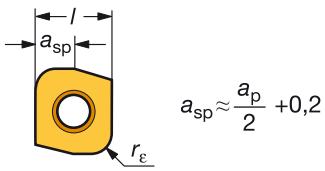
Reduced cutting edge length for Tailor Made inserts

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.



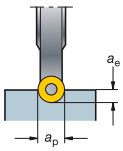


$$a_{sp} \approx \frac{a_p}{2} + 0{,}2$$

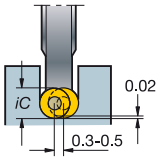
Facilitated chip evacuation

Full slot milling with round insert cutter

a_e max. IC/2



a_e more than IC/2



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

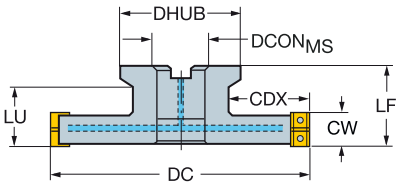
Note: The contact length of the cutting edge is 180°

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°



CW	CWX	DC	CDX		CZCMS	CNSC		Ordering code	Dimensions, mm DCONMS	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

	Accessories
CZCMS	Coolant screw
27	5512 098-05
32	5512 098-04
40	5512 098-03

I130 L2 M1 N23 N6

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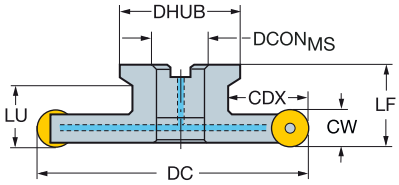
ENG

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462



CW	DC	CDX		CZCMS	CNSC		Ordering code	DCONMS	ISO	LF	LU	DHUB	BAR	NM	KG	RPMX	RE	CICT	MIID
								Dimensions, mm											
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

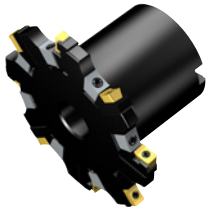
	Accessories
CZCMS	Coolant screw
27	5512 098-05
32	5512 098-04
40	5512 098-03

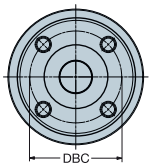
I130 L2 M1 N23 N6

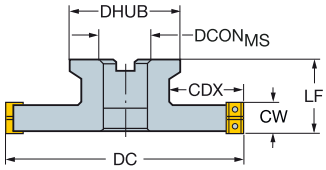
CoroMill® 331 adjustable full side and face disc milling cutter

Arbor

STDNO ISO6462
KAPR 90°







N331.1A

CW	CWX	DC	CDX		CZCMS		Ordering code	Dimensions, mm DCONMS	ISO	DBC	LF	DHUB	NM	KG	RPMX	CICT	MIID
6.00	8.0	200	51.0	04	40S	8	R331.32-200Q40CM06.00	40.0	C	66.7	63.00	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	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	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	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	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	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	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	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	R331.32-315Q60RM23.50	60.0	C	101.6	63.00	136.0	3.0	20.44	6300	20	N331.1A-14

CW	DC	Spare parts 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

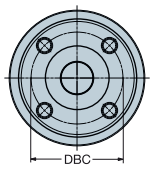
For complete list of spare parts, see www.sandvik.coromant.com

ENG

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor

STDNO



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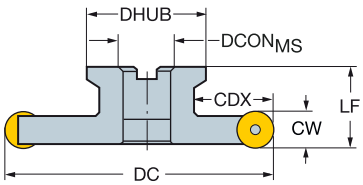


RCKT
RCHT

CW	DC	CDX		CZCMS		Ordering code	Dimensions, mm DCONMS	ISO	DBC	LF	DHUB	NM	KG	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

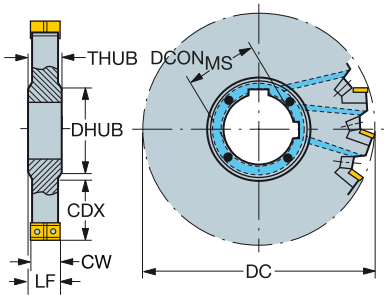
		Spare parts		
CW	DC	Insert screw	Wedge	Screw
10.00	202.00	5513 020-09	5431 105-01	339-831
12.00	202.00	5513 020-09	5431 105-02	339-831
16.00	202.00	5513 020-07	5431 105-04	339-831

For complete list of spare parts, see www.sandvik.coromant.com

CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway - Internal coolant supply

KAPR 90°



CW	CWX	DC	CDX		CZC$_{MS}$	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	LF	DRVCT	DHUB	THUB	BAR	NM	KG	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

	Accessories	
CZC$_{MS}$	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

I130 L2 N23 N6

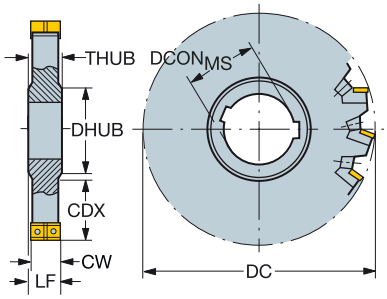
ENG

CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway

KAPR 90°

N331.1A



CW	CWX	DC	CDX		CZC$_{MS}$		Ordering code	Dimensions, mm DCON$_{MS}$	LF	DRVCT	DHUB	THUB	NM	KG	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

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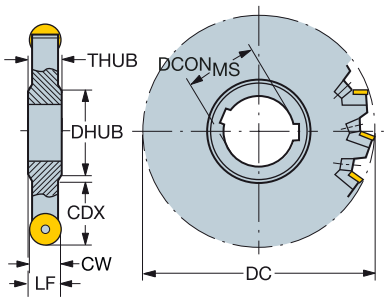
CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway



RCKT
RCHT

							Dimensions, mm										
CW	DC	CDX		CZC_{MS}		Ordering code	$DCON_{MS}$	LF	DRVCT	DHUB	THUB	NM	KG	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

J K L M N

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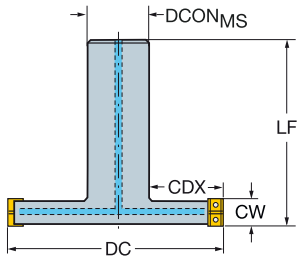
SANDVIK Coromant

ENG

CoroMill® 331 adjustable full side and face disc milling cutter

Cylindrical shank - Internal coolant supply

KAPR 90°



CW	CWX	DC	CDX		CZCMS	CNSC		Ordering code	Dimensions, mm DCONMS	LF	BAR	NM	KG	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

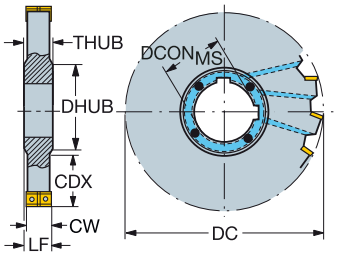
For complete list of spare parts, see www.sandvik.coromant.com

I130 L2 N23 N6

CoroMill® 331 full side and face disc milling cutter

Bore with keyway - Internal coolant supply

KAPR 90°



CW	DC	CDX		CZC_{MS}	CNSC		Ordering code	Dimensions, mm $DCON_{MS}$	LF	DRVCT	DHUB	THUB	BAR	NM	KG	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

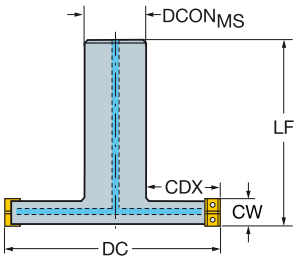
I130 L2 N23 N6

ENG

CoroMill® 331 full side and face disc milling cutter

Cylindrical shank - Internal coolant supply

KAPR 90°



CW	DC	CDX		CZC$_{MS}$	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	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
	80	23.0	04	32	1	4	R331.35C-080A32CM060	32.0	150.00	80	0.8	1.03	19000	8	N331.1A-04
8.00	40	11.0	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
	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
	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

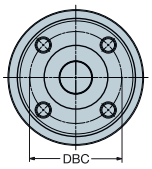
For complete list of spare parts, see www.sandvik.coromant.com

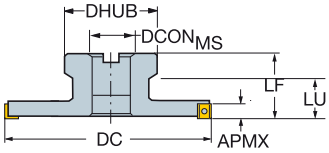
I130 L2 N23 N6

CoroMill® 331 adjustable half side and face disc milling cutter

Arbor

STDNO ISO6462
KAPR 90°





N331.1A

DC		CZC$_{MS}$	APMX		Ordering code	Dimensions, mm DCON$_{MS}$	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

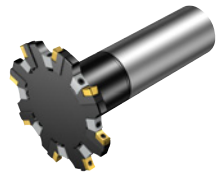
I130 L2 M1 N23 N6

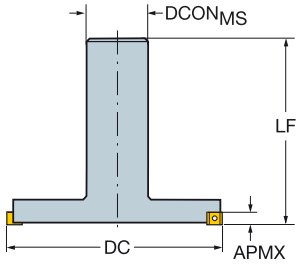
ENG

CoroMill® 331 adjustable half side and face disc milling cutter

Cylindrical shank

KAPR 90°





N331.1A

DC		CZC$_{MS}$	APMX		Ordering code	Dimensions, mm DCON$_{MS}$	LF	NM	KG	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

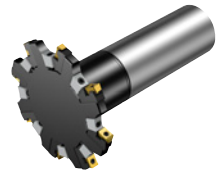
Spare parts		
Insert screw	Wedge	Screw
5513 020-24	5431 105-01	339-831

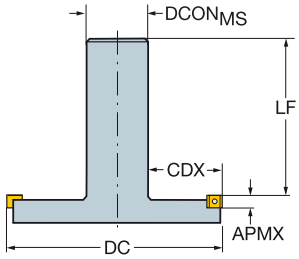
For complete list of spare parts, see www.sandvik.coromant.com

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

Cylindrical shank

KAPR 90°





N331.1A

DC	CDX		CZC$_{MS}$	APMX		Ordering code	Dimensions, mm DCON$_{MS}$	LF	NM	KG	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

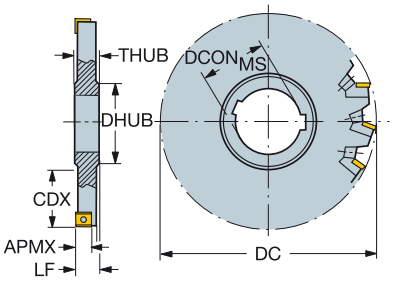
For complete list of spare parts, see www.sandvik.coromant.com

I130 L2 M1 N23 N6

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

Bore with keyway

KAPR 90°



N331.1A

DC	CDX		CZC_{MS}	APMX		Ordering code	Dimensions, mm $DCON_{MS}$	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

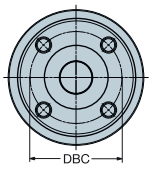
I130 L2 N23 N6

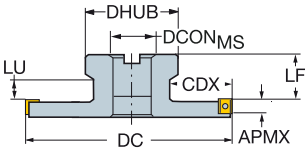
ENG

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

Arbor

STDNO ISO6462
KAPR 90°





N331.1A

DC	CDX		CZC$_{MS}$	APMX		Ordering code	Dimensions, mm DCON$_{MS}$	ISO	DBC	LF	LU	DHUB	NM	KG	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	R331.52-125Q32FML	32.0	B		51.00		64.0	1.2	1.95	14100	10	N331.1A-08
125	29.5	08	32	7.6	10	R331.52-125Q32EML	32.0	B		53.00		64.0	1.2	1.81	14100	10	N331.1A-08
160	41.0	08	40	7.6	12	R331.52-160Q40FML	40.0	B		51.00		76.0	1.2	2.90	12400	12	N331.1A-08
160	41.0	08	40	7.6	12	R331.52-160Q40EML	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

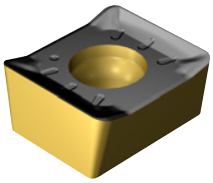
	Spare parts		
Ordering code	Insert screw	Wedge	Screw
R331.52-080Q27EML	5513 020-24	5431 105-01	269-832
R331.52-080Q27FML	5513 020-24	5431 105-02	269-832
R331.52-100Q27EML	5513 020-24	5431 105-01	5516 010-02
R331.52-100Q27FML	5513 020-24	5431 105-02	5516 010-02
R331.52-125Q32EML	5513 020-24	5431 105-01	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

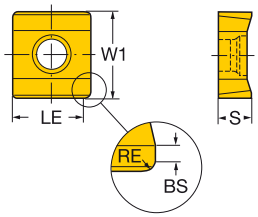
For complete list of spare parts, see www.sandvik.coromant.com

I130 L2 M1 N23 N6

CoroMill® 331 insert for side and face milling

KRINS 90°





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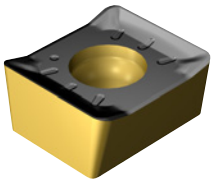
Light	04	0.50	N331.1A-04 35 05E-KL					☆										★		☆	☆	☆																	☆		9.5	4.6	3.50	0.4
		0.50	N331.1A-04 35 05H-NL	☆		☆					☆		☆						☆						☆		☆	☆		★		☆	☆				☆	☆			9.5	4.6	3.50	0.2
		0.50	N331.1A-04 35 05H-PL						☆	☆					☆								☆	☆																	9.5	4.6	3.50	0.4
		0.50	N331.1A-04 35 05H-WL	☆		☆					☆		☆						☆							☆	☆	☆			☆	☆	☆		☆		☆	☆			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
	05	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
	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
	11	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
		2.00	N331.1A-11 50 20E-KL															☆																							11.5	9.5	5.00	1.2
		2.00	N331.1A-11 50 20H-PL			☆							☆															☆				☆						☆		11.5	9.5	5.00	1.2
		0.80	N331.1A-115008E-L30									☆		☆			☆																☆		☆					11.5	10.7	4.99	1.2
		0.80	N331.1A-115008E-L50		☆	★	☆					★	☆	☆			☆															☆	☆		★					11.5	10.7	4.99	1.2
	14	0.80	N331.1A-14 50 08E-KL					☆										★		☆	☆	☆																	☆		11.5	13.7	4.95	1.2
		0.80	N331.1A-14 50 08H-NL	☆		☆					☆		☆						☆						☆		☆	☆		★		☆	☆				☆	☆			11.5	13.7	4.95	1.1
		0.80	N331.1A-14 50 08H-PL						☆	☆					☆								☆	☆																	11.5	13.7	4.95	1.2
		0.80	N331.1A-14 50 08H-WL	☆		☆					☆		☆						☆							☆	☆	☆			☆	☆	☆		☆		☆	☆			11.5	13.7	4.95	1.2
		0.80	N331.1A-145008E-L30									☆		☆			☆																☆		☆					11.5	13.7	4.98	1.2
		0.80	N331.1A-145008E-L50		☆	★	☆					★	☆	☆			☆															☆	☆		★					11.5	13.7	4.98	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

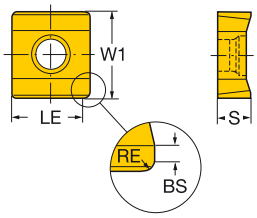
I116 I154 I175 N23 N6 N10

ENG

CoroMill® 331 insert for side and face milling

KRINS 90°



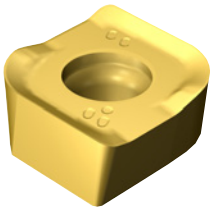


		RE	Ordering code	P								M							K								N						S						H				Dimensions, mm			
				1025	1040	1130	2040	3040	4330	4340	530	1025	1040	1130	2040	4340	530	S30T	1020	1025	3040	3220	3330	4330	4340	H10	H13A	1025	1130	530	H10	H13A	1025	1130	2040	H13A	S30T	1025	1130	3040	530	W1	LE	S	BS
Medium	11	0.80	N331.1A-11 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

I116 I154 I175 N23 N6 N10

CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor made.



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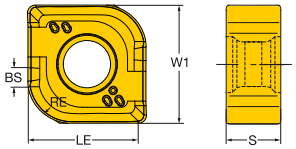


		SSC	RE	Ordering code	P					M				K			N	S			H		Dimensions, mm			
					1040	1130	2040	3040	4330	1040	1130	2040	S30T	1020	3040	4330	1130	1130	2040	S30T	1130	3040	W1	LE	S	BS
Light	L50	11	3.05	R/L331.1A-115030E-L50	☆		☆			★		☆	☆						☆	★			11.5	10.7	5.00	1.3
			4.00	R/L331.1A-115040E-L50	☆		☆			★		☆	☆						☆	★			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

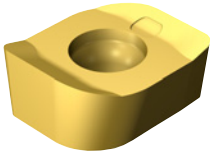
SANDVIK Coromant

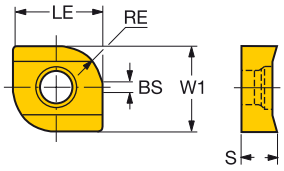
ENG

CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor made.

KRINS 90°



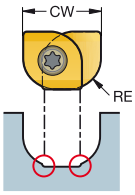


			RE	Ordering code	P 1130	P 4340	M 1025	M 1040	M 1130	K 1025	K 4340	N 1130	N H10F	S 1025	S 1040	S 1130	S S30T	S H10F	H 1130	Dimensions, mm W1	LE	S	BS
Light	WL	04	1.52	L331.1A-04 35 15H-WL	★		☆	★	☆	☆		☆		☆	★	☆			★	9.5	4.6	3.50	0.4
			2.29	L331.1A-04 35 23H-WL	★		☆	★	☆	☆		☆		☆	★	☆			★	9.5	4.6	3.50	0.4
			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

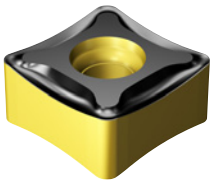
Full slot milling

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

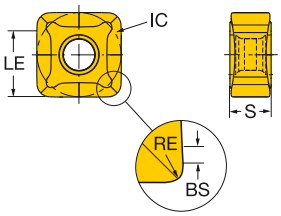


I116 I154 I175 N23 N6 N10

CoroMill® 331 insert for side and face milling

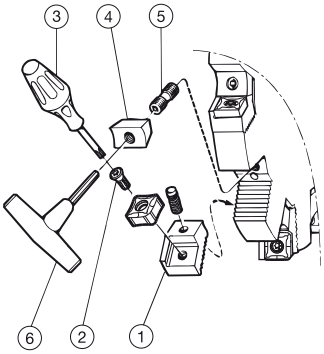


KRINS 88°



			RE	Ordering code	P					M		K					N	S	H			Dimensions, mm			
					1130	3040	4220	4330	4340	1130	4340	1020	3040	3330	4220	4330	4340	1130	1130	1130	3040	4220	IC	LE	S	BS
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.



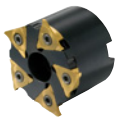
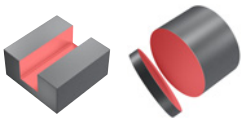
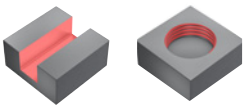
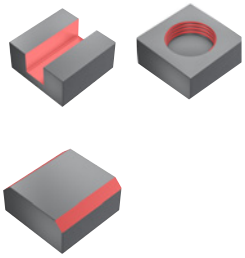
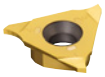
Note that the diameter of the cutter increases by 3.2 mm when using the cassettes for double sided inserts.

Cutter type	1	1	2	3		4	5	6
	Cassette Right	Cassette Left	Screw	Key (Torx Plus)	Torque wrench[1]	Wedge	Screw	Key (mm)
QM (a_p 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	265.2-817 (3.0)
RM (a_p 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	265.2-817 (3.0)

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	Groove milling I145	Chamfer milling I151
		Thread milling I148	Thread milling I149	
			Chamfer milling I150	
Material	P M K N S H	P M K N S	P M K N S	P M K N S
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 - 5.15	0.7 - 5.15	
CDX mm	21.0 - 117.5	3.0 - 5.0	0.5 - 10.0	
Insert				
Insert sizes	9 & 14	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:

P M K N S H

Benefits and features

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

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

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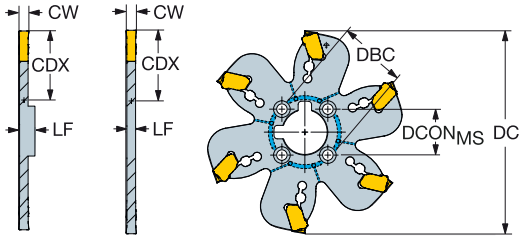
CoroMill® QD indexable grooving and parting off cutter

Arbor - Internal coolant supply

KAPR 90°



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

CW	DC	CDX	SSC	CZC_{MS}	CNSC			Ordering code	Dimensions, mm $DCON_{MS}$	DBC	LF	DRVCT	BAR	KG	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

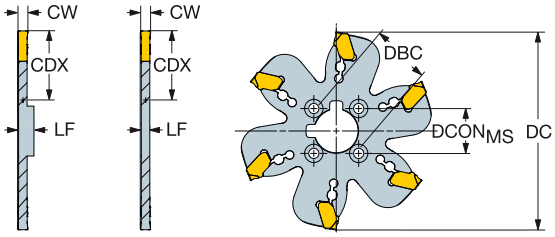
For complete list of spare parts, see www.sandvik.coromant.com

I140 L2 N23 N6 N15

CoroMill® QD indexable grooving and parting off cutter

Arbor

KAPR 90°



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

CW	DC	CDX	SSC	CZC_{MS}			Ordering code	Dimensions, mm $DCON_{MS}$	DBC	LF	DRVCT	KG	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

I140 L2 N23 N6

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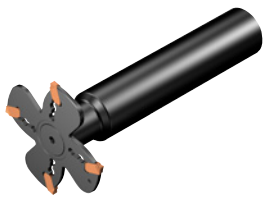
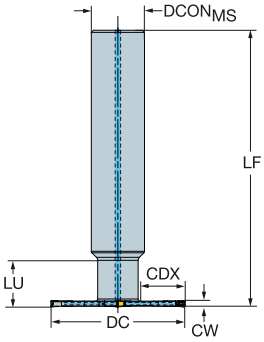
CoroMill® QD indexable grooving and parting off cutter

Cylindrical shank - Internal coolant supply

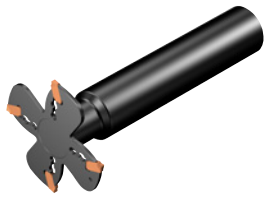


KAPR 90°

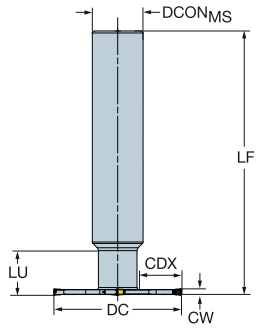


CW	DC	CDX	SSC	CZC$_{MS}$	CNSC		Ordering code	Dimensions, mm DCON$_{MS}$	LF	LU	BAR	KG	RPMX	BD	LB	MIID
2.00	63	21.0	E	25	4	4	QD-EC063A25-M	25.0	130.00	23	70	0.67	4900	19.0	21.8	QD-NE-0200-020E-PM
2.50	63	21.0	F	25	4	4	QD-FC063A25-M	25.0	130.00	23	70	0.68	5600	19.0	22.3	QD-NF-0250-020E-PM
3.00	63	21.0	G	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°



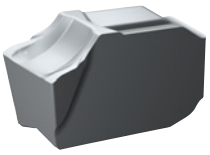
CW	DC	CDX	SSC	CZC$_{MS}$		Ordering code	Dimensions, mm DCON$_{MS}$	LF	LU	KG	RPMX	BD	LB	MIID
2.00	63	21.0	E	25	4	QD-E-063A25-M	25.0	130.00	23	0.69	4900	19.0	21.8	QD-NE-0200-020E-PM
2.50	63	21.0	F	25	4	QD-F-063A25-M	25.0	130.00	23	0.68	5600	19.0	22.3	QD-NF-0250-020E-PM
3.00	63	21.0	G	25	4	QD-G-063A25-M	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	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	QD-K-080A32-M	32.0	130.00	27	1.07	4300	25.0	25.7	QD-NK-0600-035E-PM

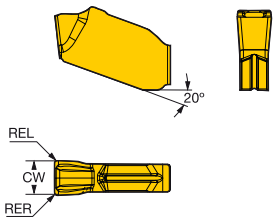
Spare parts
Coolant plug
5643 028-02

For complete list of spare parts, see www.sandvik.coromant.com

I140 L2 N23 N6 N15

CoroMill® QD insert for grooving

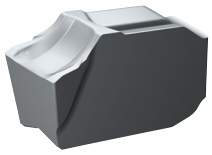


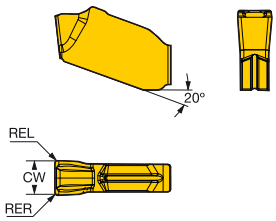


	SSC	CW	REL	RER	Ordering code	P 1040	P 1130	P 2040	P 4340	M 1040	M 1130	M 2040	M 4340	M S30T	M S40T	K 1020	K 3330	K 4340	K H13A	N 1130	N H13A	S 1130	S 2040	S H13A	S S30T	S S40T	H 1130	Dimensions, mm AN	CWTOLL	CWTOLU
Light	E	2.00	0.10	0.10	QD-NE-0200-010E-NL														☆		★			☆				7°	0.005	0.055
		2.00	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

I137 I154 I175 N23 N6 N10

CoroMill® QD insert for grooving





	SSC	CW	REL	RER	Ordering code	P 1040	P 1130	P 2040	P 4340	M 1040	M 1130	M 2040	M 4340	M S30T	M S40T	K 1020	K 3330	K 4340	K H13A	N 1130	N H13A	S 1130	S 2040	S H13A	S S30T	S S40T	H 1130	Dimensions, mm AN	CWTOLL	CWTOLU
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

I137 I154 I175 N23 N6 N10

CoroMill® 328

Grooving, threading and circlip grooving

Application

- Thread milling
- Grooving
- Circlip grooving

ISO application area:

P M K N S H

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

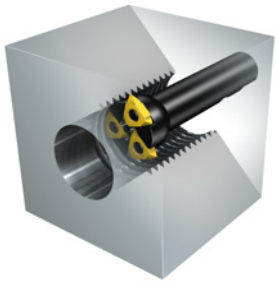
www.sandvik.coromant.com/coromill328

Couplings

- Arbor
- Weldon
- Bore with keyway

Inserts

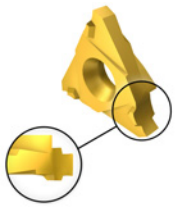
- Three cutting edges



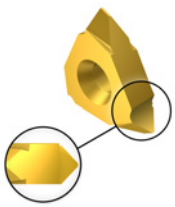
Thread forms: V-profile 60°, M 60° and UN 60°

Circlip grooving

Circlip grooving with chamfer



Thread milling



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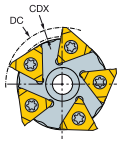
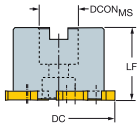
ENG

CoroMill® 328 groove milling cutter

Arbor

STDNO ISO6462
KAPR 90°

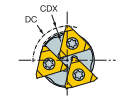


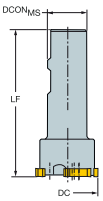


CW	DC	CDX		CZC$_{MS}$		Ordering code	Dimensions, mm DCON$_{MS}$	ISO	LF	DHUB	NM	KG	RPMX	BD	LB	MIID
1.30	63	5.0	13	22	5	328-063Q22-13M	22.0	A	40.00	51.0	6.5	0.84	11900	51.0	40.0	328R13-130 00-GM

Weldon

KAPR 90°

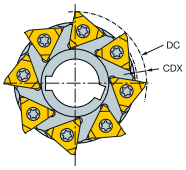


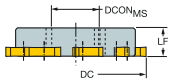


CW	DC	CDX		CZC$_{MS}$		Ordering code	Dimensions, mm DCON$_{MS}$	ISO	LF	NM	KG	RPMX	BD	LB	MIID
1.30	39	3.0	13	25	2	328-039B25-13M	25.0	WE	125.00	6.5	0.59	19300	32.0	69.0	328R13-130 00-GM
	44	4.0	13	25	3	328-044B25-13M	25.0	WE	125.00	6.5	0.61	17100	34.0	69.0	328R13-130 00-GM

Bore with keyway

KAPR 90°





CW	DC	CDX		CZC$_{MS}$		Ordering code	Dimensions, mm DCON$_{MS}$	LF	DRVCT	DHUB	NM	KG	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

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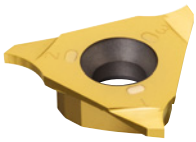
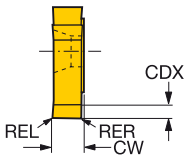
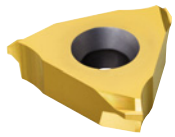
CoroMill® 328 insert for groove milling

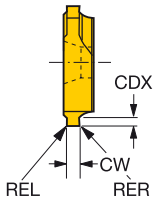




For circlip grooves

	SSC	CW	REL	RER	CDX	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	H 1025	Dimensions, mm AN	CWTOLL	CWTOLU	RETOLL	RETOLU
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

	SSC	CW	REL	RER	CDX	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	H 1025	Dimensions, mm AN	CWTOLL	CWTOLU	RETOLL	RETOLU
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

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SANDVIK Coromant

CoroMill® 327

Groove- and thread milling cutters

Application

- Thread milling
- Groove milling
- Circlip grooving
- Chamfering

ISO application area:

P M K N S

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

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Couplings

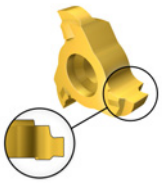
- Coromant Capto®
- Integrated ER collets
- Weldon steel or solid carbide shanks

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°

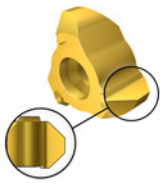
Grooving and circlip grooving

Circlip grooving with chamfer

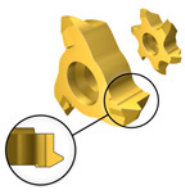


Grooving full radius

Chamfer milling

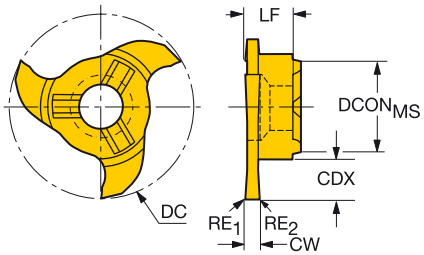


Thread milling



I146

CoroMill® 327 solid carbide head for grooving



CW	RE$_1$	RE$_2$	CZC$_{MS}$	CDX	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	DCON$_{MS}$	DC	LF	CWTOLL	CWTOLU	RPMX
												Dimensions, mm					
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

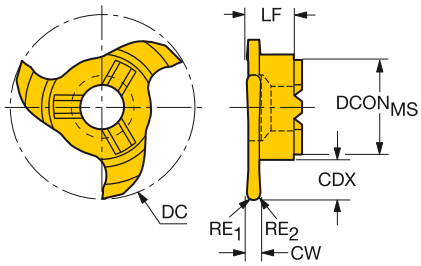
CW	RE$_1$	RE$_2$	CZC$_{MS}$	CDX	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	DCON$_{MS}$	DC	LF	CWTOLL	CWTOLU	RPMX
												Dimensions, mm					
0.70	0.00	0.00	6.0	1.5	3	327R06-10 07000-GM	☆	☆	☆	☆	☆	6.00	9.70	3.50	0.050	0.070	50000
0.80	0.00	0.00	6.0	1.5	3	327R06-10 08000-GM	☆	☆	☆	☆	☆	6.00	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

SANDVIK Coromant

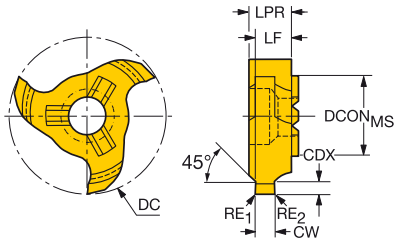
ENG

CoroMill® 327 solid carbide head for grooving



For full radius grooves

CW	RE$_1$	RE$_2$	CZC$_{MS}$	CDX	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	DCON$_{MS}$	DC	LF	CWTOLL	CWTOLU	RPMX
							Dimensions, mm										
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



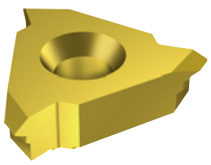
Circlip grooves with chamfer

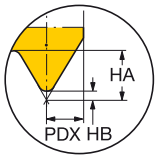
CW	RE$_1$	RE$_2$	CZC$_{MS}$	CDX	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	DCON$_{MS}$	DC	LF	LPR	CWTOLL	CWTOLU	RPMX
							Dimensions, mm											
1.10	0.00	0.00	12.0	0.5	3	327R12-22 11045-GC	☆	☆	☆	☆	☆	12.00	21.70	5.00	5.80	0.090	0.110	50000
1.30	0.00	0.00	12.0	0.7	3	327R12-22 13045-GC	☆	☆	☆	☆	☆	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

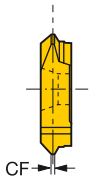
L2 I154 I175 N23 N11

CoroMill® 328 insert for thread milling

For internal threads







Metric 60° Full form

SSC	TP	NT	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	H 1025	Dimensions, mm 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 1025	M 1025	K 1025	N 1025	S 1025	H 1025	Dimensions, mm 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 1025	M 1025	K 1025	N 1025	S 1025	H 1025	Dimensions, mm 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

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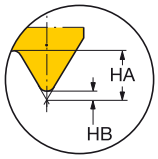
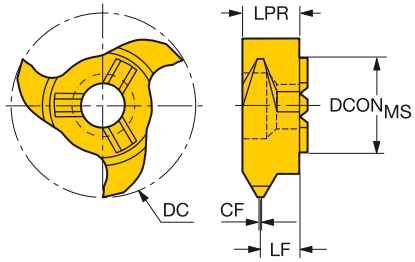
SANDVIK Coromant

CoroMill® 327 solid carbide head for thread milling

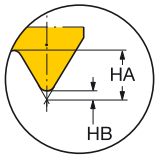
For internal threads

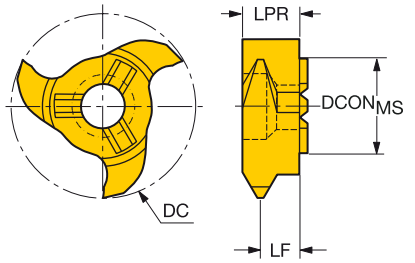




V-profile 60° Non-topping

TPN	TPX	TPIN	TPIX	DC	CZC_{MS}	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	Dimensions, mm $DCON_{MS}$	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





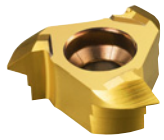
Metric 60° Full form

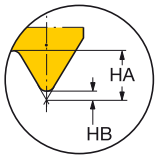
TP	DC	CZC_{MS}	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	Dimensions, mm $DCON_{MS}$	HA	HB	LF	LPR
1.50	17.70	9.0	3	327R09-18 150MM-TH	☆	☆	☆	☆	☆	9.00	0.97	0.16	4.8	5.85
1.50	17.70	9.0	6	327R09-18 150MM-THM	☆	☆	☆	☆	☆	9.00	0.97	0.16	5.0	5.85
2.00	17.70	9.0	3	327R09-18 200MM-TH	☆	☆	☆	☆	☆	9.00	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

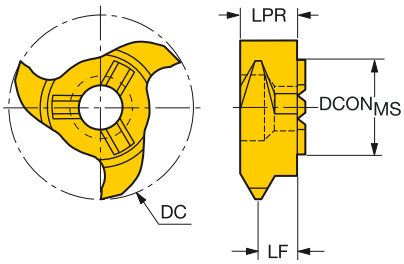
L2 I154 I175 N23 N11

CoroMill® 327 solid carbide head for thread milling

For internal threads

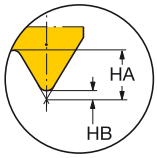


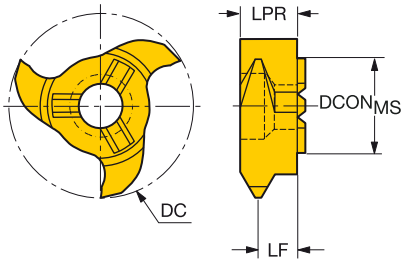




UN 60° Full form

TPI	DC	CZC$_{MS}$	APMX	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	Dimensions, mm DCON$_{MS}$	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

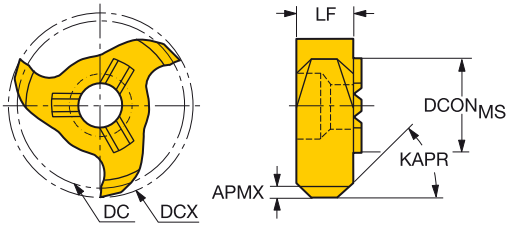




Whitworth 55° Full form

TPI	DC	CZC$_{MS}$	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	Dimensions, mm DCON$_{MS}$	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$_{MS}$	APMX	ZEFP	Ordering code	P 1025	M 1025	K 1025	Dimensions, mm DCON$_{MS}$	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

SANDVIK Coromant

ENG

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:

P M K N S H

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

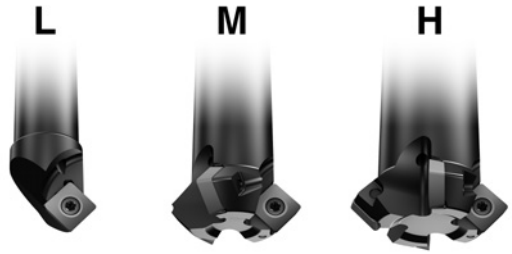
www.sandvik.coromant.com/coromill495

Couplings

- Coromant Capto®
- Cylindrical shank
- Coromant EH

Inserts

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

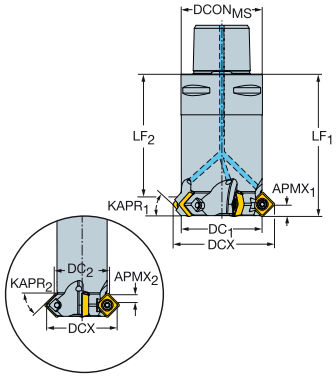


Coarse pitch | Close pitch | Extra close pitch

I152 I153

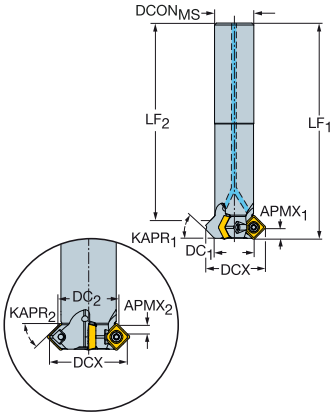
CoroMill® 495 chamfer milling cutter

Coromant Capto® - Internal coolant supply



KAPR1	KAPR2		CZCMS	APMX1	APMX2	CNSC		Ordering code	Dimensions, mm DCONMS	DC1	DC2	DCX	BD	LF1	LF2	BAR	NM	KG	RPMX	CICT	MIID
45°	45°	09	C4	5.4	5.4	3	5	495-040C4-4509H	40.0	40.5	40.5	51.9	39.7	70.0	58.4	20	1.4	0.92	6100	5	495-09T3M-XL
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	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



KAPR1	KAPR2		CZCMS	APMX1	APMX2	CNSC		Ordering code	Dimensions, mm DCONMS	DC1	DC2	DCX	BD	LF1	LF2	LU	BAR	NM	KG	RPMX	CICT	MIID
30°	60°	09	16	3.8	6.5	1	1	495-012A16-3009L	16.0	12.0	18.3	26.0	17.2	100.0	88.7		20	1.4	0.23	14400	1	495-09T3M-XL
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		1	1	495-012A16-7509L	16.0	12.0		16.2	13.0				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		1	3	495-025A25-7509H	25.0	25.5		29.7	25.2				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		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

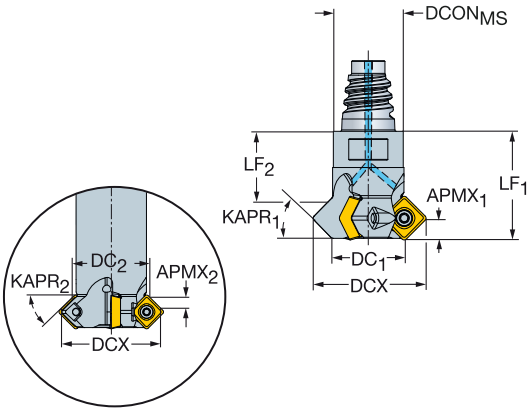
For complete list of spare parts, see www.sandvik.coromant.com

I153 L2 N23 N9 N15

ENG

CoroMill® 495 chamfer milling cutter

Coromant EH - Internal coolant supply



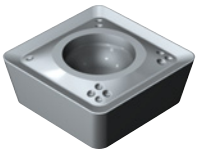
KAPR1	KAPR2		CZCMS	APMX1	APMX2	CNSC		Ordering code	Dimensions, mm DCONMS	DC1	DC2	DCX	BD	LF1	LF2	BAR	NM	KG	RPMX	CICT	MIID
45°	45°	09	E16	5.4	5.4	1	1	495-012EH16-4509L	15.5	12.0	17.7	23.4	11.2	30.0	20.8	20	1.4	0.09	14400	1	495-09T3M-XL
45°	45°	09	E20	5.4	5.4	1	3	495-020EH20-4509M	19.3	20.5	20.9	31.9	19.7	30.0	18.2	20	1.4	0.15	9500	3	495-09T3M-XL
45°	45°	09	E25	5.4	5.4	1	4	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

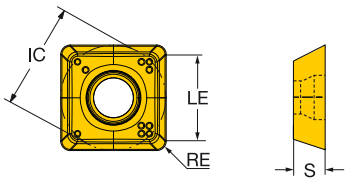
Spare parts
Insert screw
5513 020-04

For complete list of spare parts, see www.sandvik.coromant.com

CoroMill® 495 insert for milling

KRINS 90°





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

L2 I154 N23 N9 N15 N3

Milling with large engagement

ISO P			Specific cutting force k_{c1}	Hardness Brinell		CT530	GC1010	GC1025
						Max chip thickness, h_{ex} mm		
						0.1 – 0.15 – 0.2	0.05 – 0.1 – 0.2	0.05 – 0.1 – 0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Steel						
		Unalloyed						
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
		Low alloyed (alloying elements ≤ 5%)						
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
		High alloyed (alloying elements > 5%)						
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
		Castings						
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			Specific cutting force k_{c1}	Hardness Brinell		CT530	M30B	GC1130
						Max chip thickness, h_{ex} mm		
						0.1 – 0.15 – 0.2	0.1 – 0.2 – 0.4	0.05 – 0.1 – 0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Stainless steel						
		Ferritic/martensitic						
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
		Austenitic						
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		–	–	–
		Austenitic-ferritic (Duplex)						
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
		Stainless steel – Cast						
		Ferritic/martensitic						
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		–	–	–
		Austenitic-ferritic (Duplex)						
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			Specific cutting force k_{c1}	Hardness Brinell		CB50	CC6190	GC1010
						Max chip thickness, h_{ex} mm		
						0.1 – 0.15 – 0.2	0.1 – 0.2 – 0.3	0.1 – 0.2 – 0.3
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Malleable cast iron						
	07.1	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
		Grey cast iron						
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
		Nodular cast iron						
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.

ENG

GC1130	GC4220	GC4330	GC4340	GC2030	GC2040	GC3040				
Max chip thickness, h_{ex} mm										
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				
Cutting speed v_c, m/min										
375–340–280	490–405–330	400–330–270	340-280-230	295–240–165	295 –240 –165	390-320-260				
335–305–250	440–360–295	360–295–245	305-250-205	265–215–145	265 –215 –145	350-285-235				
320–290–235	415–340–280	340–280–230	290-235-195	250–205–135	250 –205 –135	330-270-220				
275–250–205	365–300–245	295–245–200	250-205-170	220–180–120	220 –180 –120	290-235-195				
205–185–155	270–220–180	220–180–150	185-155-125	160–130–90	160 –130 –90	215-175-145				
265–240–195	345–285–230	280–230–190	240-195-160	205–170–115	205 –170 –115	275-225-185				
170–155–130	225–185–150	185–150–125	155-130-105	135–110–75	135 –110 –75	180-145-120				
180–165–135	300–245–200	195–160–130	165-135-110	155–130–85	155 –130 –85	205-170-140				
150–135–110	215–180–145	160–130–110	135-110-90	125–105–70	125 –105 –70	170-140-115				
130–120–100	190–155–125	140–115–95	120-100-80	110-90-60	110 –90 –60	150-125-100				
80–75–60	120–95–80	85–70–60	75-60-50	70–55–38	70 –55 –38	95-75-65				
245–220–180	350–290–235	260–215–175	220-180-150	210–170–115	210 –170 –115	280-230-190				
195–175–145	280–230–190	205–170–140	175-145-120	170–140–95	170 –140 –95	220-180-150				
140–130–105	205–170–140	150–125–100	130-105-85	120–100–70	120 –100 –70	160-135-110				

GC1040	S30T	S40T	GC2030	GC2040	GC4330	GC4340	GC1010	GC1025		
Max chip thickness, h_{ex} mm										
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		
Cutting speed v_c, m/min										
185 – 140 – 105	255 – 190 – 140	250 – 200 – 160	240 –190 –155	240 –190 –155	275 –220 –175	210 –170 –110	285-255-230	255-225-180		
130 – 100 – 70	180 – 135 – 100	170 – 135 – 110	170 –135 –110	165 –130 –105	190 –150 –120	140 –110 –70	205-185-165	180-160-130		
135 – 100 – 75	185 – 140 – 105	180 – 145 – 115	175 –140 –115	175 –140 –110	200 –160 –125	160 –125 –80	215-190-170	185-165-135		
180 – 135 – 100	250 – 185 – 140	210 – 165 – 135	235 –190 –150	200 –160 –130	-	185 –150 –95	265-240-215	250-225-180		
125 – 95 – 70	170 – 130 – 95	165 – 130 – 105	165 –130 –105	160 –125 –100	-	135 –105 –70	200-175-160	170-155-125		
125 – 90 – 70	170 – 125 – 95	145 – 115 – 95	–	–	–	–	170-125-95	–		
150 – 115 – 85	205 – 155 – 115	175 – 140 – 110	195 –155 –125	170 –135 –105	-	170 –135 –85	260-240-215	205-185-145		
125 – 95 – 70	175 – 130 – 95	140 – 115 – 90	165 –130 –105	135 –110 –85	-	135 –110 –70	230-205-185	170-155-125		
165 – 125 – 90	225 – 165 – 125	220 – 175 – 140	215 –170 –135	210 –170 –135	245 –195 –155	185 –150 –95	255-230-205	225-200-160		
115 – 85 – 65	155 – 115 – 85	150 – 120 – 95	150 –120 –95	145 –115 –90	165 –130 –105	120 –100 –65	180-160-145	155-140-115		
125 – 90 – 70	170 – 125 – 95	165 – 135 – 105	160 –130 –105	160 –130 –100	180 –145 –115	145 –115 –75	195-175-155	170-155-120		
175 – 130 – 95	235 – 175 – 130	200 – 160 – 130	225 –180 –145	190 –155 –125	-	180 –140 –90	255-225-205	235-210-170		
115 – 85 – 65	160 – 115 – 85	150 – 120 – 95	150 –120 –95	145 –115 –90	-	125 –100 –65	180-160-145	160-140-115		
110 – 85 – 60	155 – 115 – 85	130 – 105 – 85	–	–	–	–	-	–		
145 – 105 – 80	195 – 15 – 110	165 – 130 – 105	185 –150 –120	160 –125 –100	-	160 –125 –80	245-220-195	195-175-140		
115 – 85 – 65	160 – 120 – 90	135 – 105 – 85	150 –120 –95	130 –100 –80	-	125 –100 –65	215-190-170	160-145-115		

GC3220	GC3330	GC3040	K20W	GC4330	GC4340	GC1020	H13A	K20D	K20M	K15W
Max chip thickness, h_{ex} mm										
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
Cutting speed v_c, m/min										
265–220–180	260–215–145	240–195–135	225–185–150	215 –175 –145	195–160–130	205–170–140	120–105–75	265-220-180	255-210-170	-
220–180–150	215–175–120	200–165–110	185–150–125	175 –145 –120	160–130–110	170–140–115	100– 85–65	220-180-150	210-170-140	-
290–240–195	285–235–155	260–215–145	245–200–165	230 –190 –155	215–175–145	225–185–150	130–110–85	290-240-195	275-225-185	245-200-165
235–190–155	225–185–125	210–170–115	195–160–130	185 –155 –125	170–140–115	180–145–120	105– 90–65	235-190-155	220-180-150	195-160-130
180–150–125	280–230–155	165–135–90	155–125–105	145 –120 –100	135–110–90	140–115–95	80– 70–50	180-150-125	175-140-115	-
170–140–115	225–185–125	150–125–85	140–115–95	135 –110 –90	125–100–85	130–105–90	75– 65–50	170-140-115	160-130-110	-

Milling with large engagement

ISO N MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm²	Hardness Brinell HB	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		
		Aluminium alloys						
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	400	60		1900 –1750 –1600	940 –870 –810	1050-960-890
N1.2.Z.AG	30.12	Wrought or wrought and aged	650	100		1700 –1550 –1450	850 –780 –730	930-860-800
		Aluminium alloys						
N1.3.C.UT	30.21	Cast, non-aging	600	75	0.25	1900 –1750 –1600	940 –870 –810	1050-960-890
N1.3.C.AG	30.22	Cast or cast and aged	700	90	0.25	1700 –1550 –1450	850 –790 –730	930-860-800
		Aluminium alloys						
N1.1.Z.UT	30.3	Al >99%	350	30		1900 –1750 –1600	950 –880 –810	1050-960-890
		Aluminium alloys						
	30.41	Cast, 13–15% Si	700	130		760 –700 –650	380 –350 –325	415-385-355
N1.4.C.NS	30.42	Cast, 16–22% Si	700	130		570 –530 –485	285 –265 –245	310-290-270
		Copper and copper alloys						
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	550	110	0.25	940 –870 –810	470 –435 –405	520-480-445
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	550	90		940 –870 –810	470 –435 –405	520-480-445
N3.1.U.UT	33.3	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} N/mm²	Hardness Brinell HB	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		
		Heat resistant super alloys						
		Iron base						
S1.0.U.AN	20.11	Annealed or solution treated	2400	200	0.25	60 –55 –50	60 –55 –50	60 –55 –50
S1.0.U.AG	20.12	Aged or solution treated and aged	2500	280	0.25	45 –40 –37	45 –40 –37	45 –40 –38
		Nickel base						
S2.0.Z.AN	20.21	Annealed or solution treated	2650	250	0.25	60 –55 –50	60 –55 –50	55-55-50
S2.0.Z.AG	20.22	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	Cast or cast and aged	3000	320	0.25	45 –40 –36	45 –40 –36	45-40-38
		Cobalt alloys						
S3.0.Z.AN	20.31	Annealed or solution treated	2700	200	0.25	25 –22 –20	25 –22 –20	23-21-18
S3.0.Z.AG	20.32	Solution treated and aged	3000	300	0.25	18 –16 –14	18 –16 –14	17-15-13
S3.0.C.NS	20.33	Cast or cast and aged	3100	320	0.25	16 –14 –13	16 –14 –13	16-14-13
		Titanium alloys[1]		Rm[2]				
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	1300	400	0.23	125 –115 –105	125 –115 –105	125-115-110
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	1400	950	0.23	55 –50 –45	55 –50 –45	50-45-45
S4.3.Z.AG	23.22	α + β alloys in aged cond., β 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} N/mm²	Hardness Brinell HB	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		
		Extra hard steel						
H1.3.Z.HA	04.1	Hardened and tempered	4200	59 HRC	0.25	160 –140 –115	80 –75 –55	55-45-36
		Chilled cast iron						
H2.0.C.UT	10.1	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.

ENG

GC1130	H10F	H13A	GC1025					
Max chip thickness, h_{ex} mm								
0.1 – 0.15 – 0.2	0.1 – 0.15 – 0.2	0.1 – 0.15 – 0.2	0.1-0.15-0.2					
Cutting speed v_c, m/min								
990–910–850 890–820–760	940–870–810 850–780–730	750–700–650 680–630–580	990–910–850 890–820–760					
990–910–850 990–920–850	940–870–810 850–790–730	750–700–650 680–630–580	990–910–850 990–920–850					
990–920–850	950–880–810	760–700–650	990–920–850					
395–370–340 300–275–255	380–350–325 285–265–245	300–280–260 225–210–195	395–370–340 300–275–255					
495–460–425 495–460–425 345–320–295	470–435–405 470–435–405 330–305–285	375–350–325 375–350–325 265–245–225	495–460–425 495–460–425 345–320–295					

H10F	S30T	S40T	GC2030	GC2040	GC1010			
Max chip thickness, h_{ex} mm								
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			
Cutting speed v_c, m/min								
55 –50 –45 40 –37 –35	– –	– –	55 –50 –45 40 –38 –34	60 –55 –45 45 –39 –32	– –			
50 –50 –45 32 –30 –27 40 –37 –34	– – –	– – –	55 –50 –45 34 –31 –28 40 –37 –34	55 –50 –40 35 –31 –26 40 –38 –31	– – –			
22 –19 –17 15 –14 –12 14 –13 –12	– – –	– – –	23 –21 –18 17 –15 –13 15 –14 –12	23 –21 –17 17 –15 –12 15 –14 –11	– – –			
115 –105 –100 45 –40 –38 34 –31 –29	150 –135 –125 65 –60 –55 50 –50 –45	125 –115 –110 45 –40 –39 38 –36 –33	120 –105 –95 50 –45 –39 40 –37 –34	120 –110 –100 45 –39 –36 37 –33 –30	150-135-125 65-60-55 55-50-45			

GC3040	GC1010	GC1130	GC1025					
Max chip thickness, h_{ex} mm								
0.1 – 0.2 – 0.25	0.07 – 0.12 – 0.2	0.07-0.12-0.2	0.07-0.12-0.2					
Cutting speed v_c, m/min								
45–33–29	110-95-80	40-36-29	40-36-29					
85–65–55	215-185-150	75-70-55	75-70-55					

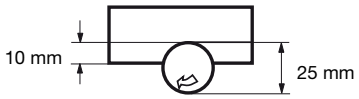
Milling with small engagement

ISO P			Specific cutting force k_{c1}	Hardness Brinell		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
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Steel						
		Unalloyed						
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
		Low-alloy (alloying elements ≤5%)						
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
		High-alloy (alloying elements >5%)						
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
		Castings						
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			Specific cutting force k_{c1}	Hardness Brinell		CT530	GC1130	GC1025
						Max chip thickness, h_{ex} mm		
						0.1 – 0.15 – 0.2	0.05 – 0.1 – 0.2	0.05-0.1-0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Stainless steel						
		Ferritic/martensitic						
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
		Austenitic						
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		-	-	-
		Austenitic-ferritic (Duplex)						
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
		Stainless steel – Cast						
		Ferritic/martensitic						
P5.0.C.UT	15.11	Non-hardened	1700	200	0.25	305 –295 –290	245 –240 –230	245 –240 –230
P5.0C.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
		Austenitic						
M1.0.C.UT	15.21	Austenitic	1800	200	0.25	300 –295 –285	260 –250 –240	260 –250 –240
M1.0C.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		-	-	-
		Austenitic-ferritic (Duplex)						
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			Specific cutting force k_{c1}	Hardness Brinell		CB50	CC6190	K20D
						Max chip thickness, h_{ex} mm		
						0.1 – 0.15 – 0.2	0.1 – 0.2 – 0.3	0.1-0.2-0.3
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Malleable cast iron						
	07.1	Ferritic (short chipping)	790	130	0.28	-	1500 –1450 –1400	305-290-280
K1.1.C.NS	07.2	Pearlitic (long chipping)	900	230	0.28	-	1250 –1200 –1150	250-240-230
		Grey cast iron						
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
		Nodular cast iron						
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.

ENG

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	405-395-380	570 –560 –520	465 –445 –425	395-380-360	340 –335 – 320	340 –325 – 315				
330-325-310	365-355-340	510 –500 –470	420 –400 –385	355-340-325	305 –300 –290	305 –295 –280				
310-305-290	345-335-320	485 –475 –445	395 –380 –360	335-320-310	290 –280 –270	290 –275 –265				
270-265-255	300-295-280	425 –415 –390	345 –330 –315	295-280-270	255 –250 –240	255 –245 –235				
200-195-190	220-220-210	310 –305 –285	255 –245 –235	220-210-200	185 –185 –175	185 –180 –170				
300-295-285	285-280-265	400 –390 –365	325 –315 –300	280-265-255	240 –235 –225	240 –230 –220				
170-165-160	185-180-175	260 –255 –240	215 –205 –195	180-175-165	155 –155 –145	155 –150 –145				
195-190-185	195-190-185	350 –340 –320	225 –215 –205	190-185-175	180 –175 –170	180 –175 –165				
160-160-150	160-160-150	250 –245 –230	185 –180 –170	160-150-145	150 –145 –140	150 –140 –135				
140-140-135	140-140-135	220 –215 –200	165 –155 –150	140-135-125	130 –125 –120	130 –125 –120				
90-85-85	90-85-85	135 –135 –125	100 –95 –95	85-85-80	80 –80 –75	80 –75 –75				
265-255-245	265-255-245	410 –400 –375	305 –290 –280	255-245-235	240 –235 –225	240 –230 –220				
210-205-195	210-205-195	325 –320 –295	240 –230 –220	205-195-190	195 –190 –185	195 –185 –180				
155-150-145	155-150-145	240 –235 –220	175 –170 –160	150-145-140	145 –140 –135	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	285 –265 –250	295 –280 –275	260 –250 –235	285 –270 –265	325 –310 –305	250 –240 –225	275-270-255	340-335-325		
145 –140 –130	200 –185 –175	205 –195 –275	185 –175 –170	195 –185 –180	225 –215 –210	165 –160 –150	195-190-180	245-240-235		
155 –145 –135	210 –195 –180	215 –205 –200	195 –185 –175	205 –195 –190	235 –225 –220	190 –180 –170	200-195-190	255-250-240		
205 –190 –175	280 –260 –245	250 –235 –230	255 –245 –230	240 –225 –220	-	220 –210 –200	-	320-310-300		
140 –135 –125	190 –180 –170	195 –185 –180	180 –170 –160	190 –180 –175	-	160 –150 –145	-	235-230-225		
140 –130 –120	190 –180 –170	175 –165 –160	-	-	-	-	-	190-180-170		
170 –160 –150	230 –215 –200	205 –195 –190	215 –205 –195	200 –190 –185	-	200 –190 –180	-	310-300-295		
140 –130 –125	195 –180 –170	165 –160 –155	180 –170 –160	160 –155 –150	-	160 –155 –145	-	275-270-260		
185 –175 –165	250 –235 –220	2 –250 –235	235 –225 –210	250 –240 –235	290 –275 –270	225 –210 –200	245-240-230	305-295-290		
130 –120 –110	175 –165 –155	180 –170 –165	160 –155 –145	170 –165 –160	195 –185 –185	145 –140 –130	170-170-160	215-210-205		
185 –175 –170	190 –180 –165	200 –190 –185	175 –165 –160	190 –180 –175	215 –205 –200	175 –165 –155	185-180-175	235-225-220		
195 –180 –170	265 –250 –235	240 –225 –220	245 –230 –220	230 –215 –210	-	210 –200 –190	-	300-295-285		
130 –120 –110	175 –165 –155	180 –170 –165	160 –155 –145	170 –165 –160	-	145 –140 –130	-	215-210-205		
125 –120 –110	175 –160 –150	155 –145 –145	-	-	-	-	-	-		
160 –150 –140	220 –205 –190	195 –185 –180	205 –195 –185	190 –180 –175	-	190 –180 –170	-	295-285-280		
130 –125 –115	180 –170 –160	160 –150 –145	165 –160 –150	150 –145 –140	-	150 –140 –135	-	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	305–290–280	280–270–255	260–250–240	250–245–235	225–220–210	240–230–220	135-130-125	250-245-235	295-290-275	-
255–250–240	250–240–230	230–220–210	215–205–195	205–200–190	185–185–175	195–190–180	110-110-105	205-200-190	245-240-225	-
340–330–315	330–315–300	305–290–280	285–270–260	270–265–255	250–240–230	260–250–240	145-140-140	270-265-255	320-315-300	285-270-260
270–265–255	265–255–240	245–235–225	225–215–210	215–210–205	200–195–185	205–200–190	120-115-110	215-210-205	260-250-240	225-215-210
210–205–200	330–315–300	190–185–175	180–170–165	170–165–160	155–150–145	160–155–150	95-90-85	170-165-160	200-195-190	-
195–195–185	265–255–240	175–170–160	165–160–150	155–155–145	145–140–135	150–145–140	85-85-80	155-155-145	185-185-175	-

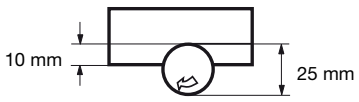
Milling with small engagement

ISO N MC No.	CMC No.	Material	Specific cutting force k_{c1} N/mm²	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		
		Aluminium alloys						
N1.2.Z.UT	30.11	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
		Aluminium alloys						
N1.3.C.UT	30.21	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
		Aluminium alloys						
N1.1.Z.UT	30.3	Al >99%	350	30		2150 –2100 –2050	1150 –1150 –1150	1050-1050-1050
		Aluminium alloys						
	30.41	Cast, 13–15% Si	700	130		850 –840 –820	470 –460 –450	425-420-410
N1.4.C.NS	30.42	Cast, 16–22% Si	700	130		640 –630 –620	350 –345 –340	320-315-310
		Copper and copper alloys						
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	550	110	0.25	1050 –1050 –1050	580 –570 –560	530-520-510
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤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/mm²	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		
		Heat resistant super alloys						
		Iron base						
S1.0.U.AN	20.11	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	-
		Nickel base						
S2.0.Z.AN	20.21	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	-
		Cobalt alloys						
S3.0.Z.AN	20.31	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	-
		Titanium alloys[1]		**Rm**[1]				
S4.1.Z.UT	23.1	Commercial pure (99,5% Ti)	1300	400	0.23	150 –145 –140	150-145-140	170-165-160
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	1400	950	0.23	65 –65 –65	65 –65 –65	75-75-70
S4.3.Z.AG	23.22	α + β alloys in aged cond., β 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/mm²	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		
		Extra hard steel						
H1.3.Z.HA	04.1	Hardened and tempered	4200	59 HRC	0.25	190 –180 –175	95 –90 –85	45 -45 -45
		Chilled cast iron						
H2.0.C.UT	10.1	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.

ENG

GC1025	GC1130	H10F	H13A							
Max chip thickness, h_{ex} mm										
0.1-0.15-0.2	0.1-0.15-0.2	0.1-0.15-0.2	0.1-0.15-0.2							
Cutting speed v_c, m/min										
1100 –1100 –1050 1000 –980 –970	1100 –1100 –1050 1000 –980 –970	1050 –1050 –1000 950 –940 –920	850 –830 –820 760 –750 –740							
1100 –1100 –1050 110 –1100 –1100	1100 –1100 –1050 1100 –1100 –1100	1050 –1050 –1000 950 –940 –920	850 –830 –820 760 –750 –740							
1100 –1100 –1100	1100 –1100 –1100	1050 –1050 –1050	850 –840 –825							
445 –440 –430 335 –330 –325	445 –440 –430 335 –330 –325	425 –420 –410 320 –315 –310	340 –335 –330 255 –250 –245							
560 –550 –540 560 –550 –540 390 –380 –375	560 –550 –540 560 –550 –540 390 –380 –375	530 –520 –510 530 –520 –510 370 –365 –360	425 –415 –410 425 –415 –410 295 –290 –285							

H13A	H10F	S30T	S40T	GC2030	GC2040					
Max chip thickness, h_{ex} mm										
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					
Cutting speed v_c, m/min										
65-65-65 50-50-50	60 –60 –60 45 –45 –40	– –	– –	65 –65 –65 50 –50 –45	70 –65 –65 50 –50 –45					
65-65-60 40-39-38 50-50-50	60 –55 –55 36 –35 –33 45 –45 –40	– – –	– – –	65 –60 –60 40 –38 –38 50 –45 –45	65 –65 –60 40 –39 –38 50 –50 –45					
28-27-26 20-19-19 19-19-18	26 –24 –23 18 –17 –16 17 –16 –16	– – –	– – –	28 –27 –26 20 –19 –19 19 –18 –17	28 –27 –26 20 –19 –19 19 –18 –17					
140-140-135 55-55-55 45-40-40	130 –125 –120 50 –50 –45 38 –37 –36	170 –165 –160 75 -75 -70 65 –60 –66	145 –145 –140 55-50-50 45-45-45	140 –135 –130 55-55-55 50 –45 –45	145 –140 –135 50 –50 –50 45 –40 –40					

GC4220	GC3040	GC1010	GC1130							
Max chip thickness, h_{ex} mm										
0.1-0.12-0.25	0.1-0.2-0.25	0.07-0.12-0.2	0.07-0.12-0.2							
Cutting speed v_c, m/min										
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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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)

ENG

Face milling tools

CoroMill® 415

Ordering code	Feed per tooth, f_z mm/tooth Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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)

ENG

Shoulder milling tools

CoroMill® 390

Ordering code	Feed per tooth, f_z mm/tooth Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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)

ENG

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)

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

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-043505M-PM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-054508M-PM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-084508M-PM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-115008M-PM	0.15	(0.06-0.3)	0.13	(0.05-0.25)
N331.1A-145008M-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)

Profile milling tools

CoroMill® 300

Ordering code	Feed per tooth, f_z mm/tooth Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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)

ENG

Profile milling tools

CoroMill® 300

Ordering code	Feed per tooth, f_z mm/tooth Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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)
RCKT1204MO	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)
RCKT1606MO	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)

ENG

Groove milling tools

CoroMill® 327

Ordering code	Feed per tooth, f_z mm/tooth Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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

ENG

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

ENG

Thread milling tools

CoroMill® 328

Ordering code	Feed per tooth, f_z mm/tooth Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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 Starting value	(min.- max.)	Max chip thickness, h_{ex} mm 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)

ENG

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

K 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_3N_4)
Boron nitride:
BN Polycrystalline boron nitride[1)]
[1)] 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[1)]

1) Polycrystalline diamond and polycrystalline boron nitride are also named superhard cutting materials.

ENG

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_3N_4)

Boron nitride:

BN Polycrystalline boron nitride[1)]

[1)] 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

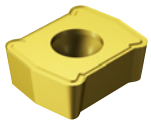
Drilling is often carried out late in the manufacturing process, after previous operations have already enhanced the initial component's value. The drilling application, although seemingly simple, is a complex operation that can have significant consequences if the tool malfunctions or is run beyond 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.

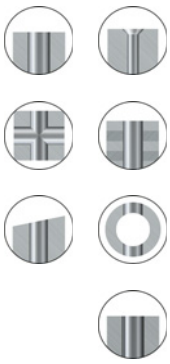
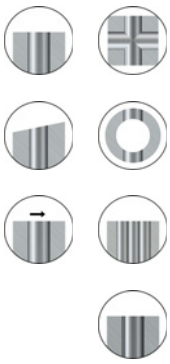
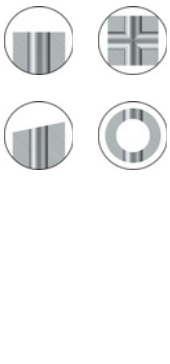
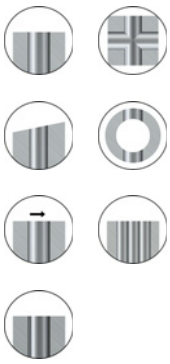
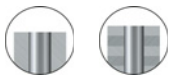
Important factors to consider:
- If drilling holes deeper than 6xD with CoroDrill 870 use a piloting operation
- Ensure that coolant flow is sufficient to evacuate chips
- Adjust your cutting data to obtain satisfactory chips, a stable process and ultimately reaching the demands of your hole

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)

	870	DS20	880	880	R416.7	R416
						
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	P M K N S	P M K N S H	P M K N S H	P M K N S H	P M K N S H	P M K N S H
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	**J4**	**J26**	**J34**	**J34**	**J44**	**J47**

Application

CoroDrill® 870

Secure and predictable holemaking process

ISO application area:

J

P M K N S

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 savinging 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.

K

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

L

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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

M

- PM optimized for ISO-P
- MM optimzed 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)

N

H9 - H10

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

J6

J8

N6

CoroDrill® 870

Geometry overview

Geometry		Geometry information
PM		-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.
MM		-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.
KM		-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.
GP		-GP is intended for piloting applications. It is based upon the PM geometry but has a larger point angle and different tolerance class.

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

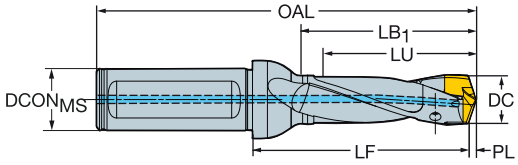
GC2334

- New thin multi-layer PVD coating (AlTiCrN) with improved resistance against flaking and chipping on secondary edge.
- A though 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



DCN	DCX		LU	CZC$_{MS}$	TCHA	Ordering code	Dimensions, mm DCON$_{MS}$	LF	OAL	LB$_1$	PL	BAR	KG	RPMX	MIID$_P$
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

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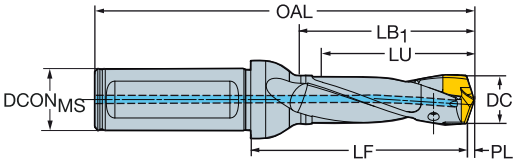
ENG

CoroDrill® 870 exchangeable tip drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



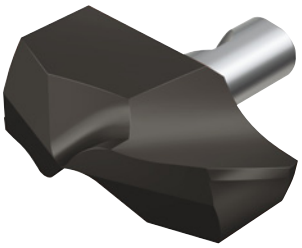
DCN	DCX		LU	CZC_{MS}	TCHA	Ordering code	Dimensions, mm $DCON_{MS}$	LF	OAL	LB_1	PL	BAR	KG	RPMX	$MIID_P$
21.00	21.99	21	69.30	25	H9	870-2100-21L25-3	25.00	89.68	149.00	72.00	3.32	10	0.450	21500	870-2190-21-PM
21.00	21.99	21	113.28	25	H9	870-2100-21L25-5	25.00	133.68	193.00	116.00	3.32	10	0.508	12000	
21.00	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	

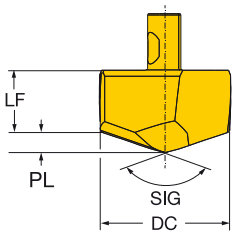
	Spare parts		Spare parts
	Insert screw		Insert screw
6	5513 031-15	19	5513 031-13
7	5513 031-15	20	5513 031-14
8	5513 031-15	21	5513 031-14
9	5513 031-15	22	5513 031-14
10	5513 031-12	23	5513 031-14
11	5513 031-12	24	5513 031-16
12	5513 031-12	25	5513 031-16
13	5513 031-12	26	5513 031-16
14	5513 031-12	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

J8 L2 N23 N6 N15

CoroDrill® 870 drill tip





DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm 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

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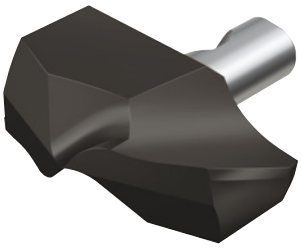
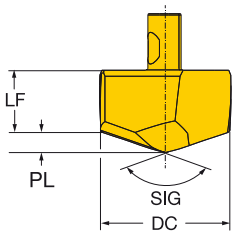
CoroDrill® 870 drill tip





DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm LF	PL	SIG	TCHA
11.00	8	870-1100-8-PM		★		☆		☆	☆		☆	5.2	1.7	142°	H9
11.00		870-1100-8-MM			★					☆		5.2	1.7	142°	H9
11.00		870-1100-8-KM	☆				★					4.9	2.0	142°	H9
11.00		870-1100-8-GP		★		★		★	☆		☆	5.2	1.2	152°	F9
11.10		870-1110-8-PM		★		☆		☆	☆		☆	5.2	1.7	142°	H9
11.10		870-1110-8-MM			★					☆		5.2	1.7	142°	H9
11.10		870-1110-8-KM	☆				★					4.9	2.0	142°	H9
11.10		870-1110-8-GP		★		★		★	☆		☆	5.2	1.2	152°	F9
11.11		870-1111-8-PM		★		☆		☆	☆		☆	5.2	1.7	142°	H9
11.11		870-1111-8-MM			★					☆		5.2	1.7	142°	H9
11.11		870-1111-8-KM	☆				★					4.9	2.0	142°	H9
11.11		870-1111-8-GP		★		★		★	☆		☆	5.2	1.2	152°	F9
11.20		870-1120-8-PM		★		☆		☆	☆		☆	5.2	1.7	142°	H9
11.20		870-1120-8-MM			★					☆		5.2	1.7	142°	H9
11.20		870-1120-8-KM	☆				★					4.9	2.0	142°	H9
11.20		870-1120-8-GP		★		★		★	☆		☆	5.2	1.2	152°	F9
11.30		870-1130-8-PM		★		☆		☆	☆		☆	5.2	1.7	142°	H9
11.30		870-1130-8-MM			★					☆		5.2	1.7	142°	H9
11.30		870-1130-8-KM	☆				★					4.9	2.0	142°	H9
11.30		870-1130-8-GP		★		★		★	☆		☆	5.2	1.2	152°	F9
11.40		870-1140-8-PM		★		☆		☆	☆		☆	5.2	1.8	142°	H9
11.40		870-1140-8-MM			★					☆		5.2	1.8	142°	H9
11.40		870-1140-8-KM	☆				★					4.9	2.0	142°	H9
11.40		870-1140-8-GP		★		★		★	☆		☆	5.2	1.2	152°	F9
11.50	9	870-1150-9-PM		★		☆		☆	☆		☆	5.1	1.8	142°	H9
11.50		870-1150-9-MM			★					☆		5.1	1.8	142°	H9
11.50		870-1150-9-KM	☆				★					4.8	2.1	142°	H9
11.50		870-1150-9-GP		★		★		★	☆		☆	5.2	1.2	152°	F9
11.60		870-1160-9-PM		★		☆		☆	☆		☆	5.1	1.8	142°	H9
11.60		870-1160-9-MM			★					☆		5.1	1.8	142°	H9
11.60		870-1160-9-KM	☆				★					4.8	2.1	142°	H9
11.60		870-1160-9-GP		★		★		★	☆		☆	5.2	1.3	152°	F9
11.70		870-1170-9-PM		★		☆		☆	☆		☆	5.1	1.8	142°	H9
11.70		870-1170-9-MM			★					☆		5.1	1.8	142°	H9
11.70		870-1170-9-KM	☆				★					4.8	2.2	142°	H9
11.70		870-1170-9-GP		★		★		★	☆		☆	5.1	1.3	152°	F9
11.80		870-1180-9-PM		★		☆		☆	☆		☆	5.1	1.8	142°	H9
11.80		870-1180-9-MM			★					☆		5.1	1.8	142°	H9
11.80		870-1180-9-KM	☆				★					4.7	2.2	142°	H9
11.80		870-1180-9-GP		★		★		★	☆		☆	5.1	1.3	152°	F9
11.90		870-1190-9-PM		★		☆		☆	☆		☆	5.1	1.8	142°	H9
11.90		870-1190-9-MM			★					☆		5.1	1.8	142°	H9
11.90		870-1190-9-KM	☆				★					4.7	2.2	142°	H9
11.90		870-1190-9-GP		★		★		★	☆		☆	5.1	1.3	152°	F9

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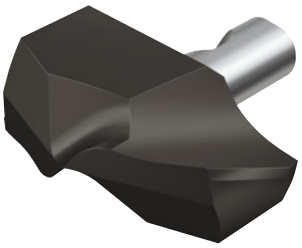
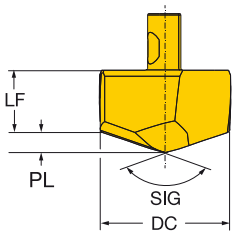
CoroDrill® 870 drill tip





DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm 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

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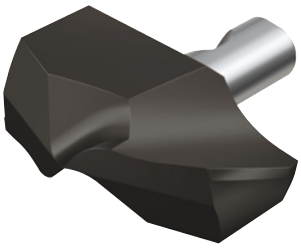
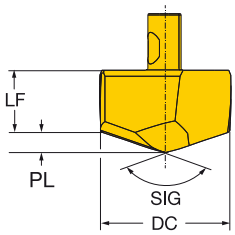
CoroDrill® 870 drill tip





DC		Ordering code	P		M		K		N	S		Dimensions, mm			
			3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	PL	SIG	TCHA
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

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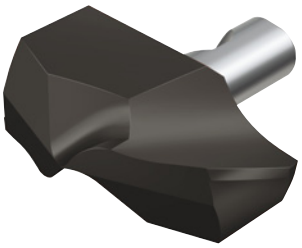
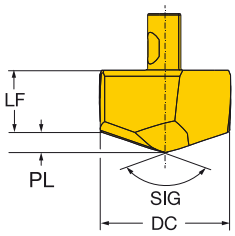
CoroDrill® 870 drill tip





DC		Ordering code	P		M		K		N	S		Dimensions, mm			
			3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	PL	SIG	TCHA
14.00	14	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

J6 J50 J5 N23 N6

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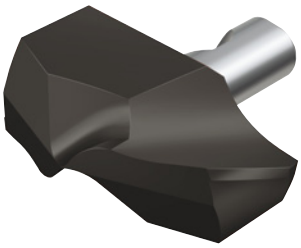
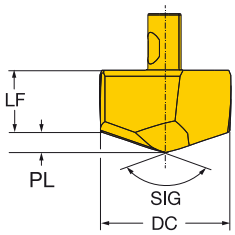
CoroDrill® 870 drill tip

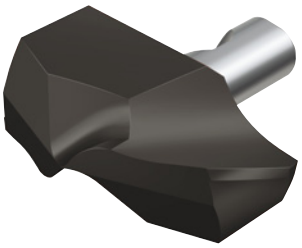


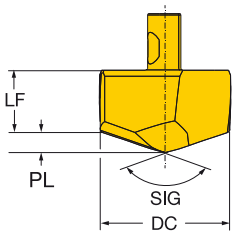


DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm LF	PL	SIG	TCHA
15.00	15	870-1500-15-PM		★		☆		☆	☆		☆	7.0	2.3	142°	H9
15.00		870-1500-15-MM			★					☆		7.0	2.3	142°	H9
15.00		870-1500-15-KM	☆				★					6.5	2.8	142°	H9
15.00		870-1500-15-GP		★		★		★	☆		☆	7.2	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	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm LF	PL	SIG	TCHA
16.00	16	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

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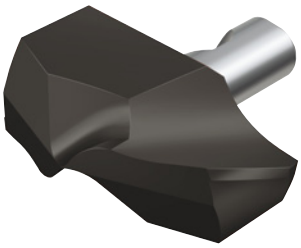
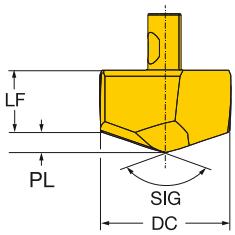
ENG

CoroDrill® 870 drill tip

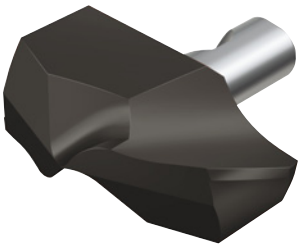


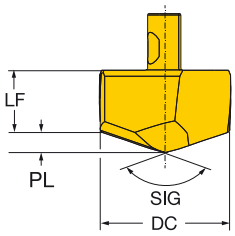


DC		Ordering code	P		M		K		N	S		Dimensions, mm			
			3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	PL	SIG	TCHA
17.00	17	870-1700-17-PM		★		☆		☆	☆		☆	8.0	2.6	142°	H9
17.00		870-1700-17-MM			★					☆		8.0	2.6	142°	H9
17.00		870-1700-17-KM	☆				★					7.4	3.2	142°	H9
17.00		870-1700-17-GP		★		★		★	☆		☆	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 N6

CoroDrill® 870 drill tip





DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm LF	PL	SIG	TCHA
18.00	18	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

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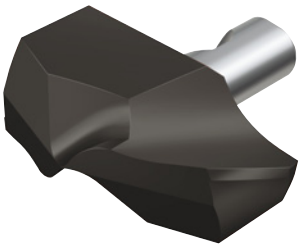
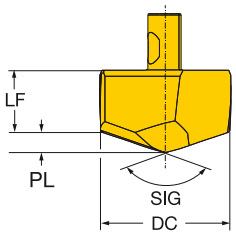
ENG

CoroDrill® 870 drill tip





DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm LF	PL	SIG	TCHA
19.00	19	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

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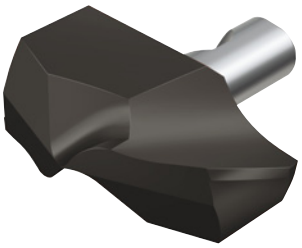
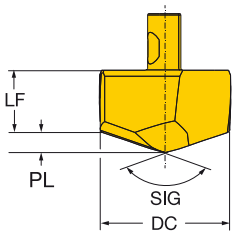
CoroDrill® 870 drill tip





DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm LF	PL	SIG	TCHA
20.00	20	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

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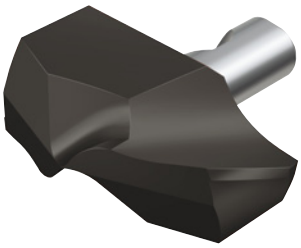
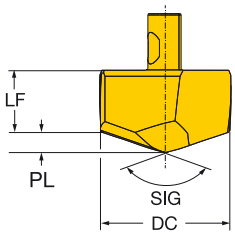
SANDVIK Coromant

ENG

CoroDrill® 870 drill tip

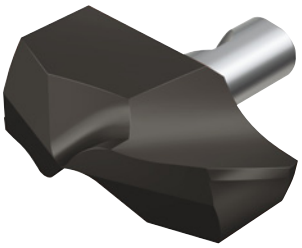


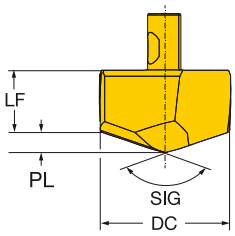


DC		Ordering code	P		M		K		N	S		Dimensions, mm			
			3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	PL	SIG	TCHA
21.00	21	870-2100-21-PM		★		☆		☆	☆		☆	10.0	3.2	142°	H9
21.00		870-2100-21-MM			★					☆		10.0	3.2	142°	H9
21.00		870-2100-21-KM	☆				★					9.2	4.0	142°	H9
21.00		870-2100-21-GP		★		★		★	☆		☆	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 N23 N6

CoroDrill® 870 drill tip





DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm LF	PL	SIG	TCHA
22.00	22	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

J6 J50 J5 N23 N6

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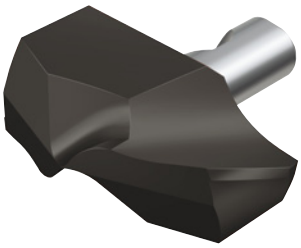
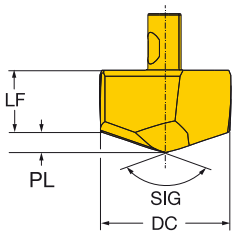
CoroDrill® 870 drill tip





DC		Ordering code	P		M		K		N	S		Dimensions, mm			
			3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	PL	SIG	TCHA
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

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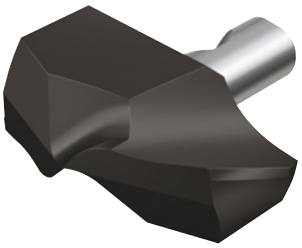
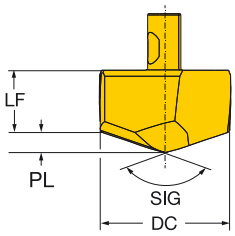
CoroDrill® 870 drill tip





DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm LF	PL	SIG	TCHA
24.00	24	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

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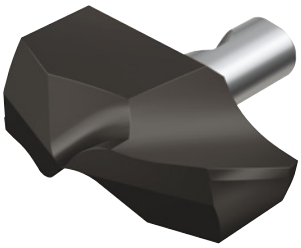
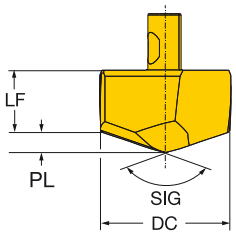
ENG

CoroDrill® 870 drill tip

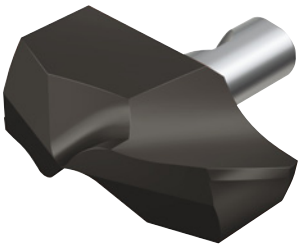


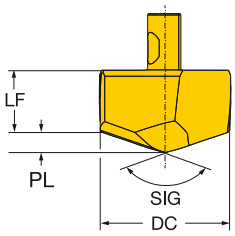


DC		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm LF	PL	SIG	TCHA
25.00	25	870-2500-25-PM		★		☆		☆	☆		☆	11.9	3.8	142°	H9
25.00		870-2500-25-MM			★					☆		11.9	3.8	142°	H9
25.00		870-2500-25-KM	☆				★					10.9	4.8	142°	H9
25.00		870-2500-25-GP		★		★		★	☆		☆	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





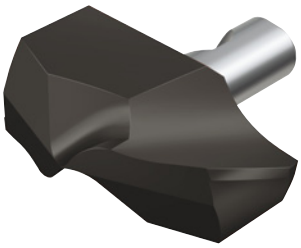
DC		Ordering code	P		M		K		N	S		Dimensions, mm			
			3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	PL	SIG	TCHA
27.00	27	870-2700-27-PM		★		☆		☆	☆		☆	13.0	4.1	142°	H9
27.00		870-2700-27-MM			★					☆		13.0	4.1	142°	H9
27.00		870-2700-27-KM	☆				★					11.8	5.2	142°	H9
27.00		870-2700-27-GP		★		★		★	☆		☆	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

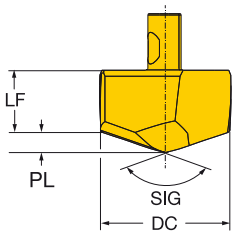
J6 J50 J5 N23 N6

SANDVIK Coromant

ENG

CoroDrill® 870 drill tip





DC		Ordering code	P		M		K		N	S		Dimensions, mm			
			3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	PL	SIG	TCHA
31.00	31	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

J

ISO application area

P M K N S H

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

K

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

L

www.sandvik.coromant.com/corodrillds20

M

Drill bodies

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

Inserts

- Inserts with optimized geometries for all materials

N

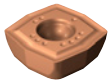
		Achievable lower tolerance (TCHAL)				Achievable upper tolerance (TCHAU)			
D_c min mm	D_c max mm	4xD	5xD	6xD	7xD	4xD	5xD	6xD	7xD
15.00	18.00	0	0	-0.1	-0.1	0.27	0.27	0.4	0.4
18.01	30.00	0	0	-0.1	-0.1	0.33	0.33	0.4	0.4
30.01	40.00	0	0	-0.1	-0.1	0.39	0.39	0.4	0.4

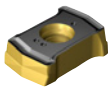
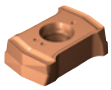
J28 J33 N6

Insert overview

Central insert			Geometry information
L5		P M N S H	- Long-chipping materials - Hardened steel - Low to medium feed - Light cutting
M7		P K	- Short-chipping material - Low to high feed - Strong reinforced edge

Peripheral insert			Geometry information
M7W		P K H	- First choice in short chipping materials - Low to high feed - Strong reinforced edge
L5W		P M N S	- Long-chipping materials - Low to medium feed - Light cutting
H5W		P M	- Complementary for long-chipping materials - Low to medium feed - Negative T-land - High cutting forces
S5W		M N S	- Sharp and extremely light cutting - Low feed
L6W		P M K N S H	- All-round geometry for mixed production - First choice in Inconel and hardened steel - Low to medium feed - Light cutting

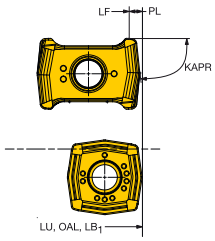
Central insert			Grade information
		P K S H	**GC1344** - PVD-coated with Zertivo® technology - Excellent wear resistance and toughness
		M S	**GC1144** - PVD-coated grade for all types of ISO M and titanium materials
		N S	**H13A** - Universal, tough and uncoated grade best for low to moderate cutting speeds - Complementary grade for ISO S

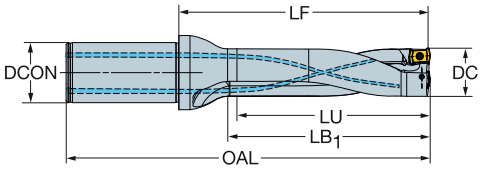
Peripheral insert			Grade information
		P M K H	**GC4334** - Good to average conditions - CVD coating with Inveio® technology provides a high level of wear resistance
		M S	**GC2044** - PVD-oxide coating for excellent wear resistance
		P M K N S H	**GC4344** - PVD-coating with Zertivo® technology - Tough and demanding operations - Provides good edge-line properties and reliable tool life
		P K	**GC4324** - MT-CVD coating with Inveio® technology - Productive choice in stable conditions
		N S	**H13A** - Universal, tough and uncoated grade best for low to moderate cutting speeds - Complementary grade for ISO S

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply





DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
15.00	01C	01P	60.00	20	1.00	0.00	0.27	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	0.27	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	0.40	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	0.40	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	0.27	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	0.27	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	0.40	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	0.40	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	0.27	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	0.27	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	0.40	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	0.40	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	0.27	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	0.27	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	DS20-D2500L25-07	25.00	200.53	257.00	179.00	0.66	81°	10	0.603	4000

	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

J33 N23 N15

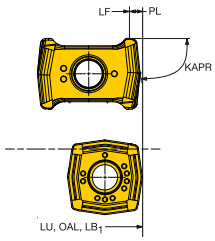
SANDVIK Coromant

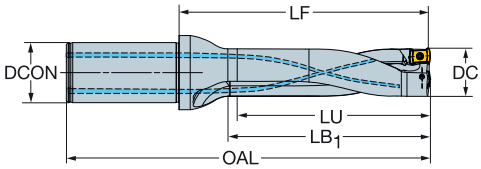
ENG

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply





DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm $DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
26.00	03C	03P	104.00	32	0.70	0.00	0.33	DS20-D2600L32-04	32.00	133.53	194.00	108.00	0.66	81°	10	0.600	14000
			130.00	32	0.70	0.00	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.33	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	0.33	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	0.40	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	0.40	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	0.35	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	0.35	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	0.40	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	0.40	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	0.35	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	0.35	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	0.40	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	0.40	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	0.35	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	0.35	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	0.40	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	0.40	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	0.35	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	0.35	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	0.40	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	0.40	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	0.35	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	0.35	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	0.40	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	0.40	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	0.35	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	0.35	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	0.40	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	0.40	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

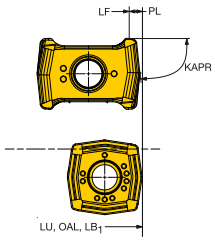
For complete list of spare parts, see www.sandvik.coromant.com

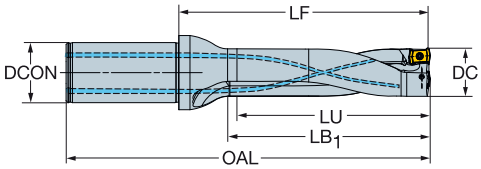
J33 N23 N15

CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply





DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm DCON$_{MS}$	LF	OAL	LB$_1$	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

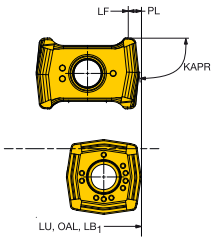
J33 N23 N15

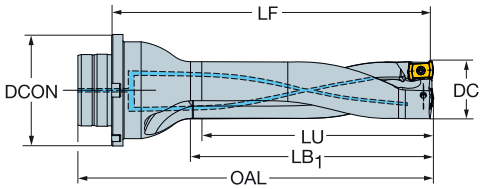
ENG

CoroDrill® DS20 indexable insert drill

Modular drill interface

Internal coolant supply





DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
									Dimensions, mm								
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

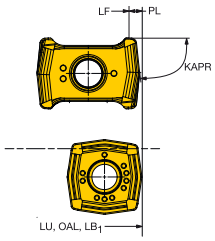
For complete list of spare parts, see www.sandvik.coromant.com

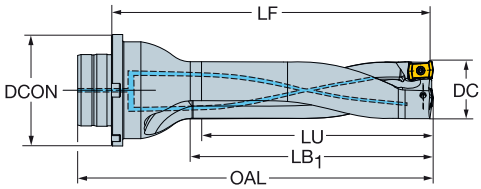
J33 N23 N15

CoroDrill® DS20 indexable insert drill

Modular drill interface

Internal coolant supply





DC	05P	05P	LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
									Dimensions, mm								
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

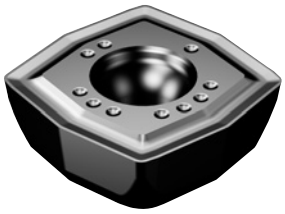
	Spare parts
DC	Insert screw
15.00-18.00	5513 020-27
18.01-22.00	5513 020-88
22.01-27.00	5513 020-58
27.01-33.00	5513 020-57
33.01-40.00	416.1-833
40.01-59.00	416.1-834

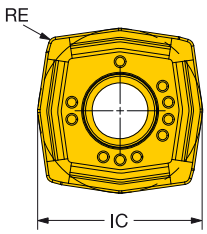
For complete list of spare parts, see www.sandvik.coromant.com

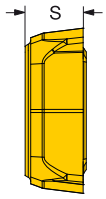
J33 N23 N15

CoroDrill® DS20 insert for drilling

Central insert

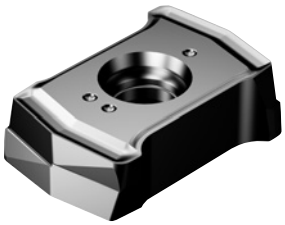


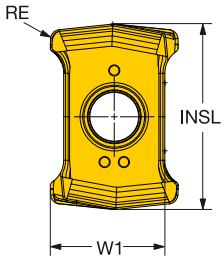


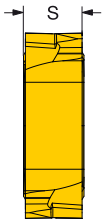


INSUC		Ordering code	P		M	K	N		S		H	Dimensions, mm		
			1344	1144	1344	H13A	1344	1344	H13A	1344		S	RE	IC
01C	C	DS20-0104-C-L5	★	★		★	☆	★	☆	★		2.30	0.35	6.0
01C	C	DS20-0104-C-M7	★		★					☆		2.30	0.35	6.0
02C	C	DS20-0205-C-L5	★	★		★	☆	★	☆	★		2.60	0.35	7.3
02C	C	DS20-0205-C-M7	★		★					☆		2.60	0.35	7.3
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	4344	2044	4334	4344	4324	4334	4344	4344	H13A	2044	4344	H13A	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

P M K N S H

K

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

L

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/corodrill880

M

Drill bodies

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

Inserts

- Inserts with optimized geometries for all materials

N

2 – 3 x DC

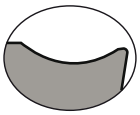
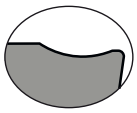
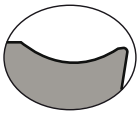
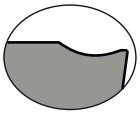
Diameter range, mm	12.00-43.99	44.00-52.99	53.00-63.50
Hole tolerance, mm	0/+0.25	0/+0.28	0/+0.30

J36 J42 N6

SANDVIK Coromant

CoroDrill® 880

Geometry overview

Geometry		Geometry information
LM		- First choice in low carbon steel - A versatile geometry with an all-around chip breaker - Operates best at low to medium feeds - Provides low cutting forces
GR		- First choice in alloyed steel and cast irons - Operates best at medium to high feeds
MS		- First choice in stainless and non-ferrous materials - Sharp edge allowing low cutting forces
GM		- Low cutting forces - Low to medium feed

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

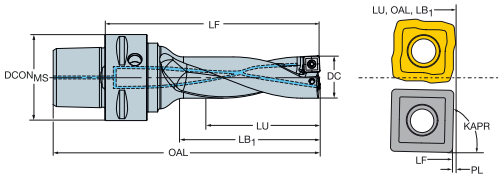
H13A

- Uncoated grade

CoroDrill® 880 indexable insert drill

Coromant Capto®

DSGN 1



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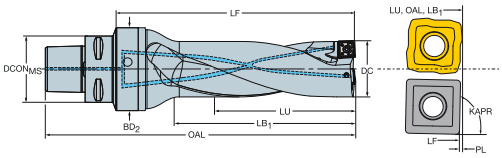


										Dimensions, mm									
DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	DSGN	Ordering code	DCON$_{MS}$	LF	OAL	LB$_1$	BD2	PL	KAPR	BAR	KG	RPMX
12.00	01C	01P	36.00	C4	0.25	0.00	0.25	1	880-D1200C4-03	40.00	70.61	95.00	39.00		0.38	79°	10	0.343	33000
12.50	01C	01P	38.00	C4	0.25	0.00	0.25	1	880-D1250C4-03	40.00	72.61	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
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

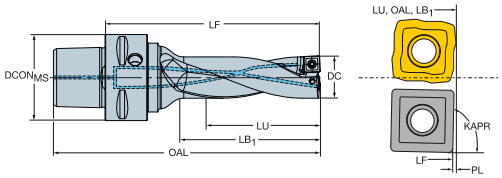
J42 L2 J62 J35 N23 N6 N15

SANDVIK Coromant

CoroDrill® 880 indexable insert drill

Coromant Capto®

DSGN 1



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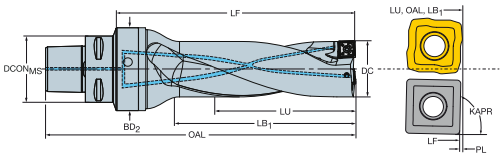


DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	DSGN	Ordering code	Dimensions, mm DCON$_{MS}$	LF	OAL	LB$_1$	BD2	PL	KAPR	BAR	KG	RPMX
25.00	05C	05P	75.00	C4	1.00	0.00	0.25	1	880-D2500C4-03	40.00	118.48	143.00	79.00		0.51	88°	10	0.526	16000
			75.00	C5	1.00	0.00	0.25	1	880-D2500C5-03	50.00	118.48	149.00	79.00		0.51	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
32.00	06C	06P	96.00	C5	0.87	0.00	0.25	1	880-D3200C5-03	50.00	143.39	174.00	100.00		0.60	88°	10	1.020	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
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
35.00	06C	06P	105.00	C5	0.50	0.00	0.25	1	880-D3500C5-03	50.00	154.37	185.00	109.00		0.62	88°	10	1.160	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
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
38.00	07C	07P	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
			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
39.00	07C	07P	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
41.00	07C	07P	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
			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
42.00	07C	07P	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

DC		Spare parts 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

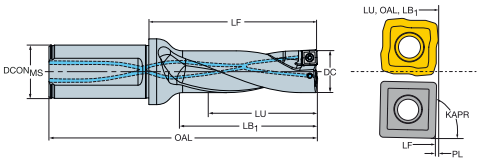
For complete list of spare parts, see www.sandvik.coromant.com

J42 L2 J62 J35 N23 N6 N15

CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
									Dimensions, mm								
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
20.90	04C	04P	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
22.00	04C	04P	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
			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
22.50	04C	04P	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
23.00	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
23.90	04C	04P	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
24.00	05C	05P	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
25.00	05C	05P	50.00	25	1.00	0.00	0.25	880-D2500L25-02	25.00	73.48	130.00	54.00	0.51	88°	10	0.400	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

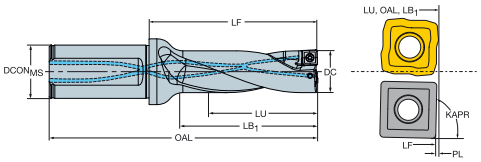
J42 L2 J62 J35 N23 N6 N15

SANDVIK Coromant

CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
									Dimensions, mm								
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

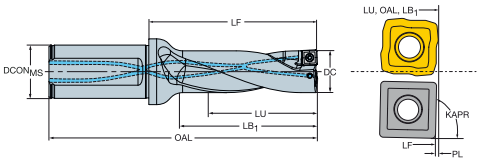
N6

N15

CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply



DC			LU	CZC$_{MS}$	ADJLX	TCHAL	TCHAU	Ordering code	DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
									Dimensions, mm								
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

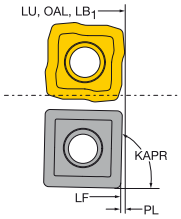
DC		Spare parts Insert screw
12.00-16.00	01-02	5513 020-28
16.50-19.50	03	5513 020-33
20.00-23.90	04	5513 020-58
24.00-28.50	05	5513 020-57
30.00-41.00	06-07	416.1-833
44.00-63.00	08-09	416.1-834

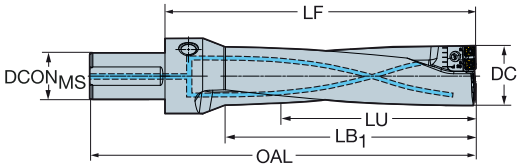
For complete list of spare parts, see www.sandvik.coromant.com

J42 L2 J62 J35 N23 N6 N15

CoroDrill® 880 indexable insert drill

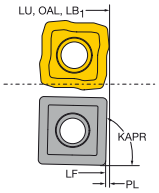
Internal coolant supply

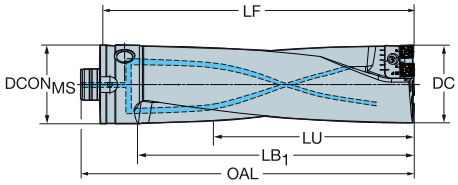




Cylindrical shank with flat according to ISO 9766

DC	C	I	I	P	LU	CZC$_{MS}$	TCHAL	TCHAU	Ordering code	DCON$_{MS}$	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
										Dimensions, mm								
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

DC	C	I	I	P	LU	CZC$_{MS}$	TCHAL	TCHAU	Ordering code	DCON	LF	OAL	LB$_1$	PL	KAPR	BAR	KG	RPMX
										Dimensions, mm								
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

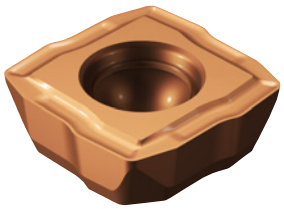
N6

N15

J48

CoroDrill® 880 insert for drilling

Central insert



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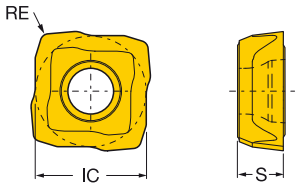

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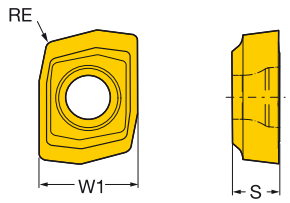


		INSUC	Ordering code	P	M		K	N			S			H	Dimensions, mm			
				1044	1044	1144	1044	1044	H13A	N134	1044	1144	H13A	1044	S	RE	IC	W1
Medium feed	01C	C	880-01 02 03H-C-LM	★	☆	★	★	☆		★	★	☆	☆	☆	2.20	0.30		4.8
	02C	C	880-02 02 04H-C-GM	☆	☆		☆	☆			☆			★	2.40	0.40	4.9	
		C	880-02 02 04H-C-LM	★	☆	★	★	☆	☆	★	★	☆	☆	☆	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

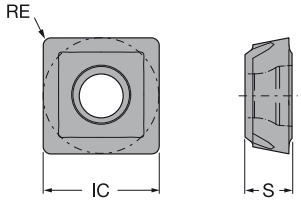
SANDVIK Coromant

ENG

CoroDrill® 880 insert for drilling

Peripheral insert

880..P



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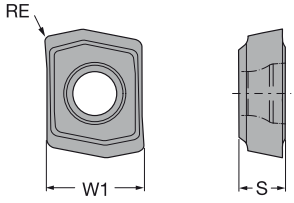


		INSUC	Ordering code	P			M			K			N			S			H		Dimensions, mm			
				4324	4334	4344	2044	4334	4344	4324	4334	4344	4344	H13A	N124	2044	4344	H13A	4334	4344	S	RE	IC	W1
Medium feed	01P	P	880-01 02 W04H-P-LM	☆	★	☆		☆	☆	☆	★	☆	☆				★		☆	☆	2.20	0.40		4.8
		P	880-01 02 W04H-P-MS				★								★	★					2.20	0.40		4.8
	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:

P M K N S

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

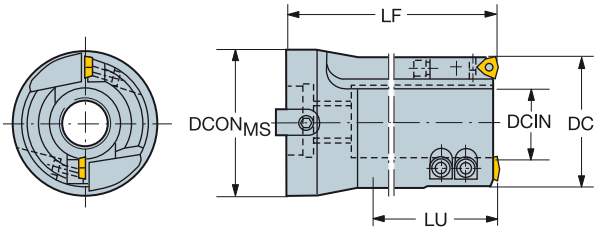
SANDVIK Coromant

ENG

Trepanning tool

VL coupling

Internal coolant supply



DC	DCIN		LU	CZC$_{MS}$	TCHAL	TCHAU	Ordering code	Dimensions, mm DCON$_{MS}$	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

Accessories

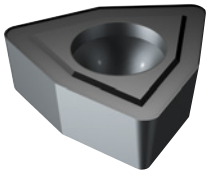
Cartridge for trepanning tool			
Inner	**Insert**	**Peripheral**	**Insert**
L430.23-1117-06	WCMX 06	R430.26-1114-06	WCMX 06

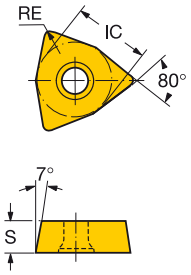
Cartridge for stack drilling with trepanning tool			
Inner	**Insert**	**Peripheral**	**Insert**
L430.23-1117-06SD	WCMX 06	R430.26-1114-06SD	WCMX 06

Accessories, must be ordered separately

J46 L2 N23 N15

Trepanning inserts





		INSUC	Ordering code	P				M				K				N		S		Dimensions, mm		
				1020	235	3040	4235	1020	235	3040	4235	1020	1125	3040	4235	1020	H13A	1020	H13A	S	RE	IC
Medium feed	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

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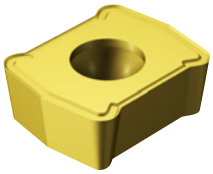
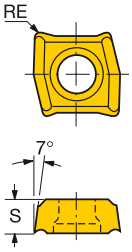
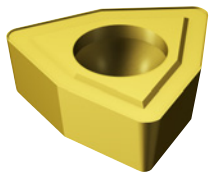
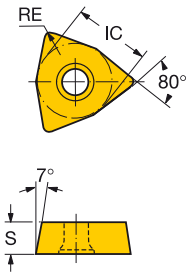
Coromant U insert for drilling





		INSUC	Ordering code	P				M				K			N			S			H			Dimensions, mm	
				1020	1120	235	3040	1020	1120	235	3040	1020	1120	3040	1020	1120	H13A	1020	1120	H13A	1020	1120	3040	S	RE
Medium feed	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
	03	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
		P+C	LCMX 03 03 08T-53	☆								☆									☆			3.18	0.80
	04	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





		INSUC	Ordering code	P					M				K				N		S		H		Dimensions, mm		
				1020	1125	235	3040	4235	1020	235	3040	4235	1020	1125	235	3040	4235	1020	H13A	1020	H13A	1020	3040	S	RE	IC
Medium feed	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

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N23

CoroDrill® 880 large diameter drill

Insert to cartridge correlation

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

		Included parts			
		Drill body		Cartridge	
DC	**Ordering code**	3xD	4xD	Central	Peripheral
65	880-D0650xxx-xx				880-D0650-P
66	880-D0660xxx-xx	880-D065-069L50-3	880-D065-069L50-4		880-D0660-P
67	880-D0670xxx-xx	880-D065-069LX50-3	880-D065-069LX50-4	880-D0650-C	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-D0710-P
72	880-D0720xxx-xx	880-D070-074LX50-3	880-D070-074LX50-4	880-D0700-C	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-D0760-P
77	880-D0770xxx-xx	880-D075-079LX50-3	880-D075-079LX50-4	880-D0750-C	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-D080-084V80-3	880-D080-084LX63-4 880-D080-084V80-4	880-D0800-C	880-D0820-P
83	880-D0830xxx-xx				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

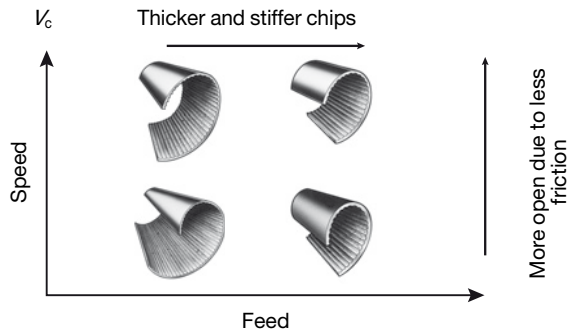
Cutting speed that is too high:
Rapid flank wear
Plastic deformation
Poor hole quality and bad hole tolerance

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_c) m/min correlating with drill diameter 10.00-20.99 mm Min.	Rec.	Max.	21.00-33.00 mm Min.	Rec.	Max.
P			**Unalloyed steel**				Grade 4334			
	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
			Low alloy steel				Grade 4334 and 3334			
	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
			High alloy steel							
	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			**Ferritic/martensitic stainless steel**				Grade 4334 and 2334			
	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
			Austenitic stainless steel				Grade 2334 and 4334			
	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
			Super-austenitic (Ni≥20%) stainless steel							
	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
			Duplex (austenitic/ferritic) stainless steel							
	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			**Malleable cast iron**				Grade 3334 and 4334			
	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
			Grey cast iron							
	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
			Nodular cast iron							
	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			**Aluminium based alloys**				Grade 4334			
	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			**Heat resistant super alloys**				Grade 2334 and 4334			
	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

SANDVIK Coromant

ENG

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.
Geometry -PM and -GP																	
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
Geometry -PM. -KM and -GP																	
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
Geometry -PM, -MM and -GP																	
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
Geometry -MM, PM and -GP																	
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
Geometry -MM and -GP																	
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
Geometry -KM, PM and -GP																	
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
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
Geometry -PM and -GP																	
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
Geometry -MM, -PM and -GP																	
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_c) m/min correlating with drill diameter 10.00-20.99mm Min.	Rec.	Max.	21.00-33.00mm Min.	Rec.	Max.
P			**Unalloyed steel**				Grade 4334			
	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
			Low alloy steel				Grade 4334 and 3334			
	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
			High alloy steel							
	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			**Ferritic/martensitic stainless steel**				Grade 4334 and 2334			
	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
			Austenitic stainless steel				Grade 2334 and 4334			
	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
			Super-austenitic (Ni≥20%) stainless steel							
	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
			Duplex (austenitic/ferritic) stainless steel				Grade 2334			
	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			**Malleable cast iron**				Grade 3334 and 4334			
	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
			Grey cast iron							
	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
			Nodular cast iron							
	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			**Aluminium based alloys**				Grade 4334			
	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			**Heat resistant super alloys**				Grade 2334 and 4334			
	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

SANDVIK Coromant

ENG

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.
Geometry -PM																	
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
Geometry -PM and -KM																	
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
Geometry -PM and -MM																	
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
Geometry -MM and -PM																	
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
Geometry -MM																	
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
Geometry -KM and -PM																	
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
Geometry -PM																	
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
Geometry -MM and -PM																	
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 4-5xD Min.	Rec.	Max.	Drill diameter	Drill length 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
P									f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev	f_n mm/rev
	P1.0.Z.AN	Unalloyed steel C=0.05-0.10%	110	4324	230	340	400	15.00-18.00	0.04-0.08	**0.04-0.08**	0.04-0.08	-	0.04-0.1	0.04-0.07	**0.04-0.07**	0.04-0.07	-	0.04-0.09
				4334	210	285	325	18.01-22.00	0.04-0.09	**0.04-0.09**	0.04-0.09	-	0.04-0.11	0.04-0.08	**0.04-0.08**	0.04-0.08	-	0.04-0.1
				4344	190	225	245	22.01-27.00	0.04-0.1	**0.04-0.1**	0.04-0.1	-	0.04-0.12	0.04-0.09	**0.04-0.09**	0.04-0.09	-	0.04-0.11
								27.01-33.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.13	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.12
								33.01-40.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.16	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.14
								40.01-52.00	0.06-0.12	**0.06-0.12**	0.06-0.12	-	0.06-0.16	0.06-0.11	**0.06-0.11**	0.06-0.11	-	0.06-0.14
								52.01-65.00	0.06-0.12	**0.06-0.12**	0.06-0.12	-	0.06-0.16	0.06-0.11	**0.06-0.11**	0.06-0.11	-	0.06-0.14
	P1.1.Z.AN	Unalloyed steel C=0.05-0.25%	125	4324	230	320	370	15.00-18.00	0.04-0.1	**0.04-0.1**	0.04-0.1	-	0.04-0.1	0.04-0.09	**0.04-0.09**	0.04-0.09	-	0.04-0.09
				4334	200	270	305	18.01-22.00	0.04-0.11	**0.04-0.11**	0.04-0.11	-	0.04-0.11	0.04-0.1	**0.04-0.1**	0.04-0.1	-	0.04-0.1
				4344	170	210	235	22.01-27.00	0.04-0.12	**0.04-0.12**	0.04-0.12	-	0.04-0.12	0.04-0.11	**0.04-0.11**	0.04-0.11	-	0.04-0.11
								27.01-33.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.13	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.12
								33.01-40.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.16	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.14
								40.01-52.00	0.06-0.14	**0.06-0.14**	0.06-0.14	-	0.06-0.16	0.06-0.13	**0.06-0.13**	0.06-0.13	-	0.06-0.14
								52.01-65.00	0.06-0.14	**0.06-0.14**	0.06-0.14	-	0.06-0.16	0.06-0.13	**0.06-0.13**	0.06-0.13	-	0.06-0.14
	P1.2.Z.AN	Unalloyed steel C=0.25-0.55%	190	4324	190	265	305	15.00-18.00	-	0.05-0.12	0.06-0.14	**0.06-0.16**	-	-	0.05-0.1	0.06-0.12	**0.06-0.14**	-
				4334	155	215	250	18.01-22.00	-	0.05-0.14	0.06-0.16	**0.06-0.18**	-	-	0.05-0.12	0.06-0.14	**0.06-0.15**	-
				4344	120	165	190	22.01-27.00	-	0.05-0.18	0.06-0.2	**0.06-0.22**	-	-	0.05-0.15	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	0.07-0.22	0.08-0.24	**0.08-0.26**	-	-	0.07-0.19	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	0.07-0.24	0.08-0.26	**0.08-0.28**	-	-	0.07-0.2	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
	P1.3.Z.AN	Unalloyed steel C=0.55-0.80%	190	4324	170	250	290	15.00-18.00	-	0.05-0.12	0.06-0.14	**0.06-0.16**	-	-	0.05-0.1	0.06-0.12	**0.06-0.14**	-
				4334	140	205	240	18.01-22.00	-	0.05-0.14	0.06-0.16	**0.06-0.18**	-	-	0.05-0.12	0.06-0.14	**0.06-0.15**	-
				4344	105	155	185	22.01-27.00	-	0.05-0.18	0.06-0.2	**0.06-0.22**	-	-	0.05-0.15	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	0.07-0.22	0.08-0.24	**0.08-0.26**	-	-	0.07-0.19	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	0.07-0.24	0.08-0.26	**0.08-0.28**	-	-	0.07-0.2	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	0.09-0.24	0.1-0.26	**0.1-0.28**	-	-	0.09-0.2	0.1-0.22	**0.1-0.24**	-
	P1.5.C.UT	Unalloyed steel Cast - untreated	150	4324	140	260	325	15.00-18.00	-	0.04-0.12	0.04-0.12	**0.04-0.12**	-	-	0.04-0.1	0.04-0.1	**0.04-0.1**	-
				4334	135	220	265	18.01-22.00	-	0.04-0.13	0.04-0.13	**0.04-0.13**	-	-	0.04-0.11	0.04-0.11	**0.04-0.11**	-
				4344	125	175	200	22.01-27.00	-	0.04-0.14	0.04-0.14	**0.04-0.14**	-	-	0.04-0.12	0.04-0.12	**0.04-0.12**	-
								27.01-33.00	-	0.05-0.15	0.05-0.15	**0.05-0.15**	-	-	0.05-0.13	0.05-0.13	**0.05-0.13**	-
								33.01-40.00	-	0.05-0.16	0.05-0.16	**0.05-0.16**	-	-	0.05-0.14	0.05-0.14	**0.05-0.14**	-
								40.01-52.00	-	0.06-0.16	0.06-0.16	**0.06-0.16**	-	-	0.06-0.14	0.06-0.14	**0.06-0.14**	-
								52.01-65.00	-	0.06-0.16	0.06-0.16	**0.06-0.16**	-	-	0.06-0.14	0.06-0.14	**0.06-0.14**	-
	P2.1.Z.AN	Low alloy steel Annealed	175	4324	180	260	305	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
				4334	150	215	250	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	115	165	190	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P2.2.Z.AN	Low alloy steel Annealed	240	4324	180	250	290	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
				4334	150	200	225	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	115	175	205	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P2.5.Z.HT	Low alloy steel Hardened and tempered	330	4324	90	190	245	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
				4334	85	155	195	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	75	125	150	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P2.6.C.UT	Low alloy steel Cast - untreated	200	4324	110	210	265	15.00-18.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4334	105	175	210	18.01-22.00	-	-	0.06-0.18	**0.06-0.2**	-	-	-	0.06-0.15	**0.06-0.17**	-
				4344	100	140	160	22.01-27.00	-	-	0.06-0.22	**0.06-0.24**	-	-	-	0.06-0.19	**0.06-0.2**	-
								27.01-33.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								33.01-40.00	-	-	0.08-0.28	**0.08-0.3**	-	-	-	0.08-0.24	**0.08-0.26**	-
								40.01-52.00	-	-	0.1-0.28	**0.1-0.3**	-	-	-	0.1-0.24	**0.1-0.26**	-
								52.01-65.00	-	-	0.1-0.28	**0.1-0.3**	-	-	-	0.1-0.24	**0.1-0.26**	-
	P3.0.Z.AN	High alloy steel Annealed	200	4324	160	245	290	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
				4334	130	200	240	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	100	150	180	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-

SANDVIK Coromant

ENG

CoroDrill® DS20

4 – 5 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 4-5xD			Drill diameter	Drill length 4xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 5xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
P	P3.0.Z.HT	High alloy steel	380	4324	80	165	210	15.00-18.00	-	-	0.06-0.14	**0.06-0.16**	-	-	-	0.06-0.12	**0.06-0.14**	-
		Hardened and tempered		4334	75	140	175	18.01-22.00	-	-	0.06-0.16	**0.06-0.18**	-	-	-	0.06-0.14	**0.06-0.15**	-
				4344	70	110	130	22.01-27.00	-	-	0.06-0.2	**0.06-0.22**	-	-	-	0.06-0.17	**0.06-0.19**	-
								27.01-33.00	-	-	0.08-0.24	**0.08-0.26**	-	-	-	0.08-0.2	**0.08-0.22**	-
								33.01-40.00	-	-	0.08-0.26	**0.08-0.28**	-	-	-	0.08-0.22	**0.08-0.24**	-
								40.01-52.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
								52.01-65.00	-	-	0.1-0.26	**0.1-0.28**	-	-	-	0.1-0.22	**0.1-0.24**	-
	P5.0.Z.AN	Ferritic/martensitic stainless steel	200	4334	115	185	225	15.00-18.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	115	155	175	18.01-22.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Annealed		2044	115	150	165	22.01-27.00	0.05-0.15	**0.05-0.15**	0.05-0.15	-	0.05-0.14	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.18	**0.07-0.18**	0.07-0.18	-	0.07-0.16	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14
								40.01-52.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
								52.01-65.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
	P5.0.Z.HT	Ferritic/martensitic stainless steel	330	4334	75	135	170	15.00-18.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	70	115	140	18.01-22.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Hardened and tempered		2044	70	115	140	22.01-27.00	0.05-0.15	**0.05-0.15**	0.05-0.15	-	0.05-0.14	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.18	**0.07-0.18**	0.07-0.18	-	0.07-0.16	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14
								40.01-52.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
								52.01-65.00	0.09-0.18	**0.09-0.18**	0.09-0.18	-	0.09-0.16	0.09-0.15	**0.09-0.15**	0.09-0.15	-	0.09-0.14
M	M1.0.Z.AQ	Austenitic Stainless steel	200	4334	115	185	225	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	115	165	190	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Annealed/quenched		2044	115	155	180	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
	M1.1.Z.AQ	Austenitic Stainless steel	200	4334	115	195	240	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	115	175	210	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		Machinability improved		2044	115	170	200	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
	M2.0.Z.AQ	Super Austenitic (Ni>20%) Stainless steel	200	4334	80	125	150	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	80	110	125	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
				2044	80	110	125	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
		Annealed/quenched						27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
	M3.1.Z.AQ	Duplex stainless steel	230	4334	85	125	145	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	85	115	130	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		>60% ferrite (N<0.10%)		2044	85	110	125	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
	M3.2.Z.AQ	Duplex stainless steel	260	4334	75	105	120	15.00-18.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1
				4344	75	100	115	18.01-22.00	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12	0.05-0.12	**0.05-0.12**	0.05-0.12	-	0.05-0.11
		<60% ferrite (N>0.10%)		2044	75	100	115	22.01-27.00	0.05-0.14	**0.05-0.14**	0.05-0.14	-	0.05-0.13	0.05-0.13	**0.05-0.13**	0.05-0.13	-	0.05-0.12
								27.01-33.00	0.07-0.15	**0.07-0.15**	0.07-0.15	-	0.07-0.14	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.13
								33.01-40.00	0.07-0.16	**0.07-0.16**	0.07-0.16	-	0.07-0.15	0.07-0.14	**0.07-0.14**	0.07-0.14	-	0.07-0.14
								40.01-52.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
								52.01-65.00	0.09-0.16	**0.09-0.16**	0.09-0.16	-	0.09-0.15	0.09-0.14	**0.09-0.14**	0.09-0.14	-	0.09-0.14
S	S2.0.Z.AN	Heat resistant super alloys	350	4334	20	40	50	15.00-18.00	0.04-0.08	**0.04-0.08**	0.04-0.08	-	-	0.04-0.07	**0.04-0.07**	0.04-0.07	-	-
	S2.0.Z.AG	Ni based		4344	20	40	50	18.01-22.00	0.04-0.09	**0.04-0.09**	0.04-0.09	-	-	0.04-0.08	**0.04-0.08**	0.04-0.08	-	-
	S2.0.Z.NS			2044	20	40	50	22.01-27.00	0.04-0.1	**0.04-0.1**	0.04-0.1	-	-	0.04-0.09	**0.04-0.09**	0.04-0.09	-	-
								27.01-33.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	-	0.05-0.1	**0.05-0.1**	0.05-0.1	-	-
								33.01-40.00	0.05-0.12	**0.05-0.12**	0.05-0.12	-	-	0.05-0.11	**0.05-0.11**	0.05-0.11	-	-
								40.01-52.00	0.06-0.12	**0.06-0.12**	0.06-0.12	-	-	0.06-0.11	**0.06-0.11**	0.06-0.11	-	-
								52.01-65.00	0.06-0.12	**0.06-0.12**	0.06-0.12	-	-	0.06-0.11	**0.06-0.11**	0.06-0.11	-	-
	S4.2.Z.AN	Heat resistant super alloys	330	H13A	40	90	120	15.00-18.00	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-
	S4.3.Z.AG	Ti based		4344	40	90	120	18.01-22.00	**0.06-0.15**	0.06-0.15	0.06-0.15	-	-	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-
				2044	40	90	120	22.01-27.00	**0.06-0.16**	0.06-0.16	0.06-0.16	-	-	**0.06-0.14**	0.06-0.14	0.06-0.14	-	-
								27.01-33.00	**0.08-0.17**	0.08-0.17	0.08-0.17	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								33.01-40.00	**0.08-0.18**	0.08-0.18	0.08-0.18	-	-	**0.08-0.15**	0.08-0.15	0.08-0.15	-	-
								40.01-52.00	**0.1-0.18**	0.1-0.18	0.1-0.18	-	-	**0.1-0.15**	0.1-0.15	0.1-0.15	-	-
								52.01-65.00	**0.1-0.18**	0.1-0.18	0.1-0.18	-	-	**0.1-0.15**	0.1-0.15	0.1-0.15	-	-

CoroDrill® DS20

4 – 5 × DC

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

SANDVIK Coromant

ENG

CoroDrill® DS20

4 – 5 × DC

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

CoroDrill® DS20

6 – 7 × DC

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

SANDVIK Coromant

ENG

CoroDrill® DS20

6 – 7 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 6-7xD			Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
P	P3.0.Z.HT	High alloy steel	380	4324	80	150	190	15.00-18.00	-	-	0.06-0.09	**0.06-0.1**	-	-	-	0.06-0.08	**0.06-0.09**	-
				4334	75	125	160	18.01-22.00	-	-	0.06-0.1	**0.06-0.12**	-	-	-	0.06-0.09	**0.06-0.1**	-
		Hardened & tempered		4344	70	100	115	22.01-27.00	-	-	0.06-0.13	**0.06-0.14**	-	-	-	0.06-0.11	**0.06-0.12**	-
								27.01-33.00	-	-	0.08-0.16	**0.08-0.17**	-	-	-	0.08-0.13	**0.08-0.14**	-
								33.01-40.00	-	-	0.08-0.17	**0.08-0.18**	-	-	-	0.08-0.14	**0.08-0.15**	-
								40.01-52.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
								52.01-65.00	-	-	0.1-0.17	**0.1-0.18**	-	-	-	0.1-0.14	**0.1-0.15**	-
	P5.0.Z.AN	Ferritic/martensitic stainless steel	200	4334	115	165	205	15.00-18.00	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08	0.05-0.07	**0.05-0.07**	0.05-0.07	-	0.05-0.07
				4344	115	140	160	18.01-22.00	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
		Annealed		2044	115	135	150	22.01-27.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
								27.01-33.00	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1	0.07-0.09	**0.07-0.09**	0.07-0.09	-	0.07-0.08
								33.01-40.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.1	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								40.01-52.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
								52.01-65.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
	P5.0.Z.HT	Ferritic/martensitic stainless steel	330	4334	75	120	155	15.00-18.00	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08	0.05-0.07	**0.05-0.07**	0.05-0.07	-	0.05-0.07
				4344	70	105	125	18.01-22.00	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
		Hardened & tempered		2044	70	105	125	22.01-27.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
								27.01-33.00	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1	0.07-0.09	**0.07-0.09**	0.07-0.09	-	0.07-0.08
								33.01-40.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.1	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								40.01-52.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
								52.01-65.00	0.09-0.12	**0.09-0.12**	0.09-0.12	-	0.09-0.1	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.09
M	M1.0.Z.AQ	Austenitic Stainless steel	200	4334	115	165	205	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
				4344	115	150	170	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
		Annealed/quenched		2044	115	140	160	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
								27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
	M1.1.Z.AQ	Austenitic Stainless steel	200	4334	115	175	215	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
				4344	115	160	190	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
		Machinability improved		2044	115	155	180	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
								27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
	M2.0.Z.AQ	Super Austenitic (Ni>20%) Stainless steel	200	4334	80	115	135	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
				4344	80	100	115	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
				2044	80	100	115	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
		Annealed/quenched						27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
	M3.1.Z.AQ	Duplex stainless steel	230	4334	85	115	130	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
				4344	85	105	115	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
		>60% ferrite (N<0.10%)		2044	85	100	115	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
								27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
	M3.2.Z.AQ	Duplex stainless steel	260	4334	75	95	110	15.00-18.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.09	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.07
				4344	75	90	105	18.01-22.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	0.05-0.1	0.05-0.08	**0.05-0.08**	0.05-0.08	-	0.05-0.08
		<60% ferrite (N>0.10%)		2044	75	90	105	22.01-27.00	0.05-0.11	**0.05-0.11**	0.05-0.11	-	0.05-0.1	0.05-0.09	**0.05-0.09**	0.05-0.09	-	0.05-0.08
								27.01-33.00	0.07-0.12	**0.07-0.12**	0.07-0.12	-	0.07-0.11	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.09
								33.01-40.00	0.07-0.13	**0.07-0.13**	0.07-0.13	-	0.07-0.12	0.07-0.1	**0.07-0.1**	0.07-0.1	-	0.07-0.1
								40.01-52.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
								52.01-65.00	0.09-0.13	**0.09-0.13**	0.09-0.13	-	0.09-0.12	0.09-0.1	**0.09-0.1**	0.09-0.1	-	0.09-0.1
S	S2.0.Z.AN	Heat resistant super alloys	350	4334	20	35	45	15.00-18.00	0.04-0.06	**0.04-0.06**	0.04-0.06	-	-	0.04-0.05	**0.04-0.05**	0.04-0.05	-	-
	S2.0.Z.AG	Ni based		4344	20	35	45	18.01-22.00	0.04-0.07	**0.04-0.07**	0.04-0.07	-	-	0.04-0.06	**0.04-0.06**	0.04-0.06	-	-
	S2.0.Z.NS			2044	20	35	45	22.01-27.00	0.04-0.08	**0.04-0.08**	0.04-0.08	-	-	0.04-0.07	**0.04-0.07**	0.04-0.07	-	-
								27.01-33.00	0.05-0.09	**0.05-0.09**	0.05-0.09	-	-	0.05-0.07	**0.05-0.07**	0.05-0.07	-	-
								33.01-40.00	0.05-0.1	**0.05-0.1**	0.05-0.1	-	-	0.05-0.08	**0.05-0.08**	0.05-0.08	-	-
								40.01-52.00	0.06-0.1	**0.06-0.1**	0.06-0.1	-	-	0.06-0.08	**0.06-0.08**	0.06-0.08	-	-
								52.01-65.00	0.06-0.1	**0.06-0.1**	0.06-0.1	-	-	0.06-0.08	**0.06-0.08**	0.06-0.08	-	-
	S4.2.Z.AN	Heat resistant super alloys	330	H13A	40	80	110	15.00-18.00	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
	S4.3.Z.AG	Ti based		4344	40	80	110	18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
				2044	40	80	110	22.01-27.00	0.06-0.13	0.06-0.13	0.06-0.13	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.11**	0.08-0.11	0.08-0.11	-	-
								33.01-40.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								40.01-52.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
								52.01-65.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-

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

CoroDrill® DS20

6 – 7 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 6-7xD			Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
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	**0.08-0.13**	-	-	0.08-0.08	0.08-0.08	**0.08-0.11**	-
				4334	110	155	180	18.01-22.00	-	0.08-0.12	0.08-0.12	**0.08-0.15**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
				4344	180	150	140	22.01-27.00	-	0.08-0.14	0.08-0.14	**0.08-0.17**	-	-	0.08-0.12	0.08-0.12	**0.08-0.14**	-
								27.01-33.00	-	0.1-0.16	0.1-0.16	**0.1-0.19**	-	-	0.1-0.13	0.1-0.13	**0.1-0.16**	-
								33.01-40.00	-	0.1-0.18	0.1-0.18	**0.1-0.21**	-	-	0.1-0.15	0.1-0.15	**0.1-0.18**	-
								40.01-52.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
								52.01-65.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
	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	**0.08-0.13**	-	-	0.08-0.08	0.08-0.08	**0.08-0.11**	-
				4334	170	210	245	18.01-22.00	-	0.08-0.12	0.08-0.12	**0.08-0.15**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
				4344	130	160	185	22.01-27.00	-	0.08-0.14	0.08-0.14	**0.08-0.17**	-	-	0.08-0.12	0.08-0.12	**0.08-0.14**	-
								27.01-33.00	-	0.1-0.16	0.1-0.16	**0.1-0.19**	-	-	0.1-0.13	0.1-0.13	**0.1-0.16**	-
								33.01-40.00	-	0.1-0.18	0.1-0.18	**0.1-0.21**	-	-	0.1-0.15	0.1-0.15	**0.1-0.18**	-
								40.01-52.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
								52.01-65.00	-	0.12-0.18	0.12-0.18	**0.12-0.21**	-	-	0.12-0.15	0.12-0.15	**0.12-0.18**	-
	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	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
				4334	100	145	175	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	75	115	135	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
	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	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
				4334	100	140	165	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	80	110	130	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
	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	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
				4334	90	130	160	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	70	100	115	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
	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	**0.08-0.12**	-	-	0.08-0.07	0.08-0.07	**0.08-0.1**	-
				4334	110	155	180	18.01-22.00	-	0.08-0.1	0.08-0.1	**0.08-0.14**	-	-	0.08-0.09	0.08-0.09	**0.08-0.12**	-
				4344	85	115	135	22.01-27.00	-	0.08-0.12	0.08-0.12	**0.08-0.16**	-	-	0.08-0.1	0.08-0.1	**0.08-0.13**	-
								27.01-33.00	-	0.1-0.14	0.1-0.14	**0.1-0.18**	-	-	0.1-0.12	0.1-0.12	**0.1-0.15**	-
								33.01-40.00	-	0.1-0.16	0.1-0.16	**0.1-0.2**	-	-	0.1-0.14	0.1-0.14	**0.1-0.17**	-
								40.01-52.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
								52.01-65.00	-	0.12-0.16	0.12-0.16	**0.12-0.2**	-	-	0.12-0.14	0.12-0.14	**0.12-0.17**	-
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	**0.06-0.08**	-	-	0.06-0.07	0.06-0.07	**0.06-0.07**	-
				4334	30	60	75	18.01-22.00	-	0.06-0.09	0.06-0.09	**0.06-0.09**	-	-	0.06-0.08	0.06-0.08	**0.06-0.08**	-
				4344	30	60	75	22.01-27.00	-	0.06-0.1	0.06-0.1	**0.06-0.1**	-	-	0.06-0.08	0.06-0.08	**0.06-0.08**	-
								27.01-33.00	-	0.08-0.1	0.08-0.1	**0.08-0.1**	-	-	0.08-0.09	0.08-0.09	**0.08-0.09**	-
								33.01-40.00	-	0.08-0.12	0.08-0.12	**0.08-0.12**	-	-	0.08-0.1	0.08-0.1	**0.08-0.1**	-
								40.01-52.00	-	0.1-0.12	0.1-0.12	**0.1-0.12**	-	-	0.1-0.1	0.1-0.1	**0.1-0.1**	-
								52.01-65.00	-	0.1-0.12	0.1-0.12	**0.1-0.12**	-	-	0.1-0.1	0.1-0.1	**0.1-0.1**	-

ENG

CoroDrill® DS20

6 – 7 × DC

ISO	MC No.	Material	HB	Grade	Cutting speed recommendations 6-7xD			Drill diameter	Drill length 6xD -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
									Recommended start value at middle of feed range									
N	N1.2.Z.AG	Aluminum based alloys	100	H13A	300	330	360	15.00-18.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
		AlSi alloys (Si<1%)		4344	300	330	360	18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								33.01-40.00	**0.08-0.16**	0.08-0.16	0.08-0.16	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								40.01-52.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
								52.01-65.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
	N1.3.C.UT	Aluminum based alloys	75	H13A	250	315	360	15.00-18.00	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-	**0.06-0.08**	0.06-0.08	0.06-0.08	-	-
		AlSi cast alloys (1%< Si >13%)		4344	250	315	360	18.01-22.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
								22.01-27.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								27.01-33.00	**0.08-0.13**	0.08-0.13	0.08-0.13	-	-	**0.08-0.11**	0.08-0.11	0.08-0.11	-	-
								33.01-40.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								40.01-52.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
								52.01-65.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
	N1.3.C.AG	Aluminum based alloys	90	H13A	250	285	315	15.00-18.00	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-	**0.06-0.08**	0.06-0.08	0.06-0.08	-	-
		AlSi cast and aged alloys (1%< Si >13%)		4344	250	285	315	18.01-22.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
								22.01-27.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								27.01-33.00	**0.08-0.13**	0.08-0.13	0.08-0.13	-	-	**0.08-0.11**	0.08-0.11	0.08-0.11	-	-
								33.01-40.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								40.01-52.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
								52.01-65.00	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-	**0.1-0.12**	0.1-0.12	0.1-0.12	-	-
	N3.3.U.UT	Copper based alloys	110	H13A	250	315	360	15.00-18.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
		Free cutting copper based alloys		4344	250	315	360	18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								33.01-40.00	**0.08-0.16**	0.08-0.16	0.08-0.16	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								40.01-52.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
								52.01-65.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
	N3.2.C.UT	Copper based alloys	90	H13A	180	200	215	15.00-18.00	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-	**0.06-0.09**	0.06-0.09	0.06-0.09	-	-
		Leaded brass and bronzes (Pb<1%)		4344	180	200	215	18.01-22.00	**0.06-0.12**	0.06-0.12	0.06-0.12	-	-	**0.06-0.1**	0.06-0.1	0.06-0.1	-	-
								22.01-27.00	**0.06-0.13**	0.06-0.13	0.06-0.13	-	-	**0.06-0.11**	0.06-0.11	0.06-0.11	-	-
								27.01-33.00	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-	**0.08-0.12**	0.08-0.12	0.08-0.12	-	-
								33.01-40.00	**0.08-0.16**	0.08-0.16	0.08-0.16	-	-	**0.08-0.14**	0.08-0.14	0.08-0.14	-	-
								40.01-52.00	**0.1-0.16**	0.1-0.16	0.1-0.16	-	-	**0.1-0.14**	0.1-0.14	0.1-0.14	-	-
								52.01-65.00	**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 f_n mm/rev	-GM f_n mm/rev	-GR f_n mm/rev	-GT f_n mm/rev
P	P1.0.Z.AN (01.0)	**Unalloyed steel** Non hardened 0.05-0.10% C	90-200	4324	230-400	12.00-13.99	**0.04-0.08**			
						14.00-16.49	**0.04-0.08**	0.04-0.06	0.04-0.06	0.04-0.06
						16.50-19.99	**0.04-0.10**	0.04-0.06	0.04-0.06	0.04-0.06
						20.00-23.99	**0.04-0.12**	0.04-0.08	0.04-0.08	0.04-0.08
				4334	210-325	24.00-29.99	**0.04-0.12**	0.04-0.08	0.04-0.08	0.04-0.08
				4344	190-245	30.00-35.99	**0.06-0.14**	0.06-0.10	0.06-0.10	0.06-0.10
						36.00-43.99	**0.06-0.16**	0.06-0.10	0.06-0.10	0.06-0.10
						44.00-52.99	**0.08-0.16**	0.08-0.12	0.08-0.12	0.08-0.12
						53.00-63.50	**0.08-0.16**	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	230-370	12.00-13.99	**0.04-0.10**			
						14.00-16.49	**0.04-0.10**	0.04-0.06	0.04-0.06	0.04-0.06
						16.50-19.99	**0.04-0.12**	0.04-0.06	0.04-0.06	0.04-0.06
						20.00-23.99	**0.04-0.14**	0.04-0.10	0.04-0.10	0.04-0.10
				4334	200-305	24.00-29.99	**0.04-0.14**	0.04-0.10	0.04-0.10	0.04-0.10
				4344	170-235	30.00-35.99	**0.06-0.16**	0.06-0.12	0.06-0.12	0.06-0.12
						36.00-43.99	**0.06-0.16**	0.06-0.12	0.06-0.12	0.06-0.12
						44.00-52.99	**0.08-0.16**	0.08-0.12	0.08-0.12	0.08-0.12
						53.00-63.50	**0.08-0.16**	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	190-305	12.00-13.99	0.04-0.10			
						14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
						16.50-19.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
				4334	155-250	24.00-29.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
				4344	120-190	30.00-35.99	0.06-0.22	0.06-0.22	**0.06-0.22**	0.06-0.22
						36.00-43.99	0.06-0.24	0.06-0.24	**0.06-0.24**	0.06-0.24
						44.00-52.99	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
						53.00-63.50	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
	P1.3.Z.AN (01.3)	Non hardened 0.55-0.80% C	150-250	4324	170-290	12.00-13.99	0.04-0.10			
						14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
						16.50-19.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
				4334	140-240	24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
				4344	105-185	30.00-35.99	0.06-0.24	0.08-0.24	**0.08-0.24**	0.08-0.24
						36.00-43.99	0.06-0.24	0.08-0.24	**0.08-0.24**	0.08-0.24
						44.00-52.99	0.06-0.24	0.08-0.24	**0.08-0.24**	0.08-0.24
						53.00-63.50	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
	P1.3.Z.AN (01.4)	High carbon & carbon tool steel	180-275	4324	200-290	12.00-13.99	0.04-0.10			
						14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
						16.50-19.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
				4334	155-240	24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
				4344	105-180	30.00-35.99	0.06-0.24	0.08-0.24	**0.08-0.24**	0.08-0.24
						36.00-43.99	0.06-0.24	0.08-0.24	**0.08-0.24**	0.08-0.24
						44.00-52.99	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
						53.00-63.50	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
	P2.1.Z.AN (02.1)	Low alloy steel (Non-hardened)	150-260	4324	180-305	12.00-13.99	0.04-0.10			
						14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
						16.50-19.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
				4334	150-250	24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
				4344	115-190	30.00-35.99	0.06-0.24	0.06-0.24	**0.06-0.24**	0.06-0.24
						36.00-43.99	0.06-0.24	0.06-0.24	**0.06-0.24**	0.06-0.24
						44.00-52.99	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
						53.00-63.50	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
	P2.5.Z.HT (02.2)	Hardened steel	220-450	4324	90-245	12.00-13.99	0.04-0.10			
						14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
						16.50-19.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
				4334	85-195	24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
				4344	75-150	30.00-35.99	0.06-0.24	0.06-0.24	**0.06-0.24**	0.06-0.24
						36.00-43.99	0.06-0.24	0.06-0.24	**0.06-0.24**	0.06-0.24
						44.00-52.99	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
						53.00-63.50	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24

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

ENG

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			
				4334	130-240	14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
				4044	100-170	16.50-19.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
						24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
						30.00-35.99	0.06-0.24	0.06-0.24	**0.06-0.24**	0.06-0.24
						36.00-43.99	0.06-0.24	0.06-0.24	**0.06-0.24**	0.06-0.24
						44.00-52.99	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
						53.00-63.50	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
	P3.0.Z.HT (03.21)	Hardened steel	250-350	4324	80-210	12.00-13.99	0.04-0.10			
				4334	75-175	14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
				4044	70-125	16.50-19.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
						24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
						30.00-35.99	0.06-0.20	0.06-0.20	**0.06-0.20**	0.06-0.20
						36.00-43.99	0.06-0.22	0.06-0.22	**0.06-0.22**	0.06-0.22
						44.00-52.99	0.10-0.22	0.10-0.22	**0.10-0.22**	0.10-0.22
						53.00-63.50	0.10-0.22	0.10-0.22	**0.10-0.22**	0.10-0.22
	06.1	Steel castings (Unalloyed)	90-225	4324	140-365	12.00-13.99	0.04-0.08			
				4334	135-265	14.00-16.49	0.04-0.08	0.04-0.08	**0.04-0.08**	0.04-0.08
				4044	125-190	16.50-19.99	0.04-0.08	0.04-0.08	**0.04-0.08**	0.04-0.08
						20.00-23.99	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
						24.00-29.99	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
						30.00-35.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						36.00-43.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						44.00-52.99	0.08-0.14	0.08-0.14	**0.08-0.14**	0.08-0.14
						53.00-63.50	0.08-0.14	0.08-0.14	**0.08-0.14**	0.08-0.14
	P1.5.C.UT (06.2)	Low alloyed (alloying elements less than 5%)	150-250	4324	110-265	12.00-13.99	0.04-0.10			
				4334	105-210	14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
				4044	100-150	16.50-19.99	0.04-0.14	0.04-0.14	**0.04-0.14**	0.04-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
						24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
						30.00-35.99	0.06-0.20	0.06-0.20	**0.06-0.20**	0.06-0.20
						36.00-43.99	0.06-0.22	0.06-0.22	**0.06-0.22**	0.06-0.22
						44.00-52.99	0.10-0.22	0.10-0.22	**0.10-0.22**	0.10-0.22
						53.00-63.50	0.10-0.22	0.10-0.22	**0.10-0.22**	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 HB	Grade	Cutting speed (m/min)	Drill diameter DC mm	Geometry/ feed (f_n mm/rev.) Drill length 2-3xD -LM	-MS[1]	-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	**0.04-0.12**		0.04-0.08	
						14.00-16.49	0.04-0.14	**0.04-0.14**	0.04-0.08	0.04-0.08	0.04-0.14
						16.50-19.99	0.06-0.16	**0.06-0.16**	0.04-0.08	0.04-0.08	0.06-0.16
						20.00-23.99	0.06-0.18	**0.06-0.18**	0.06-0.14	0.06-0.14	0.06-0.18
				4334	115-225	24.00-29.99	0.06-0.18	**0.06-0.18**	0.06-0.14	0.06-0.14	0.06-0.18
				4344	115-175	30.00-35.99	0.06-0.20	**0.06-0.20**	0.06-0.16	0.06-0.16	0.06-0.20
				2044	115-165	36.00-43.99	0.06-0.20	**0.06-0.20**	0.06-0.16	0.06-0.16	0.10-0.24
						44.00-52.99	0.10-0.24	**0.10-0.24**	0.10-0.18	0.10-0.18	0.10-0.24
						53.00-63.50	0.10-0.24	**0.10-0.24**	0.10-0.18	0.10-0.18	0.10-0.24
	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	**0.04-0.12**		0.04-0.08	
						14.00-16.49	0.04-0.14	**0.04-0.14**	0.04-0.08	0.04-0.08	0.04-0.14
						16.50-19.99	0.06-0.14	**0.06-0.14**	0.04-0.08	0.04-0.08	0.06-0.14
						20.00-23.99	0.06-0.16	**0.06-0.16**	0.06-0.12	0.06-0.12	0.06-0.16
				4334	115-225	24.00-29.99	0.06-0.16	**0.06-0.16**	0.06-0.12	0.06-0.12	0.06-0.16
				4344	115-190	30.00-35.99	0.06-0.18	**0.06-0.18**	0.06-0.16	0.06-0.16	0.06-0.20
				2044	115-180	36.00-43.99	0.06-0.20	**0.06-0.20**	0.06-0.16	0.06-0.16	0.06-0.20
						44.00-52.99	0.10-0.20	**0.10-0.20**	0.10-0.16	0.10-0.16	0.10-0.20
						53.00-63.50	0.10-0.20	**0.10-0.20**	0.10-0.16	0.10-0.16	0.10-0.20
	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	**0.04-0.12**		0.04-0.08	
						14.00-16.49	0.04-0.14	**0.04-0.14**	0.04-0.08	0.04-0.08	0.04-0.14
						16.50-19.99	0.06-0.14	**0.06-0.14**	0.04-0.08	0.04-0.08	0.06-0.14
						20.00-23.99	0.06-0.16	**0.06-0.16**	0.06-0.12	0.06-0.12	0.06-0.16
				4334	85-145	24.00-29.99	0.06-0.16	**0.06-0.16**	0.06-0.12	0.06-0.12	0.06-0.16
				4344	85-130	30.00-35.99	0.06-0.18	**0.06-0.18**	0.06-0.16	0.06-0.16	0.06-0.18
				2044	85-125	36.00-43.99	0.06-0.20	**0.06-0.20**	0.06-0.16	0.06-0.16	0.06-0.20
						44.00-52.99	0.10-0.20	**0.10-0.20**	0.10-0.16	0.10-0.16	0.10-0.20
						53.00-63.50	0.10-0.20	**0.10-0.20**	0.10-0.16	0.10-0.16	0.10-0.20
	M1.0.C.UT (15.21)	Austenitic castings	150-250	4324	150-210	12.00-13.99	0.04-0.12	**0.04-0.12**		0.04-0.08	
						14.00-16.49	0.04-0.12	**0.04-0.12**	0.04-0.08	0.04-0.08	0.04-0.12
						16.50-19.99	0.06-0.14	**0.06-0.14**	0.04-0.08	0.04-0.08	0.06-0.14
						20.00-23.99	0.06-0.16	**0.06-0.16**	0.06-0.12	0.06-0.12	0.06-0.16
				4334	115-185	24.00-29.99	0.06-0.16	**0.06-0.16**	0.06-0.12	0.06-0.12	0.06-0.16
				4344	80-165	30.00-35.99	0.06-0.18	**0.06-0.18**	0.06-0.16	0.06-0.16	0.06-0.18
				2044	80-155	36.00-43.99	0.06-0.20	**0.06-0.20**	0.06-0.16	0.06-0.16	0.06-0.20
						44.00-52.99	0.10-0.20	**0.10-0.20**	0.10-0.16	0.10-0.16	0.10-0.20
						53.00-63.50	0.10-0.20	**0.10-0.20**	0.10-0.16	0.10-0.16	0.10-0.20
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	**0.04-0.08**	0.04-0.08		0.04-0.08	
						14.00-16.49	**0.04-0.08**	0.04-0.08	0.04-0.10	0.04-0.08	0.04-0.08
						16.50-19.99	**0.05-0.08**	0.05-0.08	0.05-0.10	0.05-0.08	0.05-0.08
				H13A	15-90	20.00-23.99	**0.05-0.08**	0.05-0.08	0.05-0.10	0.05-0.08	0.05-0.08
				2044	20-90	24.00-29.99	**0.06-0.10**	0.06-0.10	0.06-0.12	0.06-0.08	0.05-0.08
						30.00-35.99	**0.06-0.12**	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
						36.00-43.99	**0.06-0.12**	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
						44.00-52.99	**0.06-0.12**	0.06-0.12	0.06-0.12	0.06-0.12	0.06-0.12
						53.00-63.50	**0.08-0.14**	0.08-0.14	0.06-0.14	0.08-0.12	0.08-0.14
	S4.2.Z.AN (23.21) S4.3.Z.AG (23.22)	Titanium: Alfa- , near Alfa- and Alfa + Beta alloys in annealed condition Titanium: Alfa + Beta alloys in aged condition, Beta alloys in annealed or aged condition	Rm (Mpa) 600-1500	4344	40-145	12.00-13.99	**0.04-0.14**	0.04-0.14		0.04-0.10	
						14.00-16.49	**0.06-0.14**	0.06-0.14	0.06-0.12	0.06-0.10	0.06-0.10
						16.50-19.99	**0.08-0.16**	0.08-0.16	0.08-0.14	0.08-0.12	0.08-0.12
						20.00-23.99	**0.08-0.16**	0.08-0.16	0.08-0.14	0.08-0.12	0.08-0.12
				H13A	40-135	24.00-29.99	**0.12-0.18**	0.12-0.18	0.10-0.16	0.10-0.14	0.10-0.14
				2044	40-135	30.00-35.99	**0.12-0.18**	0.12-0.18	0.10-0.18	0.10-0.16	0.12-0.18
						36.00-43.99	**0.12-0.18**	0.12-0.18	0.10-0.18	0.10-0.16	0.12-0.18
						44.00-52.99	**0.12-0.18**	0.12-0.18	0.10-0.18	0.10-0.16	0.12-0.18
						53.00-63.50	**0.14-0.20**	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

ENG

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				
				4334	110-200	14.00-16.49	0.06-0.10	0.06-0.12	**0.06-0.20**	
				4344	80-155	16.50-19.99	0.06-0.12	0.08-0.14	**0.08-0.22**	0.08 - 0.22
						20.00-23.99	0.08-0.14	0.10-0.18	**0.14-0.28**	0.10 - 0.26
						24.00-29.99	0.08-0.14	0.10-0.20	**0.16-0.32**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.34**	
						44.00-52.99	0.12-0.18	0.12-0.22	**0.12-0.34**	
						53.00-63.50				
	K1.1.C.NS (07.2)	Pearlitic (long chipping)	150-270	4324	105-180	12.00-13.99				
				4334	85-150	14.00-16.49	0.06-0.10	0.06-0.12	**0.06-0.16**	
				4344	65-110	16.50-19.99	0.06-0.12	0.08-0.14	**0.08-0.18**	0.08 - 0.18
						20.00-23.99	0.08-0.14	0.10-0.16	**0.10-0.24**	0.10 - 0.24
						24.00-29.99	0.08-0.14	0.10-0.18	**0.10-0.28**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.30**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						44.00-52.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						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				
				4334	170-270	14.00-16.49	0.06-0.10	0.06-0.12	**0.06-0.20**	
				4344	130-205	16.50-19.99	0.06-0.12	0.08-0.14	**0.08-0.22**	0.08 - 0.22
						20.00-23.99	0.08-0.14	0.10-0.18	**0.10-0.28**	0.10 - 0.28
						24.00-29.99	0.08-0.14	0.10-0.20	**0.10-0.32**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.34**	
						44.00-52.99	0.12-0.18	0.12-0.22	**0.12-0.34**	
						53.00-63.50				
	K2.2.C.UT (08.2)	High tensile strength	200-330	4324	125-245	12.00-13.99				
				4334	100-195	14.00-16.49	0.06-0.10	0.06-0.12	**0.06-0.16**	
				4344	75-150	16.50-19.99	0.06-0.12	0.08-0.14	**0.08-0.18**	0.08 - 0.18
						20.00-23.99	0.08-0.14	0.10-0.16	**0.10-0.24**	0.10 - 0.24
						24.00-29.99	0.08-0.14	0.10-0.18	**0.10-0.28**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.30**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						44.00-52.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						53.00-63.50				
	K3.1.C.UT (09.1)	Nodular cast iron (Ferritic)	150-230	4324	125-225	12.00-13.99				
				4334	100-185	14.00-16.49	0.06-0.10	0.06-0.12	**0.08-0.16**	
				4344	80-145	16.50-19.99	0.06-0.12	0.08-0.14	**0.10-0.18**	0.08 - 0.18
						20.00-23.99	0.08-0.14	0.10-0.16	**0.12-0.24**	0.10 - 0.24
						24.00-29.99	0.08-0.14	0.10-0.18	**0.14-0.28**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.30**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						44.00-52.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						53.00-63.50				
	K3.3.C.UT (09.2)	Pearlitic	200-330	4324	110-210	12.00-13.99				
				4334	90-175	14.00-16.49	0.06-0.10	0.06-0.12	**0.08-0.16**	
				4344	70-130	16.50-19.99	0.06-0.12	0.08-0.14	**0.10-0.18**	0.08 - 0.18
						20.00-23.99	0.08-0.14	0.10-0.16	**0.12-0.24**	0.10 - 0.24
						24.00-29.99	0.08-0.14	0.10-0.18	**0.14-0.28**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.30**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						44.00-52.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						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 f_n mm/rev.	-GM f_n mm/rev.	-GR f_n mm/rev.	-GT f_n mm/rev.
H	H1.3.Z.HA (04.1)	Hardened and tempered	47-65 (HRC)	4324	30-85	12.00-13.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
				4334	30-85	14.00-16.49	0.04-0.08	**0.04-0.12**	0.04-0.08	0.04 - 0.08
				4344	30-85	16.50-19.99	0.05-0.12	**0.06-0.14**	0.05-0.12	0.05 - 0.12
						20.00-23.99	0.05-0.14	**0.06-0.18**	0.05-0.14	0.05 - 0.14
						24.00-29.99	0.05-0.14	**0.06-0.18**	0.05-0.14	0.05 - 0.14
						30.00-35.99	0.06-0.16	**0.06-0.20**	0.06-0.16	
						36.00-43.99	0.06-0.16	**0.06-0.20**	0.06-0.16	
						44.00-52.99	0.10-0.16	**0.10-0.20**	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	300-405	12.00-13.99	0.04-0.08		0.04-0.08	
				H13A	300-400	14.00-16.49	**0.04-0.14**	0.04-0.12	0.04-0.12	0.04-0.12
						16.50-19.99	**0.04-0.16**	0.04-0.14	0.04-0.14	0.04 - 0.14
						20.00-23.99	**0.06-0.18**	0.06-0.16	0.06-0.16	0.06 - 0.16
						24.00-29.99	**0.10-0.20**	0.10-0.18	0.10-0.18	0.10-0.18
						30.00-35.99	**0.10-0.25**	0.10-0.20	0.10-0.20	
						36.00-43.99	**0.10-0.25**	0.10-0.20	0.10-0.20	
						44.00-52.99	**0.12-0.28**	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	300-405	12.00-13.99	0.04-0.12		0.04-0.12	
				H13A	300-400	14.00-16.49	**0.04-0.12**	0.04-0.14	0.04-0.12	0.04-0.12
						16.50-19.99	**0.04-0.14**	0.04-0.16	0.04-0.14	0.04 - 0.14
						20.00-23.99	**0.06-0.16**	0.06-0.18	0.06-0.16	0.06 - 0.16
						24.00-29.99	**0.10-0.18**	0.10-0.20	0.10-0.18	0.10-0.18
						30.00-35.99	**0.10-0.20**	0.10-0.22	0.10-0.20	
						36.00-43.99	**0.10-0.20**	0.10-0.24	0.10-0.20	
						44.00-52.99	**0.12-0.22**	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	250-350	12.00-13.99	0.04-0.12		0.04-0.12	
				H13A	250-350	14.00-16.49	**0.04-0.12**	0.04-0.14	0.04-0.12	0.04-0.12
						16.50-19.99	**0.04-0.14**	0.04-0.16	0.04-0.14	0.04 - 0.14
						20.00-23.99	**0.06-0.16**	0.06-0.18	0.06-0.16	0.06 - 0.16
						24.00-29.99	**0.10-0.18**	0.10-0.20	0.10-0.18	0.10-0.18
						30.00-35.99	**0.10-0.20**	0.10-0.22	0.10-0.20	
						36.00-43.99	**0.10-0.20**	0.10-0.24	0.10-0.20	
						44.00-52.99	**0.12-0.22**	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	250-400	12.00-13.99	0.04-0.14		0.04-0.12	
				H13A	250-400	14.00-16.49	**0.04-0.14**	0.04-0.12	0.04-0.12	0.04-0.12
						16.50-19.99	**0.04-0.16**	0.04-0.14	0.04-0.14	0.04 - 0.14
						20.00-23.99	**0.06-0.18**	0.06-0.16	0.06-0.16	0.06 - 0.16
						24.00-29.99	**0.10-0.20**	0.10-0.18	0.10-0.18	0.10-0.18
						30.00-35.99	**0.10-0.25**	0.10-0.20	0.10-0.20	
						36.00-43.99	**0.10-0.25**	0.10-0.20	0.10-0.20	
						44.00-52.99	**0.12-0.28**	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	180-240	12.00-13.99	0.04-0.14		0.04-0.12	
				H13A	180-240	14.00-16.49	**0.04-0.14**	0.04-0.12	0.04-0.12	0.04-0.12
						16.50-19.99	**0.04-0.16**	0.04-0.14	0.04-0.14	0.04 - 0.14
						20.00-23.99	**0.06-0.18**	0.06-0.16	0.06-0.16	0.06 - 0.16
						24.00-29.99	**0.10-0.20**	0.10-0.18	0.10-0.18	0.10-0.18
						30.00-35.99	**0.10-0.25**	0.10-0.20	0.10-0.20	
						36.00-43.99	**0.10-0.25**	0.10-0.20	0.10-0.20	
						44.00-52.99	**0.12-0.28**	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.

ENG

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		**Unalloyed steel**					
	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				
		Low alloy steel					
	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	
		High alloy steel					
	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					
		Steel castings					
	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		**Stainless steel**					
	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		**Malleable**					
	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	
		Grey cast iron					
	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	
		Nodular cast iron					
	09.1	Ferritic	125-230	60-110	0.14-0.20	125-195	-53/3040
	09.2	Ferritic	200-300		0.14-0.20	100-180	
N		**Aluminium alloys**					
	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				
		Copper and copper alloys					
	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_n mm/r	Speed v_c m/min	Geometry / Grade FIRST CHOICE Highest productivity P	C	Complementary P	C
P		**Unalloyed steel**		12.7–17.0	0.04–0.08	290 (230–380)	-53/3040	-53/1020	-53/1120	-53/1020
	01.0	Non hardened 0,05–0,10% C	80-170	17.5–25.4	0.04–0.08		-53/3040		-53/1020	T-53/1020
				26.0–30.0	0.05–0.08		-53/3040		-53/1020	
				31.0–41.3	0.07–0.10		-53/3040		-53/1020	
				42.0–80.0	0.08–0.12		-53/3040		-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	T-53/1020
				26.0–30.0	0.05–0.10		-53/3040		-53/1020	
				31.0–41.3	0.07–0.12		-53/3040		-53/1020	
				42.0–80.0	0.08–0.14		-53/3040		-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				-53/1020	T-53/1020
				26.0–30.0	0.08–0.18				-53/1020	
				31.0–41.3	0.10–0.20				-53/1020	
				42.0–80.0	0.12–0.24				-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				-53/1020	T-53/1020
				26.0–30.0	0.08–0.18				-53/1020	
				31.0–41.3	0.10–0.20				-53/1020	
				42.0–80.0	0.12–0.24				-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				-53/1020	T-53/1020
				26.0–30.0	0.08–0.18				-53/1020	
				31.0–41.3	0.10–0.20				-53/1020	
				42.0–80.0	0.12–0.24				-53/1020	
		Low alloy steel		12.7–17.0	0.04–0.10	220 (180–290)	-53/3040	-53/1020	-53/1120	-53/1020
	02.1	Non-hardened	150–260	17.5–25.4	0.06–0.12				-53/1020	T-53/1020
				26.0–30.0	0.10–0.16				-53/1020	
				31.0–41.3	0.11–0.18				-53/1020	
				42.0-80.0	0.12–0.22				-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				-53/1020	T-53/1020
				26.0–30.0	0.10–0.18				-53/1020	
				31.0–41.3	0.10–0.20				-53/1020	
				42.0–80.0	0.12–0.24				-53/1020	
		High alloy steel		12.7–17.0	0.04–0.08	180 (160–275)	-53/3040	-53/1020	-53/1120	-53/1020
	03.11	Annealed	50–250	17.5–25.4	0.04–0.14				-53/1020	T-53/1020
				26.0–30.0	0.08–0.18				-53/1020	
				31.0–41.3	0.10–0.20				-53/1020	
				42.0–80.0	0.12–0.24				-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				-53/1020	T-53/1020
				26.0–30.0	0.10–0.16				-53/1020	
				31.0–41.3	0.11–0.18				-53/1020	
				42.0–80.0	0.12–0.22				-53/1020	
		Steel castings		12.7–17.0	0.04–0.08	200 (140–310)	-53/3040	-53/1020	-53/1120	-53/1020
	06.1	Unalloyed	90–225	17.5–25.4	0.04–0.08		-53/3040		-53/1020	T-53/1020
				26.0–30.0	0.05–0.10		-53/3040		-53/1020	
				31.0–41.3	0.06–0.12		-53/3040		-53/1020	
				42.0–80.0	0.07–0.14		-53/3040		-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				-53/1020	T-53/1020
				26.0–30.0	0.10–0.16				-53/1020	
				31.0–41.3	0.11–0.18				-53/1020	
				42.0–80.0	0.12–0.22				-53/1020	
M		**Stainless steel**		12.7–17.0	0.04–0.10	170 (120–265)	53/3040	53/1020	53/1120	53/1020
	05.11	Ferritic, Martensitic 13–25% Cr	150–270	17.5–25.4	0.04–0.14		53/3040		53/1020	
				26.0–30.0	0.08–0.18		53/3040		53/1020	
				31.0–41.3	0.10–0.20		53/3040		53/1020	
				42.0–80.0	12–0.24		53/3040		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	
				26.0–30.0	0.08–0.14		53/3040		53/1020	
				31.0–41.3	0.10–0.16		53/3040		53/1020	
				42.0–80.0	0.11–0.18		53/3040		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	
				26.0–30.0	0.08–0.14		53/3040		53/1020	
				31.0–41.3	0.10–0.16		53/3040		53/1020	
				42.0–80.0	0.11–0.18		53/3040		53/1020	

Insert positioning: C = Central
P = Peripheral

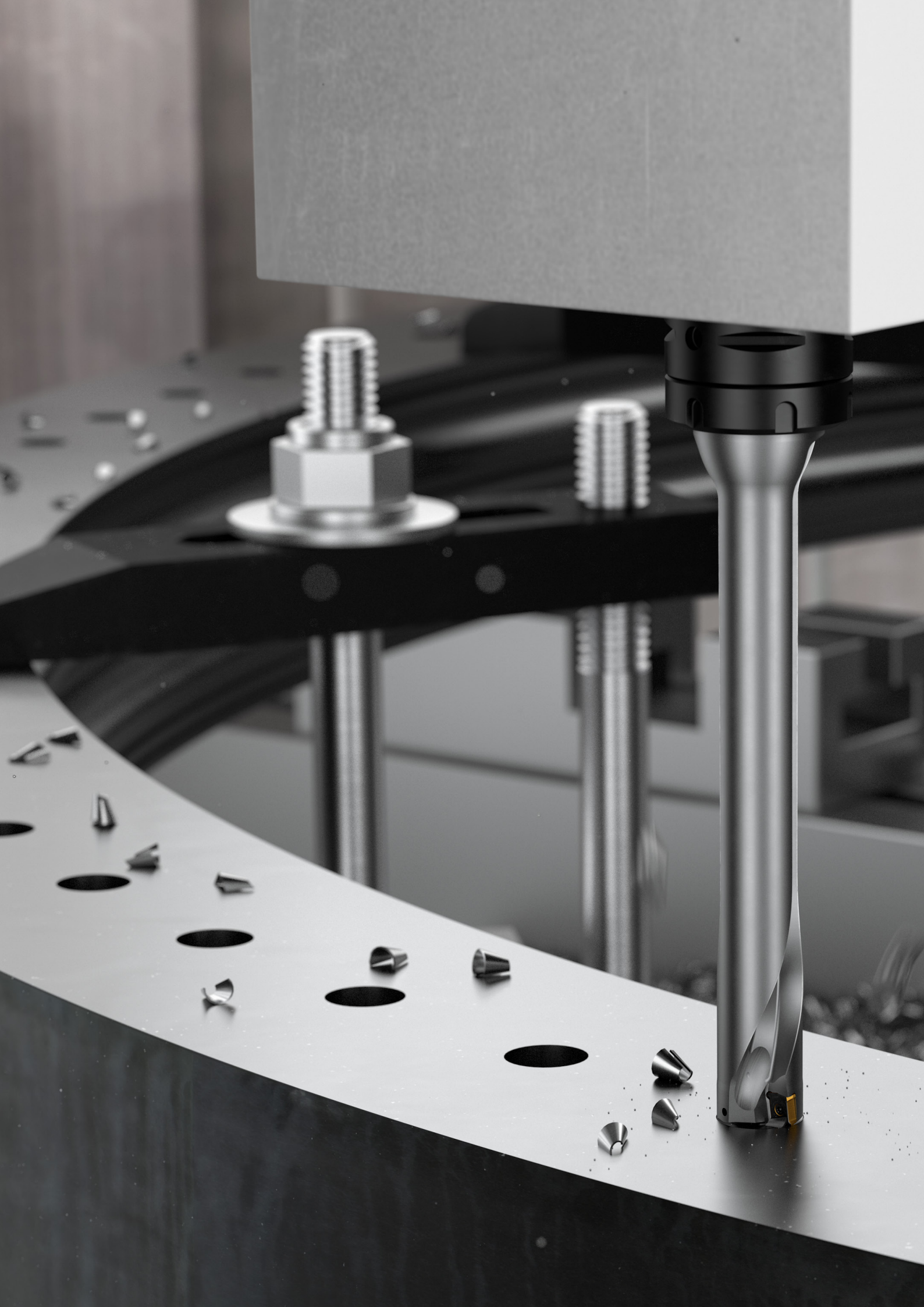
Wiper TECHNOLOGY -WM geometry for machining steel and cast iron with hardness < 200 HB in stable conditions, increase feed (fn) with 50%. For easy to machine stainless steels in stable conditions, increase feed (fn) with 25%.

SANDVIK Coromant

Coromant U indexable insert plunge drill

ISO	CMC No.	Material	Hardness Brinell HB	Drill dia DC mm	Feed f_n mm/r	Speed v_c m/min	Geometry / Grade FIRST CHOICE Highest productivity P	C	Complementary P	C
M		**Stainless steel**		12.7–17.0	0.04–0.08		-53/1120		-53/1120	-53/1020
	15.21	Austenitic castings	150–250	17.5–25.4	0.04–0.12			-53/1020	-53/1020	
				26.0–30.0	0.05–0.12	110 (80–155)	-53/1020	-53/1020	-53/1020	
				31.0–41.3	0.06–0.14			-53/1020	-53/1020	
				42.0–80.0	0.06–0.14			-53/1020	-53/1020	
S		**Heat resistant alloys**		12.7–17.0	0.03–0.08		-53/1120		-53/1120	-53/1020
	20.21	Ni based	140–425	17.5–25.4	0.04–0.08			-53/1020	-53/1020	
	20.22			26.0–30.0	0.06–0.10	50 (20– 88)	-53/1020	-53/1020	-53/1020	
	20.24			31.0–41.3	0.08–0.12			-53/1020	-53/1020	
				42.0–80.0	0.09–0.14			-53/1020	-53/1020	
		Titanium alloys		12.7–17.0	0.04–0.10		-53/1120	-53/1020	-53/1120	-53/1020
	23.21	α, near α and α+β alloys. Alloys in	600–1500	17.5–25.4	0.08–0.14		-53/H13A	-53/H13A	-53/H13A	-53/H13A
	23.22	annealed or aged conditions		26.0–30.0	0.12–0.16	60 (40–132)	-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		**Malleable cast iron**		12.7–17.0	0.04–0.14	170 (140–230)	-53/3040	-53/1020	-53/1120	-53/1020
	07.1	Ferritic (short chipping)	110–145	17.5–25.4	0.10–0.18				-53/1020	T-53/1020
				26.0–30.0	0.14–0.20				-53/1020	
				31.0–41.3	0.16–0.26				-53/1020	
				42.0–80.0	0.18–0.28				-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	T-53/1020
				26.0–30.0	0.12–0.18				-53/1020	
				31.0–41.3	0.14–0.20				-53/1020	
				42.0–80.0	0.15–0.22				-53/1020	
		Grey cast iron		12.7–17.0	0.04–0.14	250 (210–310)	-53/3040	-53/1020	-53/1120	-53/1020
	08.1	Low tensile strength	150–220	17.5–25.4	0.10–0.18				-53/1020	T-53/1020
				26.0–30.0	0.14–0.20				-53/1020	
				31.0–41.3	0.16–0.26				-53/1020	
				42.0–80.0	0.18–0.28				-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	T-53/1020
				26.0–30.0	0.12–0.18				-53/1020	
				31.0–41.3	0.14–0.20				-53/1020	
				42.0–80.0	0.15–0.22				-53/1020	
		Nodular cast iron		12.7–17.0	0.04–0.10	170 (125–215)	-53/3040	-53/1020	-53/1120	-53/1020
	09.1	Ferritic	125–230	17.5–25.4	0.08–0.14				-53/1020	T-53/1020
				26.0–30.0	0.12–0.18				-53/1020	
				31.0–41.3	0.14–0.20				-53/1020	
				42.0–80.0	0.15–0.22				-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	
				26.0–30.0	0.12–0.18				-53/1020	
				31.0–41.3	0.14–0.20				-53/1020	
				42.0–80.0	0.15–0.22				-53/1020	
H		**Extra hard steel**		12.7–17.0	0.05-0.08					
	04.1	Hardened and tempered	450	17.5–25.4	0.07-0.15					
				26.0–30.0	0.07-0.15	40 (30-80)	-53/3040	-53/1020	-53/1020	-53/1020
				31.0–41.3	0.10-0.15				-53/1120	
				42.0–80.0	0.10-0.15					
N		**Aluminium alloys**		12.7–17.0	0.04–0.12	350 (300–440)	-53/1120	-53/1020	-53/1120	-53/1020
	30.12	Wrought or wrought and aged	30–150	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
	30.21	Cast. non aging	40–100	12.7–17.0	0.04–0.12	150 (30–440)	-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
				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
				42.0–80.0	0.14–0.26		-53/H13A	-53/H13A	-53/H13A	-53/H13A
		Copper and copper alloys		12.7–17.0	0.04–0.12	300 (250–385)	-53/1120	-53/1020	-53/1120	-53/1020
	33.1	Free cutting alloys (Pb ≥ 1%)	50–160	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
	33.2	Brass and leaded alloys (Pb ≤ 1%)	50–160	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
				42.0–80.0	0.14–0.26		-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

Accessories and spare parts

- Related accessories and spare parts to all boring tool families can be found at 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
CoroBore® BR10	Conventional	32-170	IT9	1	- Single edge back-boring	- CoroTurn® 107	- Coromant Capto® - Coromant EH	K4-K5
CoroBore® BR20	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
CoroBore® BR30	Conventional	35-214	IT9	3	- Boring - Step boring - Single edge boring	- CoroTurn® 107 - T-Max® P - CoroBore® 111	- Coromant Capto®	K17-K21
Cavity boring	Conventional	85-205	IT9	4,6,8	- Boring - Step boring	- CoroTurn® 107* - CoroBore® 111	- Coromant Capto®	K22
CoroBore® 820 XL	Conventional	148-300 (350**) 298-1260	IT9	2	- Boring - Step boring - Single edge boring	- CoroTurn® 107 - T-Max® P - CoroBore® 111	- Coromant Capto® - 40X with 4 bolt circle	K24-K25 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

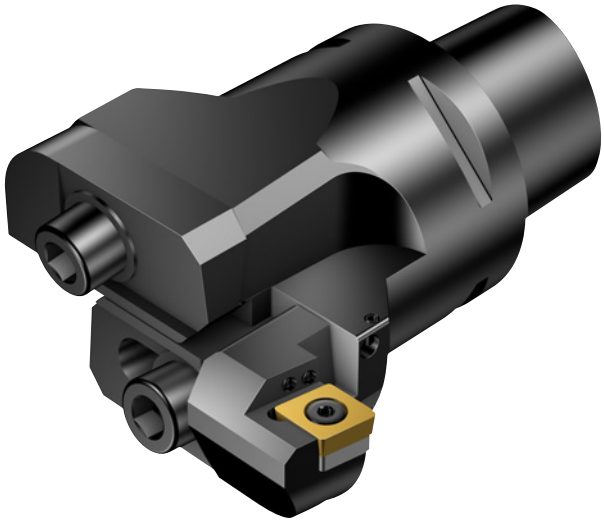
J

Application

- Rough boring
- Back boring

ISO application area:

P M K N S H



K

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

L

www.sandvik.coromant.com/coroborebr10

Tools

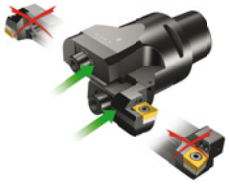
Couplings:
- Coromant Capto®
- Coromant EH

M

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.

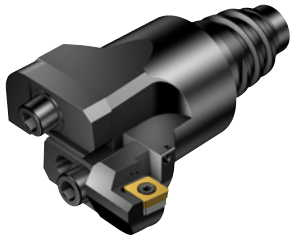


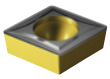
Available as complete back boring assembly kit or separate back boring slide and cover as additional items.

N

CoroBore® BR10 rough boring tool for back-boring

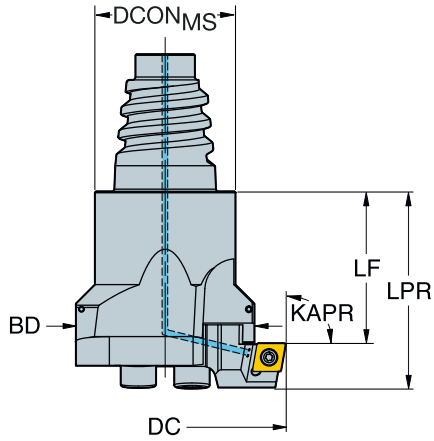
Coromant EH - Internal coolant supply





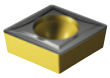
CCMT, CCGT
CCGX, CCET
CCMW

KAPR 90°



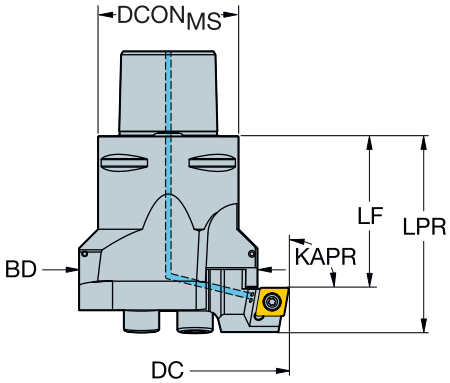
DCN	DCX		CZCMS	CNSC	Ordering code	Dimensions, mm DCONMS	ADJLXRDL	LF	LPR	BD1	BAR	KG	CICT	MIID
32.00	38.00	06	E20	1	BR10-38CC06F-EH20	19.30	3.00	15.00	25.00	20.00	70	0.070	1	CCMT 06 02 04
37.00	45.00	06	E25	1	BR10-45CC06F-EH25	24.20	4.00	14.00	24.00	24.00	70	0.110	1	CCMT 06 02 04

Coromant Capto® - Internal coolant supply



CCMT, CCGT
CCGX, CCET
CCMW

KAPR 90°



DCN	DCX		CZCMS	CNSC	Ordering code	Dimensions, mm DCONMS	ADJLXRDL	LF	LPR	BD1	BAR	KG	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
For inserts, see Turning tools catalogue

L2

M1

N23

N15

CoroBore® BR20

Twin-edge rough boring tools for flexible boring

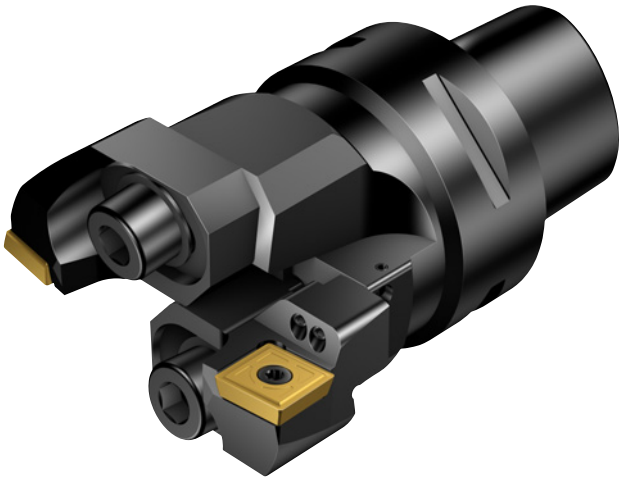
J

Application

- Rough boring
- Twin-edge boring
- Step boring
- Back boring
- Single edge boring

ISO application area:

P M K N S H



K

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

L

www.sandvik.coromant.com/coroborebr20

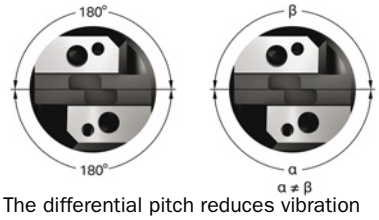
Tools

Couplings:
- Coromant Capto®
- Coromant EH

Inserts

Standard inserts with dedicated grades and geometries for all materials
- CoroBore® 111
- CoroTurn® 107

M



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.

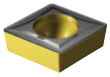
N

ENG

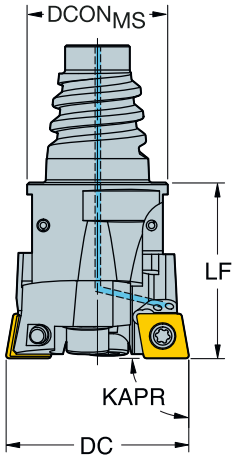
CoroBore® BR20 twin-edge rough boring tool

Coromant EH - Internal coolant supply

KAPR 90°



CCMT, CCGT
CCGX, CCET
CCMW



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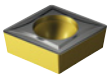
23.00	29.00	06	E20	1	BR20-29CC06F-EH20	19.30	3.00	25.00	70	0.070	2	CCMT 06 02 04
28.00	36.00	06	E25	1	BR20-36CC06F-EH25	24.20	4.00	25.00	70	0.110	2	CCMT 06 02 04

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

L2 M1 N23 N15 K85

CoroBore® BR20 twin-edge rough boring tool

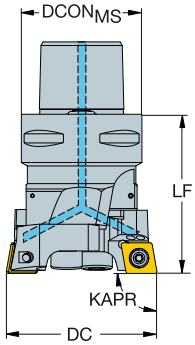
Coromant Capto® - Internal coolant supply

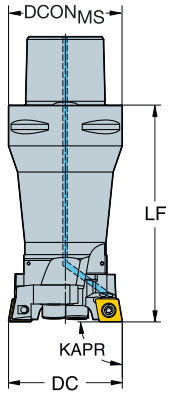


CCMT, CCGT
CCGX, CCET

CCMW

KAPR	90°	90°
DSGN	1	2





							Dimensions, mm								
DCN	DCX		CZC$_{MS}$	CNSC	DSGN	Ordering code	DCON$_{MS}$	ADJLX$_{RDL}$	ULDR	LF	BD$_1$	BAR	KG	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
For inserts, see Turning tools catalogue
For all DSGN 2; LU = DC*ULDR

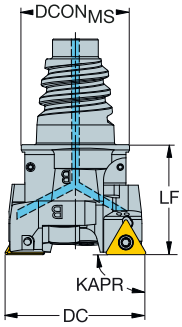
L2 M1 N23 N15 K85

ENG

CoroBore® BR20 twin-edge rough boring tool

Coromant EH - Internal coolant supply

KAPR 90°



TCMT, TCMX, TCGT, TCGX TCEX

TCMW

DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	BAR	KG	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

For inserts, see Turning tools catalogue

L2 M1 N23 N15 K85

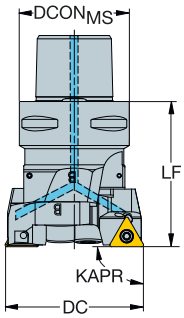
CoroBore® BR20 twin-edge rough boring tool

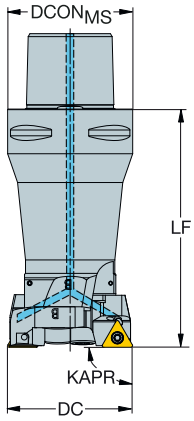
Coromant Capto® - Internal coolant supply

TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR	90°	90°
DSGN	1	2





							Dimensions, mm								
DCN	DCX		CZC$_{MS}$	CNSC	DSGN	Ordering code	DCON$_{MS}$	ADJLX$_{RDL}$	ULDR	LF	BD$_1$	BAR	KG	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

For inserts, see Turning tools catalogue

For all DSGN 2; LU = DC*ULDR

L2 M1 N23 N15 K85

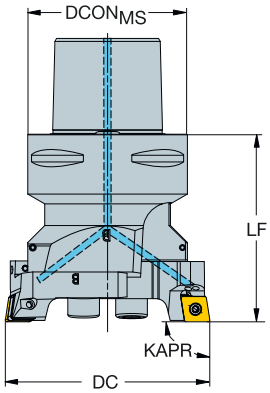
ENG

CoroBore® BR20 twin-edge rough boring tool

Coromant Capto® - Internal coolant supply

CNMU

KAPR 90°



DCN	DCX		CZCMS	CNSC	Ordering code	Dimensions, mm DCONMS	ADJLXRDL	LF	BAR	KG	CICT	MIID
70.00	90.00	12	C6	3	BR20-90CN12F-C6	63.00	10.00	78.00	70	2.200	2	CNMU 12 04 12
89.00	116.00	12	C8	3	BR20-116CN12F-C8	80.00	13.50	94.00	70	2.900	2	CNMU 12 04 12
115.00	150.00	12	C8	3	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

For inserts, see Turning tools catalogue

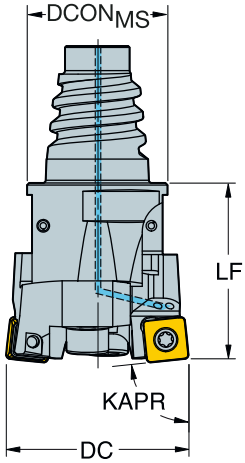
L2 M1 N23 N15 K85

CoroBore® BR20 twin-edge rough boring tool

Coromant EH - Internal coolant supply

SPMT

KAPR 84°



DCN	DCX		CZCMS	CNSC	Ordering code	Dimensions, mm DCONMS	ADJLXRDL	LF	BAR	KG	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

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

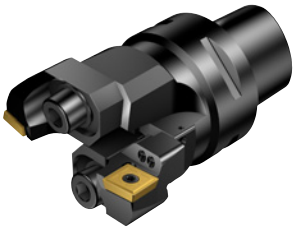
K32 L2 M1 N23 N15 K85

SANDVIK Coromant

ENG

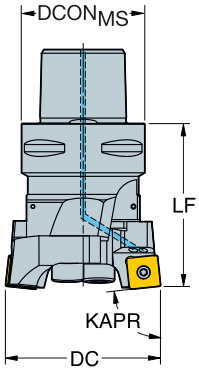
CoroBore® BR20 twin-edge rough boring tool

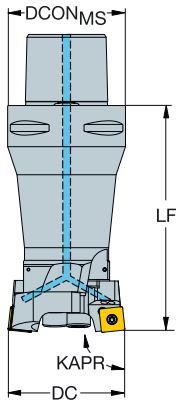
Coromant Capto® - Internal coolant supply



SPMT

KAPR	84°	84°
DSGN	1	2





							Dimensions, mm								
DCN	DCX		CZC_{MS}	CNSC	DSGN	**Ordering code**	$DCON_{MS}$	$ADJLX_{RDL}$	ULDR	LF	BD_1	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

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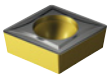
For all DSGN 2; LU = DC*ULDR

K32 L2 M1 N23 N15 K85

CoroBore® BR20 twin-edge damped rough boring tool

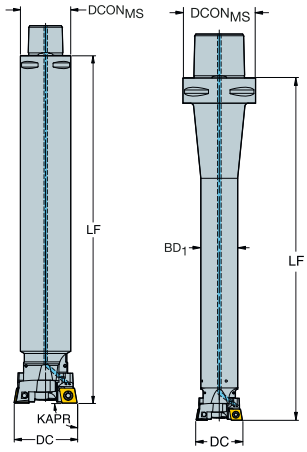
Coromant Capto® - Internal coolant supply

SilentTools®



CCMT, CCGT
CCGX, CCET
CCMW

KAPR	90°	90°
DSGN	1	2



DCN	DCX		CZCMS	CNSC	DSGN	Ordering code	Dimensions, mm DCONMS	ADJLXRDL	ULDR	LF	BD1	BAR	KG	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		221.00		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		220.00		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		300.00		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		400.00		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		500.00		70	18.490	2	CCMT 12 04 08
89.00	116.00	12	C8	3	1	BR20D-116CC12F-C8S	80.00	13.50		410.00		70	16.140	2	CCMT 12 04 08
115.00	150.00	12	C8	3	1	BR20D-150CC12F-C8M	80.00	17.50		500.00		70	18.620	2	CCMT 12 04 08

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For inserts, see Turning tools catalogue
For all DSGN 2; LU = DC*ULDR

L2 M1 N23 N15 K85

ENG

CoroBore® BR20 twin-edge damped rough boring tool

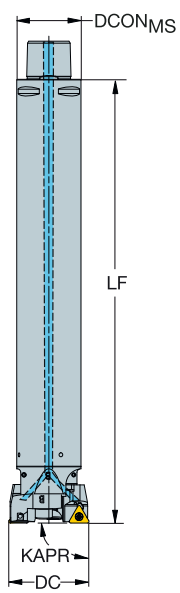
Coromant Capto® - Internal coolant supply

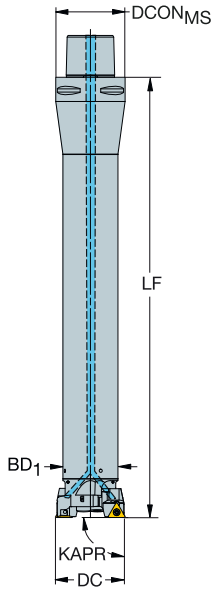
KAPR	90°	90°
DSGN	1	2

SilentTools®

TCMT, TCMX, TCGT, TCGX TCEX

TCMW





DCN	DCX		CZC_{MS}	CNSC	DSGN	Ordering code	Dimensions, mm $DCON_{MS}$	$ADJLX_{RDL}$	ULDR	LF	BD_1	BAR	KG	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

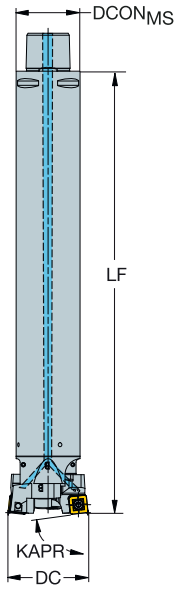
CoroBore® BR20 twin-edge damped rough boring tool

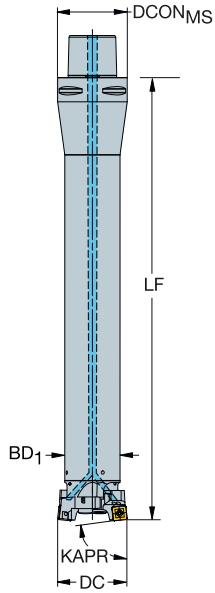
Coromant Capto® - Internal coolant supply

SilentTools®

SPMT

KAPR	84°	84°
DSGN	1	2





DCN	DCX		CZC$_{MS}$	CNSC	DSGN	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	ULDR	LF	BD$_1$	BAR	KG	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
For all DSGN 2; LU = DC*ULDR

L2 M1 N23 N15 K85

SANDVIK Coromant

CoroBore® BR30

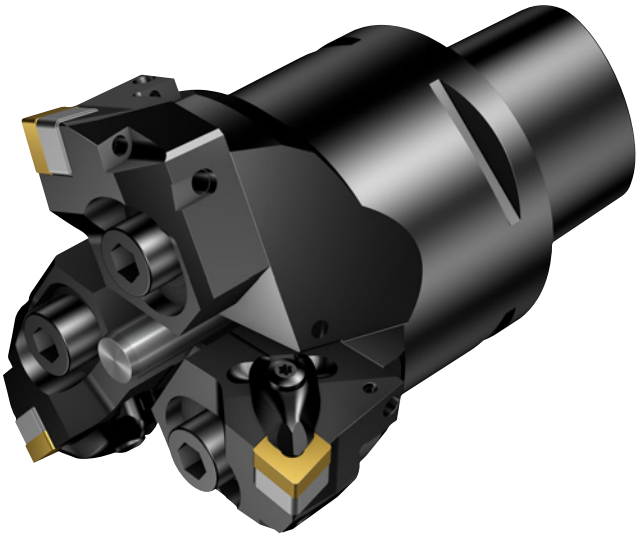
Multi-edge rough boring tools for maximum productivity

Application

- Rough boring
- Multi-edge boring
- Step boring
- Single edge boring

ISO application area

P M K N S H



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

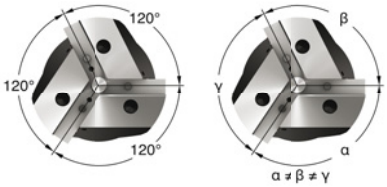
www.sandvik.coromant.com/coroborebr30

Tools

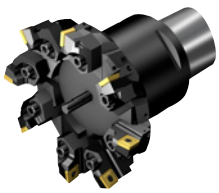
Couplings:
- Coromant Capto®

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.



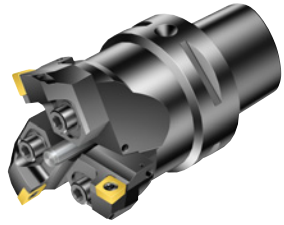
From diameter 85 to 205 mm, CoroBore® BR30 is available with up to 8 cutting edges for maximum metal removal rate.

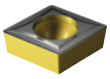
If no pre-setter is available, adjust diameter of CoroBore BR30 by measuring the distance from pin to insert and subtract half the pin diameter. Multiply by two for the effective boring diameter.

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

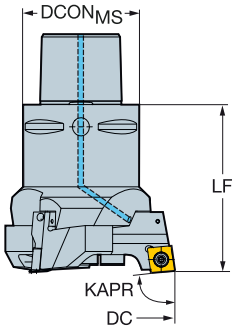


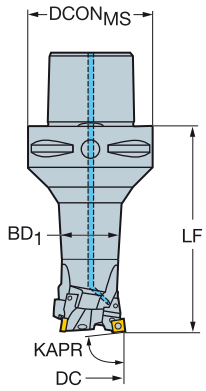


CCMT, CCGT
CCGX, CCET

CCMW

KAPR	90°	90°
DSGN	1	2





							Dimensions, mm								
DCN	DCX		CZC$_{MS}$	CNSC	DSGN	Ordering code	DCON$_{MS}$	ADJLX$_{RDL}$	ULDR	LF	BD$_1$	BAR	KG	CICT	MIID
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

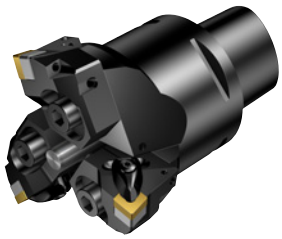
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue
For all DSGN 2; LU = DC*ULDR

L2 M1 N23 N15 K86

ENG

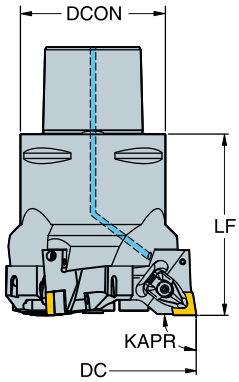
CoroBore® BR30 three-edge rough boring tool

Coromant Capto® - Internal coolant supply



CNMM
CNMG
CNMA, CNGA

KAPR 90°



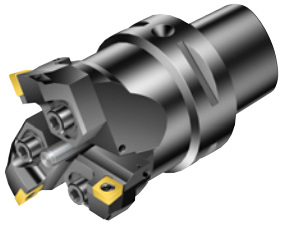
DCN	DCX		CZC_{MS}	CNSC	Ordering code	Dimensions, mm $DCON_{MS}$	$ADJLX_{RDL}$	LF	BAR	KG	CICT	MIID
106.00	122.00	12	C8	3	**BR30-122CN12F-C8**	80.00	8.00	100.00	70	4.190	3	CNMG 12 04 08
121.00	137.00	12	C8	3	**BR30-137CN12F-C8**	80.00	8.00	100.00	70	4.340	3	CNMG 12 04 08
136.00	152.00	12	C8	3	**BR30-152CN12F-C8**	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
For inserts, see Turning tools catalogue

L2 M1 N23 N15 K86

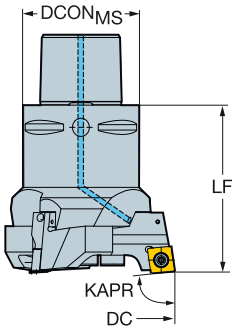
CoroBore® BR30 three-edge rough boring tool

Coromant Capto® - Internal coolant supply



SPMT

KAPR 84°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	BAR	KG	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

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

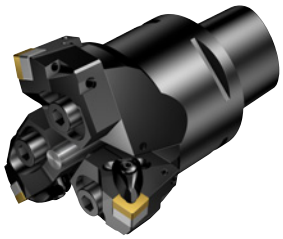
K32 L2 M1 N23 N15 K86

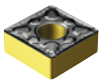
SANDVIK Coromant

ENG

CoroBore® BR30 three-edge rough boring tool

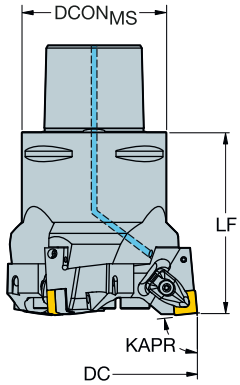
Coromant Capto® - Internal coolant supply





SNMM
SNMG
SNMA, SNGA

KAPR 84°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	BAR	KG	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

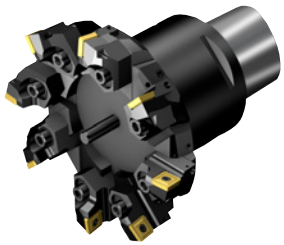
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

L2 M1 N23 N15 K86

CoroBore® BR30 multi-edge rough boring tool

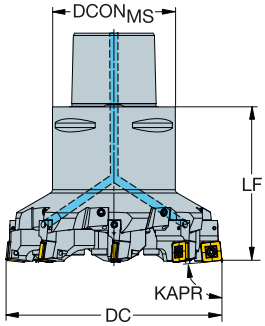
Coromant Capto® - Internal coolant supply

Dedicated for cavity boring operations



SPMT

KAPR 84°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	BAR	KG	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

K32 L2 M1 N23 N15 K86

CoroBore® 820 XL

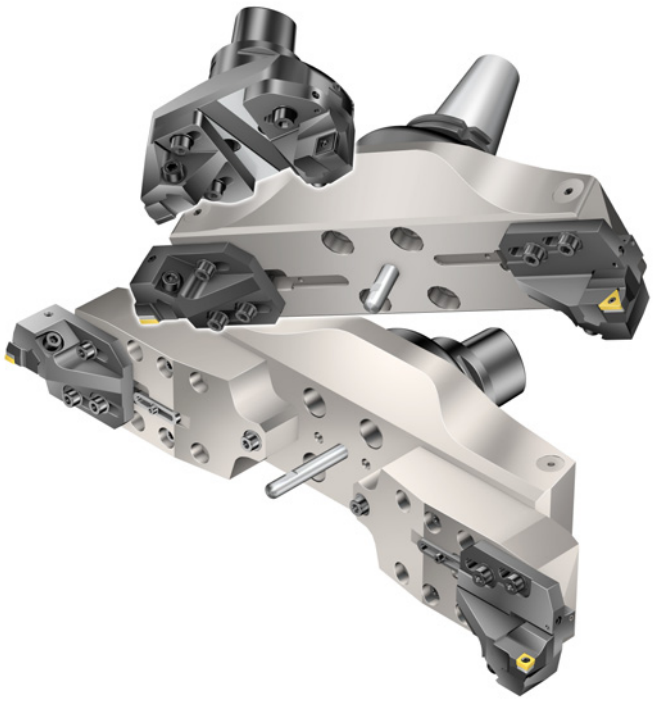
Rough boring tool for large diameters

Application

- Rough boring
- Twin-edge boring
- Step boring
- Single edge boring

ISO application area

P M K N S H



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

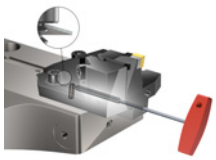
SilentTools®

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.

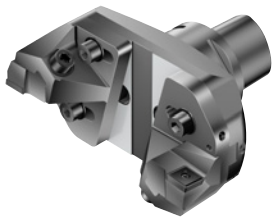
Use same bridge/bridge extension for roughing, finishing and face grooving from diameter 148 mm (counterweight needed for finishing).

Bore large diameter without increasing tool weight.

Dedicated CoroBore® 111 rough boring inserts. With excellent chip breaking and increased lifetime.

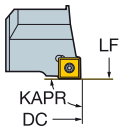
CoroBore® 820 XL rough boring tool

Coromant Capto® - Internal coolant supply

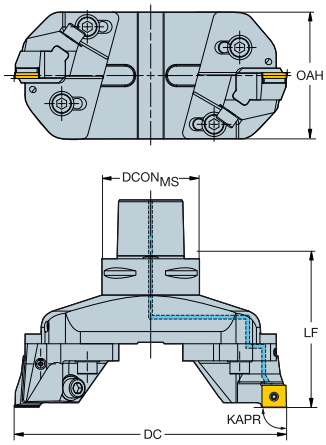


SPMT

KAPR



90°

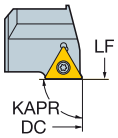


DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	LF	OAH	BAR	KG	CICT	MIID
148.00	200.00	18	C8	3	820-200SP18-C8	80.00	1.50	26.00	122.00	104.00	70	6.900	2	SPMT 1810-BM
148.00	200.00	18	C10	3	820-200SP18-C10	100.00	1.50	26.00	128.00	104.00	70	9.900	2	SPMT 1810-BM
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

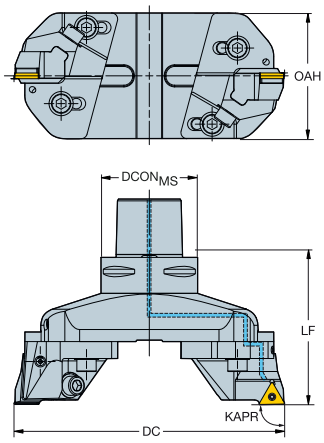
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR



90°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	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

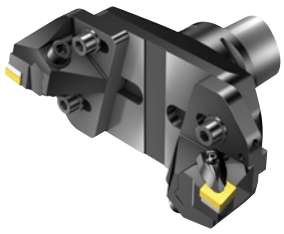
For inserts, see Turning tools catalogue

K32 L2 M1 N23 N15 K87

SANDVIK Coromant

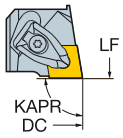
CoroBore® 820 XL rough boring tool

Coromant Capto® - Internal coolant supply

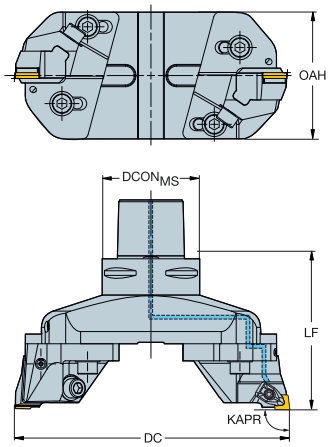


CNMM
CNMG
CNMA, CNGA

KAPR

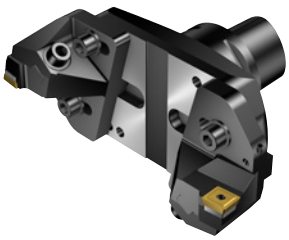


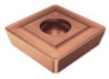
90°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	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

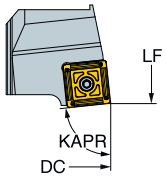
For inserts, see Turning tools catalogue



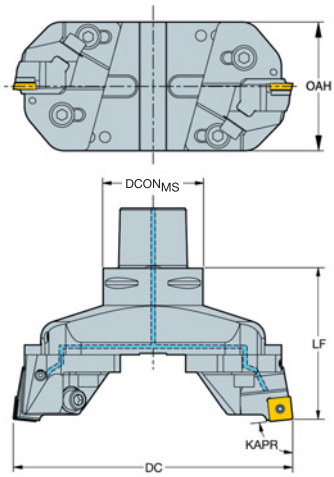


SPMT

KAPR



84°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	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

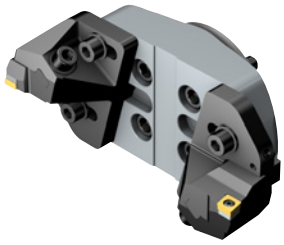
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

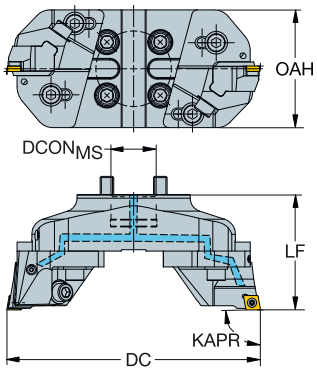
K32 L2 M1 N23 N15 K87

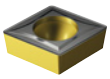
CoroBore® 820 XL lightweight rough boring tool

Arbor - Internal coolant supply

KAPR 90°





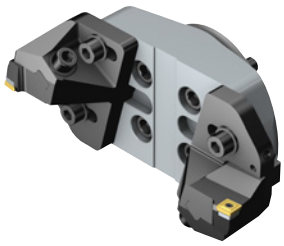


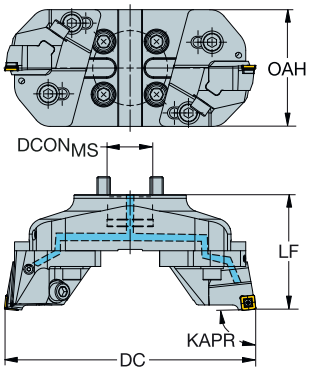
CCMT, CCGT
CCGX, CCET
CCMW

DCN	DCX		CZCMS	CNSC	Ordering code	Dimensions, mm DCONMS	ADJLXAXL	ADJLXRDL	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

DCN	DCX		CZCMS	CNSC	Ordering code	Dimensions, mm DCONMS	ADJLXAXL	ADJLXRDL	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

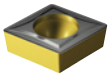
K32 L2 N23 N15 K87

ENG

CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

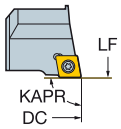
Dedicated for Silent Tools boring



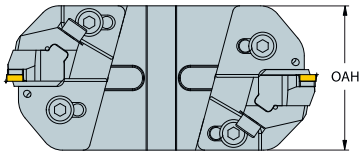
CCMT, CCGT
CCGX, CCET

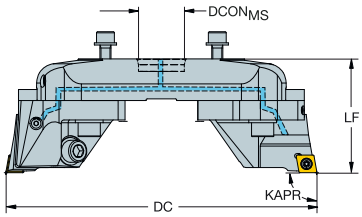
CCMW

KAPR



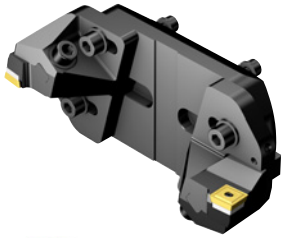
90°





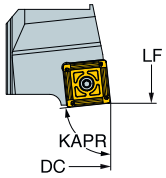
DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	LF	OAH	BAR	KG	CICT	MIID
148.00	200.00	12	33	1	**820D-200CC12**	33.00	1.50	26.00	82.00	104.00	70	3.350	2	CCMT 12 04 08
198.00	250.00	12	33	1	**820D-250CC12**	33.00	1.50	26.00	82.00	104.00	70	3.670	2	CCMT 12 04 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

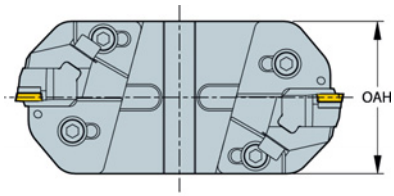


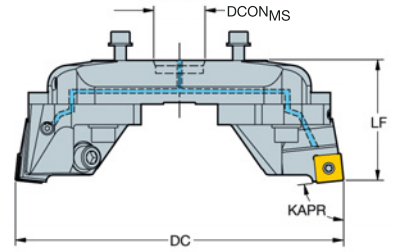
SPMT

KAPR



84°





DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	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

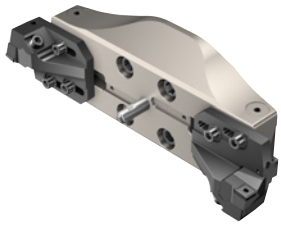
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

These light weight assemblies are dedicated for use with damped boring adaptors. Damped adaptors are bought separately, see page K77.

K32 N23 N15 K87

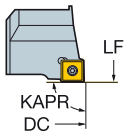
CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

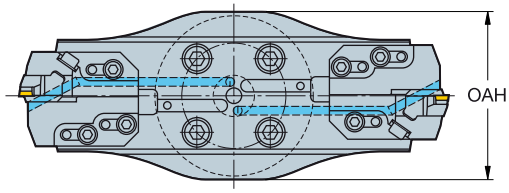


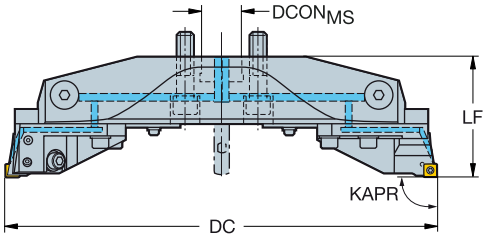
SPMT

KAPR

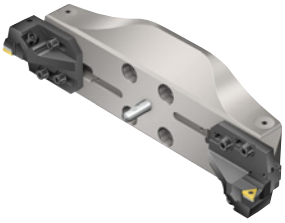


90°





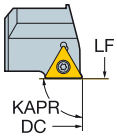
DCN	DCX		CZC_{MS}	CNSC	Ordering code	Dimensions, mm $DCON_{MS}$	$ADJLX_{AXL}$	$ADJLX_{RDL}$	LF	OAH	BAR	KG	CICT	MIID
298.00	380.00	18	40X	1	820-380SP18	40.00	1.50	41.00	114.00	164.00	70	10.000	2	SPMT 1810-BM
378.00	460.00	18	40X	1	820-460SP18	40.00	1.50	41.00	119.00	164.00	70	13.131	2	SPMT 1810-BM
458.00	540.00	18	40X	1	820-540SP18	40.00	1.50	41.00	124.00	164.00	70	16.741	2	SPMT 1810-BM



TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR



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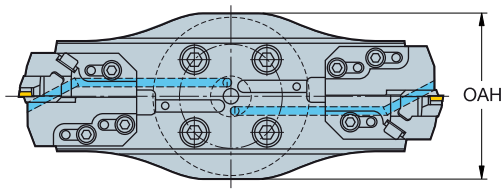
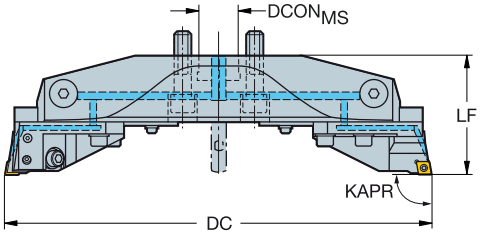




DCN	DCX		CZC_{MS}	CNSC	Ordering code	Dimensions, mm $DCON_{MS}$	$ADJLX_{AXL}$	$ADJLX_{RDL}$	LF	OAH	BAR	KG	CICT	MIID
298.00	380.00	22	40X	1	820-380TC22	40.00	1.50	41.00	114.00	164.00	70	10.980	2	TCMT 22 04 08
378.00	460.00	22	40X	1	820-460TC22	40.00	1.50	41.00	119.00	164.00	70	12.720	2	TCMT 22 04 08
458.00	540.00	22	40X	1	820-540TC22	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

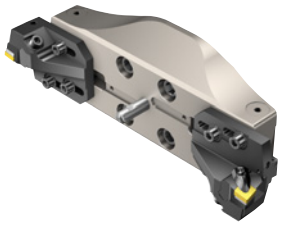
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

K32 K76 N23 N15 K87

SANDVIK Coromant

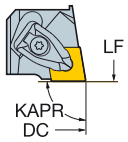
CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

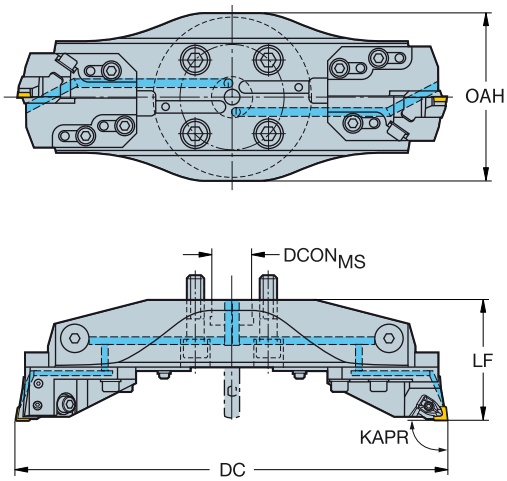


CNMM
CNMG
CNMA, CNGA

KAPR

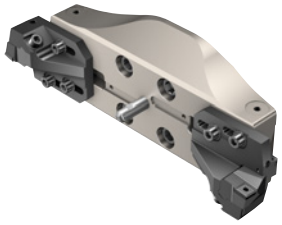


90°



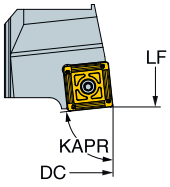
DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	LF	OAH	BAR	KG	CICT	MIID
298.00	380.00	19	40X	1	820-380CN19	40.00	1.50	41.00	114.00	164.00	70	10.815	2	CNMG 19 06 12
378.00	460.00	19	40X	1	820-460CN19	40.00	1.50	41.00	119.00	164.00	70	12.685	2	CNMG 19 06 12
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

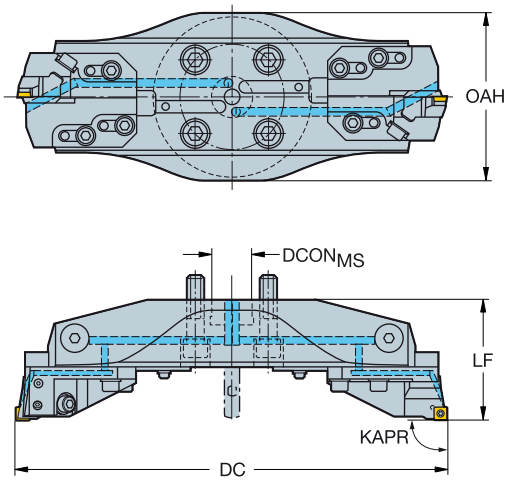


SPMT

KAPR



84°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	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

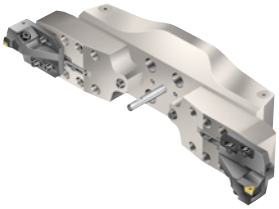
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

K32 K76 N23 N15 K87

CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

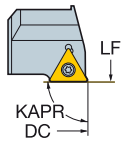
With bridge extension



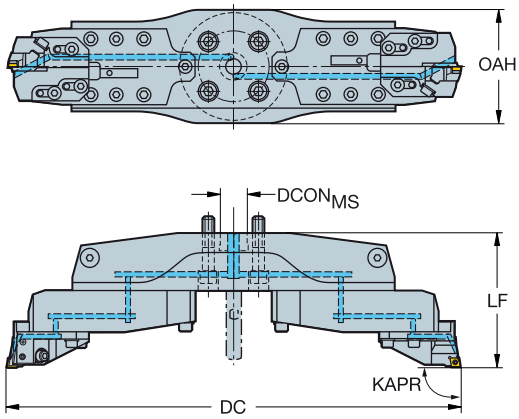
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR

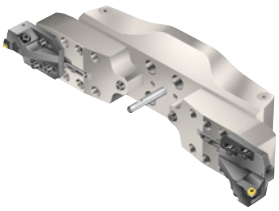


90°



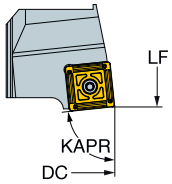
DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	LF	OAH	BAR	KG	CICT	MIID
538.00	780.00	22	40X	1	**820-780TC22**	40.00	1.50	121.00	198.00	164.00	70	28.000	2	TCMT 22 04 08
778.00	1020.00	22	40X	1	**820-1020TC22**	40.00	1.50	121.00	218.00	164.00	70	48.000	2	TCMT 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

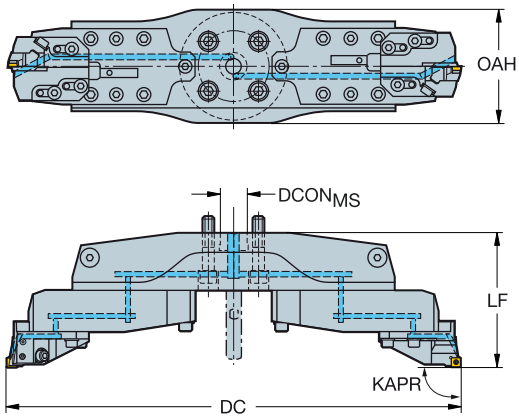


SPMT

KAPR



84°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	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

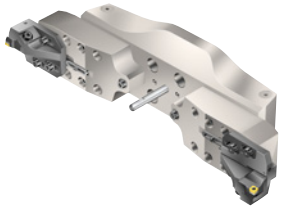
K32 K76 N23 N15 K87

SANDVIK Coromant

CoroBore® 820 XL rough boring tool

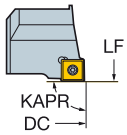
Arbor - Internal coolant supply

With bridge extension

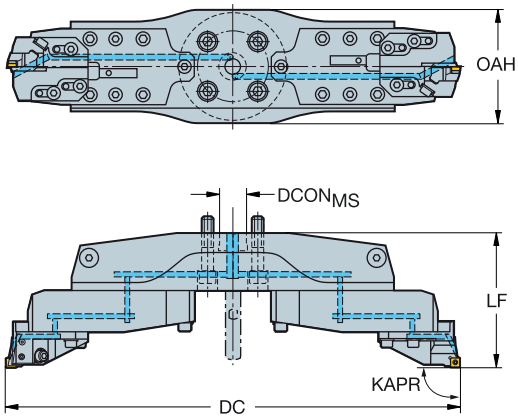


SPMT

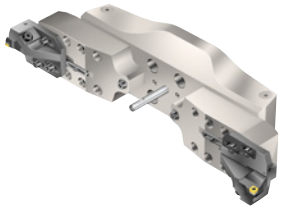
KAPR



90°

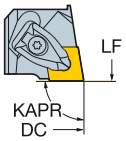


DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	LF	OAH	BAR	KG	CICT	MIID
538.00	780.00	18	40X	1	**820-780SP18**	40.00	1.50	121.00	198.00	164.00	70	39.000	2	SPMT 1810-BM
778.00	1020.00	18	40X	1	**820-1020SP18**	40.00	1.50	121.00	218.00	164.00	70	36.380	2	SPMT 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

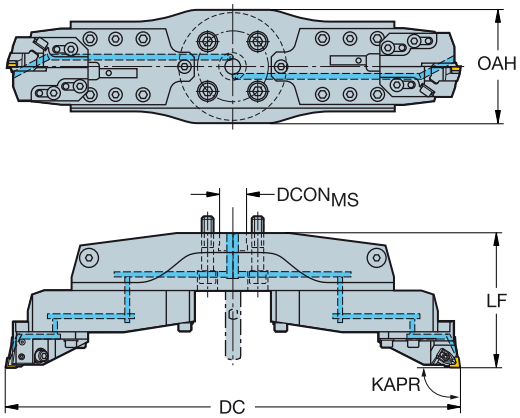


CNMM
CNMG
CNMA, CNGA

KAPR



90°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	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

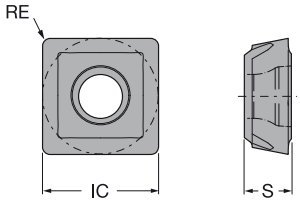
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

K32 K76 N23 N15 K87

CoroBore® 111 inserts for rough boring

S-style insert (Square)



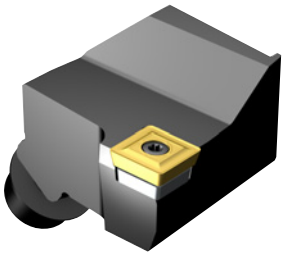
		IC	S	RE	ISO CODE	P 4325	M 2025	K 3210	S 1145
Medium	BM	06	6.0	2.60	0.60	SPMT0606-BM		☆		☆
		08	8.9	3.00	0.80	SPMT0808-BM		☆		☆
		12	12.65	4.00	1.00	SPMT1210-BM		☆		☆
		18	18.6	5.50	1.00	SPMT1810-BM		☆		☆
Roughing	BR	06	6.0	2.60	0.60	SPMT0606-BR	☆		☆	
		08	8.9	3.00	0.80	SPMT0808-BR	☆		☆	
		12	12.65	4.00	1.20	SPMT1212-BR	☆		☆	
		18	18.6	5.50	1.20	SPMT1812-BR	☆		☆	

K91 N23

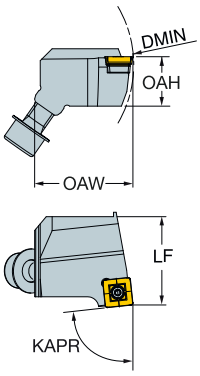
ENG

Cartridge for CoroBore® XL

KAPR 84°

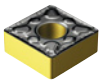


SPMT

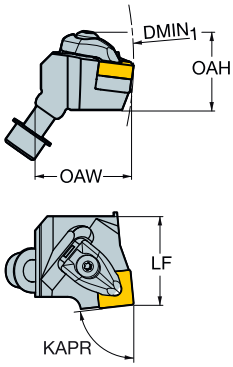


DMIN1		CZCMS	Ordering code	Dimensions, mm LF	HF	WF	OAH	OAL	KG	CICT	MIID
148.0	12	S12	S12-R820XLR40SSYP12	40.00	22.40	42.00	30.16	43.30	0.250	1	SPMT 1210-BM

KAPR 84°



SNMM
SNMG
SNMA, SNGA

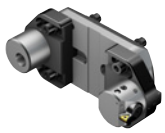


DMIN1		CZCMS	Ordering code	Dimensions, mm LF	LPR	HF	WF	OAH	OAL	KG	CICT	MIID
148.0	15	S12	S12-R820XLR40DSYN15	40.00	41.80	20.00	42.00	39.70	43.80	0.310	1	SNMG 15 06 08

For inserts, see Turning tools catalogue
For spare parts, visit www.sandvik.coromant.com

K32 N23 N15

Fine boring

	Tool concept	Diameter range, mm	Hole tolerance	Cutting edge	Operation	Insert choice	Machine side interface	Page
CoroBore® 824	Conventional	1-20	IT6	- Solid carbide bars - Indexable carbide bars	- Single edge boring	- CoroTurn® 107 - CoroTurn® XS	- Coromant Capto® - Coromant EH	K35-K37
391.37A/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
CoroBore® 826 HP	Conventional	35-154	IT6	- Indexable cartridges	- Single edge boring	- CoroTurn® 107	- Coromant Capto®	K48-K50
CoroBore® 825	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	23-167	IT6	- Indexable cartridges	- Single edge boring - Back boring	- CoroTurn® 107	- Coromant Capto®	K52
CoroBore® 825 XL/CoroBore® 826 XL	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

SANDVIK Coromant

CoroBore® 824

Small-diameter fine boring

Application

- Fine boring
- Single edge boring

ISO application area

P M K N S H

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

Tools

Couplings:
- Coromant Capto®
- Coromant EH

Inserts and cutting tools

Standard inserts with dedicated grades and geometries for all materials
- CoroTurn® XS
- CoroTurn® 107

$DCON_{WS}$	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.

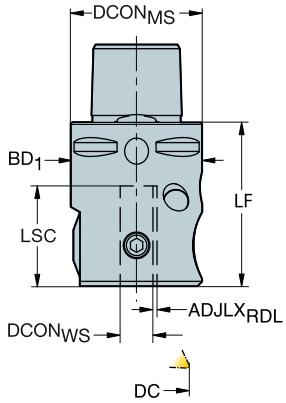
Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.

Coromant Capto® to CoroTurn® XS adaptor

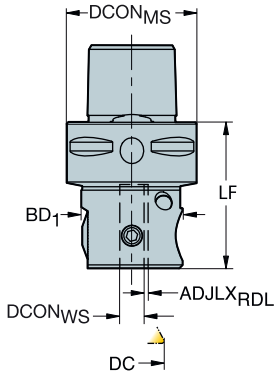
CoroBore® 824 XS

Internal coolant supply

DSGN 1



2

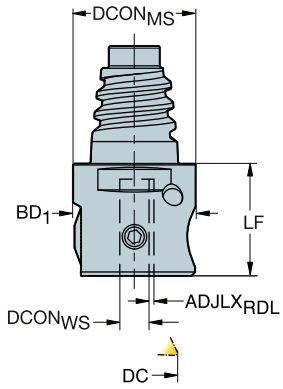


DCN	DCX	CZC_{MS}	CZC_{WS}	CNSC	DSGN	Ordering code	Dimensions, mm $DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	LF	BAR	KG
1.00	6.00	C3	4	3	2	C3-R824XS04-021	32.00	4.00	1.00	36.00	20	0.213
6.00	10.00	C3	6	3	2	C3-R824XS06-016	32.00	6.00	1.00	36.00	20	0.210
10.00	14.00	C3	8	3	1	C3-R824XS08-015	32.00	8.00	1.00	40.00	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



DCN	DCX	CZC_{MS}	CZC_{WS}	CNSC	Ordering code	Dimensions, mm $DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	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

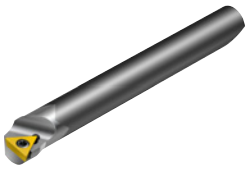
L2 N23 N15

ENG

CoroTurn® XS boring bar for boring

CXS connection - Internal coolant supply

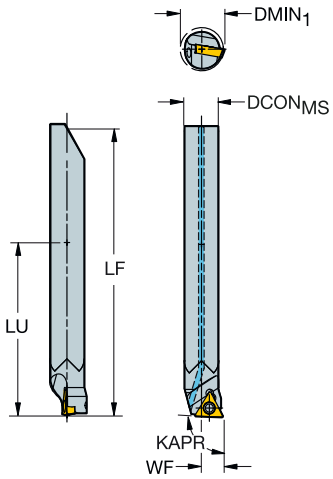
Indexable solid carbide bar



TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR 92°



DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm DCONMS	LU	LF	WF	BAR	KG	CICT	MIID
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

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

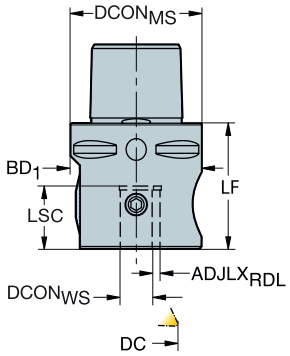
DCON$_{WS}$	Max. rotation speed: RPMX	Diameter range ADJRG (mm)
12	7000	3
16	5000	3
20	3500	5

Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.

ENG

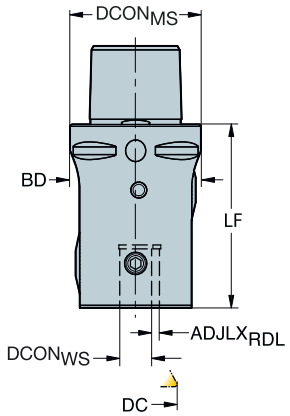
Coromant Capto® to fine boring head adaptor

Internal coolant supply



391.37A adaptor

DCN	DCX	CZC$_{MS}$	CZC$_{WS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	ADJLX$_{RDL}$	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

DCN	DCX	CZC$_{MS}$	CZC$_{WS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	ADJLX$_{RDL}$	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

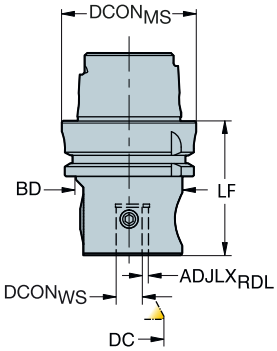
To be used with R429U/R429.90 boring bars

For spare parts, visit www.sandvik.coromant.com

L2 M26 N23 N15

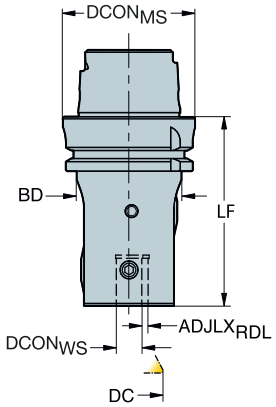
HSK to fine boring head adaptor

Internal coolant supply



391.37A adaptor

DCN	DCX	CZC_{MS}	CZC_{WS}	CNSC	Ordering code	Dimensions, mm $DCON_{MS}$	$DCON_{WS}$	ISO	$ADJLX_{RDL}$	LF	BD_1	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

DCN	DCX	CZC_{MS}	CZC_{WS}	CNSC	Ordering code	Dimensions, mm $DCON_{MS}$	$DCON_{WS}$	ISO	$ADJLX_{RDL}$	LF	BD_1	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

L2 M26 N23 N15

ENG

Boring bar with indexable insert for fine boring heads

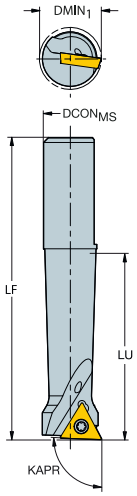
Cylindrical shank - Internal coolant supply

Steel bar

TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR 92°



DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm DCONMS	LU	LF	WF	BAR	KG	CICT	MIID
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

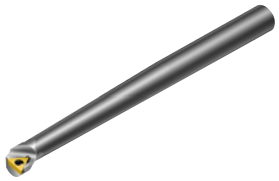
For spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

K39 M26 N23 N15

Boring bar with indexable insert for fine boring heads

Cylindrical shank - Internal coolant supply

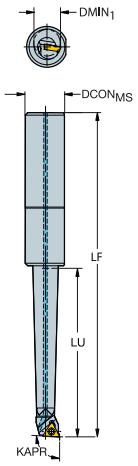
Carbide bar with brazed steel head



TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR 92°

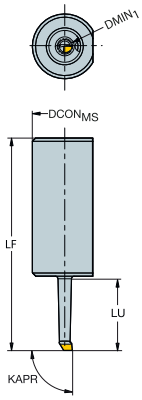


DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm DCONMS	LU	LF	WF	BAR	KG	CICT	MIID
8.0	06	16	1	R429U-E16-08048TC06	16.00	48.00	109.00	4.00	20	0.130	1	TCMT 06 T1 02
11.0	06	16	1	R429U-E16-11066TC06	16.00	66.00	127.00	5.50	20	0.170	1	TCMT 06 T1 02
14.0	09	16	1	R429U-E16-14084TC09	16.00	84.00	145.00	7.00	20	0.275	1	TCMT 09 02 02
17.0	09	16	1	R429U-E16-17096TC09	16.00	96.00	157.00	8.50	20	0.391	1	TCMT 09 02 02
20.0	09	16	1	R429U-E16-20096TC09	16.00	96.00	157.00	10.00	20	0.394	1	TCMT 09 02 02
23.0	09	16	1	R429U-E16-23096TC09	16.00	96.00	157.00	11.50	20	0.395	1	TCMT 09 02 02
26.0	09	16	1	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°



DMIN1	CZCMS	CNSC	Ordering code	P	M	K	N	S	Dimensions, mm DCONMS	LU	LF	WF	BAR	KG
				H10F	H10F	H10F	H10F	H10F						
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

DMIN1	CZCMS	CNSC	Ordering code	Dimensions, mm 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

K39 M26 N23 N15

SANDVIK Coromant

CoroBore® 825

Fine boring tool for high precision boring

Application

- Conventional fine boring
- Back boring

ISO application area

P M K N S H

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

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

J

Application

- High precision fine boring

ISO application area

P M K N S H

K

Benefits and features

- High precision coolant directed at the cutting edge for excellent chip control up to 80 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 IT5
- CoroBore® 826 high precision adjusts the cutting edge with a resolution of 2 micrometer on diameter

L

www.sandvik.coromant.com/corobore826

Tools

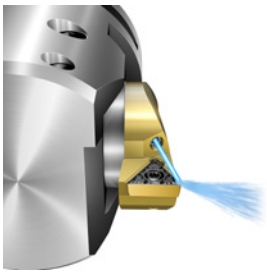
Couplings:
- Coromant Capto®

Inserts

Standard inserts with dedicated grades and geometries for all materials
- CoroTurn® 107

M

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

N

ENG

CoroBore® 825 fine boring tool

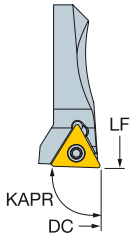
Coromant Capto® - Internal coolant supply

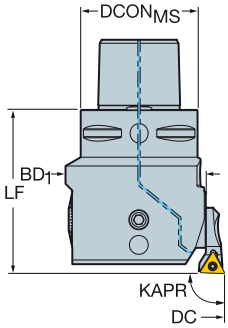
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

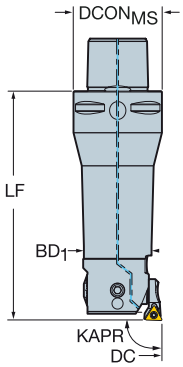
KAPR
DSGN

92°
1





92°
2



							Dimensions, mm								
DCN	DCX		CZC_{MS}	CNSC	DSGN	Ordering code	$DCON_{MS}$	$ADJLX_{RDL}$	ULDR	LF	BD_1	BAR	KG	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
For inserts, see Turning tools catalogue
For all DSGN 2; LU = DC*ULDR

L2 N23 N15 K89

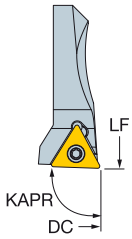
CoroBore® 825 fine boring tool

Cylindrical shank - Internal coolant supply

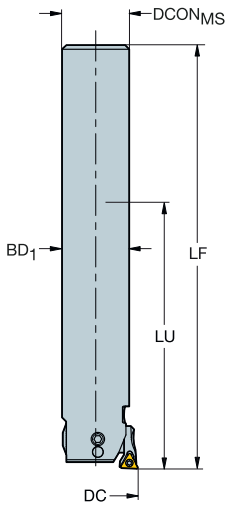
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR



92°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LU	LF	BD$_1$	BAR	KG	CICT	MIID
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

For inserts, see Turning tools catalogue

L2 N23 N15 K89

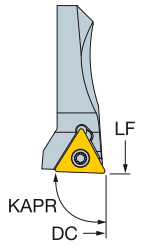
CoroBore® 825 fine boring tool

Coromant EH coupling - Internal coolant supply

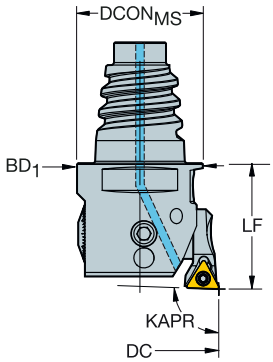
TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR



92°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	BD$_1$	BAR	KG	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

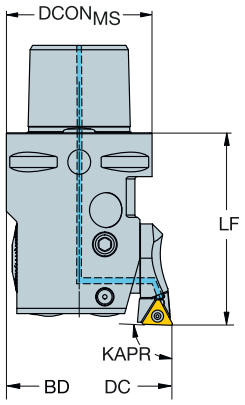
For inserts, see Turning tools catalogue

L2 N23 N15 K89

CoroBore® 826 fine boring tool

Coromant Capto® - Precision coolant supply

KAPR 92°



TCMT, TCMX, TCGT, TCGX TCEX

TCMW

DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	BD$_1$	BAR	KG	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

For inserts, see Turning tools catalogue

L2 N23 N15 K89

ENG

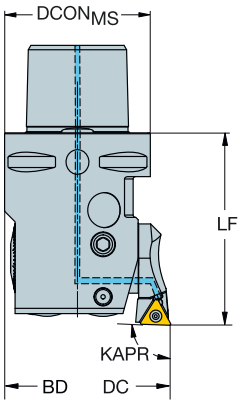
CoroBore® 826 fine boring tool

Coromant Capto® - Precision coolant supply

TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR 92°



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	BD$_1$	BAR	KG	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

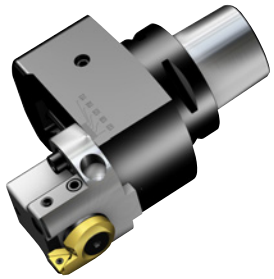
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning tools catalogue

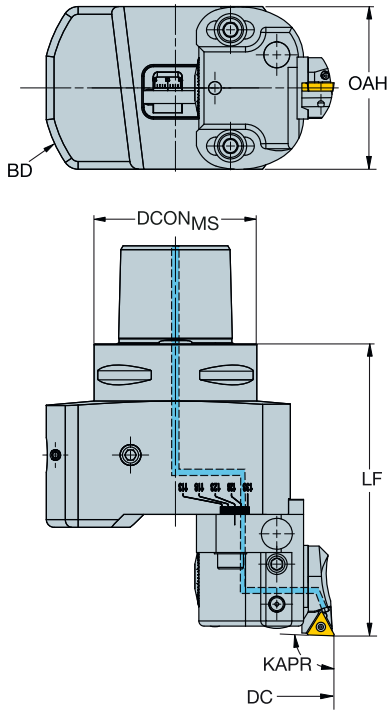
L2 N23 N15 K89

CoroBore® 826 fine boring tool

Coromant Capto® - Internal coolant supply



KAPR 92°



TCMT, TCMX, TCGT, TCGX TCEX

TCMW

DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	OAH	BD$_1$	BAR	KG	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

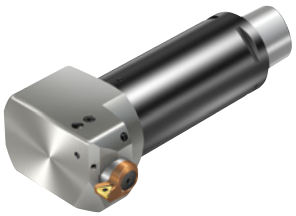
For inserts, see Turning tools catalogue

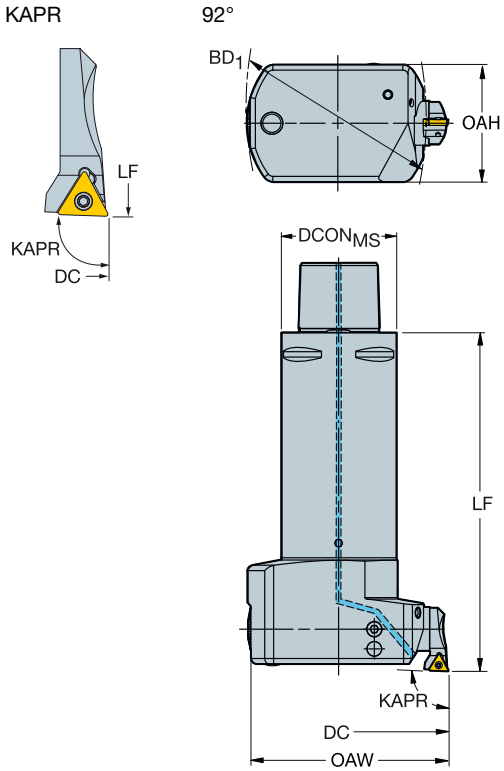
L2 N23 N15 K89

ENG

CoroBore® 825 lightweight fine boring tool

Coromant Capto® - Internal coolant supply





TCMT, TCMX, TCGT, TCGX TCEX

TCMW

DCN	DCX		CZC_{MS}	CNSC	Ordering code	Dimensions, mm $DCON_{MS}$	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR	KG	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

For inserts, see Turning tools catalogue

L2 N23 N15 K89

CoroBore® 825 damped fine boring tool

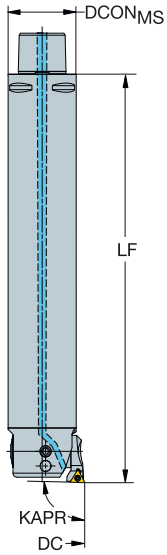
Coromant Capto® - Internal coolant supply

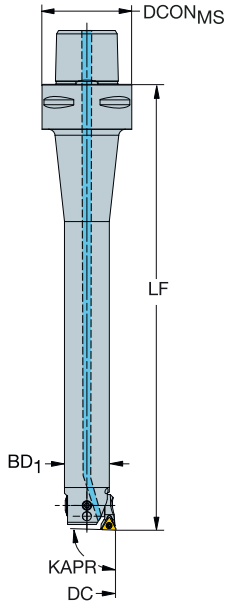
SilentTools®

TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR	92°	92°
DSGN	1	2





DCN	DCX		CZC$_{MS}$	CNSC	DSGN	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	ULDR	LF	OAH	BD$_1$	BAR	KG	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		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		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	401.00		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		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		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		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		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		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		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		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		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		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
For inserts, see Turning tools catalogue

L2 N23 N15 K89

CoroBore® 825 XL/CoroBore® 826 XL

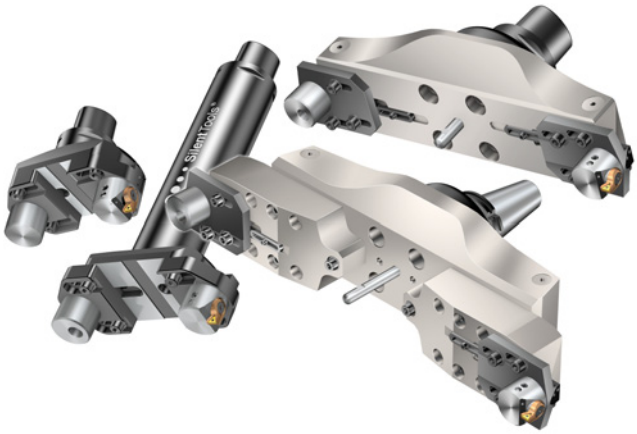
Fine boring tool for large diameters

Application

- Fine boring
- Back boring
- External operations

ISO application area

P M K N S H



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

SilentTools®

Tools

Couplings:
- Coromant Capto®
- Arbor

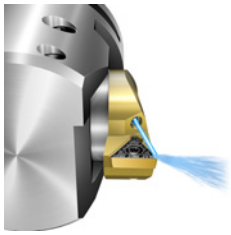
Inserts

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.

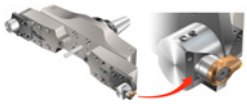


High precision coolant nozzle for precise coolant flow to cutting edge

Available as lightweight tools. Bore large diameters without increasing the tool weight.

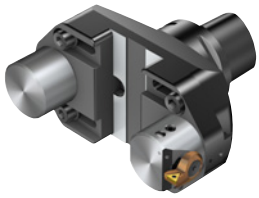
Use same bridge/bridge extension for roughing, finishing and face grooving from diameter 150 mm (counterweight needed for finishing).

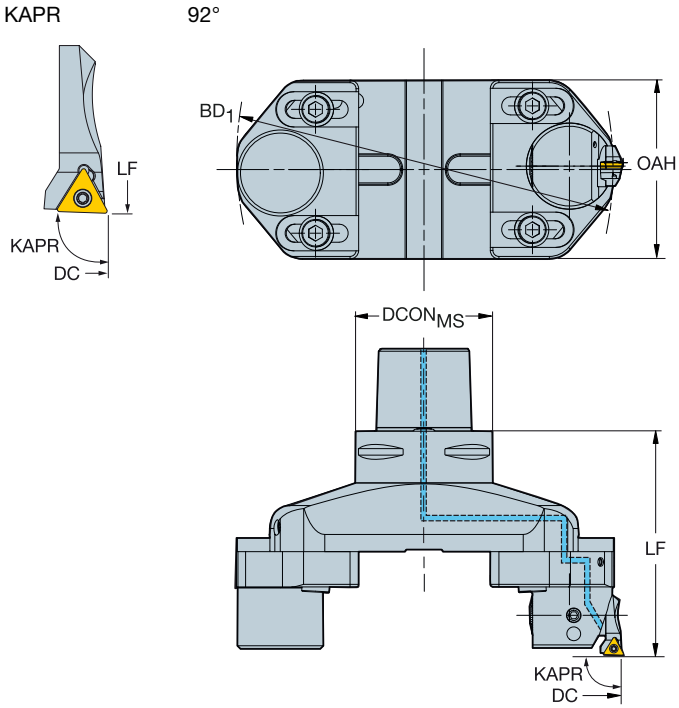
Use slide extensions for radial adjustment and back boring



CoroBore® 825 XL fine boring tool

Coromant Capto® - Internal coolant supply





TCMT, TCMX, TCGT, TCGX TCEX

TCMW

DCN	DCX	⟷	CZC_{MS}	CNSC	Ordering code	$DCON_{MS}$	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR	KG	CICT	MIID
						Dimensions, mm								
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

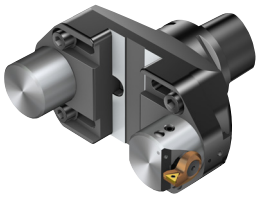
For inserts, see Turning tools catalogue

L2 N23 N15 K90

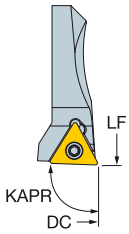
ENG

CoroBore® 826 XL fine boring tool

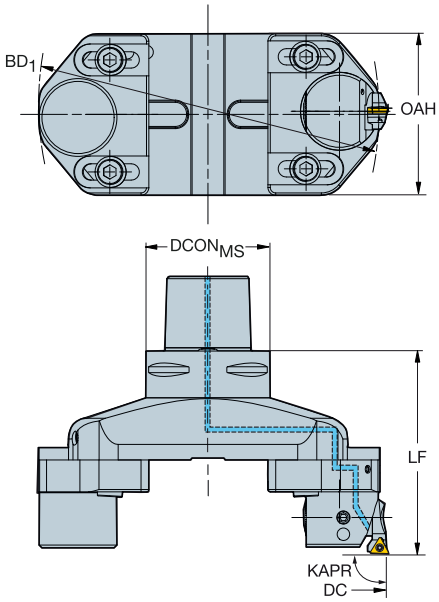
Coromant Capto® - Internal coolant supply



KAPR
STDNO



92°
ISO26623-1



TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

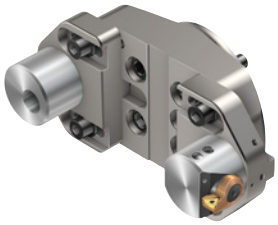
DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm $DCON_{MS}$	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR PSI	KG	CICT	MIID
154.35	207.65	11	1/4	C6	3	826-207TC11-C6HP	63.00	26.65	125.00	104.00	145.00	70	3.560	1	TCMT 11 03 04
154.35	207.65	11	1/4	C8	3	826-207TC11-C8HP	80.00	26.65	137.00	104.00	145.00	70	6.430	1	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

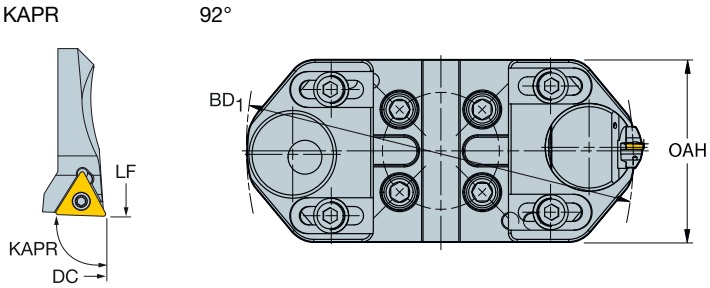
Diameters are valid when frontboring.
Backboring is not recommended with CoroBore® 826
For more information about use of slide extensions, see page K92
For more information about external boring, see page K94
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

L2 N23 N15 K90

CoroBore® 825 XL lightweight fine boring tool

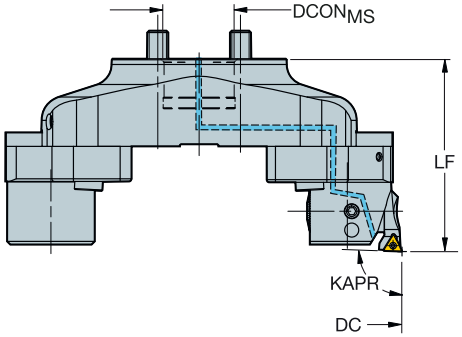
Arbor - Internal coolant supply





TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW



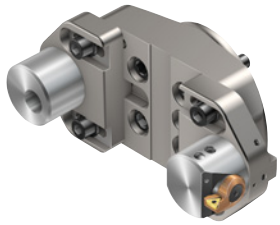
DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	DCON$_{MS}$	ADJLX$_{RDL}$	LF	OAH	BD$_1$	BAR	KG	CICT	MIID
						Dimensions, mm								
148.00	215.00	11	40S	1	**825L-215TC11**	40.00	33.50	110.00	104.00	145.00	70	4.450	1	TCMT 11 03 04
198.00	265.00	11	40S	1	**825L-265TC11**	40.00	33.50	110.00	104.00	195.00	70	4.920	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

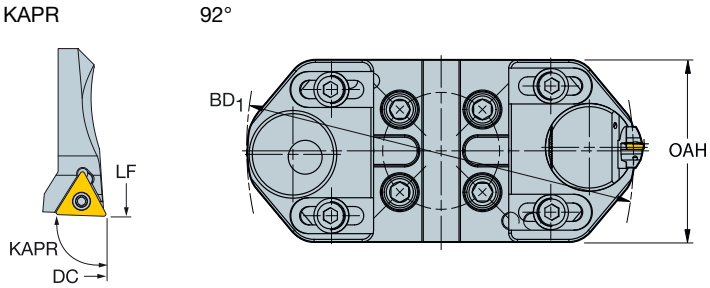
Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.
Diameters are valid when frontboring.
For more information about backboring, see page K92
For more information about use of slide extensions, see page K90
For more information about external boring, see page K94
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

L2 N23 N15 K90

CoroBore® 826 XL lightweight fine boring tool

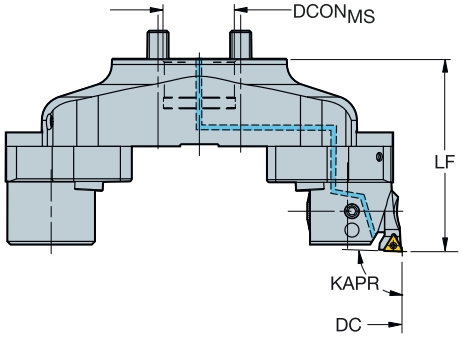
Arbor - Internal coolant supply





TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ISO	ADJLX$_{RDL}$	LF	OAH	BD$_1$	BAR	KG	CICT	MIID
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

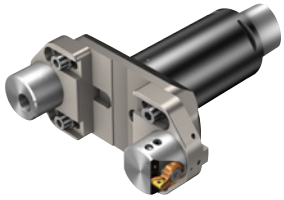
Use with 40S facemill holders, for example: C8-391.05-40 060M. To be ordered separately.
Backboring is not recommended with CoroBore® 826
For more information about external boring, see page K94
For more information about use of slide extensions, see page K90
Diameters are valid when frontboring.

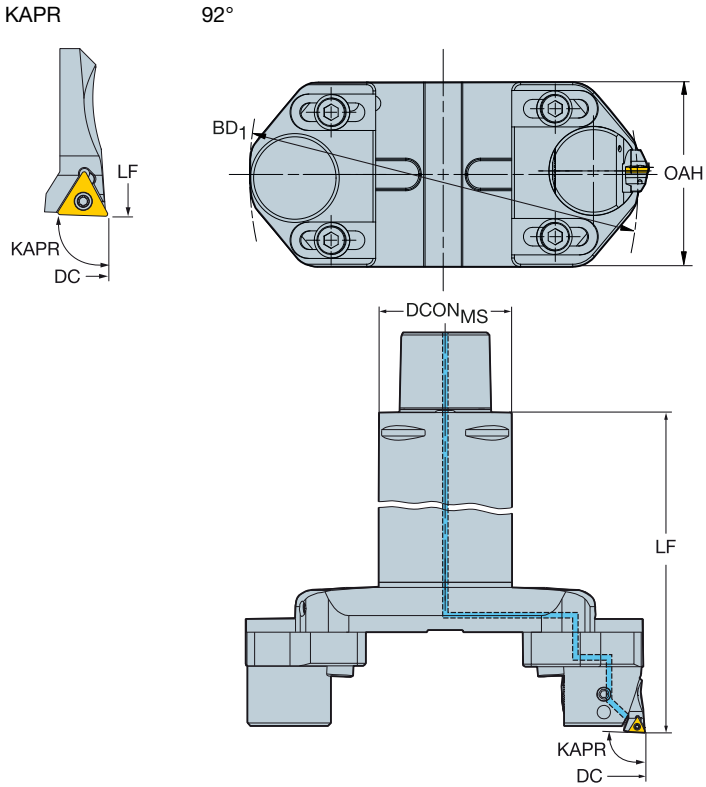
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

L2 N23 N15 K90

CoroBore® 825 XL lightweight fine boring tool

Coromant Capto® - Internal coolant supply





TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW

DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	OAH	BD$_1$	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

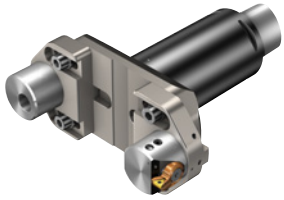
Diameters are valid when frontboring.
For more information about external boring, see page K94
For more information about backboring, see page K92
For more information about use of slide extensions, see page K90
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

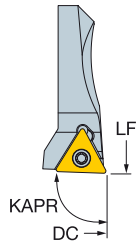
L2 N23 N15 K90

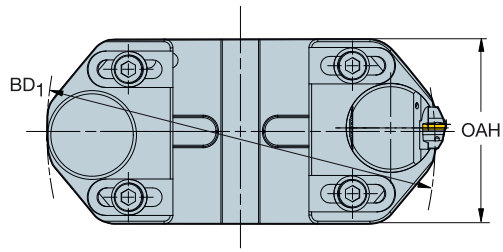
ENG

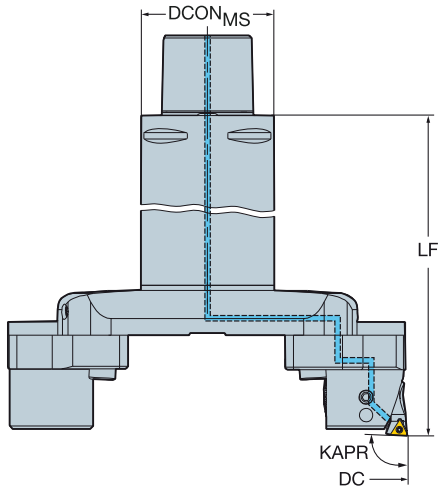
CoroBore® 826 XL lightweight fine boring tool

Coromant Capto® - Internal coolant supply









TCMT, TCMX, TCGT, TCGX TCEX

TCMW

DCN	DCX	⟷	CZC_{MS}	CNSC	Ordering code	Dimensions, mm $DCON_{MS}$	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR	KG	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

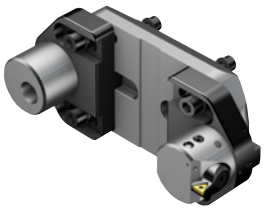
For inserts, see Turning tools catalogue

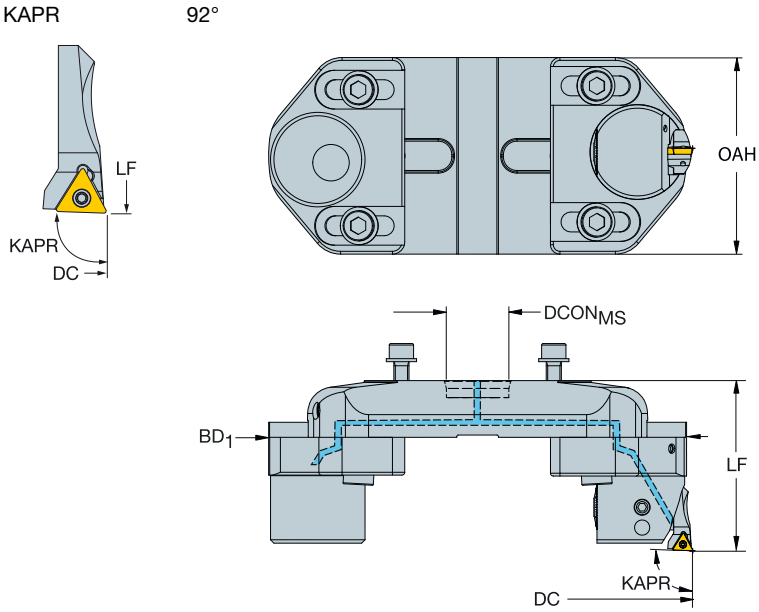
L2 N23 N15 K90

CoroBore® 825 XL fine boring tool

Arbor - Internal coolant supply

Dedicated for Silent Tools boring





TCMT, TCMX, TCGT, TCGX TCEX

TCMW

DCN	DCX	⟷	CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	OAH	BD$_1$	BAR	KG	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
For inserts, see Turning tools catalogue

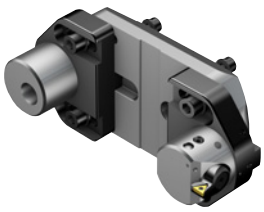
K77 N23 N15 K90

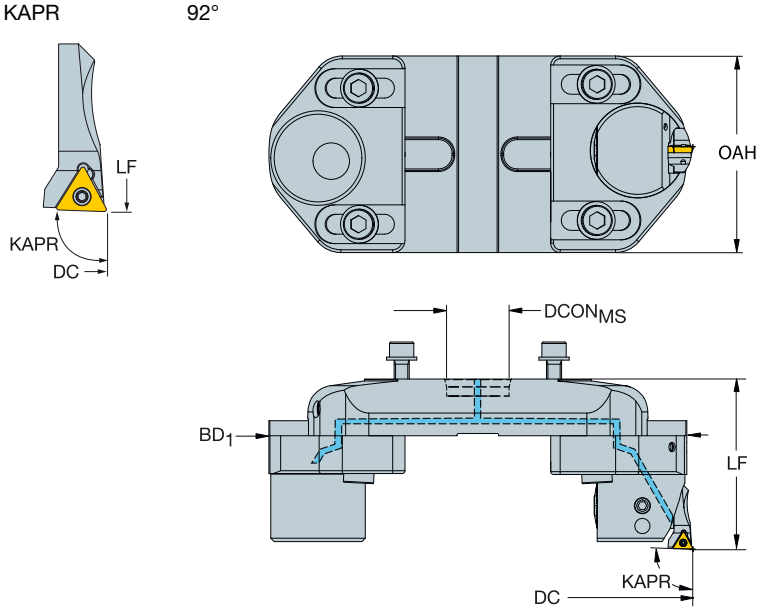
ENG

CoroBore® 826 XL fine boring tool

Arbor - Internal coolant supply

Dedicated for Silent Tools boring





TCMT, TCMX, TCGT, TCGX TCEX

TCMW

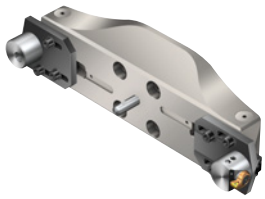
DCN	DCX	⟷	CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	OAH	BD$_1$	BAR	KG	CICT	MIID
154.35	207.65	11	33	1	**826D-207TC11HP**	33.00	26.65	97.00	104.00	145.00	70	2.770	1	TCMT 11 03 04
204.35	257.65	11	33	1	**826D-257TC11HP**	33.00	26.65	97.00	104.00	195.00	70	3.110	1	TCMT 11 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
For inserts, see Turning tools catalogue

K77 N23 N15 K90

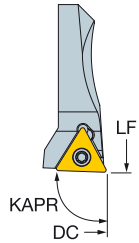
CoroBore® 825 XL fine boring tool

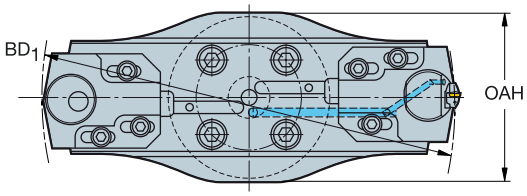
Arbor - Internal coolant supply

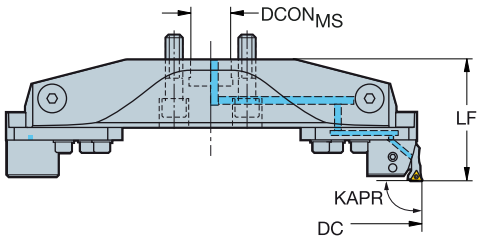


TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW







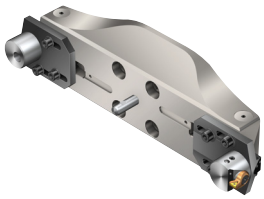
DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	OAH	BD$_1$	BAR	KG	CICT	MIID
298.00	395.00	11	40X	1	825-395TC11	40.00	48.50	114.00	164.00	295.00	70	10.385	1	TCMT 11 03 04
378.00	475.00	11	40X	1	825-475TC11	40.00	48.50	119.00	164.00	375.00	70	12.280	1	TCMT 11 03 04
458.00	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
For inserts, see Turning tools catalogue

K76 N23 N15 K90

CoroBore® 826 XL fine boring tool

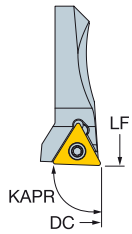
Arbor - Internal coolant supply



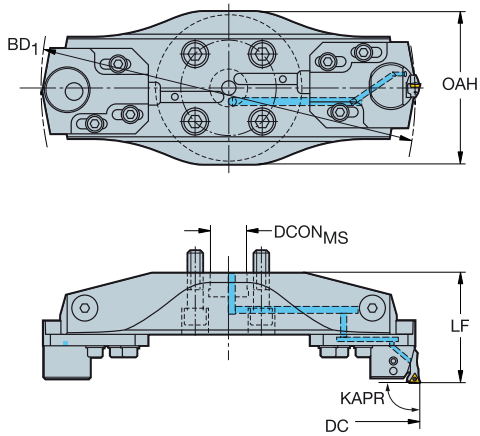
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR



92°



DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	$DCON_{MS}$	$ADJLX_{RDL}$	LF	OAH	BD_1	BAR PSI	KG	CICT	MIID
							Dimensions, mm								
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

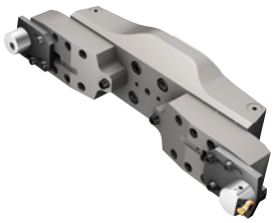
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

K76 N23 N15 K90

CoroBore® 825 XL fine boring tool

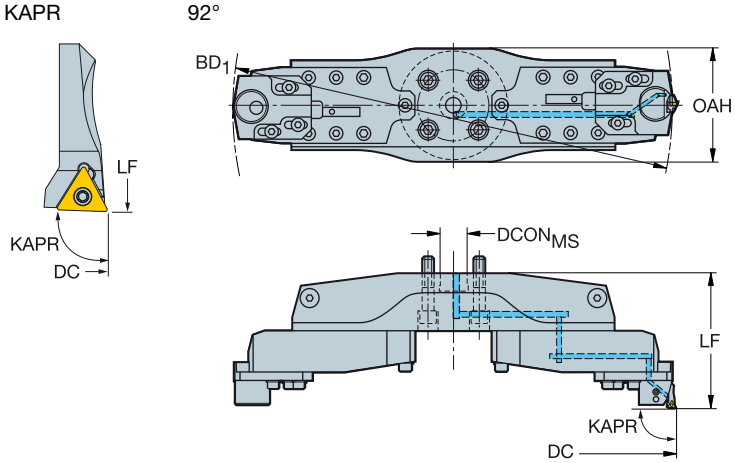
Arbor - Internal coolant supply

With bridge extension



TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LF	OAH	BD$_1$	BAR	KG	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

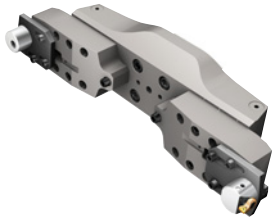
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning tools catalogue

K76 N23 N15 K90

CoroBore® 826 XL fine boring tool

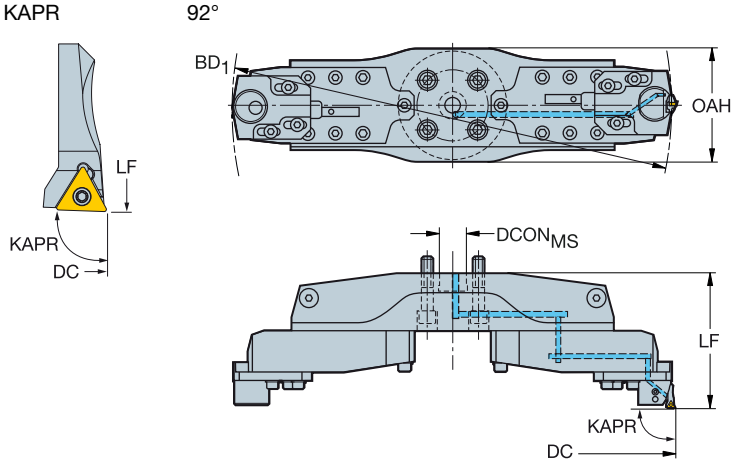
Arbor - Internal coolant supply

With bridge extension



TCMT, TCMX, TCGT, TCGX TCEX

TCMW



DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	DCON$_{MS}$	ADJLX$_{RDL}$	LF	OAH	BD$_1$	BAR	KG	CICT	MIID
						Dimensions, mm								
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.

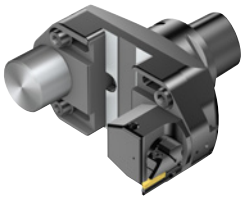
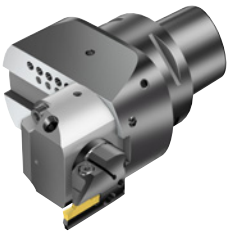
In case of direct flange to the machine spindle, use centering plug, see page K77

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

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
CoroCut® MB	14-50	IT7	1	- Face grooving	- CoroCut® MB	- Coromant Capto®	K67
CoroBore® 825 SL 	47-150	IT7	1	- Face grooving	- CoroCut®	- Coromant Capto®	K68-K69
CoroBore® 825 SL XL 	148-1275	IT7	1	- Face grooving	- CoroCut®	- Coromant Capto® - 40X with 4 bolt circle	K70
SpiroGrooving™	30-289		1 (Internal and external)	- Spirogrooving	- CoroTurn® 107	- Coromant Capto®	K71-K73

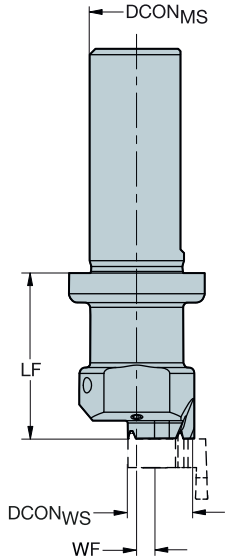
ENG

Cylindrical shank to CoroCut® MB adaptor

For face grooving

Internal coolant supply

MB...FA



				Dimensions, mm					
CZC_{MS}	CZC_{WS}	CNSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	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

Recommended adaptors:

A16: 391.37A

L2 N23 N15

CoroBore® 825 SL

Face grooving

J

Application

- Face grooving
- Axial grooving

ISO application area:

P M K N S H

K

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

L

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.

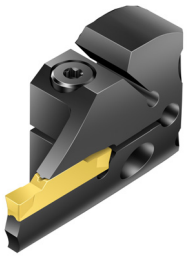
M

825 - Adjusts diameter 0.002 mm with a nonius scale. A 360° turn change diameter by 0.5 mm.

Radially fine adjustable face grooving heads for pre-setting with same interface as CoroBore 825 fine boring head

First choice geometries: -CM or -TF depending on chosen nose radius. Recommended starting value for feed: 0.15 mm/rev

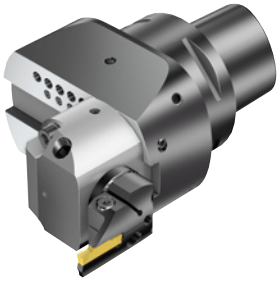
If grooves with larger width tolerance is required, chose -GF geometry. Recommended starting value for feed: 0.10 mm/rev

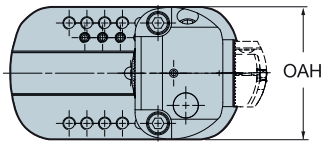


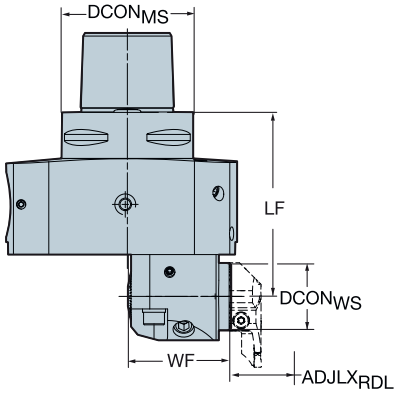
N

Coromant Capto® to CoroTurn® SL adjustable adaptor

Coromant Capto® - Internal coolant supply

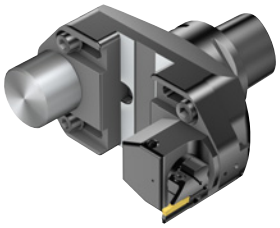


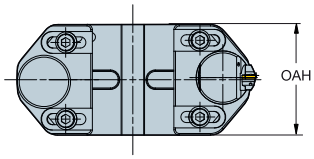


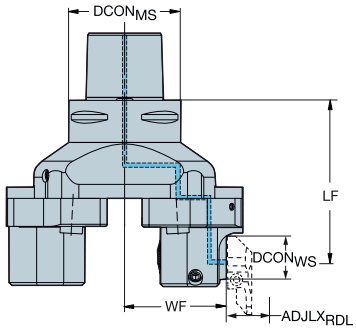


CoroBore® 825 fine adjustment

				Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	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_{MS}	CZC_{WS}	CNSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	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

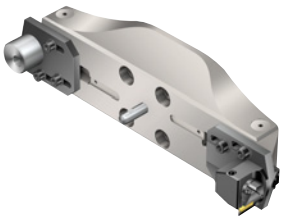
CoroTurn® SL head diameter and tool diameter range should match the requirement of the component. For more information about CoroTurn® SL heads, see Turning tools catalogue

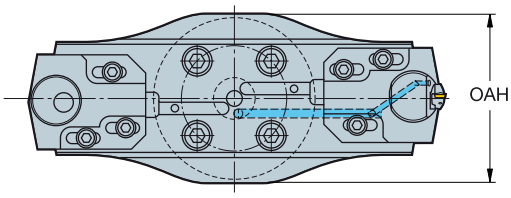
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

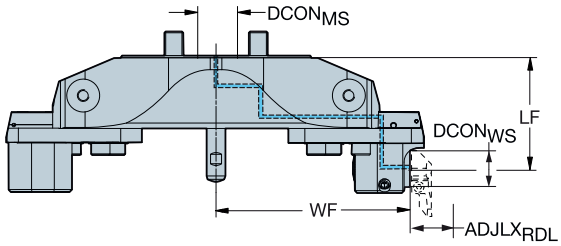
L2 N23 N15

Arbor to CoroTurn® SL adjustable adaptor

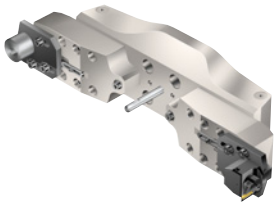
Arbor - Internal coolant supply

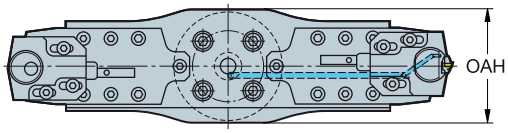


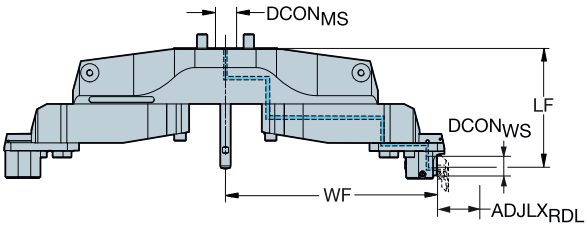




				Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	LF	LPR	WF	OAH	OAW	BAR	KG
40X	32	1	825-395SL32	40.00	32.00	48.50	96.00	117.00	131.00	164.00	334.00	20	8.980
40X	32	1	825-475SL32	40.00	32.00	48.50	101.00	122.00	171.00	164.00	414.00	20	12.830
40X	32	1	825-555SL32	40.00	32.00	48.50	106.00	127.00	211.00	104.00	494.00	20	12.670







With bridge extension

				Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	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

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:

P M K N S H

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

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.

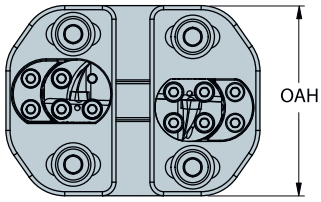
Wondering how to program?

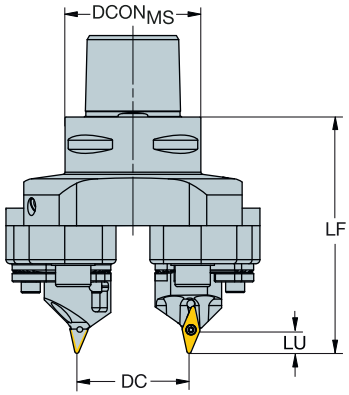
With the SpiroGrooving NC-code generator you can get your NC code in a few quick steps.
NC-code generator – input groove geometry and cutting parameters and receive an NC-code

CoroBore® XL adjustable tool for SpiroGrooving™

Coromant Capto® - Internal coolant supply

KAPR 67°





VCMT

Radially and axially adjustable

DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	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

For inserts, see Turning tools catalogue

L2 N23 N15

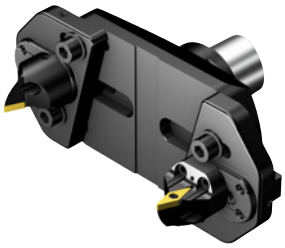
SANDVIK Coromant

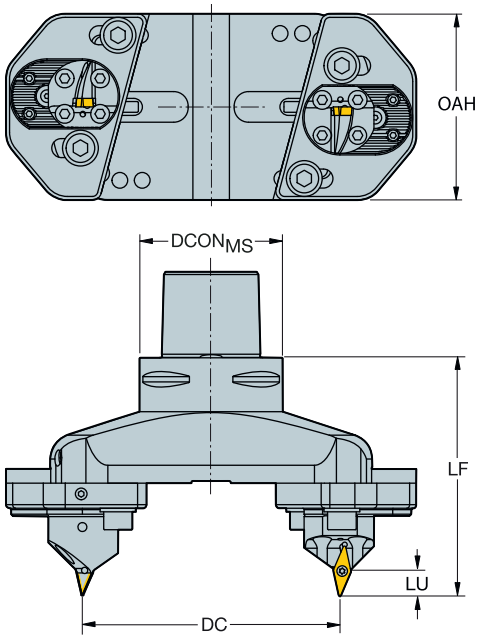
ENG

CoroBore® XL adjustable tool for SpiroGrooving™

Coromant Capto® - Internal coolant supply

KAPR 67°





VBMT

Radially and axially adjustable

DCN	DCX		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	ADJLX$_{RDL}$	LU	LF	OAH	BAR	KG	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
For inserts, see Turning tools catalogue

L2 N23 N15

Interpolation turning

Turning the unturnable

J

Application

Interpolation turning is a new, flexible turning method developed for advanced machining centres and B-axis multi-task machines.

ISO application area:

P M K N S H

K

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)

L

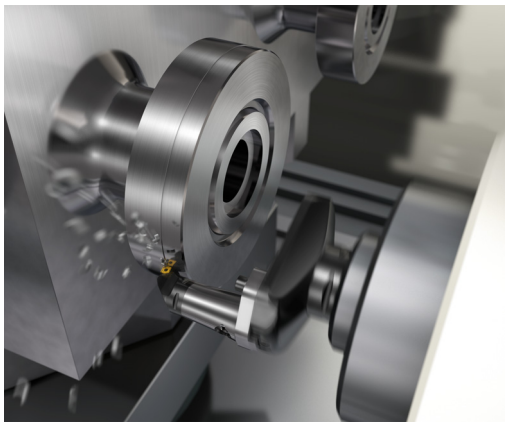
Tools

- Coromant Capto®

Inserts

- CoroTurn® 107

M



N

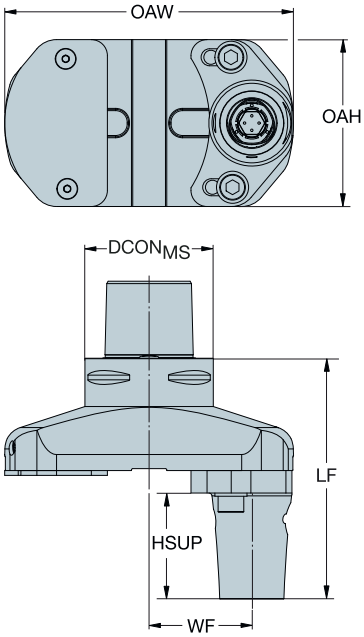
Component can be machined completely without moving it- especially beneficial for large non-symmetrical components

ENG

Coromant Capto® adjustable adaptor with Quick change

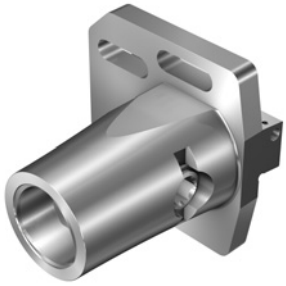
For Interpolation Turning

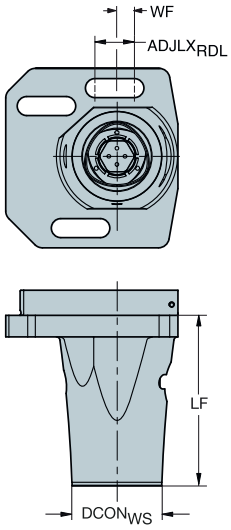
Internal coolant supply



CZCMS	CZCWS	CNSC	Ordering code	Dimensions, mm DCONMS	DCONWS	ADJLXRDL	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





CZCMS	CZCWS	CNSC	Ordering code	Dimensions, mm DCONWS	ADJLXRDL	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

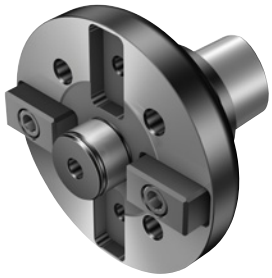
For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

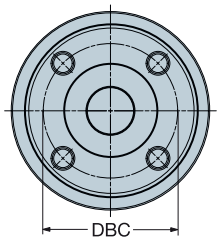
For cutting heads and inserts, see Turning tools catalogue

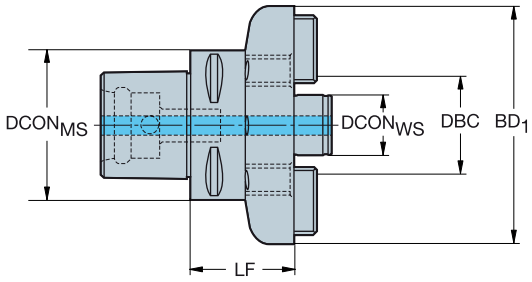
L2 N23 N15

Coromant Capto® to CoroBore® XL adaptor

Internal coolant supply



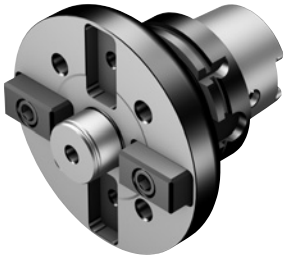


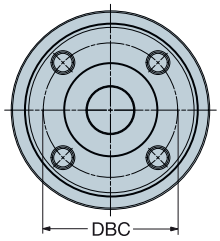


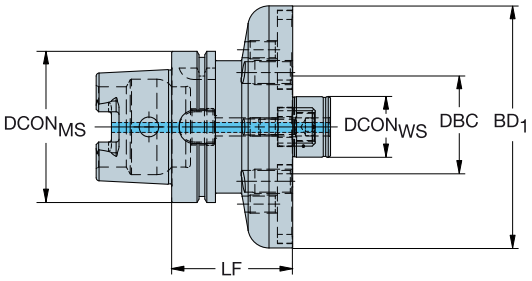
					Dimensions, mm						
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	**Ordering code**	DCON$_{MS}$	DBC	DCON$_{WS}$	LF	BD$_1$	BAR	KG
C8	40X	1	1	**C8-391.XL-40 065**	80.0	101.6	40.0	65.0	160.0	80	7.09
C10	40X	1	1	**C10-391.XL-40 070**	100.0	101.6	40.0	70.0	160.0	80	8.67

HSK to CoroBore® XL adaptor

Internal coolant supply



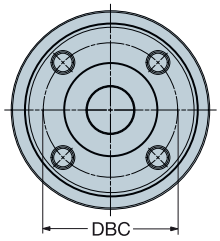


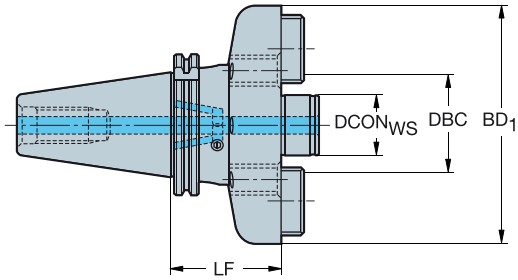


						Dimensions, mm						
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	**Ordering code**	DCON$_{MS}$	DBC	DCON$_{WS}$	LF	BD$_1$	BAR	KG
100	40X	1	1	1	**392.410XL-10040 080**	100.0	101.6	40.0	80.0	160.0	80	8.16

ISO 7388-1 to CoroBore® XL adaptor

Internal coolant supply





ISO7388.1/MAS-BT 403

						Dimensions, mm						
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	**Ordering code**	DBC	DCON$_{WS}$	LF	LB$_1$	BD$_1$	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.

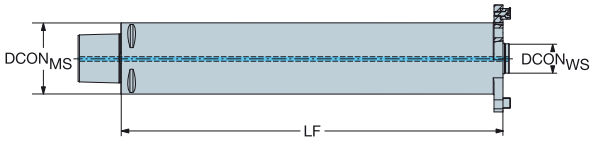
N23

N15

ENG

Coromant Capto® to CoroBore® XL damped tool body

Internal coolant supply



SilentTools®

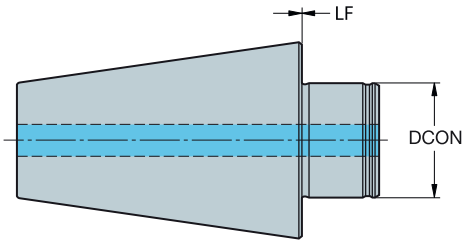
CZC$_{MS}$	CZC$_{WS}$	CNSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LF	BAR	KG
C8	33	3	C8-R822XLA33-F410	80.00	33.00	410.00	70	17.800
C10	33	3	C10-R822XLA33-F560	100.00	33.00	560.00	70	26.400

For boring tool components, accessories and spare parts, visit www.sandvik.coromant.com

See page K27 for boring tool kit to be used with this adaptor

Centering plug

Internal coolant supply



ISO7388.1/MAS-BT 403

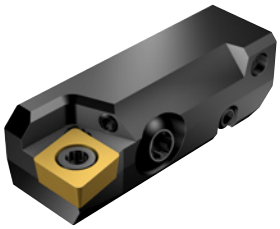
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm LF	BAR	KG
50	40 plug	1	1	392.647XL-5040	0.0	80	8.93

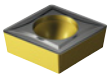
L2 N23 N15

Indexable boring cartridge

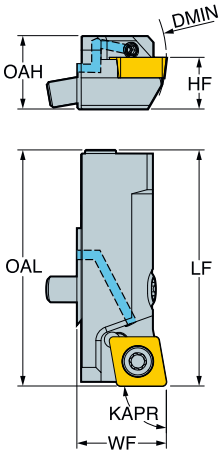
Axial and radial adjustment

KAPR 90°



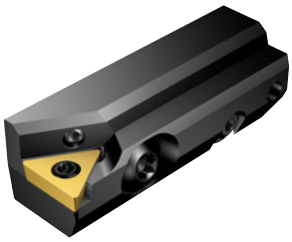


CCMT, CCGT
CCGX, CCET
CCMW

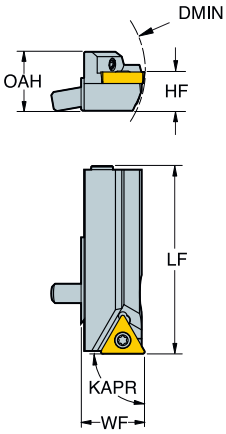


DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm ADJLXAXL	ADJLXRDL	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID
25.0	06	08CB	2	SCFCR08CBX06	0.50	0.20	40.00	8.00	13.50	12.20	40.00	70	0.050	1	CCMT 06 02 04
40.0	09	10CB	2	SCFCR10CBX09	0.50	0.20	45.00	10.00	16.50	14.20	45.00	70	0.070	1	CCMT 09 T3 08
50.0	12	12CB	2	SCFCR12CBX12	0.50	0.20	50.00	12.00	19.00	16.20	50.00	70	0.100	1	CCMT 12 04 08

KAPR 90°



TCMT, TCMX,
TCGT, TCGX
TCEX
TCMW



DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm ADJLXAXL	ADJLXRDL	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

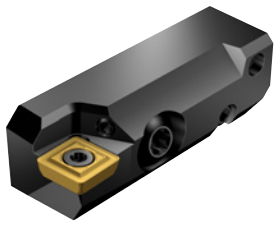
N23 N15

ENG

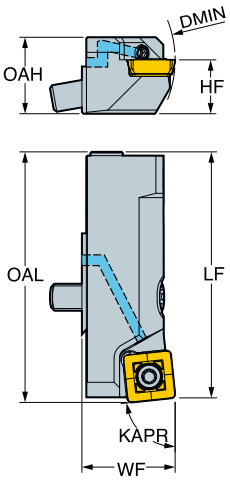
Indexable boring cartridge

Axial and radial adjustment

KAPR 84°



SPMT



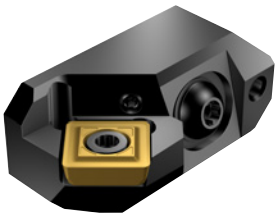
DMIN$_1$		CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm ADJLX$_{AXL}$	ADJLX$_{RDL}$	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID
25.0	06	08CB	2	SSYPR08CBX06	0.50	0.20	40.00	8.00	13.50	12.20	40.60	70	0.050	1	SPMT 0606-BM
40.0	08	10CB	2	SSYPR10CBX08	0.50	0.20	45.00	10.00	16.50	14.20	45.80	70	0.070	1	SPMT 0808-BM
50.0	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

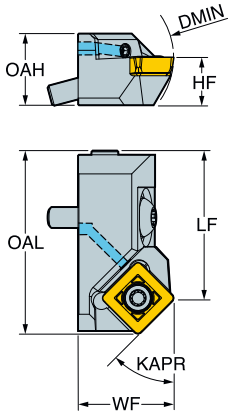
Indexable boring cartridge

Axial adjustment

KAPR 45°

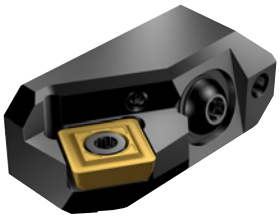


SPMT

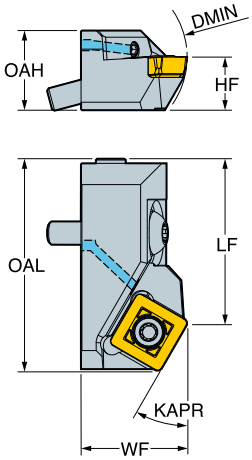


DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm ADJLXAXL	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID
20.0	06	06CC	2	SSSPR06CCX06	0.50	21.00	6.00	11.00	10.20	24.80	70	0.020	1	SPMT 0606-BM
25.0	08	08CC	2	SSSPR08CCX08	0.50	25.00	8.00	16.00	12.20	30.70	70	0.040	1	SPMT 0808-BM
40.0	12	10CC	2	SSSPR10CCX12	0.50	32.00	10.00	21.00	14.00	40.20	70	0.070	1	SPMT 1210-BM

KAPR 30°



SPMT



DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm ADJLXAXL	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID
20.0	06	06CC	2	SSTPR06CCX06	0.50	21.00	6.00	11.00	10.20	25.60	70	0.020	1	SPMT 0606-BM
25.0	08	08CC	2	SSTPR08CCX08	0.50	25.00	8.00	16.00	12.20	31.90	70	0.040	1	SPMT 0808-BM
40.0	12	10CC	2	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

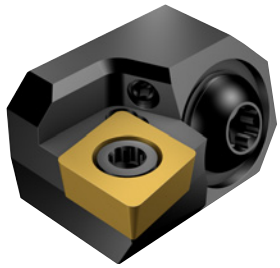
K32 N23 N15

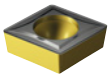
ENG

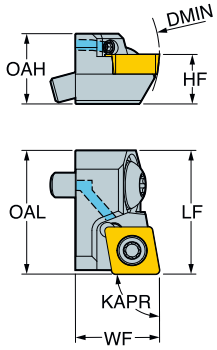
Indexable boring cartridge

No adjustment

KAPR 90°





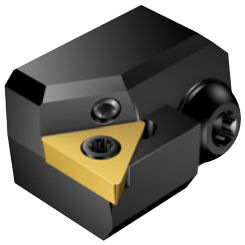


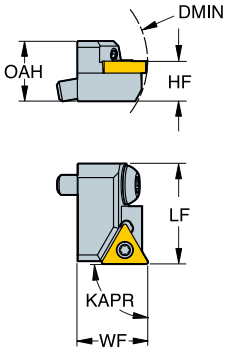
CCMT, CCGT
CCGX, CCET

CCMW

DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID
20.0	06	06CD	2	SCFCR06CDX06	16.00	6.00	11.00	10.20	16.00	70	0.020	1	CCMT 06 02 04
25.0	06	08CD	2	SCFCR08CDX06	20.00	8.00	14.00	12.00	20.00	70	0.030	1	CCMT 06 02 04
40.0	09	10CD	2	SCFCR10CDX09	25.00	10.00	17.00	14.20	25.00	70	0.050	1	CCMT 09 T3 08
50.0	12	12CD	2	SCFCR12CDX12	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

DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm LF	HF	WF	OAH	OAL	BAR	KG	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

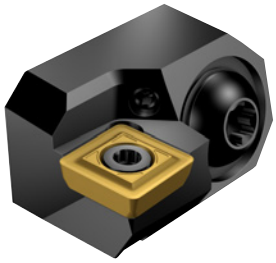
For inserts, see Turning tools catalogue

N23 N15

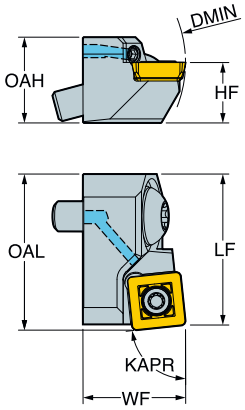
Indexable boring cartridge

No adjustment

KAPR 84°



SPMT

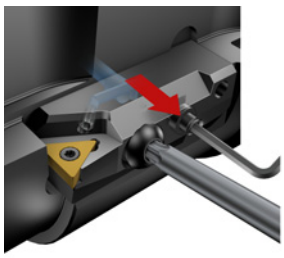


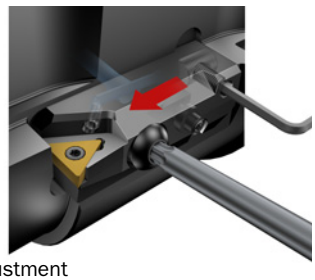
DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID
20.0	06	06CD	2	SSYPR06CDX06	16.00	6.00	11.00	10.20	16.60	70	0.020	1	SPMT 0606-BM
25.0	08	08CD	2	SSYPR08CDX08	20.00	8.00	14.00	12.20	20.80	70	0.030	1	SPMT 0808-BM
40.0	08	10CD	2	SSYPR10CDX08	25.00	10.00	17.00	14.00	25.80	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®

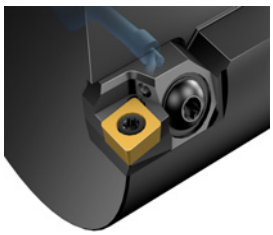
Built-in cartridges - CB, CC and CD



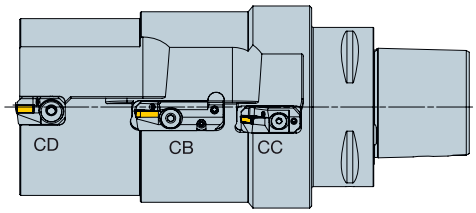


CB - Boring axial and radial adjustment

CC - Chamfer axial adjustment



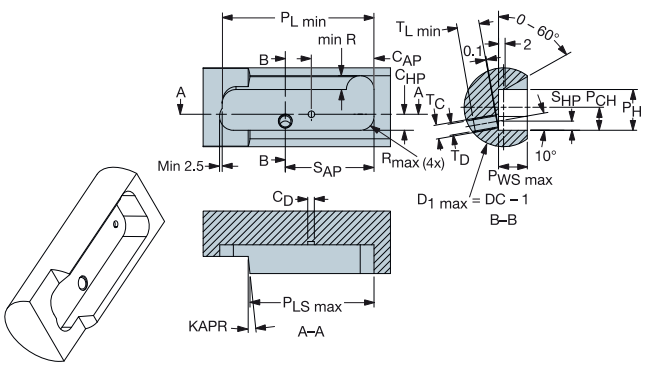
CD - Fixed, no adjustment



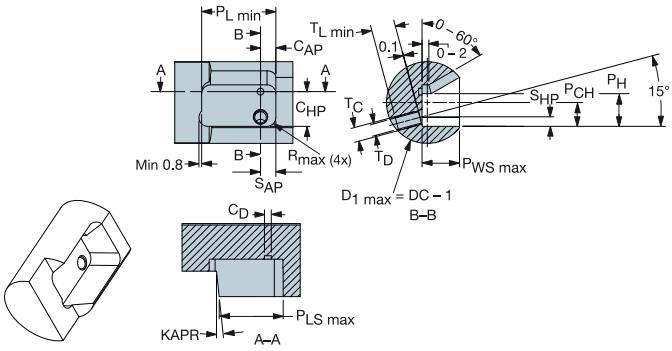
Size/type	Clamping set	Clamping torque (Nm)	Key size
06CB	5519 201-01	4.8	15IP
10CB	5519 201-02	9.0	20IP
12CB	5519 201-03	16.0	25IP
06CC	5519 202-01	3.2	10IP
08CC	5519 202-02	4.8	15IP
10CC	5519 202-04	16.0	25IP
06CD	5519 202-01	3.2	10IP
08CD	5519 202-02	4.8	15IP
10CD	5519 202-03	16.0	25IP
12CD	5519 202-04	16.0	25IP

Parameter	Description
P_L min	Pocket length min
P_{CH}	Pocket center height
P_H	Pocket height
P_{LS} max	Pocket length support max
KAPR	Tool cutting edge angle
P_{WS} max	Pocket width support max
R_{max}	Radius max
S_{AP}	Screw axial position
S_{HP}	Screw height position
T_D	Thread size
T_C	Thread counterbore dia
T_L min	Thread length min
C_{AP}	Coolant axial position
C_{HP}	Coolant height position
C_D	Coolant hole dia

Type CB

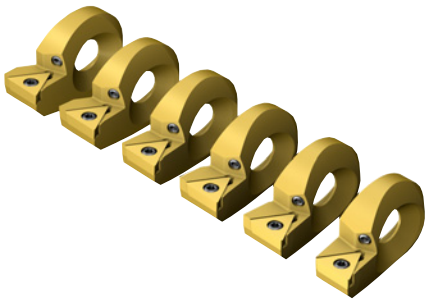


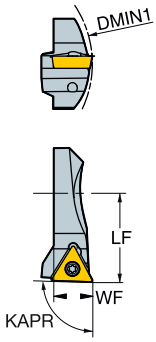
Type CC and CD



CoroBore® 826 HP

Cartridge set



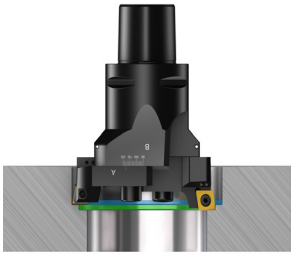


	Ordering code	Included cartridges	WF
Size B set	826B-4-TC09U	R826B-AF17STUC09HP	7.0
		R826B-BF17STUC09HP	7.5
		R826B-CF17STUC09HP	8.0
		R826B-DF17STUC09HP	8.5
Size C set	826C-6-TC11U	R826C-AF23STUC11HP	10.0
		R826C-BF23STUC11HP	10.5
		R826C-CF23STUC11HP	11.0
		R826C-DF23STUC11HP	11.5
		R826C-EF23STUC11HP	12.0
		R826C-FF23STUC11HP	12.5

CoroBore® BR20

Operations

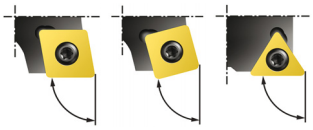
1



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	90°	84°	90°	84°
Lead angle	0°	6°	0°	6°

CoroTurn® 107 screw clamping

For applications that require lower cutting forces

CoroBore® 111 screw clamping

Dedicated rough boring insert with optimized grade selection for P,M,K,S

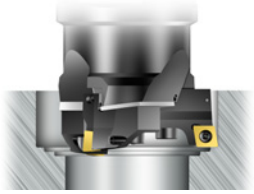
Maximum cutting speed, V_c max:

BR20: 1200 m/min
BR20 Damped: 900 m/min

CoroBore® BR30

Operations

1



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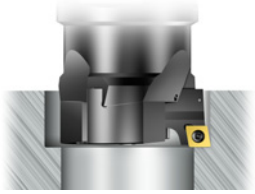


3

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

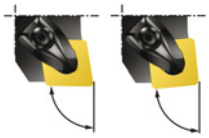
3. Single-edge boring:
   - Two covers are required, to be ordered separately.

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	90°	84°	90° 84°
Lead angle	0°	6°	0° 6°

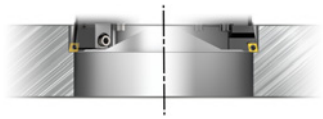
CoroTurn® 107 screw clamping
For applications that require lower cutting forces

CoroBore® 111 screw clamping
Dedicated rough boring insert with optimized grade selection for P,M,K,S

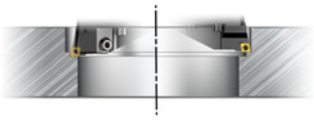
T-Max® P, CoroTurn® RC rigid clamping
For applications that require strong inserts in stable conditions

CoroBore® 820 XL

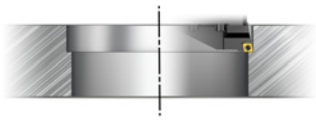
Operations



1



2



3

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.

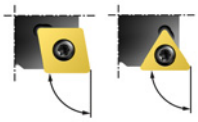
3. Single-edge boring:
   - Adjust unused cutting edge to a smaller diameter and use it as a counterweight.

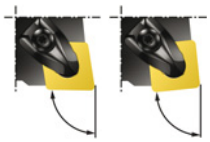
Holders for CoroBore XL, diameter 150–1275 mm

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	90°	90°	90°	84°	90°	84°
Lead angle	0°	0°	0°	6°	0°	6°

CoroTurn® 107 screw clamping

- For applications that require lower cutting forces

CoroBore® 111 screw clamping

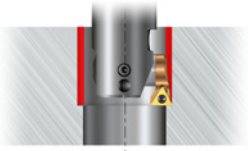
- Dedicated rough boring insert with optimized grade selection for P,M,K,S

T-Max® P, CoroTurn® RC rigid clamping

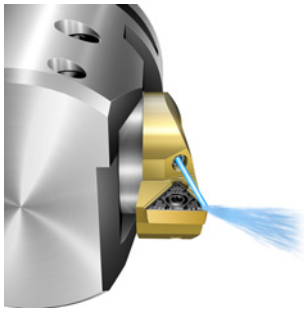
- For applications that require strong inserts in stable conditions

CoroBore® 826 HP

Operations



Boring



- Use the High precision coolant for improved chip breaking

- Feel the microns! Every diameter increment of 0.002 mm can be felt with a click

- The CB826 cartridge is rotated 90 degrees compared to CB825 cartridge!

Maximum cutting speed, V_c max**:** V_c 1200 m/min

Insert choice

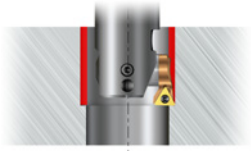
CoroTurn® 107 inserts

Entering angle	92°
Lead angle	-2°

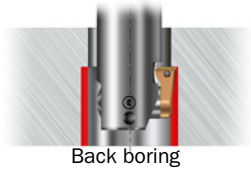
CoroTurn® 107:
TC.. 1103

CoroBore® 825

Operations



Boring



Back boring

Conventional:

The geometrical restriction (LU) is only valid when boring diameter (DC) is smaller than the coupling diameter ($DCON_{MS}$). Maximum recommended hole depth (for forward boring) when the boring diameter (DC) is larger than the coupling diameter ($DCON_{MS}$)

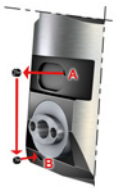
CoroBore® 825 EH:

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 possibile 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).

1.



2.

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

Backboring for CoroBore® 825D (Damped)

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_c max**: Conventional:** V_c 1200 m/min, **Light weight:** Vc 600 m/min **Damped:** V_c 900m/min

Insert choice

CoroTurn® 107 inserts

Entering angle	92°	95°
Lead angle	-2°	-5°

CoroTurn® 107:
TC.. 06, 09
(TC.. 1.2, 1.8)

CoroTurn® 107:
TC.. 1103

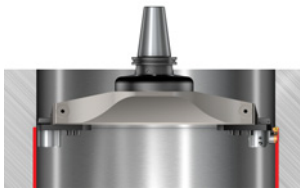
CoroTurn® 107:
CCMT 09
(CCMT3 (2.5))

CoroTurn® 111

CoroBore® 825 XL/CoroBore® 826 XL

Operations

Boring



Back boring

External operations

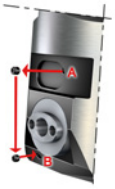
Holders for CoroBore XL

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).

1.



2.

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: Vc 600 m/min, Damped:V_c 600 m/min

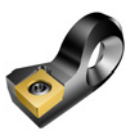
Insert choice

CoroTurn® 107 inserts

Entering angle	92°	95°
Lead angle	-2°	-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.f 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

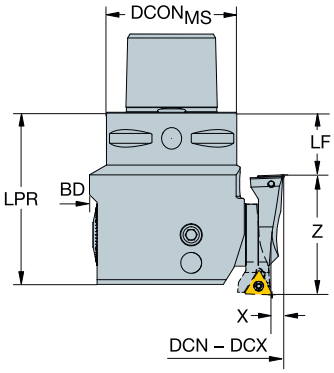
Fine boring												
AP	Nose radius	Max feed for required surface		Material								
		Ra 1.6	Ra 0.8	P		M		K	N	S (nickel)		S (titanium)
0.1-0.15	02	0.08	0.05	PF 5015	L-K 1515	MF-1115	L-K 1515	PF 1515	AL H10	MF 1115	L-K 1115	AL H10
0.15-0.3	04	0.12	0.07	PF 5015	L-K 1515	MF 2015	L-K 1515	PF 4215	AL H10	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

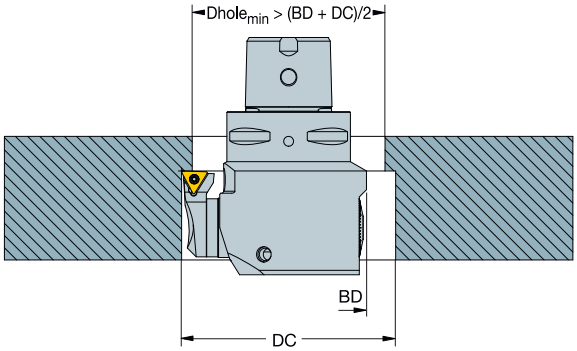
Face grooving

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-AF**11**STUC06T1A)
- LF – 34 mm for Size B (e.g. R825B-AF**17**STUC0902A)
- LF – 46 mm for Size C (e.g. R825C-AF**23**STUC1103A)
- Attention change rotation direction -> left hand!

DC will be increased by twice WF of slide extension. That means:
- 2 x 3.0 = 6.0 mm for Size A (825A-**030**A)
- 2 x 3.6 = 7.2 mm for Size B (825B-**036**A)
- 2 x 4.8 = 9.6 mm for Size C (825C-**048**A)
- Calculation of minimum possible hole diameter: $Dhole_{min}$ = (BD+DC)/2+1

Backboring for CoroBore® 825XL

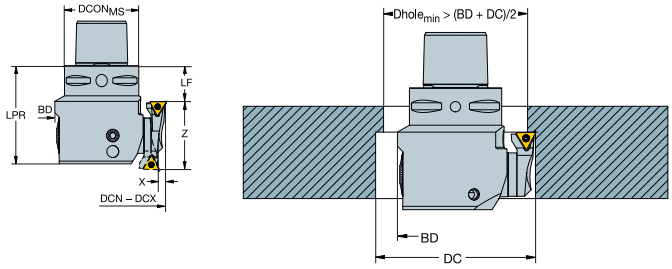
In case of backboring, LF will be reduced by twice LF of cartridge. That means:
- LF – 46 mm for Size C (e.g. R825C-AF**23**STUC1103A)
- Attention change rotation direction -> left hand!

DC will be increased by twice WF of slide extension. That means:
- 2 x 4.8 = 9.6 mm for Size C (825C-**048**A)
- Calculation of minimum possible hole diameter: $Dhole_{min}$>(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	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

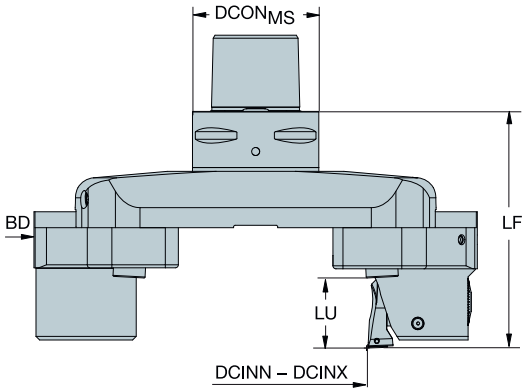
Backboring for CoroBore® 825D

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 x (3.0 - 5.0 + 8.0) = 12.0 mm for Size A
- DC + 2 x (3.6 - 7.0 + 9.9) = 13.0 mm for Size B
- DC + 2 x (4.8 - 10.0 + 12.2) = 14.0 mm for Size C
- Calculation of minimum possible hole diameter: $Dhole_{min}$ = (BD+DC)/2+1

Note! Backboring is only valid for CoroBore® 825D and not CoroBore® 825D XL or CoroBore® 825

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)-(2xDMIN A34-R825) = 148 mm-110 mm = **38 mm**
- **DCX (external)** = DCX(forward)-(2xDMIN 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

Coromant EH coupling

Size	NM
16	30
20	50
25	65

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

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 148-300	NM	Screw size
Bridge	100	M12
Slide	60	M10
Cartridge	60	M10

CoroBore® 820 XL

Diameter range, mm 298-1260	NM	Screw size
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 825: 148-315 826: 148-300	NM	Screw size
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 825: 298-1275 826: 298-1260	NM	Screw size
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
Cartridge screw		
R825A...	1.2	M3.5
R825B..., R826B...	3.0	M5
R825C..., R826C...	6.0	M8
Locking screw		
...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
1-20
Locking screw / Boring bar (Insert) screw

Size	NM	Screw size
XS04	1.2	M5
XS06	1.2	M5
XS08	3	M6
XS10	3	M6

CoroBore® 825 SL

Diameter range, mm 47-150	NM	Screw size
Face grooving head (S20)	14	M6
Locking screw	8	M10
Counterweight	8	M10
Blade	9	M5

CoroBore® 825 SL XL

Diameter range, mm 150-1275	NM	Screw size
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
Screw for boring bar:		
12	10	M8
16	10	M8
20	18	M10
Locking screw:		
12	8	M8
16	8	M8
20	12	M10

SANDVIK Coromant

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	**Coromant Capto®**	-Extension -Extension with Quick change -Reduction L4-L7 Coolant inducer L108	-Adaptor -Quick change L28-L30	-Adaptor -Quick change L43	-Adaptor -Quick change L52-L53	-Adaptor -Quick change L61	-Adaptor -Quick change L74-L75
	Coromant EH	-Adaptor L8-L9	-Adaptor L31			-Adaptor L62	-Adaptor L76
	Arbor	-Adaptor -With driving screws -Side and face mill L10-L12	-Adaptor -With driving screws L32-L33	-Adaptor L44	-Adaptor L54	-Adaptor -With driving screws -Side and face mill L63-L64	-Adaptor -With driving screws -Side and face mill L77-L78
	VL	-Adaptor L13	-Adaptor L33	-Adaptor L45	-Adaptor L55	-Adaptor L65	-Adaptor L80
	Weldon	-Adaptor L14	-Adaptor L34			-Adaptor L66	-Adaptor L79
	MDI	-Adaptor L15	-Adaptor L35				
	ISO 9766	-Adaptor L16 Coolant inducer L108	-Adaptor L36			-Adaptor -Adjustable adaptor L67-L68	-Adaptor -Adjustable adaptor L81
	Weldon/ISO 9766	-Adaptor L17		-Adaptor L46	-Adaptor L55		
	CoroMill® 327	-Adaptor L17					
	CoroChuck™ 930	-Adaptor L18-L22	-Adaptor L37-L39	-Adaptor L47	-Adaptor L56	-Adaptor L69	-Adaptor L82-L83
	Shrink fit chuck	-Adaptor L23	-Adaptor L40				
	ER	-Collet chuck -Drill chuck L24-L25	-Collet chuck L40	-Collet chuck L49	-Collet chuck L58	-Collet chuck L71	-Collet chuck L84
	CoroChuck™ 970	-Adaptor L26	-Adaptor L41	-Adaptor L50	-Adaptor L59	-Adaptor L72	-Adaptor L85

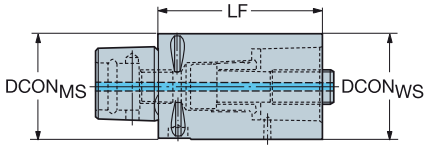
Damped adaptors

		Machine side	
		Coromant Capto®	**HSK**
Workpiece side	**Coromant EH**	-Adaptor L110	
	Arbor	-Adaptor -With driving screws L111	-Adaptor L112

SANDVIK Coromant

DIN 2080	DIN 2079	Cylindrical shank	Weldon shank	Bridgeport	Coromant EH	ER
-Adaptor L87	-Adaptor -Quick change 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	

Coromant Capto® extension adaptor



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	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	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	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	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	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	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

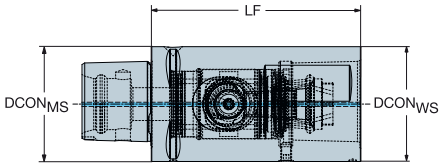
Short design, for segment clamping only

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	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	C4	3	1	C4-391.01-40 040	40.0	40.0	40.0	80	55.00	0.40
C5	C5	3	1	C5-391.01-50 050	50.0	50.0	50.0	80	95.00	0.73
C6	C6	3	1	C6-391.01-63 060	63.0	63.0	60.0	80	170.00	1.36
C8	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

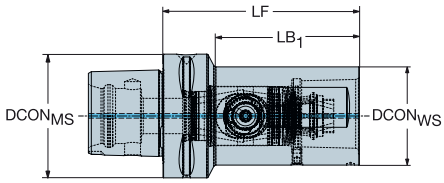
M1 N23 N6 N15

Coromant Capto® extension adaptor with Quick change



					Dimensions, mm						
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	**Ordering code**	DCON$_{MS}$	DCON$_{WS}$	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$_{MS}$	CZC$_{WS}$	CNSC	CXSC	**Ordering code**	DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	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

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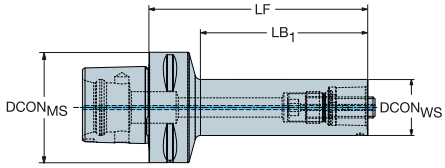
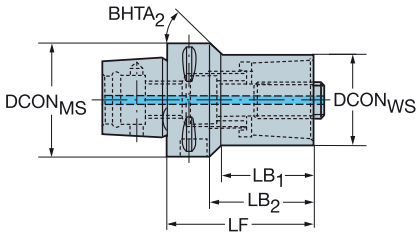
M1 N23 N6 N15

Coromant Capto® reduction adaptor



					Dimensions, mm						
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	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



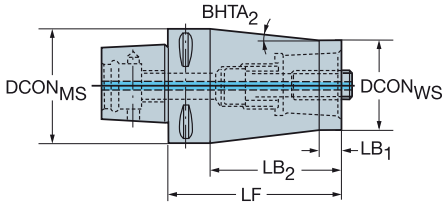
					Dimensions, mm								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	$BHTA_2$	BAR	NM	KG
C8	C6	3	1	C8-391.02-63 120A	80.0	63.0	120.0	10.0	89.2	6°	80	170.00	4.10
C10	C3	3	1	C10-391.02-32 085	100.0	32.0	85.0	36.7	48.2	71°	80	45.00	4.15
	C4	3	1	C10-391.02-40 090	100.0	40.0	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

M1 N23 N6 N15

ENG

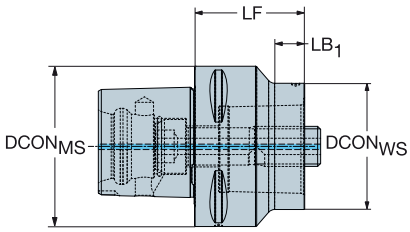
Coromant Capto® reduction adaptor



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BHTA$_2$	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
	C5	3	1	C6-391.02-50 110A	63.0	50.0	110.0	10.0	87.2	5°	80	95.00	2.23
C8	C4	3	1	C8-391.02-40 200	80.0	40.0	200.0	5.0	169.2	7°	80	55.00	5.42
	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



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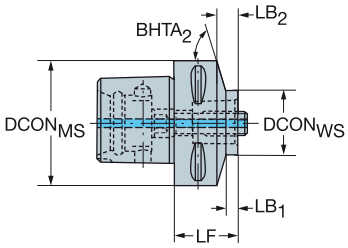


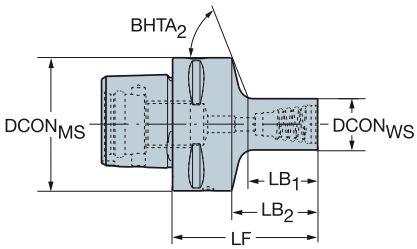
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	LB$_3$	BD$_2$	BD$_3$	BHTA$_2$	BAR	NM	KG
C5	C3	3	1	2	C5-391.02-32 033A	50.0	32.0	33.0	5.0	33.0		50.0		0°	80	45.00	0.54
	C4	3	1	2	C5-391.02-40 040A	50.0	40.0	40.0	15.0	40.0		50.0		0°	80	55.00	0.59
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

M1 N23 N6 N15

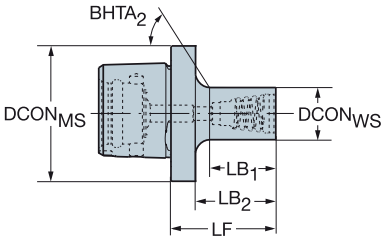
Coromant Capto® to Coromant EH adaptor

Short design



					Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	$BHTA_2$	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



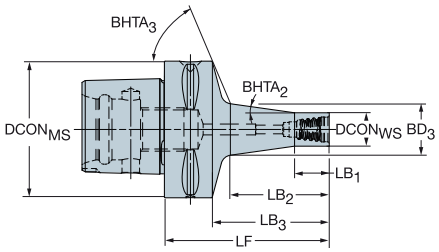
					Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	$BHTA_2$	BAR	NM	KG	RPMX
C3	E10	3	1	C3-391.EH-10 026	32.0	9.6	26.0	13.0	18.0	45°	150	12.00	0.15	40000
	E12	3	1	C3-391.EH-12 029	32.0	11.6	29.0	16.0	21.0	45°	150	15.00	0.17	40000
	E16	3	1	C3-391.EH-16 027	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

M1 N23 N15 N3

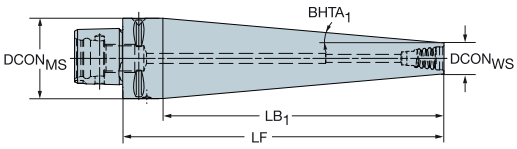
Coromant Capto® to Coromant EH adaptor

Long design



					Dimensions, mm												
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_3	$BHTA_2$	$BHTA_3$	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_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	$BHTA_1$	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

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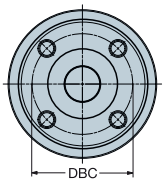
M1 N23 N15 N3

Coromant Capto® to arbor adaptor

DSGN



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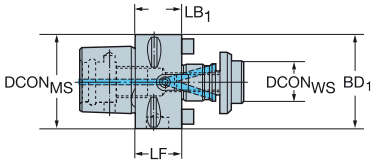

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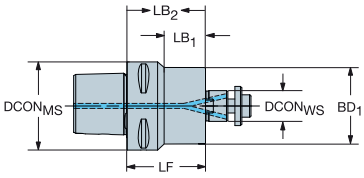
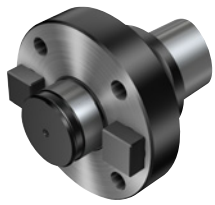
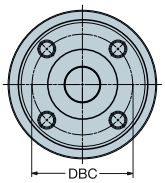
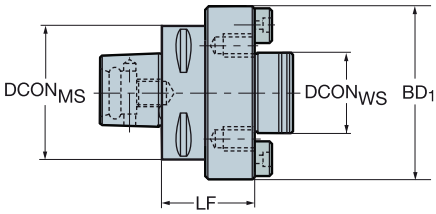


Coolant through arbor

						Dimensions, mm											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{MS}$	DBC	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	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	32.0	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







			Dimensions, mm							
CZC_{MS}	CZC_{WS}	Ordering code	$DCON_{MS}$	DBC	$DCON_{WS}$	LF	BD_1	NM	KG	RPMX
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

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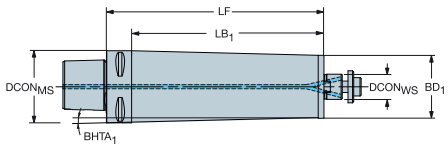
M1 N23 N15

Coromant Capto® to arbor adaptor

DSGN 3



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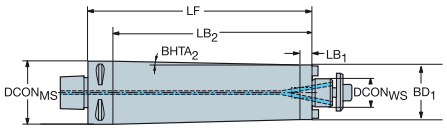
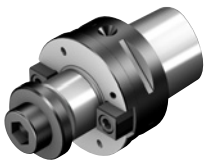
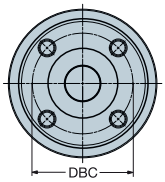
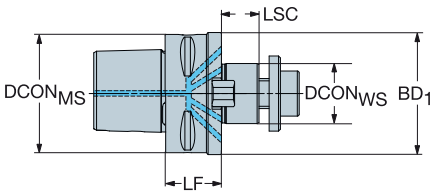


						Dimensions, mm														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	$BHTA_2$	BAR	NM	KG	RPMX
C4	16	3	4	7	**C4-391.05C-16 120**	40.0	16.0	120.0	22.0	100.0	120.0	32.0	32.0	40.0	0°	2°	80	22.00	0.99	18000
C5	22	3	4	7	**C5-391.05C-22 150**	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	DBC	$DCON_{WS}$	LSC	LF	BD_1	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.

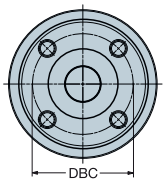
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

Coromant Capto® to arbor with driving screws adaptor

For CoroMill® QD with internal coolant supply

DSGN



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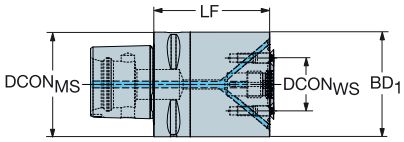

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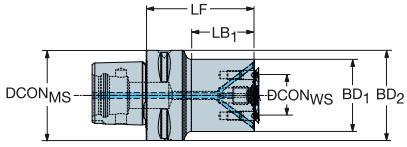


						Dimensions, mm												
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	DBC	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG	RPMX
C3	X10	3	3	1	**C3-X10-032-040**	32.0	22.0	10.0	2	40.0	40.0		32.0		80	6.40	0.28	12000
C4	X10	3	3	2	**C4-X10-032-050**	40.0	22.0	10.0	2	50.0	25.5	50.0	32.0	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

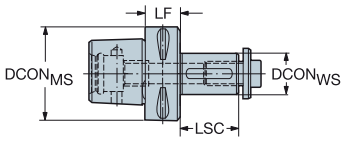
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

Coromant Capto® to side and face mill arbor adaptor

DSGN

1



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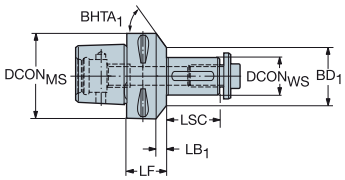

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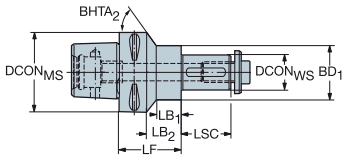
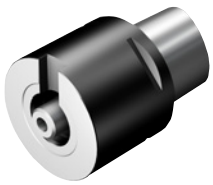
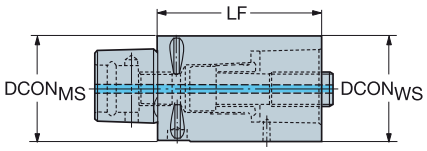


						Dimensions, mm															
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_2$	BD$_3$	BHTA$_1$	BHTA$_2$	BAR	NM	KG	RPMX
C3	16	3	1	3	C3-391.10-16 020	32.0	16.0	30	20.0	5.0	20.0		28.0	32.0		21°	0°	80	22.00	0.22	8000
C4	16	3	1	3	C4-391.10-16 025	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$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LF	BAR	NM	KG
C8	80	3	1	C8-391.01-V80 065	80.0	80.0	65.0	80	170.00	3.05

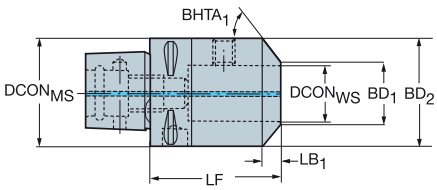
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

Coromant Capto® to Weldon adaptor

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN 3



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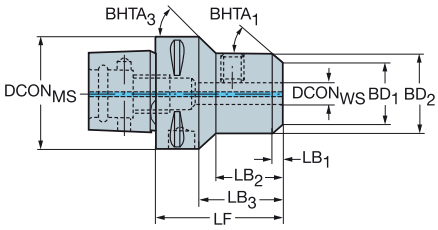


						Dimensions, mm																
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	$BHTA_3$	BAR	NM	KG	RPMX
C3	6	3	1	14	C3-391.20-06 045A	32.0	6.0	46.0	4.0	27.5	29.5	46.0	17.0	25.0	25.0	32.0	45°	60°	20	3.00	0.24	32000
	8	3	1	14	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

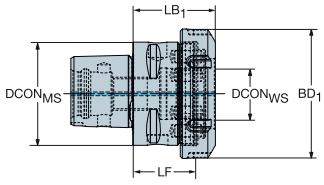
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

ENG

Coromant Capto® to MDI adaptor

DSGN 1



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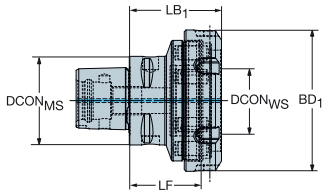

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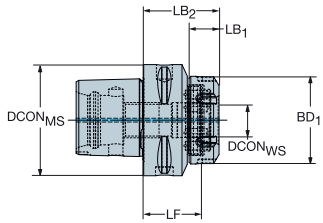

						Dimensions, mm										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG	RPMX
C3	MDI-20	3	1	1	C3-DM20-N-032	32.0	20.0	32.0	42.0		49.7		80	135.00	0.31	55000
C4	MDI-20	3	1	1	C4-DM20-N-028	40.0	20.0	28.0	38.0		49.7		80	135.00	0.40	39000
	MDI-25	3	1	1	C4-DM25-N-035	40.0	25.0	35.0	45.0		62.7		80	170.00	0.58	39000
	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
C5	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
	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
	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
C6	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
	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
	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
C8	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
	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

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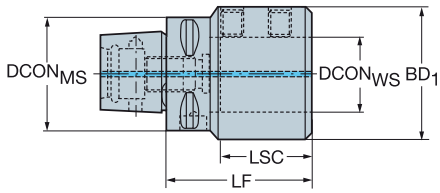
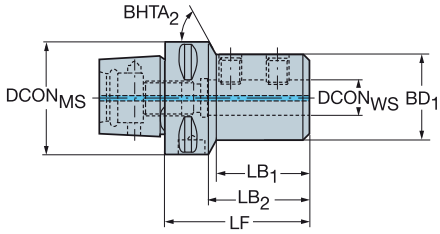
M1 N23 N15

Coromant Capto® to ISO 9766 adaptor

DSGN 1



DSGN 7



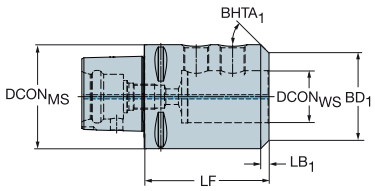
						Dimensions, mm														
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_2$	BD$_3$	BHTA$_2$	BAR	NM	KG	RPMX
C3	16	3	1	1	C3-391.27-16 056	32.0	16.0	49	56.0	56.0			36.0				20	10.00	0.40	32000
	20	3	1	1	C3-391.27-20 060	32.0	20.0	51	60.0	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
	50	3	1	1	C6-391.27-50 115	63.0	50.0	81	115.0	115.0			75.0				20	45.00	2.70	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

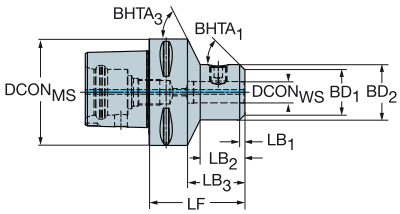
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

Coromant Capto® to Weldon / ISO 9766 adaptor

DSGN 3 14

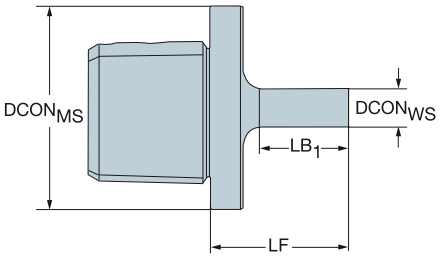




						Dimensions, mm																
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	$BHTA_3$	BAR	NM	KG	RPMX
C10	20	3	1	14	**C10-391.23-20 090**	100.0	20.0	90.0	5.0	42.0	54.0	90.0	42.0	52.0	52.0	100.0	45°	63°	20	20.00	4.00	10000
	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	10000

Coromant Capto® to CoroMill® 327 adaptor

Short design, for segment clamping only



			Dimensions, mm						
CZC_{MS}	CZC_{WS}	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	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

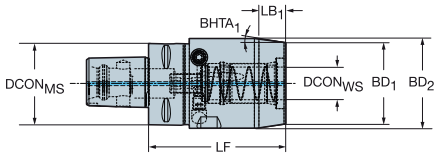
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

Coromant Capto® to CoroChuck™ 930

Heavy Duty design

DSGN 3



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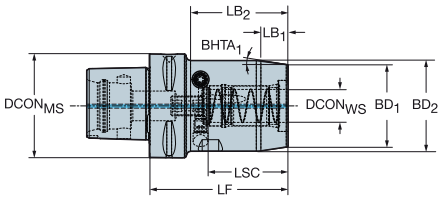


						Dimensions, mm														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	BAR	NM	KG	RPMX
C4	20	3	1	3	**930-C4-HD-20-084**	40.0	20.0	51	84.0	17.8	84.0		50.0	55.0		8°	80	10.00	1.25	39000
C5	20	3	1	3	**930-C5-HD-20-082**	50.0	20.0	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
	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
C8	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
	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
C10	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

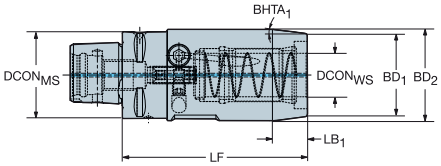
M1 N23 N6 N15 N4

ENG

Coromant Capto® to CoroChuck™ 930

Slender design

DSGN 3



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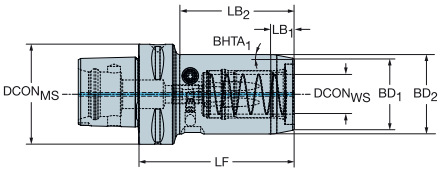
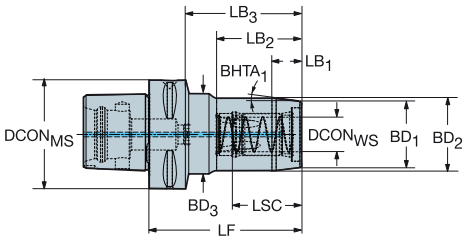


						Dimensions, mm														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	BAR	NM	KG	RPMX
C3	6	3	1	6	930-C3-S-06-064	32.0	6.0	37	64.0	11.3	33.2	64.0	22.0	26.0	32.0	10°	80	8.00	0.32	55000
	8	3	1	6	930-C3-S-08-065	32.0	8.0	37	65.0	11.3	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
	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
C6	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_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	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
	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
C8	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

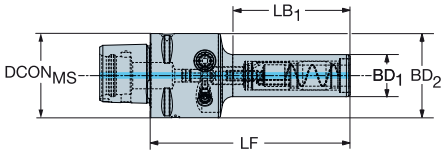
For spare parts, visit www.sandvik.coromant.com

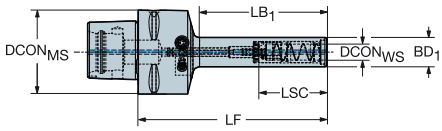
M1 N23 N6 N15 N4

Coromant Capto® to CoroChuck™ 930

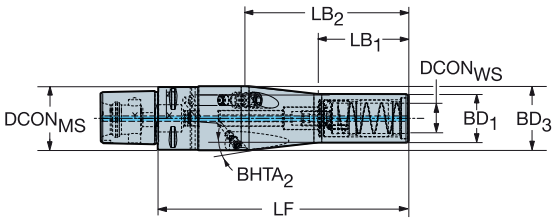
Pencil design

DSGN 2 5





						Dimensions, mm													
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	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	65.0	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	64.9	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	74.9	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_3	$BHTA_2$	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

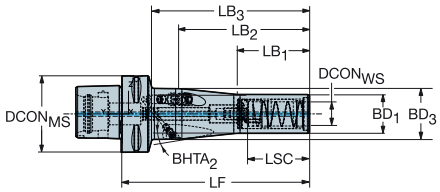
For spare parts, visit www.sandvik.coromant.com

M1 N23 N6 N15 N4

Coromant Capto® to CoroChuck™ 930

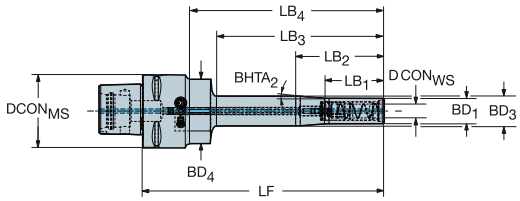
Pencil design

DSGN 11



						Dimensions, mm														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_3	$BHTA_2$	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
	20	3	1	11	**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
	20	3	1	11	**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
	20	3	1	11	**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_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_3	BD_4	$BHTA_2$	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

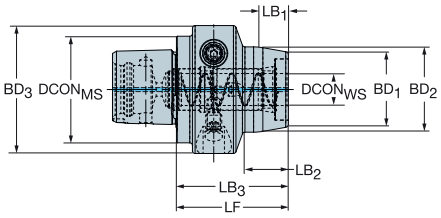
M1 N23 N6 N15 N4

Coromant Capto® to CoroChuck™ 930

For driven tool holders

Segment clamping and manual tool change only

DSGN 6



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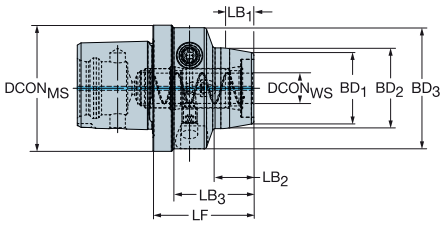
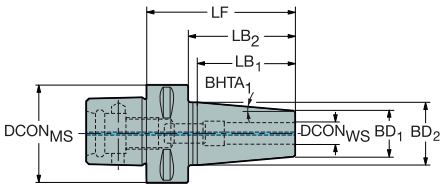


						Dimensions, mm															
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	BAR	KG	RPMX
C3	12	3	1	6	**930-C3-T-12-046**	32.0	12.0	46	46.0	11.3	22.8	46.0		28.0	32.0	48.0		10°	80	0.39	10000
C4	12	3	1	6	**930-C4-T-12-042**	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

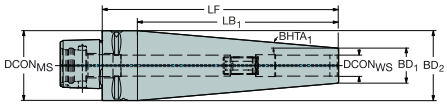
For spare parts, visit www.sandvik.coromant.com

Coromant Capto® to shrink fit chuck



Short design

					Dimensions, mm										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	$BHTA_1$	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_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	BD_1	BD_2	$BHTA_1$	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

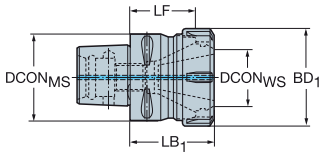
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

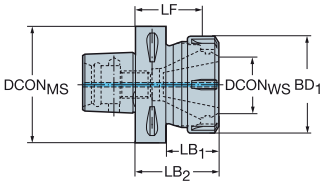
Coromant Capto® to ER collet chuck

Workpiece side interface DIN 6499-B

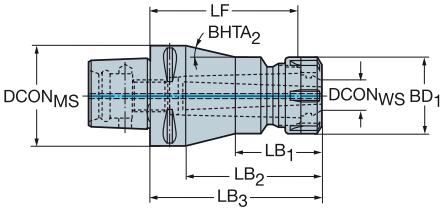
DSGN 1



DSGN 2



						Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	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_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	$BHTA_2$	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
C8	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
	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
C10	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
	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

M1 N23 N15

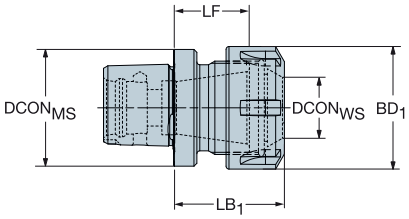
ENG

Coromant Capto® to ER collet chuck

Workpiece side interface DIN 6499-B

Short design, for segment clamping only

DSGN 1



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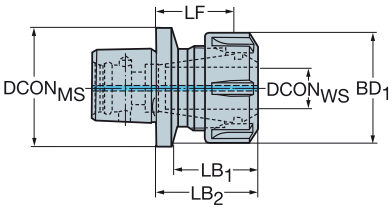
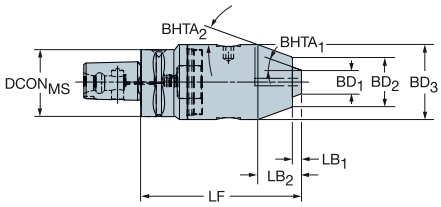


						Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR	KG	RPMX
C3	ER16	3	1	2	**C3-391.14-16 035**	32.0	17.0	24.0	26.6	34.6	28.0	32.0	80	0.10	55000
	ER20	3	1	1	**C3-391.14-20 036**	32.0	21.0	24.5	36.0		33.7		80	0.17	55000
C4	ER16	3	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

DSGN 8



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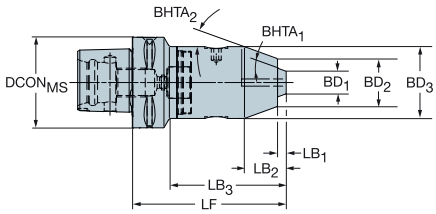


						Dimensions, mm															
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	$BHTA_2$	BAR	NM	KG	RPMX
C3	8 - 1	3	1	8	**C3-391.32-08 076**	32.0	76.0	3.0	19.1	76.0		9.9	24.1	36.0		19°	20°	50	10.00	0.54	8000
	1 - 13	3	1	8	**C3-391.32-13 102**	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

M1

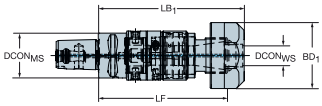
N23

N15

Coromant Capto® to CoroChuck™ 970

Workpiece side interface DIN 6499-B

DSGN 1



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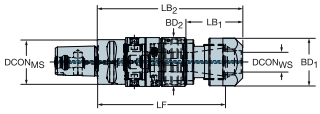

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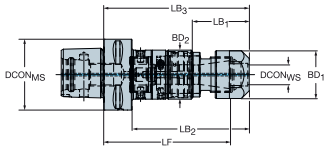

							Dimensions, mm											
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BAR	KG	RPMX
C3	ER11	M5	3	1	5	**970-C3-11-078**	32.0	11.3	74.2	24.1	63.0	78.0	18.7	23.5	32.0	80	0.27	8000
	ER20	M12	3	1	2	**970-C3-20-102**	32.0	20.8	89.2	35.3	97.2		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

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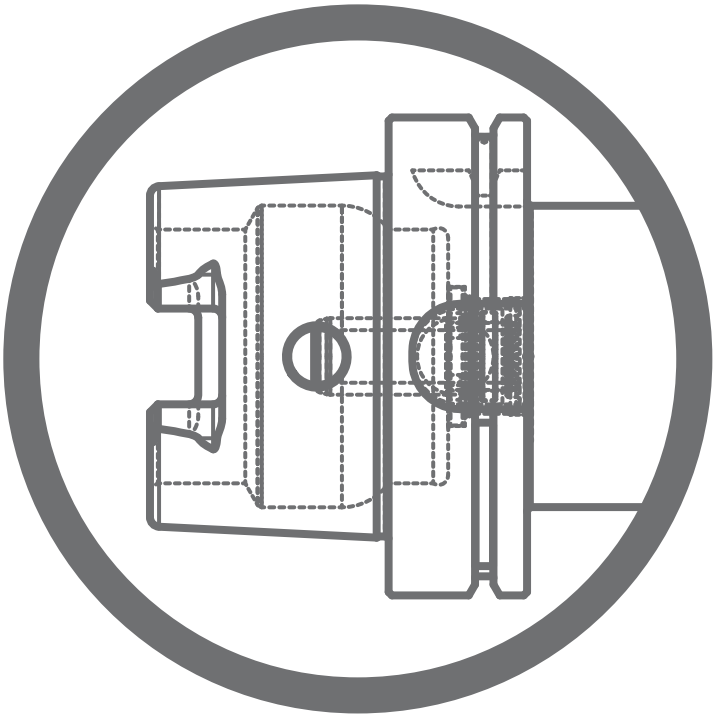
M1 N23 N15 N5

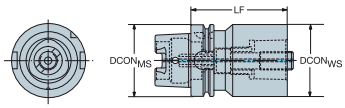
Machine side interface HSK



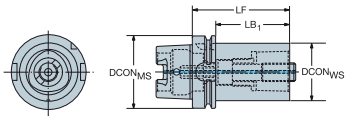
HSK to Coromant Capto® adaptor

Machine side interface HSK A/C

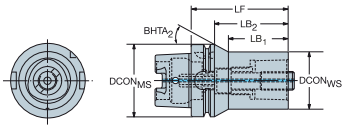
DSGN 1



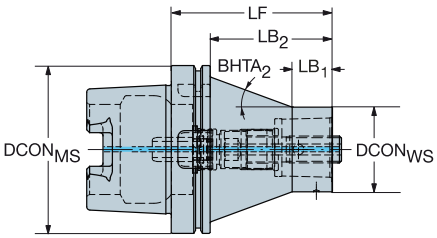
DSGN 2



DSGN 7



						Dimensions, mm											
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	LB$_3$	BD$_2$	BD$_3$	BHTA$_2$	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$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BHTA$_2$	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

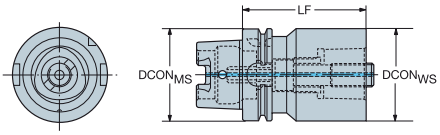
A special coolant tube is delivered together with the HSK basic holders.
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

HSK to Coromant Capto® adaptor

Machine side interface HSK A/C/T

DSGN 1



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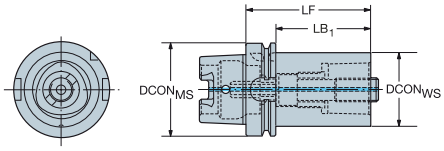
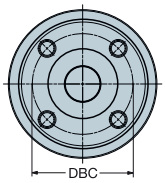
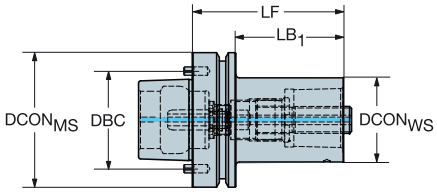


						Dimensions, mm								
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	**Ordering code**	DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_2$	BAR	NM	KG
40	C3	1	1	2	**C3-390.419-40 065**	40.0	32.0	65.0	45.0	65.0	40.0	100	45.00	0.46
	C4	1	1	1	**C4-390.419-40 075**	40.0	40.0	75.0	75.0			100	55.00	0.60
63	C5	1	1	2	**C5-390.419-63 090**	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$_{MS}$	CZC$_{WS}$	CNSC	CXSC	**Ordering code**	DCON$_{MS}$	DBC	DCON$_{WS}$	LF	LB$_1$	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

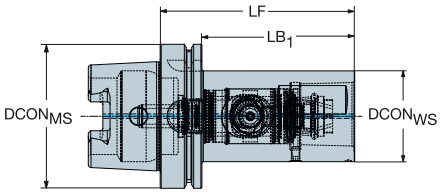
A special coolant tube is delivered together with the HSK basic holders.
HSK80F - Compatible with the Makino MAG machine family 1, 3, 4, 7 - for aerospace frame aluminium machining

For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

HSK to Coromant Capto® adaptor with Quick change

Machine side interface HSK A/C



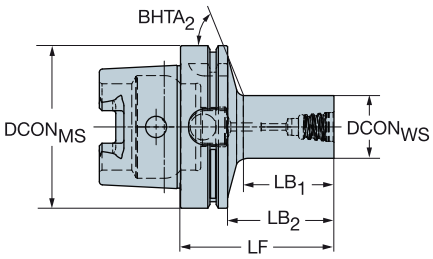
					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	BAR	NM	KG	RPMX
63	C5	1	1	**HA06-QC-C5-115**	63.0	50.0	115.0	88.0	100	70.00	1.77	20500
100	C6	1	1	**HA10-QC-C6-135**	100.0	63.0	135.0	105.0	100	90.00	4.17	12500
	C8	1	1	**HA10-QC-C8-165**	100.0	80.0	165.0	135.0	100	130.00	6.32	12500

For spare parts, visit www.sandvik.coromant.com

M1 N23 N6 N15

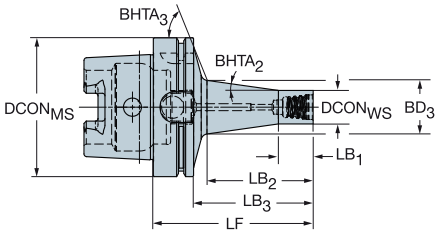
HSK to Coromant EH adaptor

Machine side interface HSK A/C



Short design

					Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	$BHTA_2$	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_3	$BHTA_2$	$BHTA_3$	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
	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
100	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

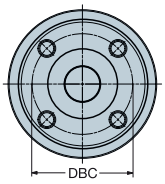
M1 N23 N15 N3

HSK to arbor adaptor

Machine side interface HSK A/C

Coolant through arbor

DSGN



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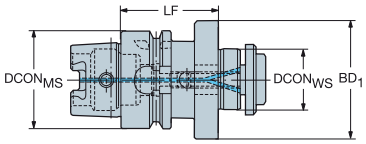

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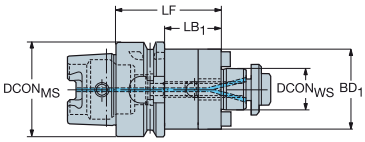
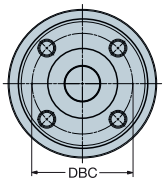
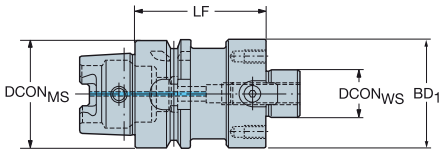


						Dimensions, mm											
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	**Ordering code**	DCON$_{MS}$	DBC	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR	NM	KG	RPMX
40	16	1	4	2	**392.41005C-4016050**	40.0		16.0	50.0	30.0	50.0	32.0	40.0	80	22.00	0.45	30000
	22	1	4	1	**392.41005C-4022050**	40.0		22.0	50.0	50.0		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$_{MS}$	CZC$_{WS}$	DSGN	**Ordering code**	DCON$_{MS}$	DBC	DCON$_{WS}$	LF	BD$_1$	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

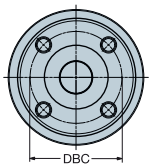
M1 N23 N15

HSK to arbor with driving screws adaptor

Machine side interface HSK A/C

For CoroMill® QD with internal coolant supply

DSGN



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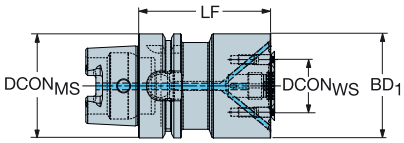

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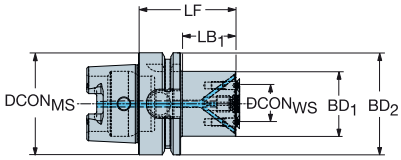
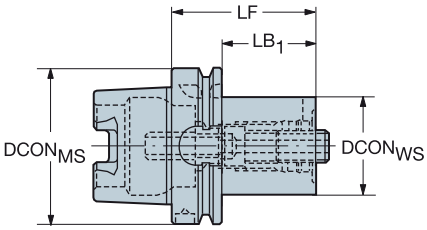


						Dimensions, mm												
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	DBC	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG	RPMX
63	X10	1	3	2	**HA06-X10-032-055**	63.0	22.0	10.0	2	55.0	28.0	55.0	32.0	63.0	80	6.40	0.85	12000
	X22	1	3	2	**HA06-X22-040-060**	63.0	32.0	22.0	2	60.0	33.0	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	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

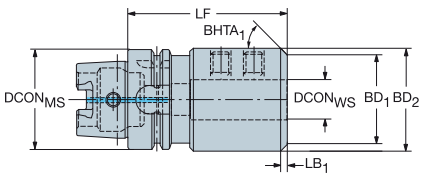
M1 N23 N15

HSK to Weldon adaptor

Machine side interface HSK A/C

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN 3



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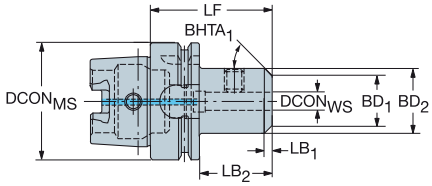


						Dimensions, mm													
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	BAR	NM	KG	RPMX
63	8	1	1	6	**392.41020-63 08 065B**	63.0	8.0	65.0	2.0	39.0	65.0	24.0	28.0	63.0	45°	20	7.00	0.83	20500
	10	1	1	6	**392.41020-63 10 065B**	63.0	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
	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
100	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

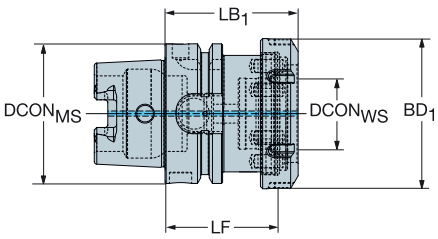
M1 N23 N15

ENG

HSK to MDI adaptor

Machine side interface HSK A/C/T

DSGN 1



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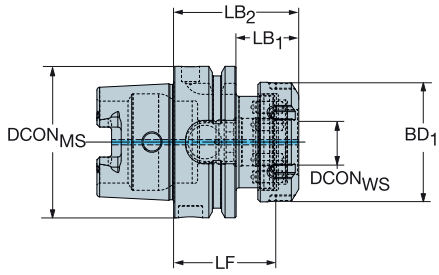

						Dimensions, mm										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG	RPMX
63	MDI-20	1	1	2	**HT06-DM20-N-042**	63.0	20.0	42.0	26.0	52.0	49.7	63.0	80	135.00	0.86	20000
	MDI-25	1	1	2	**HT06-DM25-N-050**	63.0	25.0	50.0	34.0	60.0	62.7	63.0	80	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

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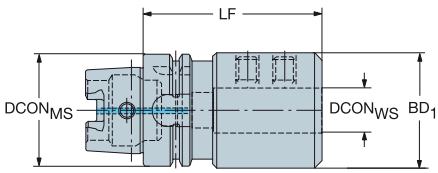
M1 N23 N15 N5

HSK to ISO 9766 adaptor

Machine side interface HSK A/C

DSGN 1



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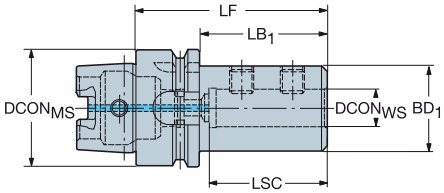
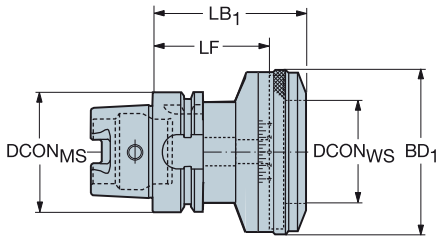


						Dimensions, mm											
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR	NM	KG	RPMX
63	16	1	1	2	392.41027-63 16 080B	63.0	16.0	49	80.0	54.0	80.0	36.0	63.0	20	10.00	1.02	20500
	20	1	1	2	392.41027-63 20 080B	63.0	20.0	51	80.0	54.0	80.0	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
	40	1	1	1	392.41027-63 40 110	63.0	40.0	71	110.0	110.0		65.0		20	40.00	1.93	20500
80	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
	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
100	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
	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$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	BD$_1$	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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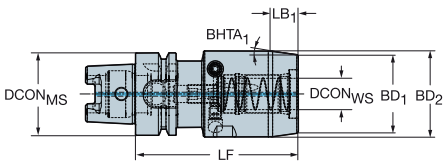
M1 N23 N15

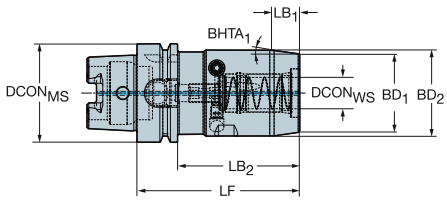
HSK to CoroChuck™ 930

Heavy Duty design

Machine side interface HSK A/C

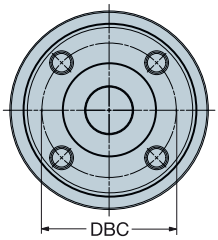
DSGN 3 6

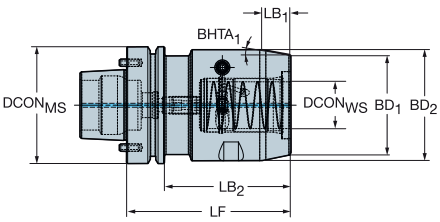




						Dimensions, mm														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	BAR	NM	KG	RPMX
63	20	1	1	6	**930-HA06-HD-20-104**	63.0	20.0	51	104.0	17.8	78.0	104.0	50.0	55.0	62.9	8°	80	10.00	1.89	20000
	25	1	1	3	**930-HA06-HD-25-110**	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
80	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	DBC	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	$BHTA_1$	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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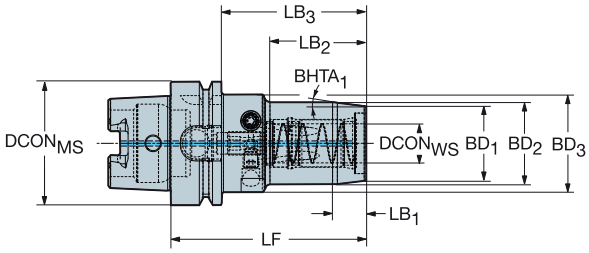
M1 N23 N6 N15 N4

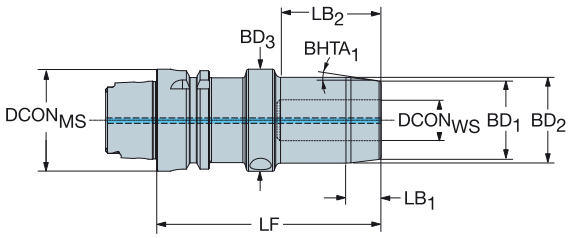
HSK to CoroChuck™ 930

Slender design

Machine side interface HSK A/C



					Dimensions, mm														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	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	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
100	12	1	1	930-HA10-S-12-095	100.0	12.0	46	95.0	11.3	38.2	66.0	28.0	32.0	50.0	10°	80	8.00	2.63	10000
	20	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_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	$BHTA_1$	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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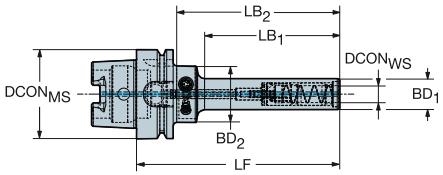
M1 N23 N6 N15 N4

ENG

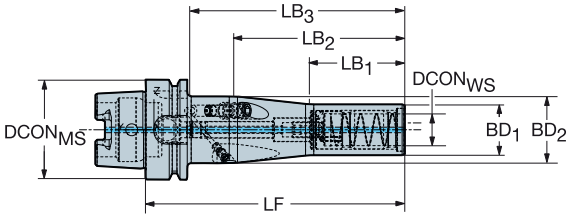
HSK to CoroChuck™ 930

Pencil design

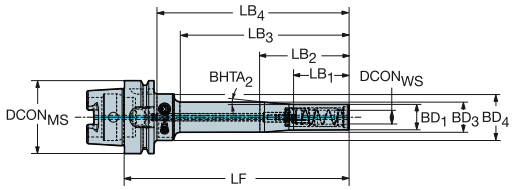
Machine side interface HSK A/C



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	LB$_4$	BD$_1$	BD$_2$	BD$_3$	BD$_4$	BHTA$_2$	BAR	NM	KG	RPMX
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



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_3$	BHTA$_2$	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



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	LB$_4$	BD$_1$	BD$_3$	BD$_4$	BHTA$_2$	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

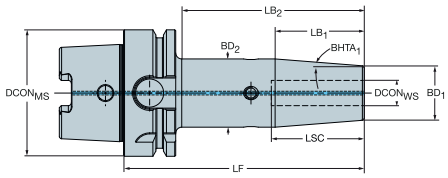
For spare parts, visit www.sandvik.coromant.com

M1 N23 N6 N15 N4

HSK to shrink fit chuck

Machine side interface HSK A/C

Internal coolant supply



For MQL machining

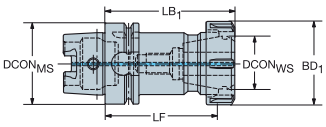
					Dimensions, mm											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	$BHTA_1$	BAR	KG	RPMX
63	6	1	1	HA06-SH06Q-S-080	63.0	6.0	22	80.0	38.1	54.0	21.0	27.0	4°	10	0.83	20500
	6	1	1	HA06-SH06Q-S-120	63.0	6.0	22	120.0	38.1	94.0	21.0	27.0	4°	10	1.01	20500
	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 1



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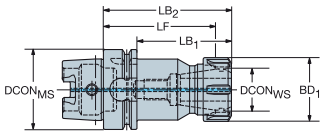


						Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR	KG	RPMX
40	ER25	1	1	1	392.41014-4025062	40.0	26.0	50.0	62.0		42.0		80	0.42	30000
50	ER32	1	1	1	392.41014-5032072	50.0	33.0	59.0	72.0		50.0		80	0.70	25000
63	ER16	1	1	2	392.41014-63 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

For spare parts, visit www.sandvik.coromant.com

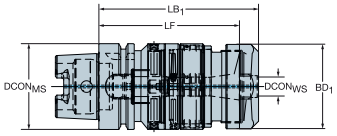
M1 N23 N15

HSK to CoroChuck™ 970

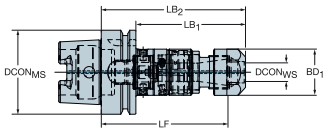
Machine side interface HSK A/C

Workpiece side interface DIN 6499-B

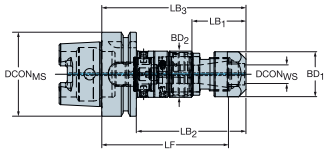
DSGN 1



DSGN 2



DSGN 5



							Dimensions, mm									
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR	KG	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_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BAR	KG	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
	ER20	M12	1	1	5	**970-HA06Q-20-108**	63.0	20.8	95.1	40.3	82.1	108.1	33.7	34.6	80	1.10	8000
	ER25	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
	ER25	M20	1	1	5	**970-HA06Q-25-128**	63.0	25.8	114.0	43.2	101.5	127.5	41.7	44.0	80	1.05	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
	ER20	M12	1	1	5	**970-HA10Q-20-115**	100.0	20.8	101.6	40.7	85.6	114.6	33.7	34.6	80	2.53	8000
	ER25	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
	ER25	M20	1	1	5	**970-HA10Q-25-134**	100.0	25.8	120.5	42.1	105.0	134.0	41.7	44.0	80	2.89	8000

For spare parts, visit www.sandvik.coromant.com

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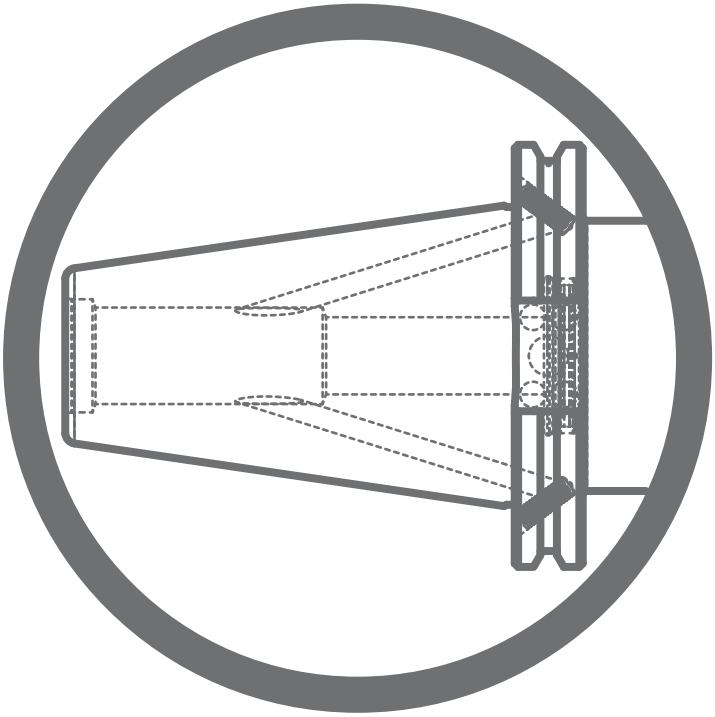
M1 N23 N15 N5

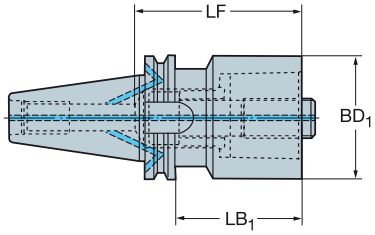
Machine side interface BIG-PLUS® ISO



BIG-PLUS ISO to Coromant Capto® adaptor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

DSGN 1



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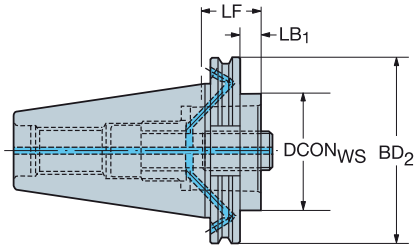
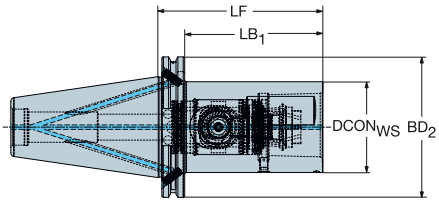


						Dimensions, mm								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_2	BAR	NM	KG
40	C3	7	1	2	**C3-390B.540-40 030**	M16	32.0	30.0	10.9	30.0	63.5	80	45.00	0.89
	C4	7	1	2	**C4-390B.540-40 040**	M16	40.0	40.0	20.9	40.0	63.5	80	55.00	0.96
	C5	7	1	2	**C5-390B.540-40 050**	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_2	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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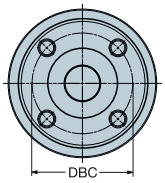
M1 N23 N15

BIG-PLUS ISO to arbor adaptor

Coolant through arbor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

DSGN



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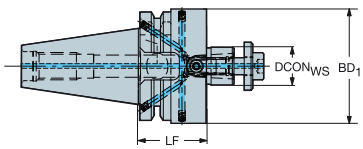

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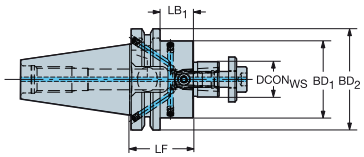
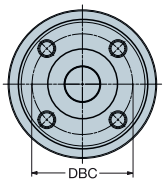
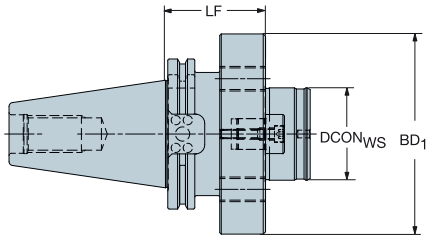


						Dimensions, mm											
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	**Ordering code**	DBC	CRKS	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR	NM	KG	RPMX
40	16	7	4	2	**392.54005C4016045**		M16	16.0	45.0	25.9	45.0	32.0	63.5	80	22.00	1.04	18000
	22	7	4	2	**392.54005C4022040**		M16	22.0	40.0	20.9	40.0	48.0	63.5	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$_{MS}$	CZC$_{WS}$	**Ordering code**	DBC	CRKS	DCON$_{WS}$	LF	BD$_1$	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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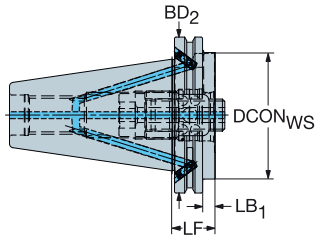
M1 N23 N15

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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_2	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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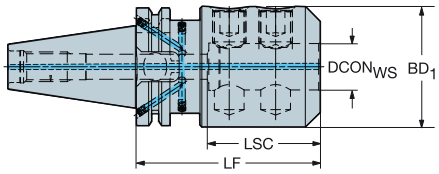
M1 N23 N15

BIG-PLUS ISO to Weldon / ISO 9766 adaptor

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

DSGN 1



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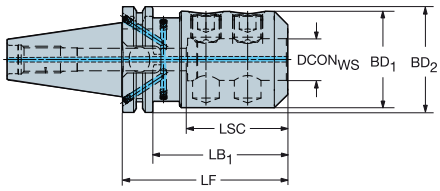

						Dimensions, mm											
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	**Ordering code**	CRKS	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR	NM	KG	RPMX
40	16	7	1	2	392.54023-4016060	M16	16.0		60.0	40.9	60.0	48.0	63.5	20	25.00	1.32	18000
	20	7	1	2	392.54023-4020070	M16	20.0		70.0	50.9	70.0	52.0	63.5	20	25.00	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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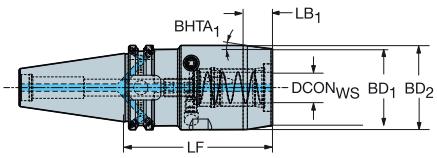
M1 N23 N15

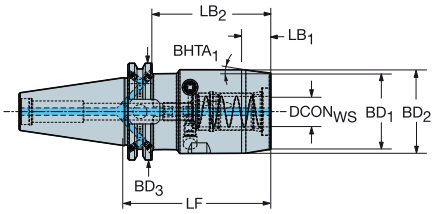
BIG-PLUS ISO to CoroChuck™ 930

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

DSGN 3



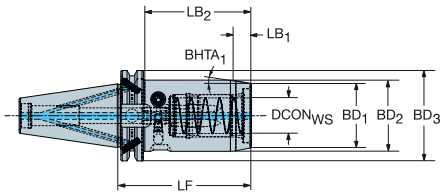
DSGN 6



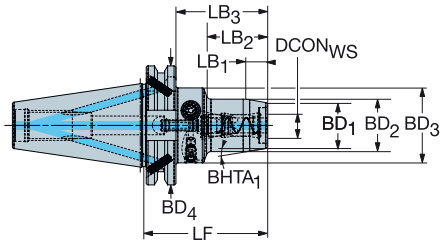
Heavy Duty design

						Dimensions, mm															
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	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



DSGN 10



Slender design

						Dimensions, mm																
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	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
	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
50	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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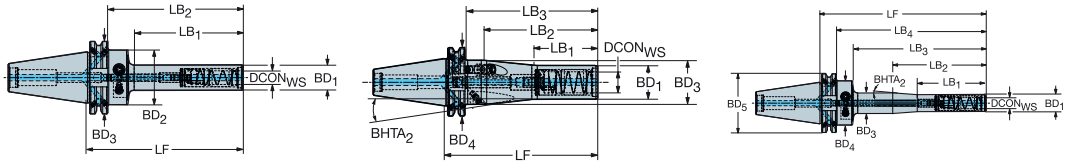
M1 N23 N15 N4

BIG-PLUS ISO to CoroChuck™ 930

Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB

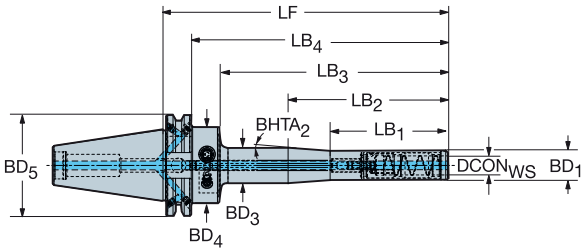
DSGN 5 11 17



Pencil design

						Dimensions, mm																		
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	LB_5	BD_1	BD_2	BD_3	BD_4	BD_5	$BHTA_2$	BAR	NM	KG	RPMX
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

DSGN 17



						Dimensions, mm																	
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	BAR	NM	KG	RPMX
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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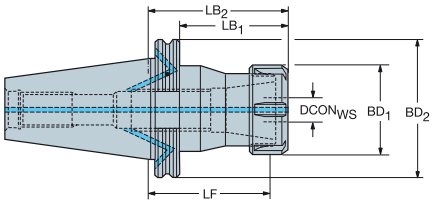
M1 N23 N15 N4

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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	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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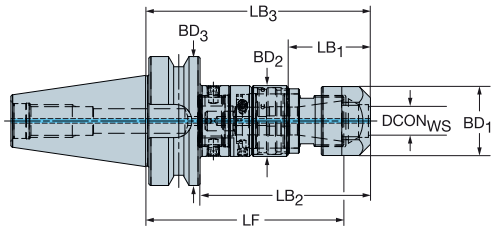
M1 N23 N15

BIG-PLUS ISO to CoroChuck™ 970

Workpiece side interface DIN 6499-B



						Dimensions, mm											
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	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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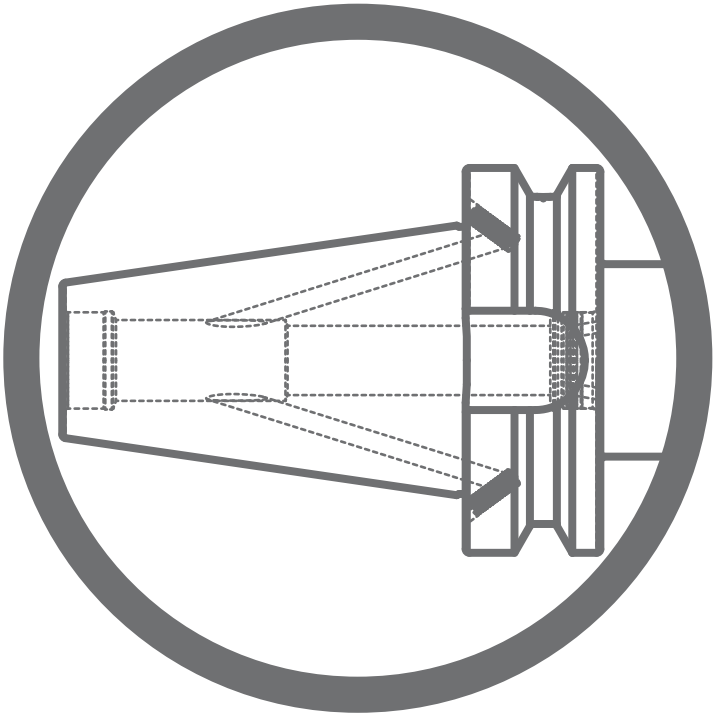
N23 N15 N5

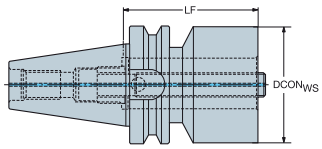
Machine side interface BIG-PLUS® MAS-BT



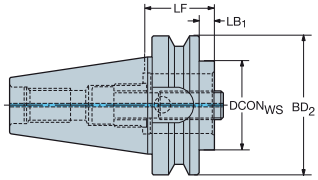
BIG-PLUS MAS-BT to Coromant Capto® adaptor

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN 1

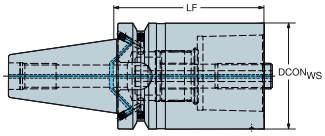


DSGN 2

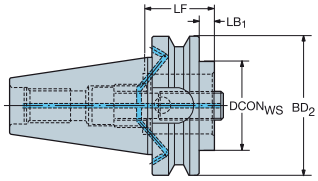


						Dimensions, mm								
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_2$	BAR	NM	KG
30	C3	1	1	2	C3-390.555-30 040	M12	32.0	40.0	18.0	40.0	46.0	80	45.00	0.48
	C4	1	1	2	C4-390.555-30 060	M12	40.0	60.0	38.0	60.0	46.0	80	55.00	0.67
	C5	1	1	1	C5-390.555-30 080	M12	50.0	80.0	80.0			80	95.00	1.08

DSGN 1



DSGN 2



						Dimensions, mm								
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_2$	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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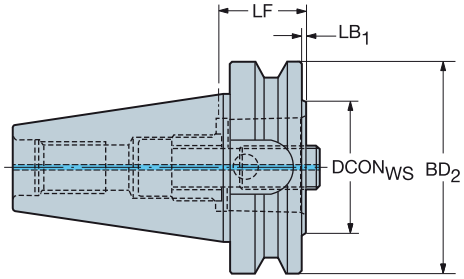
M1 N23 N15

BIG-PLUS MAS-BT to Coromant Capto® adaptor

90° rotated polygon for precision tool tip control

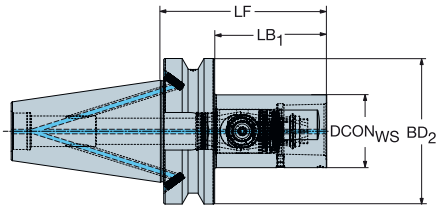
Designed for Mazak™ e-machine and Mori Seiki NT™ -Series



					Dimensions, mm							
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	CRKS	DCON$_{WS}$	LF	LB$_1$	BD$_2$	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

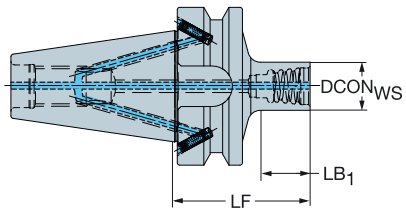
BIG-PLUS MAS-BT to Coromant Capto® adaptor with Quick change

Machine side interface compatible with MAS-BT 403 and JIS B 6339



					Dimensions, mm							
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	CRKS	DCON$_{WS}$	LF	LB$_1$	BD$_2$	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$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	CRKS	DCON$_{WS}$	LF	LB$_1$	BD$_2$	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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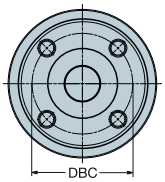
M1 N23 N15 N3

BIG-PLUS MAS-BT to arbor adaptor

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN



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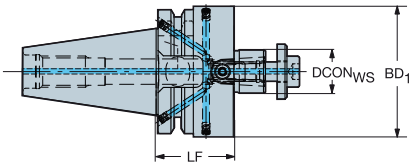

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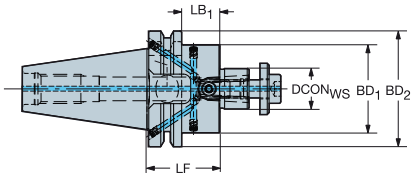
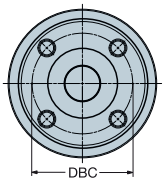
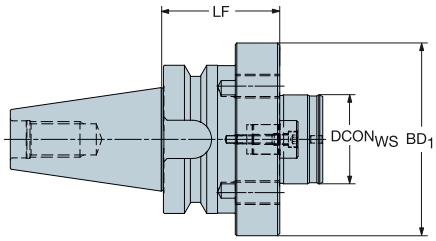


						Dimensions, mm											
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	**Ordering code**	DBC	CRKS	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR	NM	KG	RPMX
30	16	1	4	2	392.55505C3016040		M12	16.0	40.0	18.0	40.0	32.0	46.0	80	22.00	0.55	25000
	22	1	4	1	392.55505C3022040		M12	22.0	40.0	40.0		48.0		80	45.00	0.73	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$_{MS}$	CZC$_{WS}$	**Ordering code**	DBC	CRKS	DCON$_{WS}$	LF	BD$_1$	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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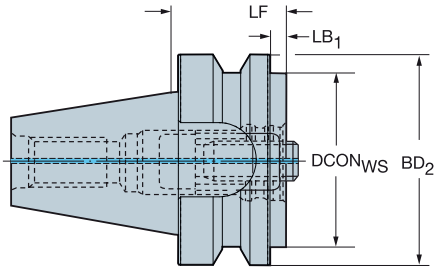
M1 N23 N15

BIG-PLUS MAS-BT to VL adaptor

Machine side interface compatible with MAS-BT 403 and JIS B 6339

Coolant through centre



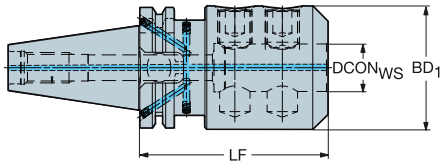
					Dimensions, mm								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_2	BAR	NM	KG
50	80	1	1	390.558-50 80 040	M24	80.0	40.0	2.0	100.0	80	180.00	3.50

BIG-PLUS MAS-BT to Weldon / ISO 9766 adaptor

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN

1



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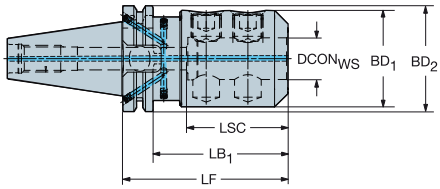

						Dimensions, mm										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG	RPMX
30	16	1	1	1	392.55523-3016060	M12	16.0	60.0	60.0		48.0		20	20.00	0.86	25000
	20	1	1	1	392.55523-3020065	M12	20.0	65.0	65.0		52.0		20	20.00	0.97	25000
	25	1	1	1	392.55523-3025090	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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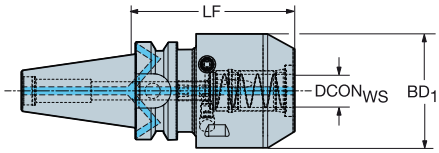
M1 N23 N15

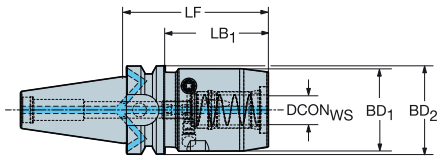
BIG-PLUS MAS-BT to CoroChuck™ 930

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN 3



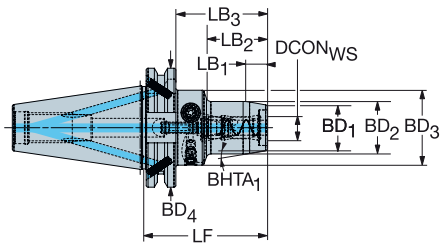
DSGN 6



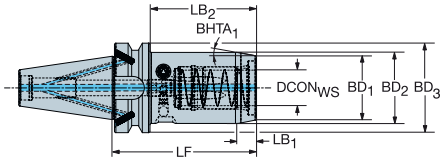
Heavy Duty design

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm CRKS	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_2$	BD$_3$	BHTA$_1$	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



DSGN 6



Slender design

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm CRKS	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	LB$_4$	BD$_1$	BD$_2$	BD$_3$	BD$_4$	BHTA$_1$	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
	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
50	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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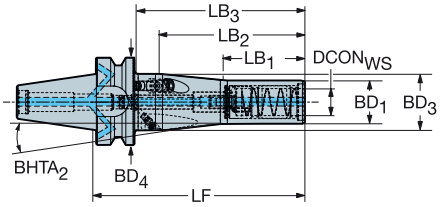
M1 N23 N15 N4

BIG-PLUS MAS-BT to CoroChuck™ 930

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN 11



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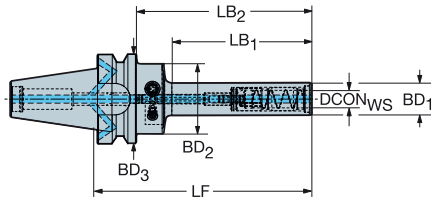
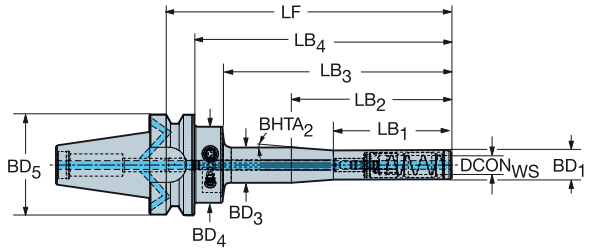


Pencil design

						Dimensions, mm																
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_2$	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
	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
40	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_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	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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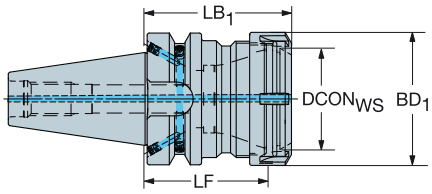
M1 N23 N15 N4

BIG-PLUS MAS-BT to ER collet chuck

Machine side interface compatible with MAS-BT 403 and JIS B 6339

DSGN 1



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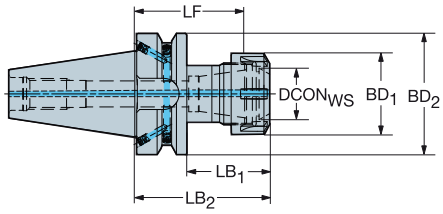

Workpiece side interface DIN 6499-B

						Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR	KG	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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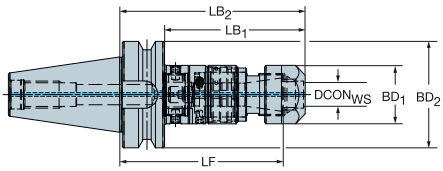
M1 N23 N15

SANDVIK Coromant

BIG-PLUS MAS-BT to CoroChuck™ 970

Workpiece side interface DIN 6499-B

DSGN 2



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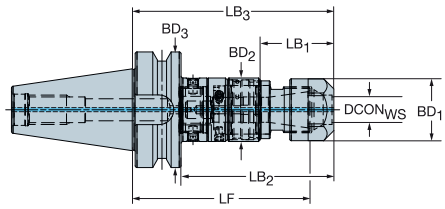

							Dimensions, mm											
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BAR	KG	RPMX
30	ER11	M5	1	1	5	**970-BB30-11-082**	M12	11.3	78.2	24.1	60.0	82.0	18.7	23.5	46.0	80	0.52	8000
	ER20	M12	1	1	5	**970-BB30-20-105**	M12	20.8	92.2	40.3	83.1	105.2	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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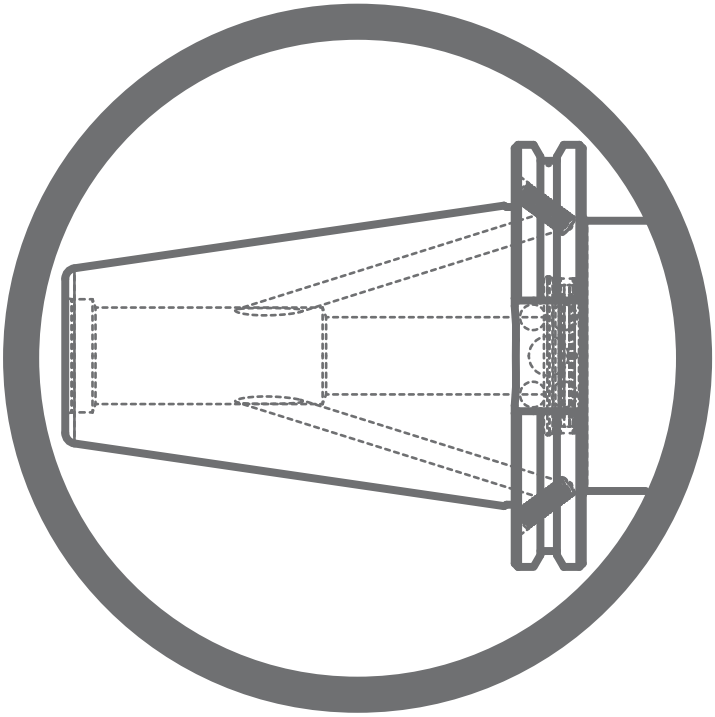
M1 N23 N15 N5

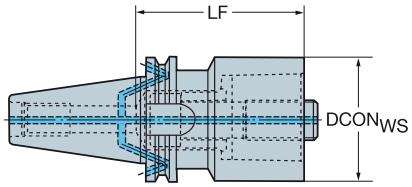
Machine side interface ISO 7388-1



ISO 7388-1 to Coromant Capto® adaptor

Machine side interface compatible with DIN 69871-ADB

DSGN 1



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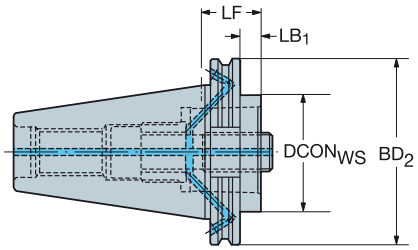
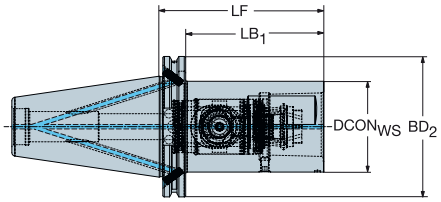


						Dimensions, mm								
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_2$	BAR	NM	KG
40	C3	7	1	2	C3-390B.140-40 030	M16	32.0	30.0	10.9	30.0	63.5	80	45.00	0.87
	C3	7	1	2	C3-390B.140-40 060	M16	32.0	60.0	40.9	60.0	63.5	80	45.00	1.02
	C4	7	1	2	C4-390B.140-40 030	M16	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$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	CRKS	DCON$_{WS}$	LF	LB$_1$	BD$_2$	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

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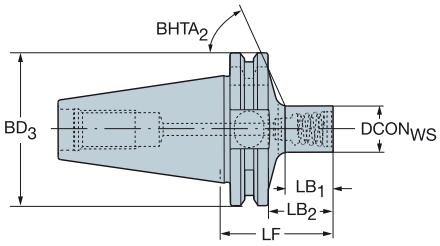
M1 N23 N15

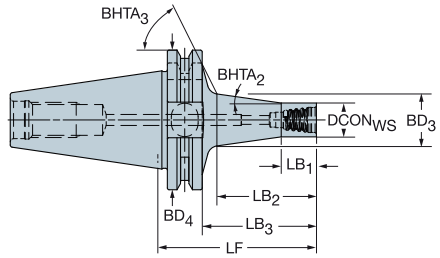
ISO 7388-1 to Coromant EH adaptor

Machine side interface compatible with DIN 69871-AD



Short design

					Dimensions, mm										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_3	$BHTA_2$	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_3	BD_4	$BHTA_2$	$BHTA_3$	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

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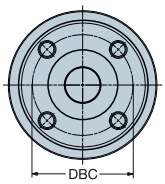
M1 N23 N15 N3

ISO 7388-1 to arbor adaptor

Machine side interface compatible with DIN 69871-ADB

DSGN



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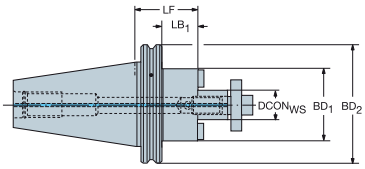

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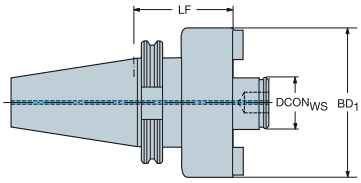


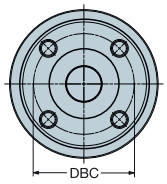
						Dimensions, mm											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	DBC	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG	RPMX
40	16	7	1	2	**A1B05-40 16 035**		M16	16.0	35.0	15.9	35.0	36.0	63.5	80	22.00	1.04	18000
	16	7	1	2	**A1B05-40 16 100**		M16	16.0	100.0	78.9	100.0	36.0	63.5	80	22.00	1.47	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
	32	7	1	1	**A1B05-40 32 050**		M16	32.0	50.0	50.0		78.0		80	180.00	1.82	18000
50	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	

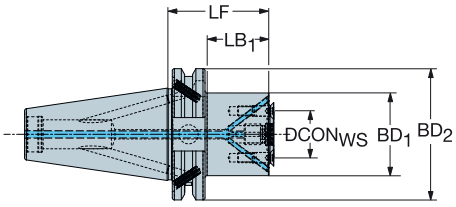
All holders are delivered with a standard screw without hole for coolant.
For cutters with coolant channels a new screw with radial coolant holes is necessary and can be ordered separately.
See page M13

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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	DBC	CRKS	$DCON_{WS}$	LSC	LF	LB_1	BD_1	BD_2	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

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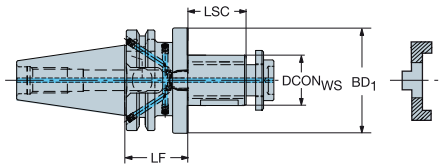
M1 N23 N15

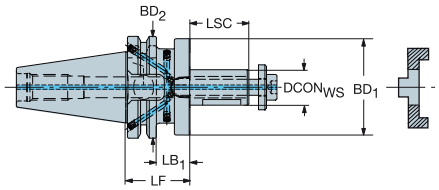
ISO 7388-1 to side and face mill arbor adaptor

Machine side interface compatible with DIN 69871-ADB

DSGN 1



DSGN 2

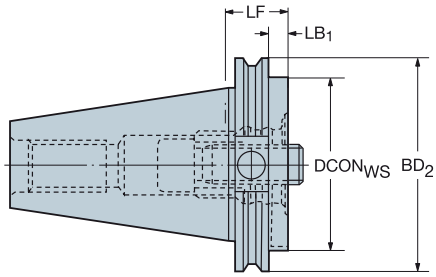


						Dimensions, mm										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG
40	22	7	1	2	**A1B08-40 22 055**	M16	22.0	31	43.0	19.9	43.0	40.0	63.5	80	45.00	1.26
	27	7	1	2	**A1B08-40 27 055**	M16	27.0	33	43.0	22.9	43.0	48.0	63.5	80	80.00	1.45
	32	7	1	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

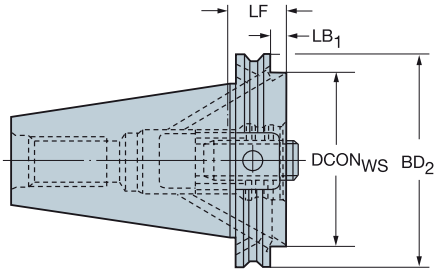
M1 N23 N15

ISO 7388-1 to VL adaptor



Machine side interface compatible with DIN 69871-AD

					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_2	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_2	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

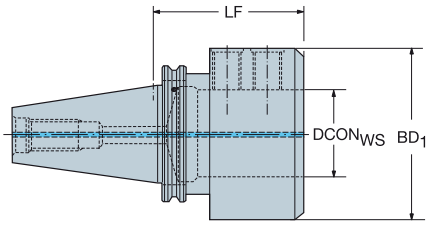
M1 N23 N15

ISO 7388-1 to Weldon adaptor

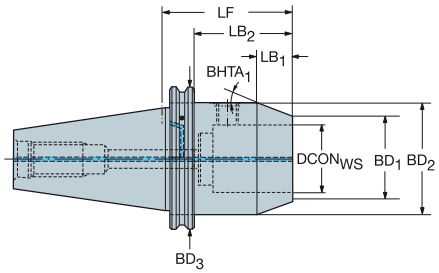
Machine side interface compatible with DIN 69871-ADB

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN 3



DSGN 6



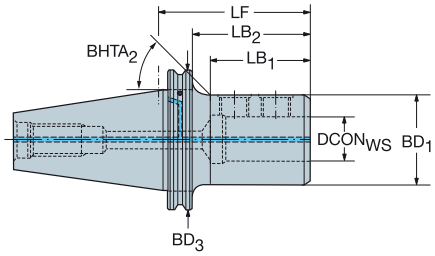
						Dimensions, mm												
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	BAR	NM	KG
40	6	7	1	6	**A1B20-40 06 050**	M16	6.0	50.0	11.0	28.9	50.0	12.3	25.0	63.5	30°	20	3.00	0.91
	6	7	1	6	**A1B20-40 06 100**	M16	6.0	100.0	11.0	78.9	100.0	12.3	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

M1 N23 N15

ISO 7388-1 to ISO 9766 adaptor

Machine side interface compatible with DIN 69871-ADB



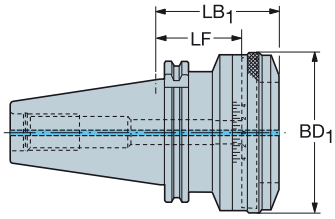
					Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	BD_1	BD_2	BAR	NM	KG
40	16	7	1	**A1B27-40 16 080**	M16	16.0	49	80.0	55.9	36.0	63.5	20	10.00	1.21
	20	7	1	**A1B27-40 20 080**	M16	20.0	51	80.0	55.9	40.0	63.5	20	12.00	1.27
	25	7	1	**A1B27-40 25 085**	M16	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

M1 N23 N15

ISO 7388-1 to ISO 9766 adjustable adaptor

Machine side interface compatible with DIN 69871-AD



					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_1	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

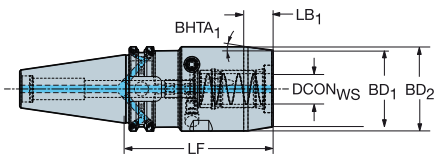
M1

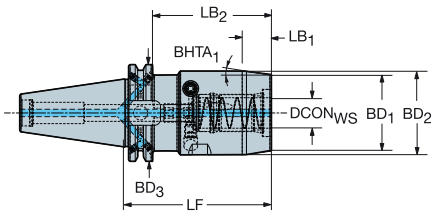
N23

ISO 7388-1 to CoroChuck™ 930

Machine side interface compatible with DIN 69871-ADB

DSGN 3 6

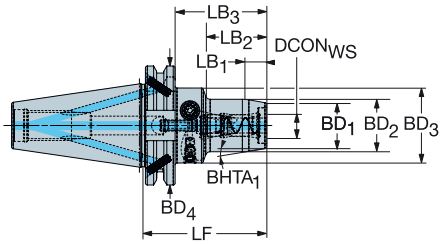


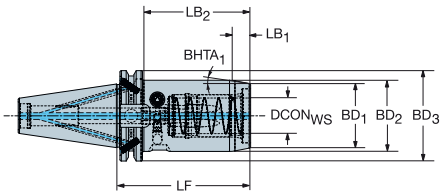


Heavy Duty design

						Dimensions, mm															
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	BAR	NM	KG	RPMX
40	20	7	1	6	**930-I40-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-I40-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-I50-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-I50-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-I50-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-I50-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

DSGN 10 6





Slender design

						Dimensions, mm																
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BD_4	$BHTA_1$	$BHTA_3$	BAR	NM	KG	RPMX
40	6	7	1	10	**930-I40-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-I40-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-I40-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-I40-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-I40-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-I40-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-I50-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-I50-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

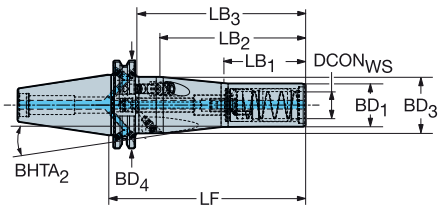
For spare parts, visit www.sandvik.coromant.com

M1 N23 N6 N15 N4

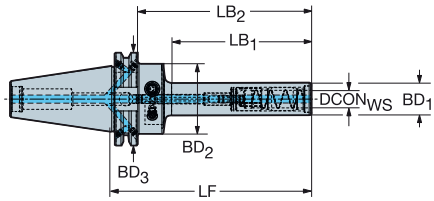
ISO 7388-1 to CoroChuck™ 930

Machine side interface compatible with DIN 69871-ADB

DSGN 11



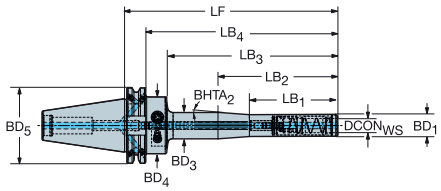
DSGN 5



Pencil design

						Dimensions, mm																
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_2$	BAR	NM	KG	RPMX
40	8	7	1	5	**930-I40-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-I40-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-I40-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-I40-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-I40-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-I40-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_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	BAR	NM	KG	RPMX
40	12	7	1	17	**930-I40-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

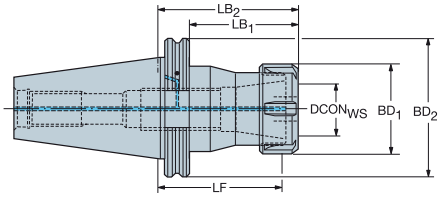
For spare parts, visit www.sandvik.coromant.com

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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	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
	ER16	7	1	**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
	ER20	7	1	**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
	ER25	7	1	**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
	ER40	7	1	**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
	ER20	7	1	**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
	ER25	7	1	**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
	ER32	7	1	**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

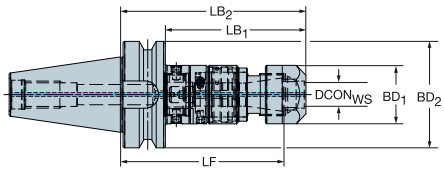
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

ISO 7388-1 to CoroChuck™ 970

Workpiece side interface DIN 6499-B

DSGN 2



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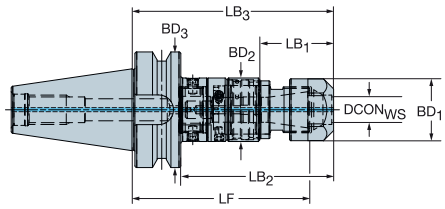


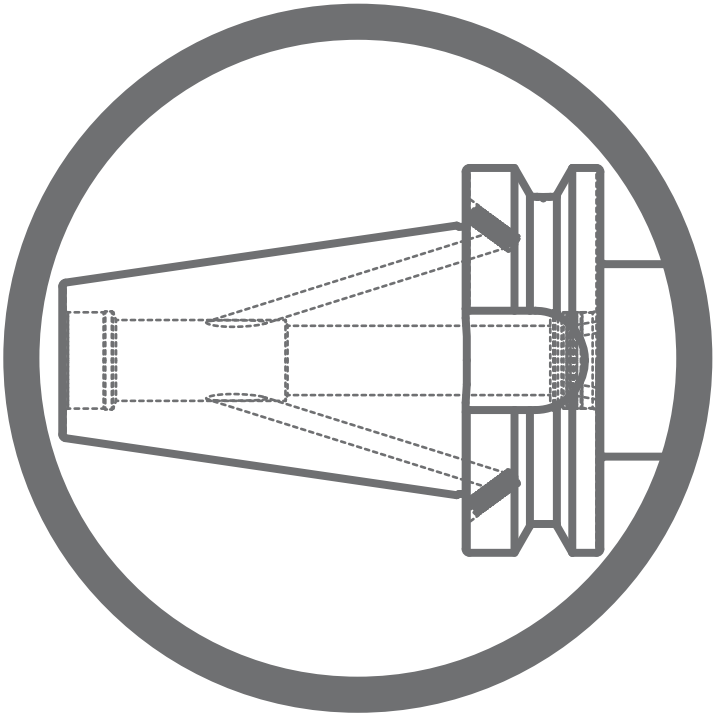
							Dimensions, mm											
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BAR	KG	RPMX
40	ER20	M12	1	1	5	**970-I40-20-102**	M16	20.8	89.2	35.3	78.1	97.2	33.7	35.0	63.5	80	1.26	8000
	ER25	M20	1	1	5	**970-I40-25-122**	M16	25.8	108.1	37.1	97.5	116.6	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

M1 N23 N15 N5

SANDVIK Coromant

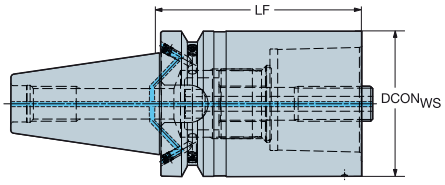
Machine side interface MAS-BT



MAS-BT 403 to Coromant Capto® adaptor

Machine side interface compatible with JIS B 6339

DSGN 1



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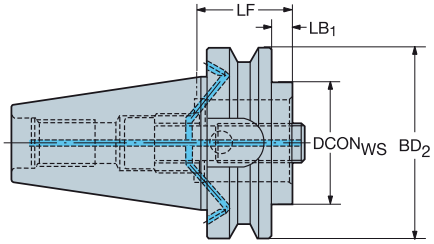
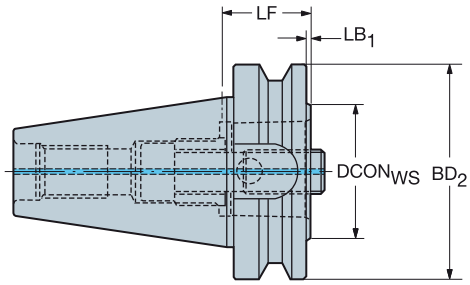


						Dimensions, mm								
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_2$	BAR	NM	KG
30	C3	1	1	2	C3-390.55-30 030	M12	32.0	30.0	8.0	30.0	46.0	80	45.00	0.42
	C3	1	1	2	C3-390.55-30 060	M12	32.0	60.0	38.0	60.0	46.0	80	45.00	0.58
	C4	1	1	2	C4-390.55-30 060	M12	40.0	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



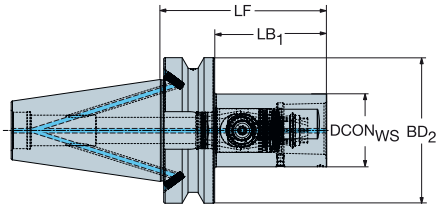
					Dimensions, mm							
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	CRKS	DCON$_{WS}$	LF	LB$_1$	BD$_2$	BAR	NM	KG
40	C5	1	1	C5-390.605-40 030	M16	50.0	30.0	3.0	63.0	80	95.00	0.88
50	C6	1	1	C6-390.605-50 040	M24	63.0	40.0	2.0	100.0	80	170.00	3.26
	C8	1	1	C8-390.605-50 070	M24	80.0	70.0	32.0	100.0	80	170.00	4.14

For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

MAS-BT 403 to Coromant Capto® adaptor with Quick change

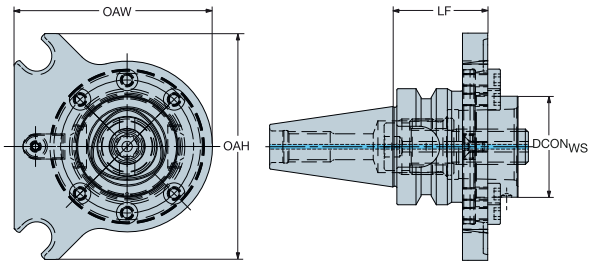
Machine side interface compatible with JIS B 6339



					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_2	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

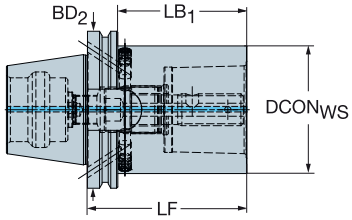
MAS-BT 403 to Coromant Capto® turning adaptor

For Brother Speedio mill-turn



					Dimensions, mm						
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	LF	LB_1	BD_2	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

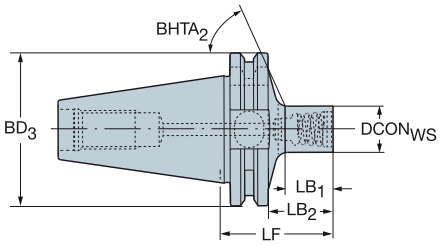
For spare parts, visit www.sandvik.coromant.com

M1 N23 N23 N15

MAS-BT 403 to Coromant EH adaptor

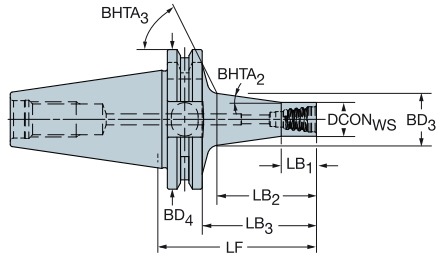
Machine side interface compatible with JIS B 6339

DSGN 7



						Dimensions, mm											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_3	$BHTA_2$	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
	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
40	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
	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_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_3	BD_4	$BHTA_2$	$BHTA_3$	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

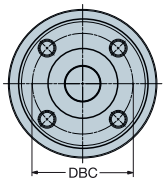
For spare parts, visit www.sandvik.coromant.com

N23 N15 N3

MAS-BT 403 to arbor adaptor

Machine side interface compatible with JIS B 6339

DSGN



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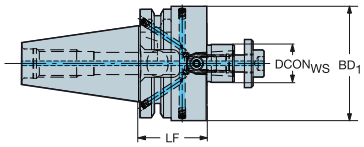

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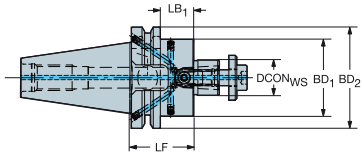


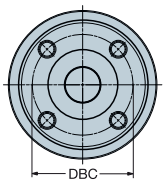
						Dimensions, mm											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	DBC	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG	RPMX
30	16	1	1	2	**A205-30 16 035**		M12	16.0	35.0	13.0	35.0	36.0	46.0	80	22.00	0.54	25000
	22	1	1	2	**A205-30 22 035**		M12	22.0	35.0	11.9	35.0	42.0	46.0	80	45.00	0.63	25000
	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

DSGN



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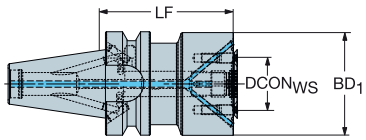

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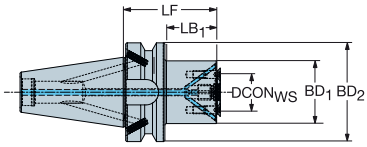


						Dimensions, mm												
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	DBC	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG	RPMX
30	X10	1	3	2	**B30-X10-032-050**	22.0	M12	10.0	2	50.0	27.0	50.0	32.0	46.0	80	6.40	0.60	12000
	X22	1	3	2	**B30-X22-040-055**	32.0	M12	22.0	2	55.0	32.0	55.0	40.0	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

M1

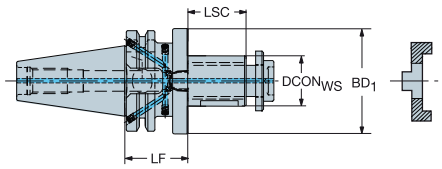
N23

N15

MAS-BT 403 to side and face mill arbor adaptor

Machine side interface compatible with JIS B 6339

DSGN 1



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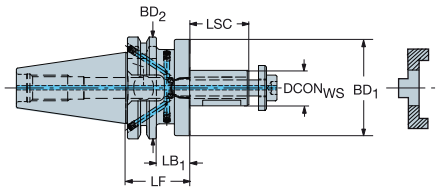


						Dimensions, mm											
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	BAR	NM	KG	RPMX
30	22	1	1	2	**A208-30 22 047**	M12	22.0	31	35.0	13.0	35.0	40.0	46.0	80	45.00	0.71	25000
	27	1	1	1	**A208-30 27 050**	M12	27.0	33	38.0	38.0		48.0		80	80.00	0.87	25000
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

M1 N23 N15

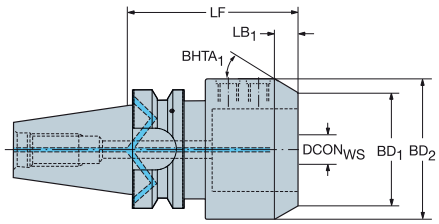
SANDVIK Coromant

MAS-BT 403 to Weldon adaptor

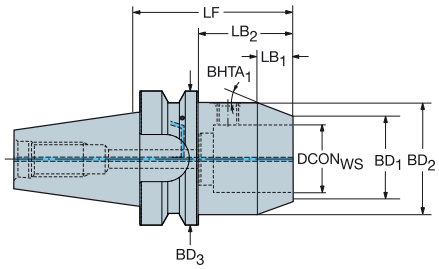
Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6535-HB and DIN 1835-B

DSGN 3



DSGN 6



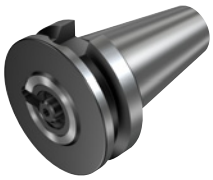
						Dimensions, mm												
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	BAR	NM	KG
30	12	1	1	6	A2B20-30 12 052	M12	12.0	52.0	12.6	28.9	52.0	27.0	41.5	46.0	30°	20	12.00	0.63
	16	1	1	3	A2B20-30 16 063	M12	16.0	63.0	12.6	63.0		33.0	47.5		30°	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

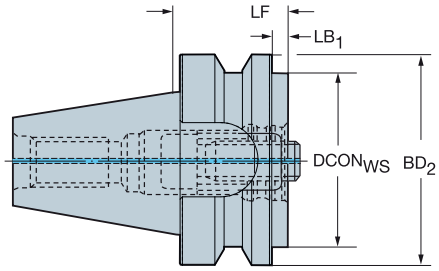
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

MAS-BT 403 to VL adaptor

Machine side interface compatible with JIS B 6339





					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_2	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

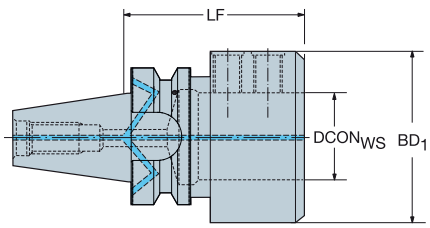
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

MAS-BT 403 to ISO 9766 adaptor

Machine side interface compatible with JIS B 6339

DSGN 1



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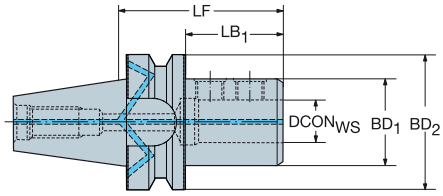
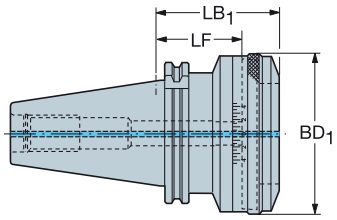


						Dimensions, mm											
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	**Ordering code**	CRKS	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR	NM	KG	RPMX
30	16	1	1	2	**A227-30 16 080**	M12	16.0	49	80.0	58.0	80.0	36.0	46.0	20	10.00	0.76	25000
	20	1	1	2	**A227-30 20 080**	M12	20.0	51	80.0	56.9	80.0	40.0	46.0	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$_{MS}$	CZC$_{WS}$	CNSC	CXSC	**Ordering code**	CRKS	DCON$_{WS}$	LF	LB$_1$	BD$_1$	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

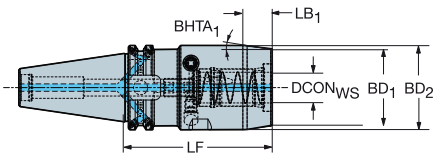
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

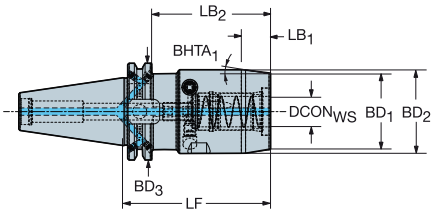
MAS-BT 403 to CoroChuck™ 930

Machine side interface compatible with JIS B 6339

DSGN 3



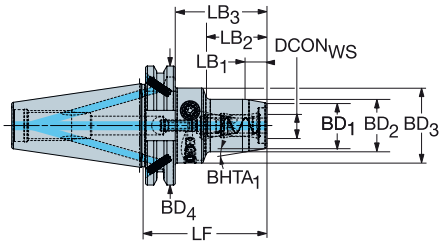
DSGN 6



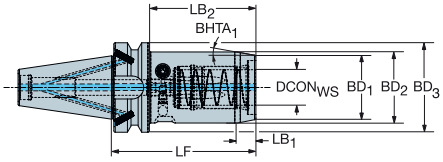
Heavy Duty design

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_2$	BD$_3$	BHTA$_1$	BAR	NM	KG	RPMX
						Dimensions, mm														
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



DSGN 6



Slender design

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	CRKS	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	LB$_4$	BD$_1$	BD$_2$	BD$_3$	BD$_4$	BHTA$_1$	BAR	NM	KG	RPMX
						Dimensions, mm																
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
	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
40	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

M1 N23 N6 N15 N4

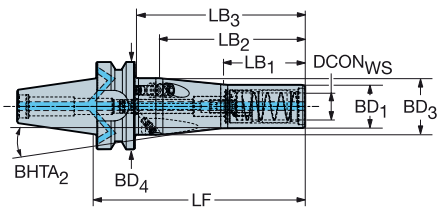
SANDVIK Coromant

MAS-BT 403 to CoroChuck™ 930

Machine side interface compatible with JIS B 6339

Pencil design

DSGN 11



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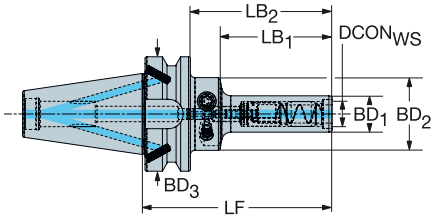
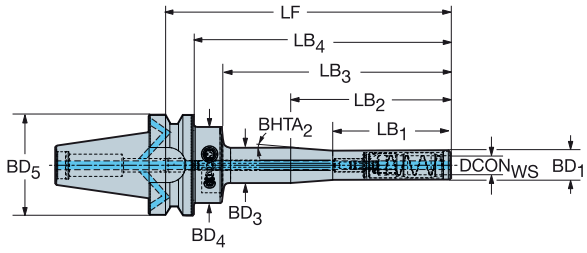


						Dimensions, mm																
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_2	BD_3	BD_4	$BHTA_2$	BAR	NM	KG	RPMX
30	6	1	1	11	930-B30-P-06-088	M12	6.0	37	88.0	45.8	52.1	66.0	88.0	14.5	14.5	40.0	46.0	0°	80	8.00	0.62	25000
	8	1	1	5	930-B30-P-08-088	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_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LSC	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	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

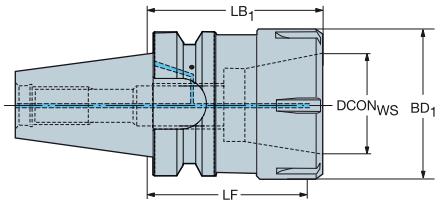
M1 N23 N6 N15 N4

MAS-BT 403 to ER collet chuck

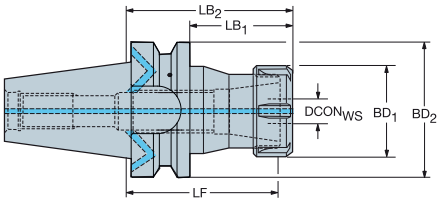
Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6499-B

DSGN 1



DSGN 2



						Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	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

M1 N23 N15

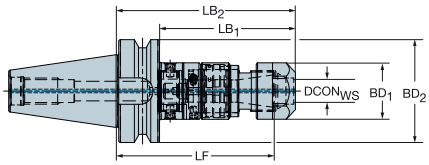
ENG

MAS-BT 403 to CoroChuck™ 970

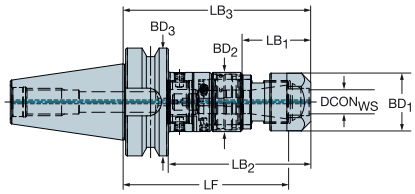
Machine side interface compatible with JIS B 6339

Workpiece side interface DIN 6499-B

DSGN 2



DSGN 5

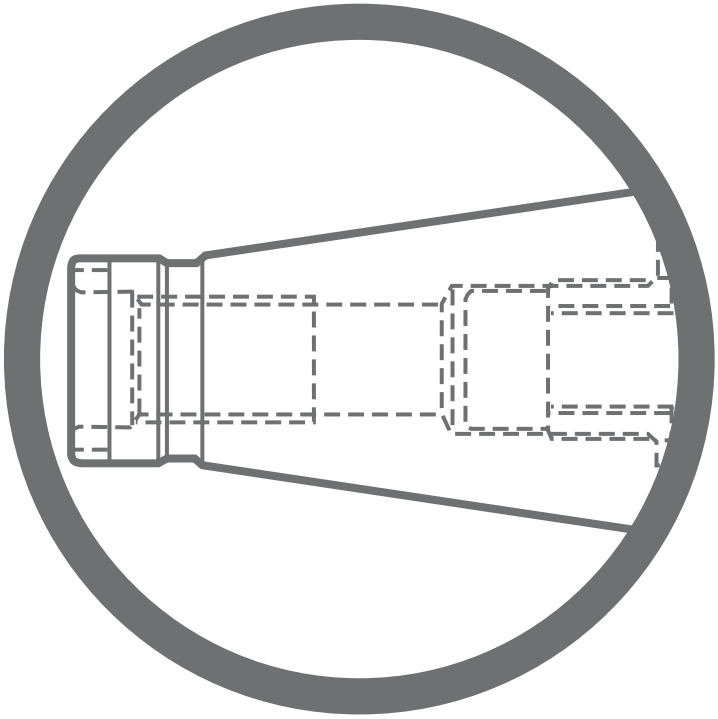


							Dimensions, mm											
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BAR	KG	RPMX
30	ER11	M5	1	1	5	**970-B30-11-082**	M12	11.3	78.2	24.1	60.0	82.0	18.7	23.5	46.0	80	0.55	8000
	ER20	M12	1	1	5	**970-B30-20-105**	M12	20.8	92.2	35.3	78.1	100.2	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

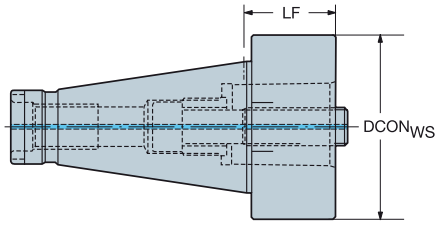
M1 N23 N15 N5

Machine side interface DIN 2080

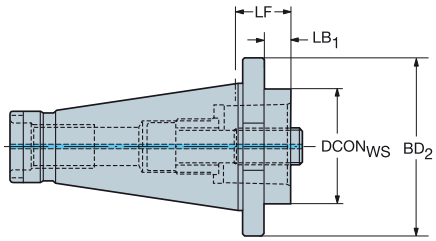


DIN 2080 to Coromant Capto® adaptor

DSGN 1



2

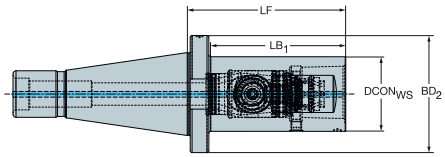


						Dimensions, mm								
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	**Ordering code**	CRKS	DCON$_{WS}$	LF	LB$_1$	LB$_2$	BD$_2$	BAR	NM	KG
40	C3	1	1	2	**C3-390.00-40 030**	M16	32.0	30.0	18.4	30.0	63.0	80	45.00	0.86
	C4	1	1	2	**C4-390.00-40 030**	M16	40.0	30.0	18.4	30.0	63.0	80	55.00	0.09
	C4	1	1	2	**C4-390.00-40 060**	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	2.78
	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

N23 N15

DIN 2080 to Coromant Capto® adaptor with Quick change



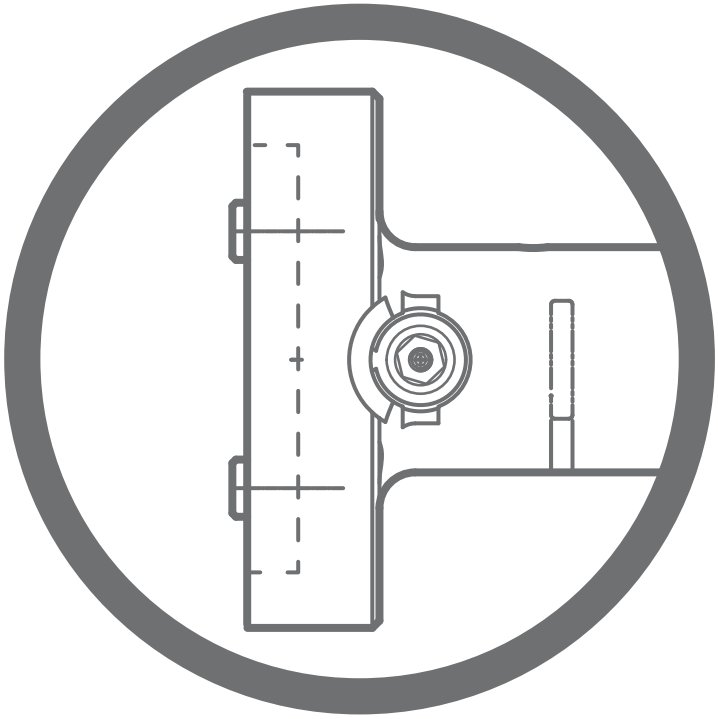
					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	CRKS	$DCON_{WS}$	LF	LB_1	BD_2	BAR	NM	KG
40	C5	1	1	**DN40-QC-C5-095**	M16	50.0	95.0	83.4	62.8	80	70.00	1.70
50	C8	1	1	**DN50-QC-C8-140**	M24	80.0	140.0	124.8	97.3	80	130.00	6.30

For spare parts, visit www.sandvik.coromant.com

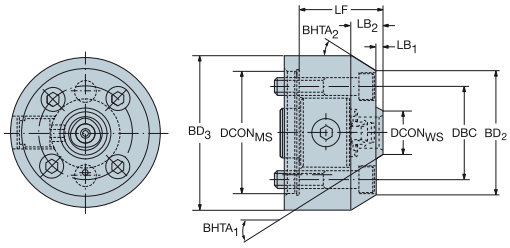
N23

N15

Machine side interface DIN 2079

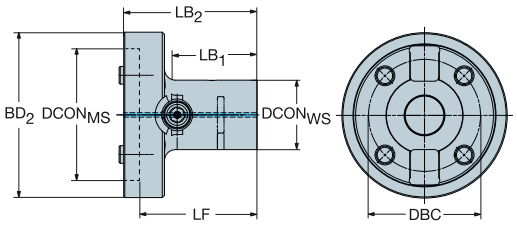


DIN 2079 to Coromant Capto® adaptor



			Dimensions, mm											
CZC_{MS}	CZC_{WS}	**Ordering code**	$DCON_{MS}$	DBC	$DCON_{WS}$	LF	LB_1	LB_2	BD_2	BD_3	$BHTA_1$	$BHTA_2$	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

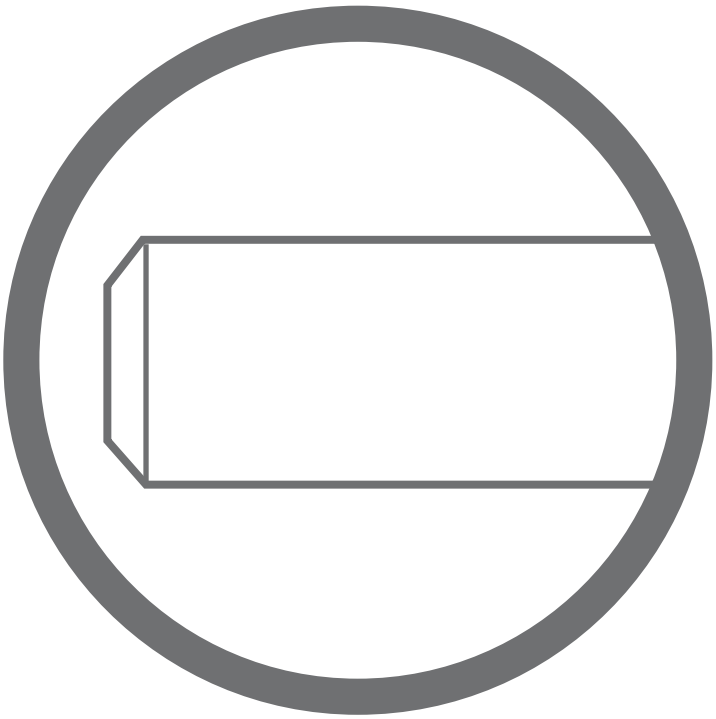


					Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	DBC	$DCON_{WS}$	LF	LB_1	LB_2	BD_2	BAR	NM	KG
40	C5	1	1	**SI40-QC-C5-090**	88.8	66.7	50.0	90.0	70.0	102.0	110.0	80	70.00	2.30
50	C6	1	1	**SI50-QC-C6-105**	128.5	101.6	63.0	105.0	74.0	121.0	150.0	80	90.00	5.00
	C8	3	1	**SI50-QC-C8-135**	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

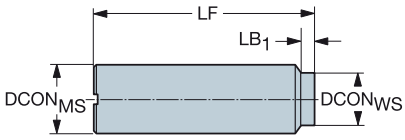
N23 N15

Machine side interface Cylindrical shank



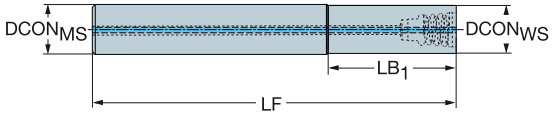
Cylindrical shank to Coromant EH adaptor

Straight design



Steel shank

					Dimensions, mm								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	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_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	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

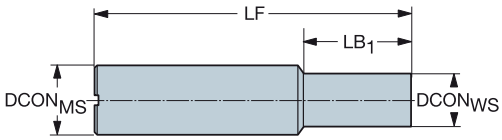
For spare parts, visit www.sandvik.coromant.com

N23 N6 N15 N3

ENG

Cylindrical shank to Coromant EH adaptor

Straight design



Cemented carbide shank

					Dimensions, mm								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	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!

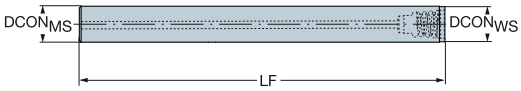
Cemented carbide shank to be used for Finishing/Semi finishing only

For spare parts, visit www.sandvik.coromant.com

N23 N6 N15 N3

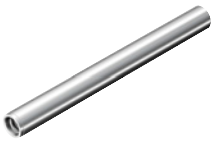
Cylindrical shank to Coromant EH adaptor

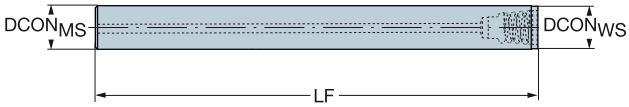
Straight design



G-undersized steel shank

CZCMS	CZCWS	CNSC	CXSC	Ordering code	Dimensions, mm DCONMS	DCONWS	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

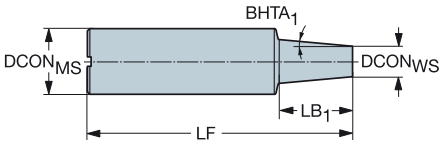
CZCMS	CZCWS	CNSC	CXSC	Ordering code	Dimensions, mm DCONMS	DCONWS	LSC	LF	BAR	NM	KG	RPMX
9	E10	1	1	EH10-A09.7-SH-120	9.7	9.6	117	120.0	80		0.20	19000
	E10	1	1	EH10-A09.7-SH-100	9.7	9.6	97	100.0	80	12.00	0.17	23000
11	E12	1	1	EH12-A11.7-SH-135	11.7	11.6	132	135.0	80		0.29	17000
	E12	1	1	EH12-A11.7-SH-110	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

N23 N15 N3

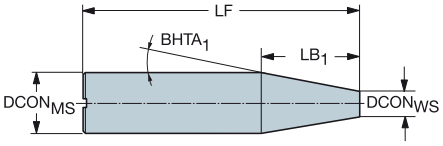
Cylindrical shank to Coromant EH adaptor

Conical design



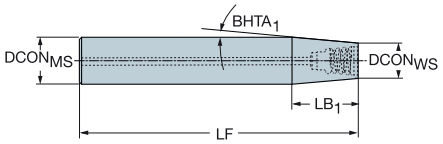
Steel shank

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	BHTA$_1$	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
	E12	1	1	E12-A16-CS-170	16.0	11.6	108	170.0	60.0	1°	80	15.00	0.30	12000
20	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

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	BHTA$_1$	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

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	BHTA$_1$	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
	E12	1	1	E12-A16-CE-150	16.0	11.6	58	150.0	90.0	1°	80	15.00	0.39	23000
20	E16	1	1	EH16-A20-CE-165	20.0	15.4	138	165.0	26.3	5°	80		0.78	27000
	E16	1	1	E16-A20-CE-175	20.0	15.4	55	175.0	118.0	1°	80	30.00	0.72	22000
25	E20	1	1	EH20-A25-CE-150	25.0	19.2	116	150.0	33.1	5°	80	50.00	1.05	23000
	E20	1	1	EH20-A25-CE-200	25.0	19.2	117	200.0	83.0	2°	80	50.00	1.08	19000
32	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!

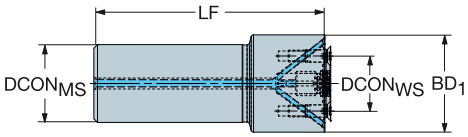
Cemented carbide shank to be used for Finishing/Semi finishing only

For spare parts, visit www.sandvik.coromant.com

N23 N6 N15 N3

Cylindrical shank to arbor with driving screws adaptor

For CoroMill® QD with internal coolant supply



					Dimensions, mm									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	DBC	$DCON_{WS}$	LSC	LF	BD_1	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

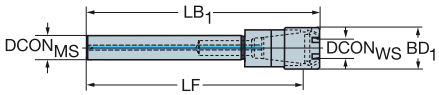
N23

N15

ENG

Cylindrical shank to ER collet chuck

Workpiece side interface DIN 6499-B



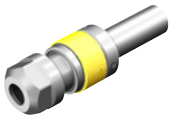
					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	BD_1	BAR	KG
8	ER11	1	1	**393.14-08 11 056**	8.0	11.4	52	75.0	82.5	16.0	20	0.05
12	ER16	1	1	**393.14-12 16 080**	12.0	17.0	77	107.0	118.5	22.0	20	0.13
16	ER11	1	1	**393.14-16 11 150**	16.0	11.4	149	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

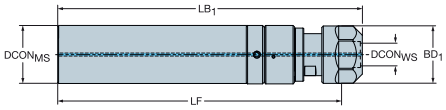
M1 N23 N15

Cylindrical shank to CoroChuck™ 970

Workpiece side interface DIN 6499-B



DSGN 1



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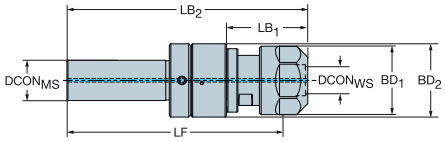
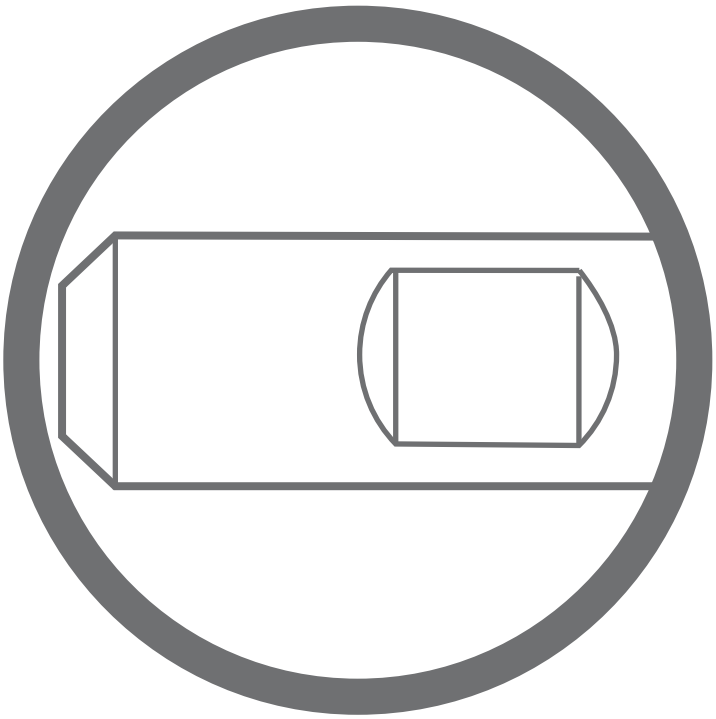


							Dimensions, mm										
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	BAR	KG	RPMX
12	ER8	M3	1	1	1	**970-CY12-8-052**	12.0	8.5	70	94.0	100.0		12.0		60	0.12	8000
16	ER11	M5	1	1	2	**970-CY16-11-052**	16.0	11.3	44	91.5	25.2	96.4	18.7	23.5	80	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

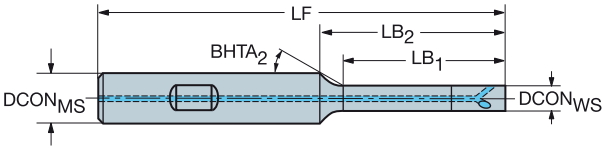
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15 N5

Machine side interface Weldon shank



Weldon to CoroMill® 327 adaptor



CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	BD$_1$	BHTA$_2$	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	1	327-20B35SC-14	20.0	14.3	51	93.5	28.5	33.2	14.0	30°	20	6.50	0.28	40000

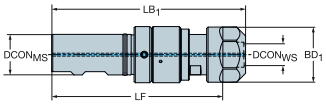
S = Steel shank

E = Cemented carbide shank

Weldon to CoroChuck™ 970

Workpiece side interface DIN 6499-B

DSGN 1



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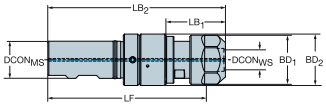

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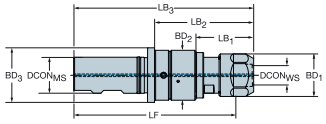
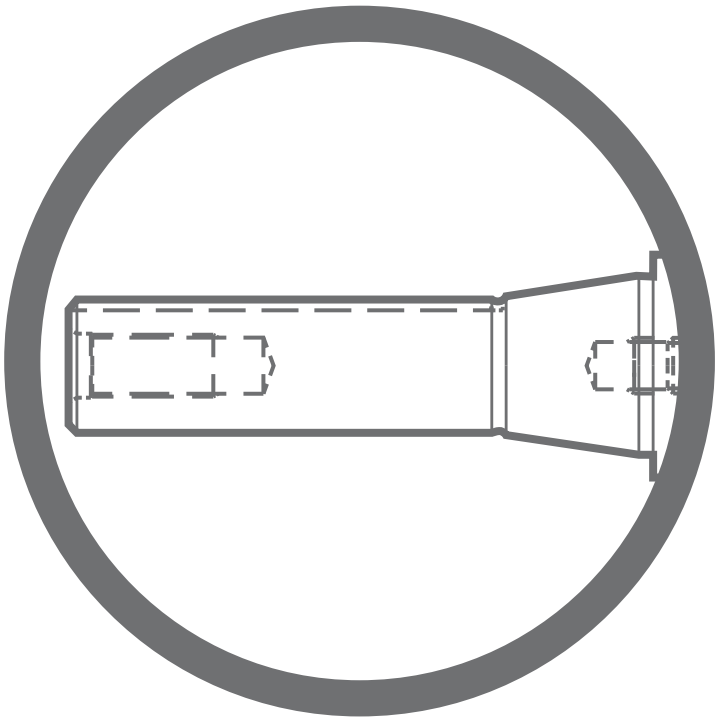


CZC$_{MS}$	CZC$_{WS}$	TRMAX	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_2$	BD$_3$	BAR	KG	RPMX
16	ER11	M5	1	1	2	970-WE16-11-052	16.0	11.3	44	91.5	25.2	96.4		18.7	23.5		80	0.18	8000
20	ER11	M5	1	1	5	970-WE20-11-052	20.0	11.3	50	97.8	25.2	48.6	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

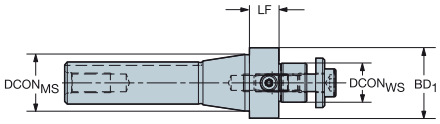
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15 N5

Machine side interface Bridgeport



R8 (Bridgeport) to arbor adaptor

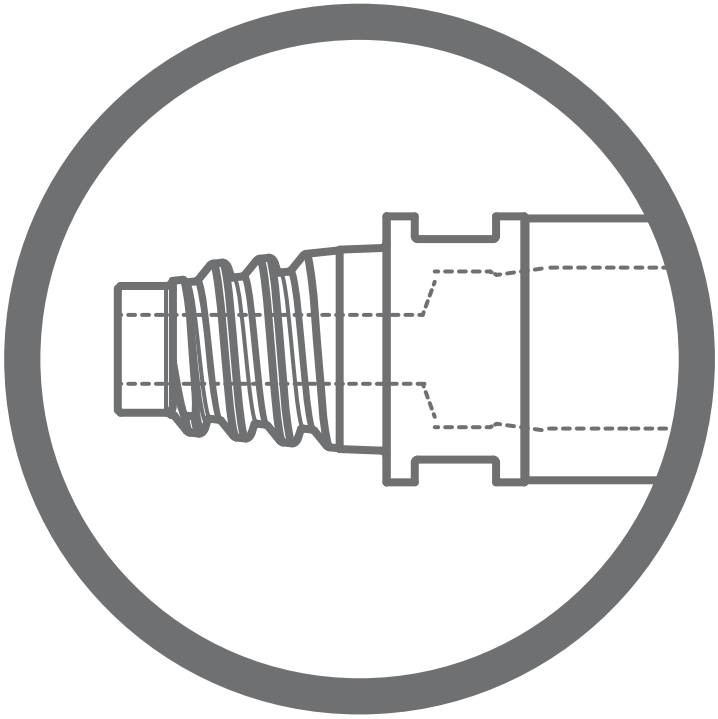


			Dimensions, mm					
CZC$_{MS}$	CZC$_{WS}$	**Ordering code**	DCON$_{WS}$	LF	BD$_1$	NM	KG	RPMX
R8	22	**392.R8.05-22 020**	22.0	20.0	40.0	45.00	0.67	10000

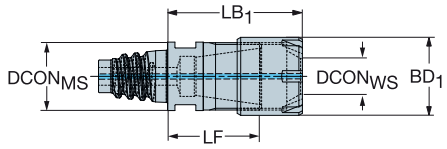
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15

Machine side interface Coromant EH

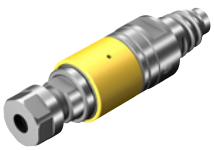


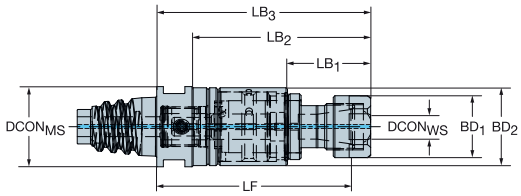
Coromant EH to ER adaptor



					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	BD_1	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

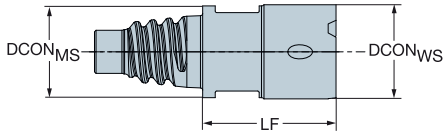
Coromant EH to CoroChuck™ 970





						Dimensions, mm										
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	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

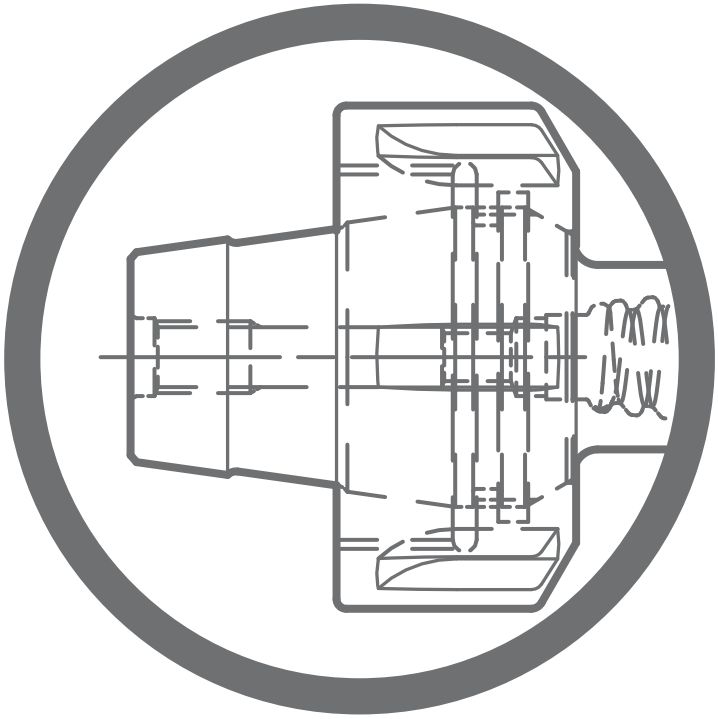


					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	BD_1	BAR	NM	KG	RPMX
E10	09	1	3	**327-EH10-09-015**	9.7	9.0	15.0	10.0	20	4.30	0.02	40000
E12	12	1	3	**327-EH12-12-017**	11.7	12.0	17.0	12.0	20	6.50	0.02	40000
	14	1	3	**327-EH12-14-017**	11.7	14.3	17.0	14.3	20	6.50	0.01	40000

For spare parts, visit www.sandvik.coromant.com

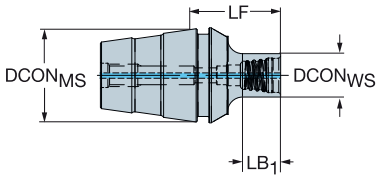
N23 N6 N15 N3

Machine side interface ER

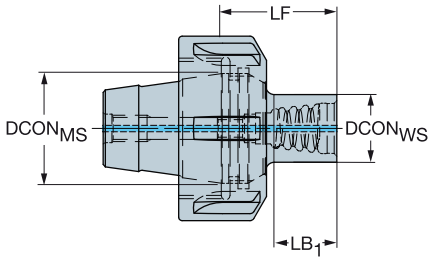


ER to Coromant EH adaptor

Machine side interface DIN 6499-B



					Dimensions, mm							
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	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



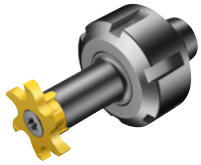
					Dimensions, mm							
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	BAR	NM	KG	RPMX
ER11	E10	1	1	392.EREH-11 10 008	11.4	9.6	16.8	8.0	80	12.00	0.09	40000
ER16	E12	1	1	392.EREH-16 12 010	17.0	11.6	20.5	10.0	80	15.00	0.16	40000
ER20	E16	1	1	392.EREH-20 16 014	21.0	15.4	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

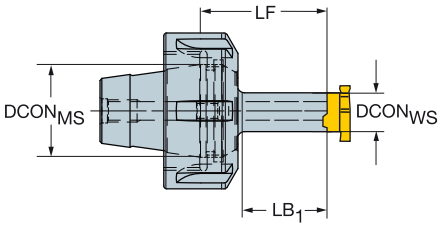
For spare parts, visit www.sandvik.coromant.com

M1 N23 N15 N3

ER to CoroMill® 327 adaptor

Machine side interface DIN 6499-B

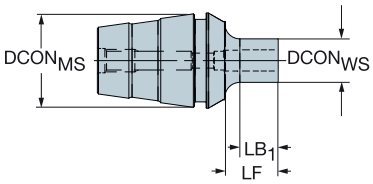




			Dimensions, mm							
CZC$_{MS}$	CZC$_{WS}$	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	BD$_1$	NM	KG	RPMX
ER11	09	392.ER327-11 09 022	11.4	9.0	25.0	16.0	9.0	4.30	0.07	40000
ER16	09	392.ER327-16 09 022	17.0	9.0	26.8	16.2	9.0	4.30	0.15	40000
	12	392.ER327-16 12 030	17.0	12.0	34.8	24.3	12.0	6.50	0.22	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!



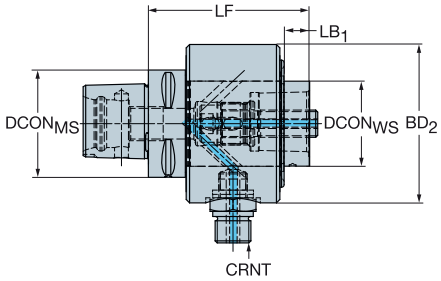
			Dimensions, mm							
CZC$_{MS}$	CZC$_{WS}$	Ordering code	DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	BD$_1$	NM	KG	RPMX
ER11	06	327-ER11-06-016	11.4	6.0	17.5	12.8	6.0	1.80	0.03	40000
ER20	09	327-ER20-09-022	21.0	9.0	24.7	16.5	9.0	4.30	0.09	40000
ER25	09	327-ER25-09-022	26.0	9.0	25.2	16.5	9.0	4.30	0.13	32000
	12	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
	14	327-ER25-14-035	26.0	14.3	37.4	28.8	14.0	6.50	0.23	32000
ER32	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

M1 N23

Coromant Capto® reduction adaptor

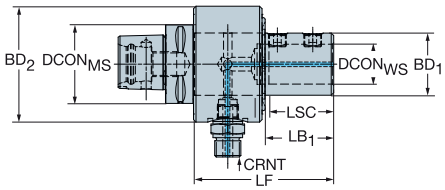
Coolant inducer



CZCMS	CZCWS	CNSC	CXSC	Ordering code	Dimensions, mm DCONMS	DCONWS	LF	LB1	BD2	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



CZCMS	CZCWS	CNSC	CXSC	Ordering code	Dimensions, mm DCONMS	DCONWS	LSC	LF	LB1	BD1	BD2	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

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

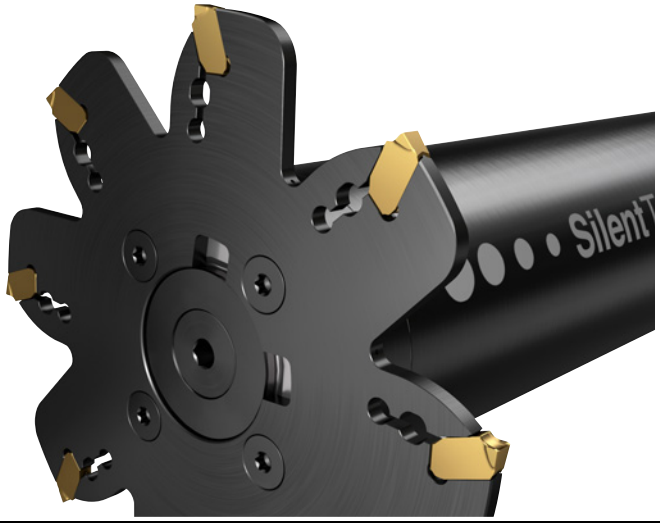
SilentTools®

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.



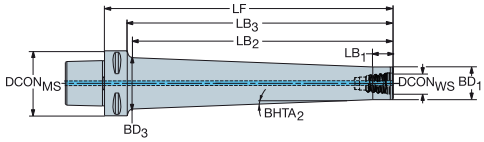
www.sandvik.coromant.com/silenttools

The dampening system consists of a heavy mass, supported on rubber spring elements

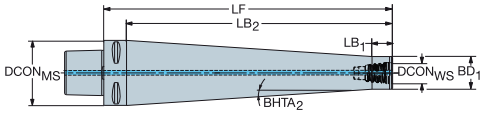
Coromant Capto® to Coromant EH damped adaptor

SilentTools®

DSGN 12



7



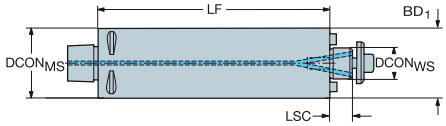
						Dimensions, mm																
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	LB_4	BD_1	BD_3	BD_4	$BHTA_2$	$BHTA_3$	BAR	NM	KG	RPMX
C4	E16	3	1	12	**C4-EH16D-175**	40.0	15.4	175.0	3.0	150.0	155.0	175.0	19.5	29.7	40.0	2°	45°	70	30.00	1.05	15000
C5	E20	3	1	12	**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
	E25	3	1	7	**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
	E25	3	1	12	**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

N23 N15 N3

Coromant Capto® to arbor damped adaptor

DSGN 1



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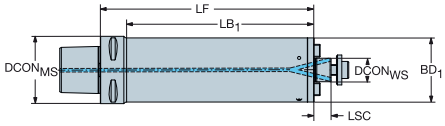
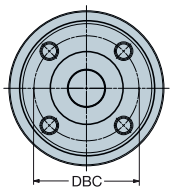
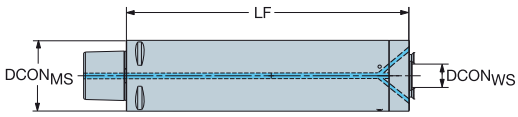


SilentTools®

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	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
	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
C8	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
	32	3	4	1	C8-Q32D-080-360	80.0	32.0	20	360.0	360.0		80.0		70	180.00	19.60	4000
C10	32	3	4	2	C10-Q32D-095-400	100.0	32.0	20	400.0	361.0	400.0	95.0	100.0	70	180.00	30.00	5000
	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®

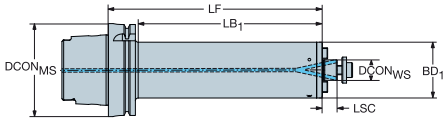
For CoroMill® QD with internal coolant supply

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DBC	DCON$_{WS}$	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

M1 N23 N15

HSK to arbor damped adaptor



SilentTools®

CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	BD$_1$	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

M1 N23 N15

Accessories

Coromant Capto® M2

Assembly fixture M3
Tool wagon for Coromant Capto® M4
Cassettes (polygon seating) M5
Locking mechanism for casettes 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

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

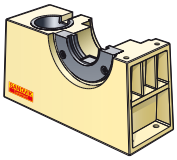
Coromant Capto programme includes machine interface adaptors, clamping units, tool holders, integrated cutting tools, adaptors and chucks.

ENG

Assembly fixture

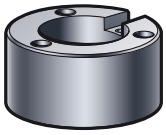
Fixture body
Ordering code:

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

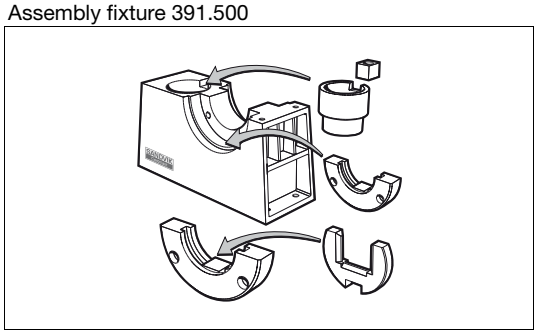
Note: Key is delivered with the sleeve.

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
	391.530-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

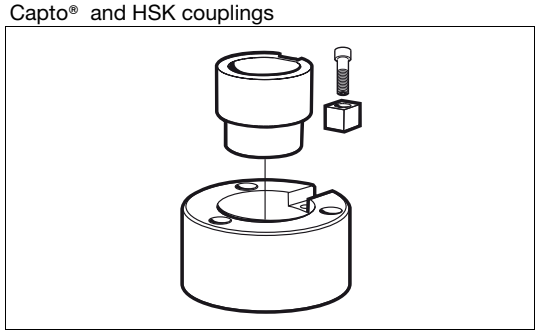
* Combined collar and flange

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

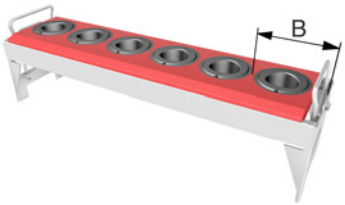
To order a complete wagon 1 pcs CCW-KIT + Molded tool holders
Tool cradles and cradle carriers could be bought extra as accessories.

Bench stand

Ordering code
BS-KIT

No accessory codes for bench stand.

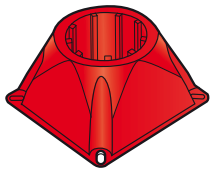
Molded tool holders - to be ordered separately

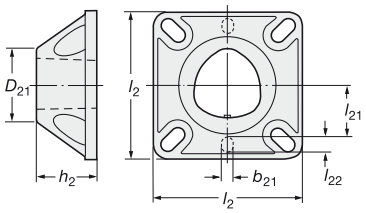


Ordering code	Width (B), mm	Max. number of tool holders in a cradle
C3-IC-1	58	C3 = 9
C4-IC-1	58	C4 = 9
C5-IC-1	65.5	C5 = 8
C6-IC-1	81.5	C6 = 6
C8-IC-1	105	C8 = 5
C10-IC-1	120	C10 = 4

Cassettes (polygon seating)

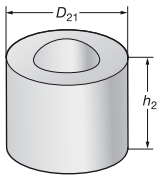
Coromant Capto®



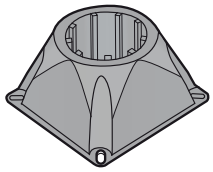


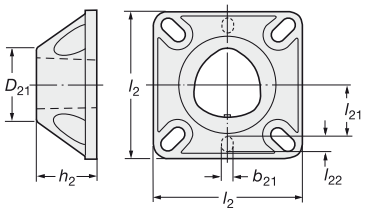
-4000
Plastic storage cassettes (red)

-6000-B



Aluminium cassette blanks



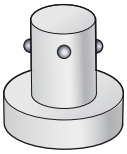


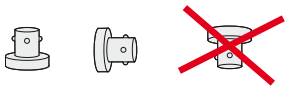
-5000
High grade plastic in-machine tool storage (black)

Coupling size	Ordering code	Dimensions, mm b_{21}	D_{21}	h_2	l_2	l_{21}	All plastic cassettes conforming to hole pattern 17 mm, 20 mm, 25 mm.
C3	**C3-C-4000**	-	32	26	65	-	-	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	
C4	**C4-C-5000**	6	50	39	74	26	8	High grade re-inforced black plastic. For in-machine tool storage with mechanism AL-01.
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	
C6	**C6-C-6000-B**	-	120	63	-	-	-	Aluminium cassette blanks for individual adaptation. To be used with AL-01.
C8	**C8-C-6000-B**		120	63	-	-	-	
C10	**C10-C-6000-B**		138	80	-	-	-	

Locking mechanism for casettes

-PL

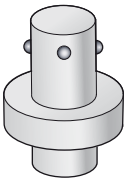


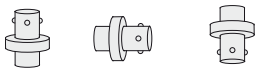


Passive locking mechanism

For vertical upwards and horizontal storage. NEVER upside down storage.

-AL





Active locking mechanism

For storage at all angles: vertical upwards and downwords or horizontal.

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	

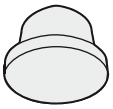
CZC	**Ordering code**	Rec. max. tool weight, kg	
C4	**C4-AL-01**	40	Active locking mechanism – mechanical push action. Fits directly into all cassettes type 5000/6000.
C5	**C5-AL-01**	60	
C6	**C6-AL-01**	75	
C8	**C8-AL-01**	110	
C10	**C10-AL-01**	150	

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	

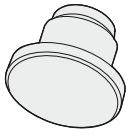
Assembly item

Cover plug

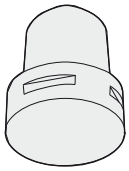
CP-11



CP-01



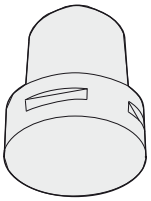
CPA-01



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



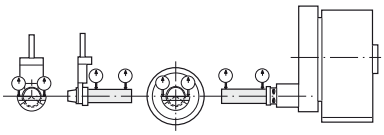
Coupling size	Ordering code
C3	**C3-BAT-01**
C4	**C4-BAT-01**
C5	**C5-BAT-01**
C6	**C6-BAT-01**
C8	**C8-BAT-01**
C10	**C10-BAT-01**

Assembly item

Master setting gauges

Checking position for grippers

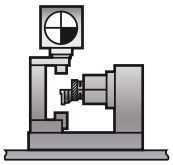
Spindle orientation

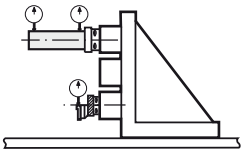


The Coromant Capto system guarantees exceptional, repeatable accuracy but this is of little use unless the various other components in the total machining process are correctly and accurately positioned.

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:

Tool post centre line





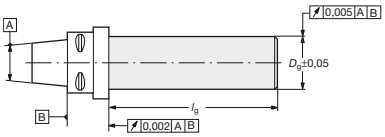
- The centre line of the tool post
- Spindle orientation
- The position of the tool for grippers
- Tool centre height and cutting edge position (f_1 and l_1 dimensions). Gauges can be used in a pre-measuring fixture
- Component fixtures

Tool presetting

Component fixture geometric control

Axial gauge

Master setting gauges MAS-11

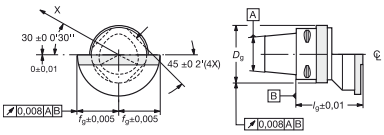


Coupling size	Ordering code	Dimensions, mm D_g	l_g
C3	C3-MAS-11	25	160
C4	C4-MAS-11	25	160
C5	C5-MAS-11	32	210
C6	C6-MAS-11	40	315
C8	C8-MAS-11	40	315
C10	C10-MAS-11	60	420

Centre height gauge

Master setting gauges MAS-01

(Polygon) Gripper groove



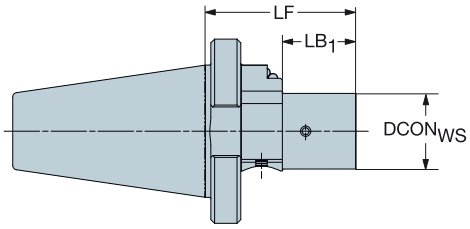
Coupling size	Ordering code	Dimensions, mm f_g	l_g	D_g
C3	C3-MAS-01	22	40	34
C4	C4-MAS-01	27	50	42
C5	C5-MAS-01	35	60	52
C6	C6-MAS-01	45	65	65
C8	C8-MAS-01	55	80	82
C10	C10-MAS-01	65	100	102

Centre height gauge

Coupling size	Ordering code	Dimensions, mm 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

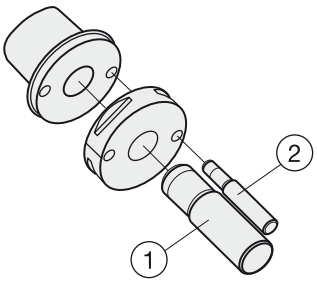
Pre-measuring unit



					Dimensions, mm		
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	LF	LB_1
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.



	Ordering code	Spare parts	
		1	2
Coupling size	**Tool**	Gauge pin	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

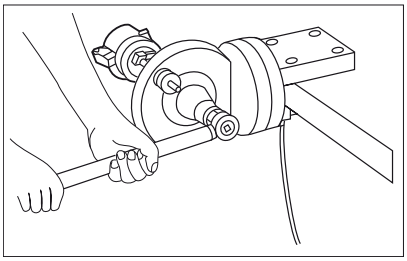
Tightening torque recommendations

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 BD	THL	OAL	KG	Key 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	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

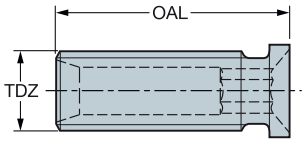
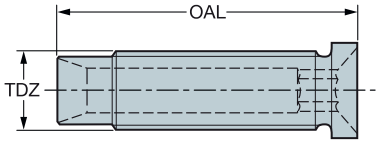


Fig. 2



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

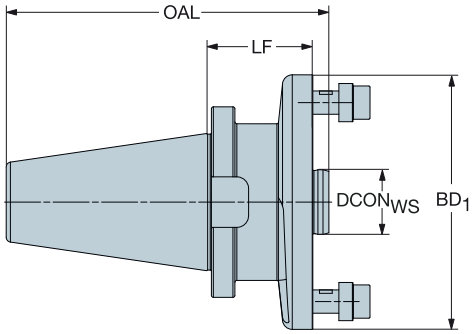
Adjustment screws for MQL tap holder Corochuck 970-HAxxQ-xx-xxx

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

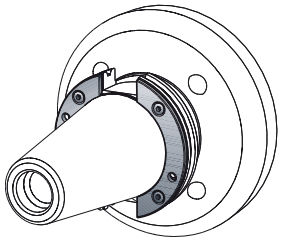
N23

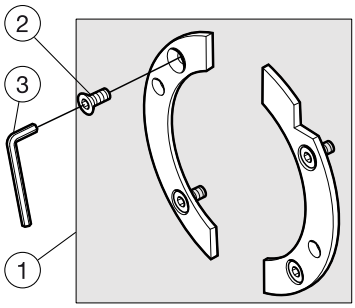
Corobore® XL pre measuring unit



				Dimensions, mm				
CZC_{MS}	CZC_{WS}	CNSC	**Ordering code**	DCON	OAL	LF	BD_1	KG
50	33	0	**I50-PMU-A33**	33	178.30	50.0	130.0	5.59

Shim set

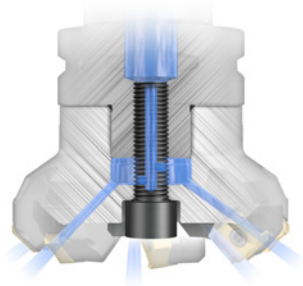




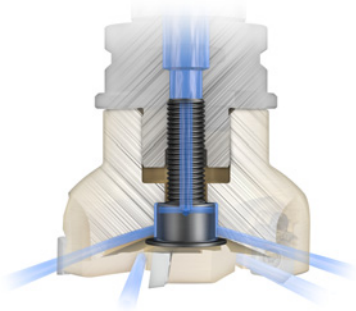
1	2	3
Shim set	Screw	Key
5549 128-50	3213 011-256	3021 010-025 (2.5)

Arbor mounting screws with coolant hole

ISO A



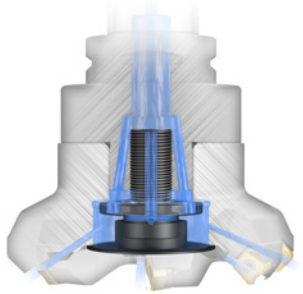
Arbor size	Screw		Key
16	5512 073-03	(M8)	3021 010-060 (6.0)
22	5512 073-01	(M10)	3021 010-080 (8.0)
22	5512 073-04	(M10)	3021 010-080 (8.0)
27	5512 073-02	(M12)	3021 010-100 (10.0)
32	5512 073-05	(M16)	3021 010-140 (12.0)



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

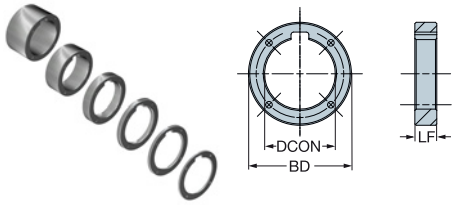
ISO B



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)

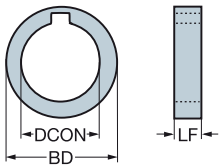
Spacing rings

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

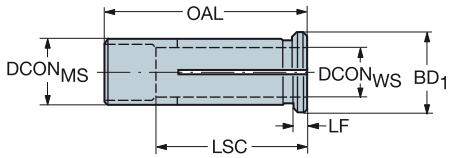
Coolant screw and washer to CoroMill® 331

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



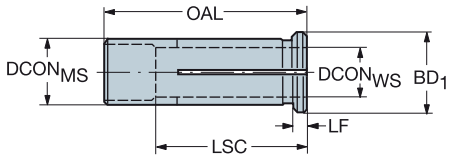
					Dimensions, mm							
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	**Ordering code**	DCON$_{MS}$	DCON$_{WS}$	BD	LSC	OAL	LF	BAR	KG
6	3	1	1	393.CGS-06 03 27	6	3	9	27.0	30	3	80	0.012
12	3	1	1	393.CGS-12 03 40	12	3	16	40.0	44	4	80	0.036
	4	1	1	393.CGS-12 04 40	12	4	16	40.0	44	4	80	0.035
	5	1	1	393.CGS-12 05 40	12	5	16	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	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	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	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	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	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	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	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	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	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	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



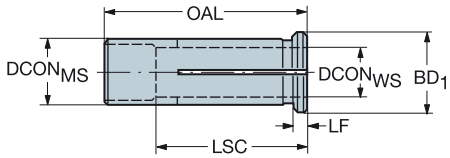
					Dimensions, mm						
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	OAL	LF	BAR	KG
12	2.90	1	4	393.CF-12 02.9 40	12.00	2.90	40.00	44.00	4	80	0.03
	3.00	1	4	393.CF-12 03 40	12.00	3.00	40.00	44.00	4	80	0.03
	3.80	1	4	393.CF-12 03.8 40	12.00	3.80	29.00	44.00	4	80	0.03
	4.00	1	4	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



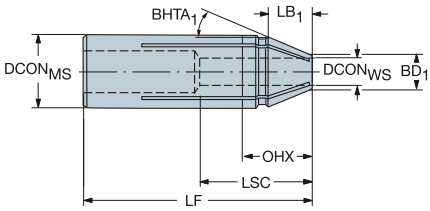
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm DCON$_{MS}$	DCON$_{WS}$	BD	LSC	OAL	LF	BAR	KG
12	6	1	4	393.CG-12 06 40	12	6	16	40.0	44	4	80	0.034
	7	1	4	393.CG-12 07 40	12	7	16	40.0	44	4	80	0.030
	8	1	4	393.CG-12 08 40	12	8	16	40.0	44	4	80	0.029
	9	1	4	393.CG-12 09 40	12	9	16	40.0	44	4	80	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
	16	1	4	393.CG-20 16 52	20	16	25	50.0	54	4	80	0.064
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

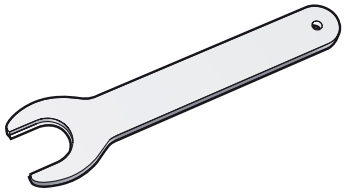
Cylindrical sleeves

Pencil type



					Dimensions, mm								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	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



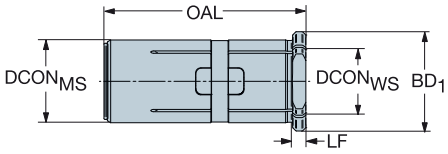
Ordering code	For collet size
5680 061-01	12
5680 061-02	16
5680 061-03	20
5680 061-04	25
5680 061-05	32

N23

N15

Cylindrical sleeve with mechanical locking interface

393.CLF

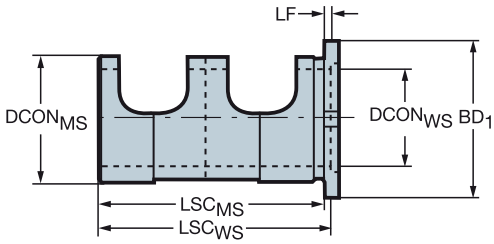


Application	Ordering code	Dimensions, mm DCON$_{WS}$	DCON$_{MS}$	BD$_1$	LF	OAL	Accessories Anchor screw	Assembly tool
CoroChuck™ 930 HD32	393.CLF-321660	16	32	36	4	65	5519 140-02	5680 140-02
	393.CLF-322060	20	32	36	4	65		
	393.CLF-322560	25	32	36	4	65		
CoroChuck™ 930 HD/S25	393.CLF-251256	12	25	30	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

Eccentric sleeve

For CoroDrill® 880



					Dimensions, mm						
CZC$_{MS}$	CZC$_{WS}$	ADJLN	ADJLX	**Ordering code**	DCON$_{MS}$	DCON$_{WS}$	BD$_1$	LB$_1$	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

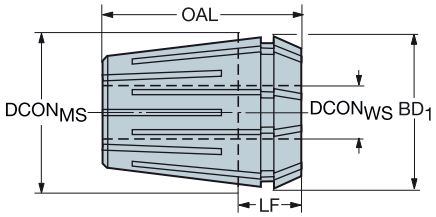
N23 N15

ENG

ER collet

Metallic sealed for coolant through tool

Compatible with DIN 6499-B



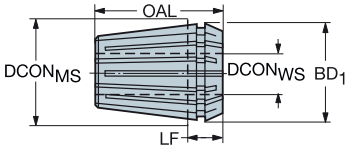
					Dimensions, mm								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	$DCONN_{WS}$	$DCONX_{WS}$	BD_1	OAL	LF	BAR	KG
ER16	3 (h9)	1	1	**393.15-16 03**	17	3			17	27	10	300	0.026
	4 (h9)	1	1	**393.15-16 04**	17	4			17	27	10	300	0.025
	5.0 - 4.5	1	1	**393.15-16 05**	17		4.5	5.0	17	27	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCONN_{WS}$	$DCONX_{WS}$	BD_1	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

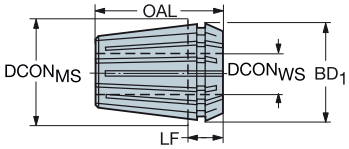
N23 N15

ENG

ER collet

Coolant through collet

Compatible with DIN 6499-B



					Dimensions, mm							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCONN_{WS}$	$DCONX_{WS}$	BD_1	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

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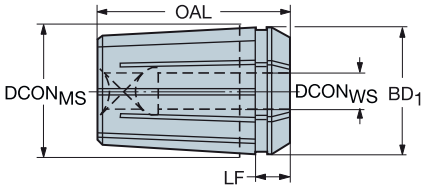
ER Collet for tap shank

Compatible with DIN 6499-B



					Dimensions, mm						
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	BD_1	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

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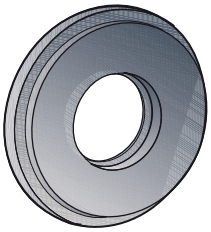
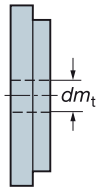
N15

ER collet sealing discs



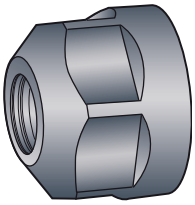


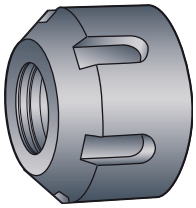
Size 16		Size 25		Size 32		Size 40	
Range, mm dm_t	**Ordering code**	Range, mm dm_t	**Ordering code**	Range, mm dm_t	**Ordering code**	Range, mm dm_t	**Ordering code**
3.0-2.5	**3916.00300**	6.0-5.5	**3925.00600**	3.0-2.5	**3932.00300**	6.0-5.5	**3940.00600**
4.0-3.5	**3916.00400**	7.0-6.5	**3925.00700**	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.

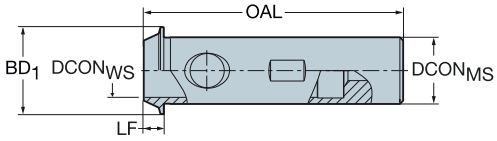
ER collet nuts for through-coolant with sealing disc





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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	BD_1	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

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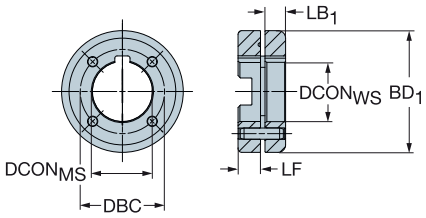
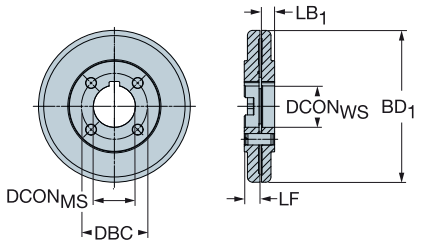
ENG

Assembly item

Driving collar for CoroMill® QD



					Dimensions, mm								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	OAL	LF	LB_1	BD_1	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_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	OAL	LF	LB_1	BD_1	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

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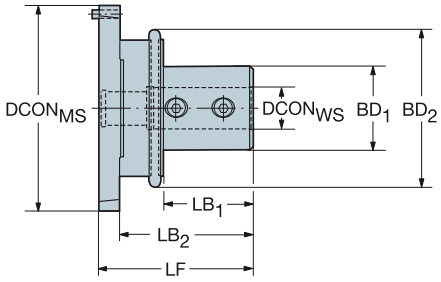
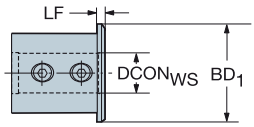
Slide to adjustable drill adaptor



CZCMS	CZCWS	CNSC	CXSC	Ordering code	Dimensions, mm DCONMS	DCONWS	LF	LB1	LB2	LB3	BD1	BD2	BD3	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

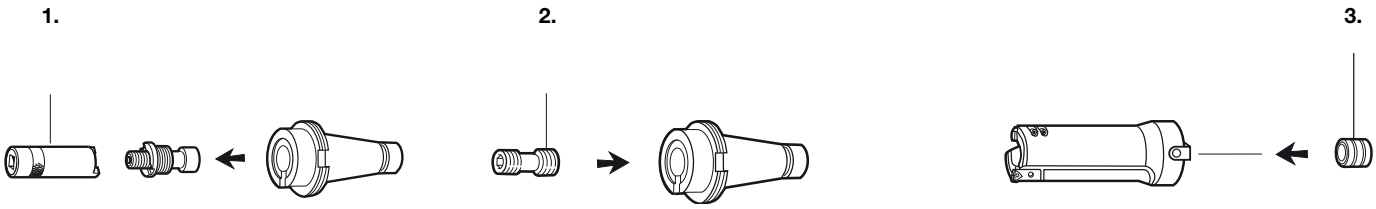
Sleeve



CZCMS	CZCWS	CNSC	CXSC	Ordering code	Dimensions, mm DCONMS	DCONWS	LSC	LF	BD1	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



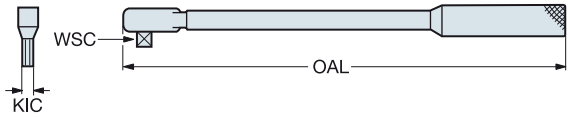
1. Ordering code Key	2. Ordering code Screw	3. Ordering code Centering sleeve
5680 065-02	5516 030-01	5638 030-01

N23 N15

Assembly tools

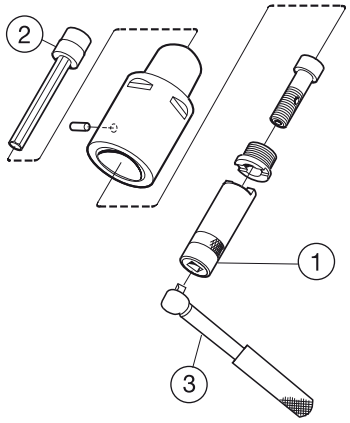
Coromant Capto®

Torque wrench for manual clamping units, Quick change



	Torque wrench	Dimensions, mm			**Key adaptor**	
Coupling size	**Ordering code**	Torque range, Nm	WSC	OAL	**Ordering code**	KIC
C3	**C-TK-01M**	20-100	1/2"	345	**5680 035-14**	8
C4	**C-TK-01M**	20-100	1/2"	345	**5680 035-06**	10
C5	**C-TK-01M**	20-100	1/2"	345	**5680 035-07**	12
C6	**C-TK-01M**	20-100	1/2"	345	**5680 035-07**	12
C8	**C-TK-02**	40-200	1/2"	440	**5680 035-07**	12
C10	**C-TK-03**	60-300	1/2"	548	**5680 035-10**	17

Torque wrench for modular assemblies, centre bolt clamping



	3. Torque wrench	Dimensions, mm			**2. Extension key**		**1. Retaining nut spanner**
Coupling size	**Ordering code**	Torque range, Nm	WSC	OAL	**Ordering code**	KIC	**Ordering code**
C3	**C-TK-02**	40-200	1/2"	345	**5680 015-05**	8	**5680 065-13**
C4	**C-TK-02**	40-200	1/2"	345	**5680 015-05**	8	**5680 065-10**
C5	**C-TK-02**	40-200	1/2"	345	**5680 015-01**	10	**5680 065-11**
C6	**C-TK-02**	40-200	1/2"	345	**5680 015-02**	14	**5680 065-12**
C8	**C-TK-02**	40-200	1/2"	440	**5680 015-02**	14	**5680 065-12**
C10	**C-TK-04**	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

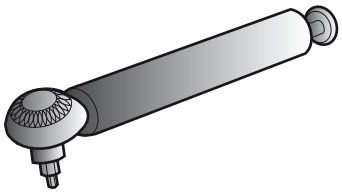
Assembly tools

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

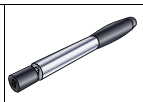
Torque wrench



Ordering code
5680 099-01

Coromant EH

Main spare parts

Coupling size	Key	Torque wrench head[1]	Torque wrench head for 2-edge end mill[1]	Torque value Nm	Torque wrench[1] 	Torque range 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

[1] Accessories, must be ordered separately

Torx Plus® torque wrench

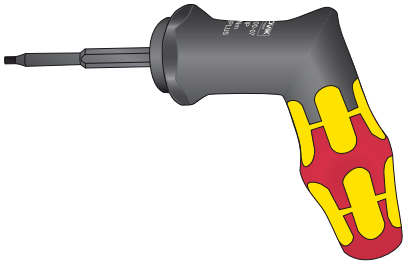
Correct torque when mounting of inserts in milling cutters is a prerequisite for a well functioning tool. Together with the Torx Plus screws the new wrench is a guarantee for improved and secure insert clamping.

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)

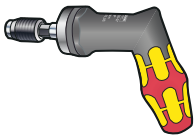
Torx Plus® torque wrench

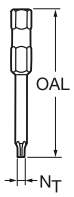
Torque wrench	Size	Torque Nm	
5680 100-01	6IP	0.6	
5680 100-02	7IP	0.9	
5680 100-03	8IP	1.2	
5680 100-04	9IP	1.4	
5680 100-05	10IP	2.0	
5680 100-06	15IP	3.0	
5680 100-07	20IP	5.0	
5680 100-08	25IP	7.5	
5680 100-09	HEX 5	6.0	
5680 100-10	20IP	6.0	

Torque wrench and bits

5680 105-01
5680 105-02

5680 105-05
5680 105-06





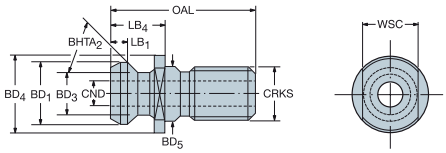
Torque wrench	Torque range Nm	Handle
5680 105-01	0.3 - 1.2	Straight
5680 105-02	1.2 - 3.0	Straight
5680 105-05	3.0 - 6.0	Angled
5680 105-06	4.0 - 8.8	Angled

Bit	OAL mm	N_T Torx Plus
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 mm	N_T Torx Plus
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

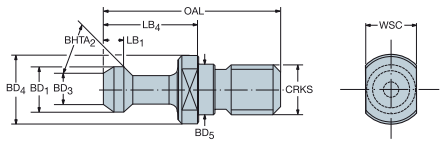
PS-VxxC



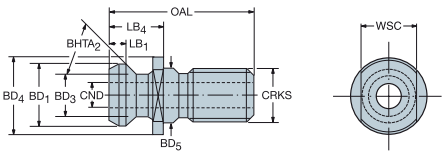
CAT-V

CZC	CRKS	CNSC	CXSC	Ordering code	Dimensions, mm WSC	LB_1	LB_4	CND	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	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



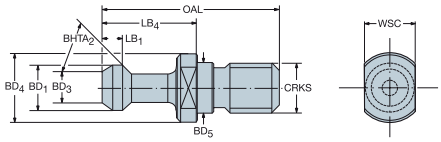
ISO

CZC	CRKS	CNSC	CXSC	Ordering code	Dimensions, mm WSC	LB_1	LB_4	CND	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	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

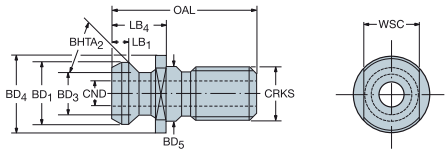
N23 N15

Pull studs

PS-Bxx



PS-BxxC



MAS-BT

CZC	CRKS	CNSC	CXSC	Ordering code	Dimensions, mm WSC	LB_1	LB_4	CND	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	OAL	KG	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

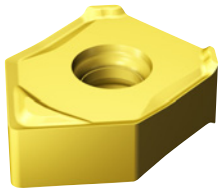
Wiper

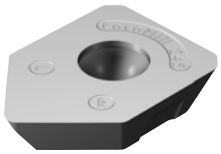
Inserts for increased productivity

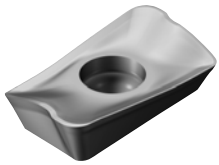
Wiper

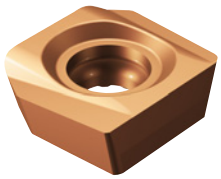
Excellent surface finishes can be achieved with standard inserts in combination with one or more wiper inserts. Wiper inserts work most usefully at a high feed per revolution, fn, in larger diameter cutters with extra close pitch and setting facilities.

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.



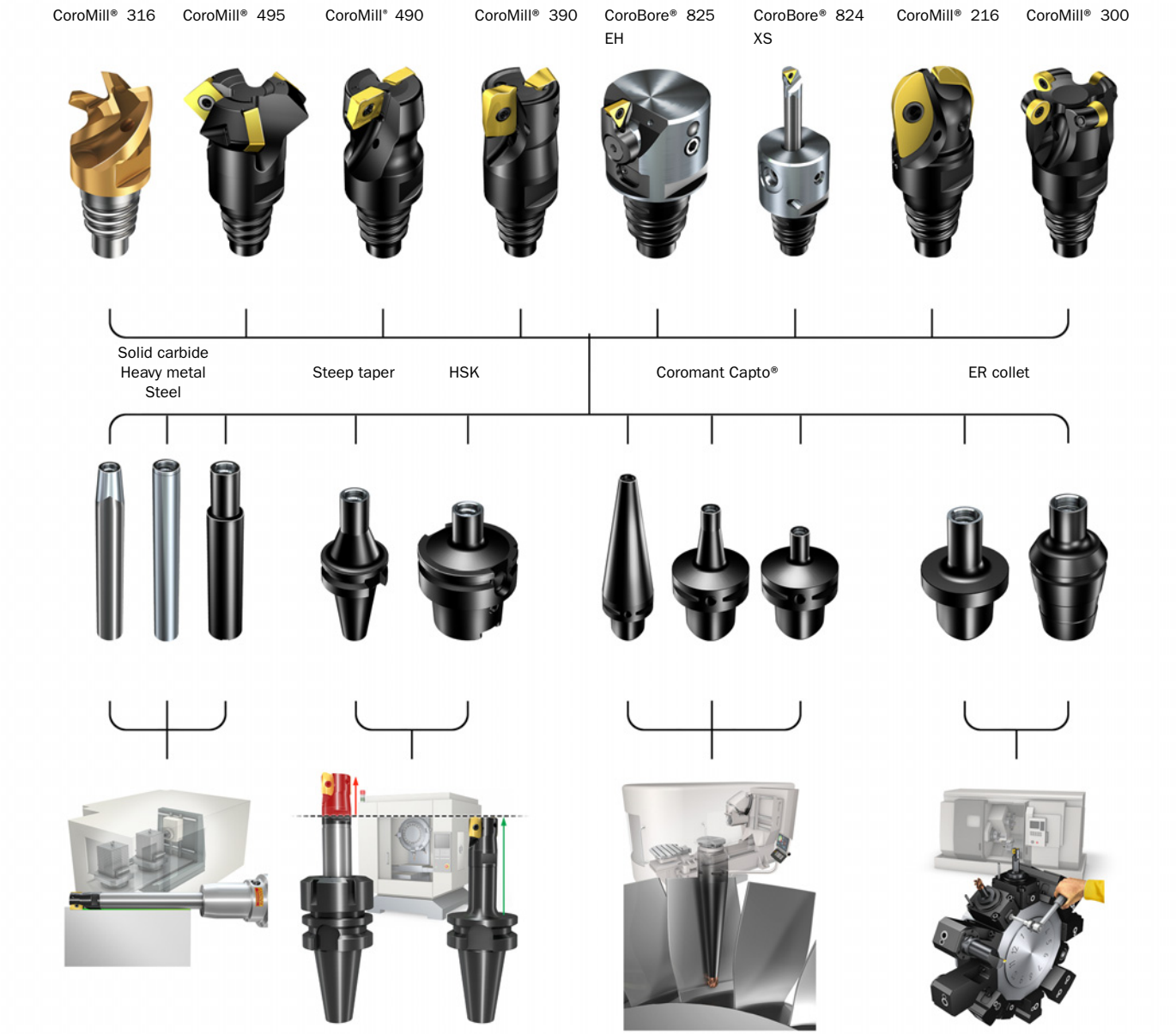






Modular system - Coromant EH

Tooling flexibility for small diameters



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.

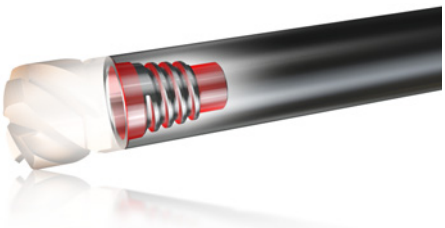
Turning centres with driven tool holders

Short gauge length and swing diameter.

For more information about Coromant EH system:
www.sandvik.coromant.com/coromanteh

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

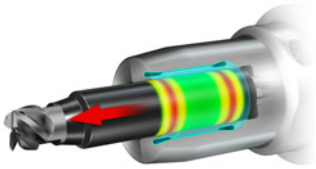
- High metal removal rate provides increased productivity
- Secure process and safe machining
- Quick tool change and set-up
- Enhanced surface finish and increased tool life
- Close hole tolerance
- Best pull-out security on the market due to the latest Fulcrum technology* used for uppermost clamping 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

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

Available coupling types

- Coromant Capto®
- ISO-Cone (ISO, MAS-BT, CAT-V)
- HSK
- Cylindrical
- Weldon
- Coromant EH

Product range

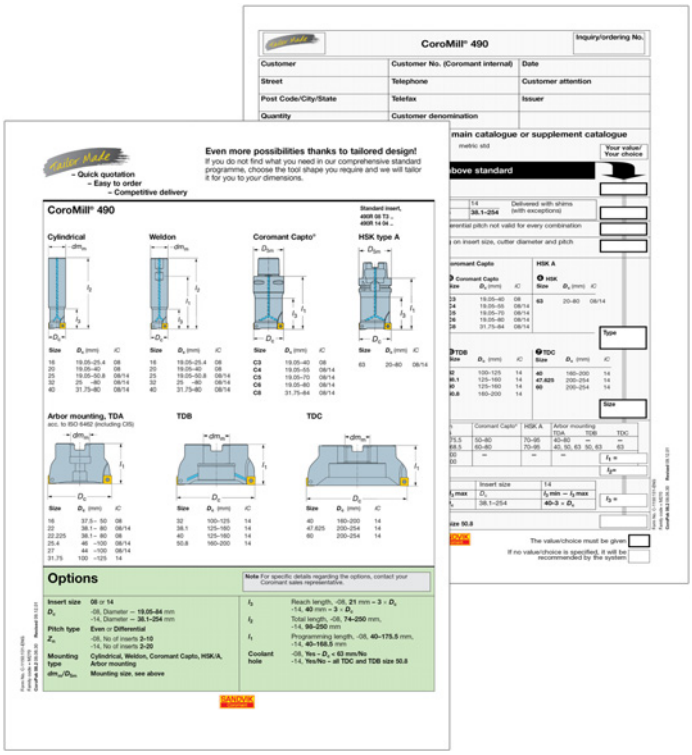
- ER sizes for CoroChuck 970: 8, 11, 20, 25, 32, 40 and 50.
- ER-size 50 has a square inside the adaptor and should be used with the largest tap (M48). The collet that will be used with this large tap will be a collet without a square.
- For HSK 63 and HSK 100 it is possible to use MQL on ER sizes 20 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.

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

The Tailor Made option is available in the following product families:

Milling

- CoroMill® 245
- CoroMill® 300
- CoroMill® 390
- CoroMill® 419
- CoroMill® 490
- CoroMill® 790
- CoroMill® Century
- CoroMill® 331
- CoroMill® QD
- CoroMill® 415
- CoroMill® 425
- CoroMill® 345
- CoroMill® 365
- CoroMill® 745

Drilling

- CoroDrill® 870
- CoroDrill® 880
- CoroDrill® DS20

Adaptors

- Coromant EH
- CoroChuck™ 930
- Coromant Capto®

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

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 environmently 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 and select your market.

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

Safety information

Safety information in connection with grinding of cemented carbide

Material compositon

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.

ENG

General code key for CoroMill cutter

R	A	390	-	063	Q	22	L	-	11	M	050
1	2	3		4	5	6	7		8	9	10

1 Style

R = Right hand rotating

2 Performance

A = Inch

3 Main code

E.g.: 390 = CoroMill® 390

4 Cutting diameter

E.g.: 063 = 63 mm

5 Type of coupling

A = Cylindrical, mm
B = Weldon mm
C = Coromant Capto®
D = Cylindrical inch
J = CIS arbor mounting
M = Weldon, inch
N = Whistle Notch inch
Q = Arbor mounting mm
O = Cylindrical inch
R = Arbor mounting inch
T = Threaded coupling
W = Whistle Notch mm
HA= HSK form A

6 Coupling size

22 = 22 mm

7 Extra long

L = Extra long

8 Insert size

11 = 11 mm (LE)

9

L = Coarse pitch
M = Close pitch
H = Extra close pitch

10 Length, LF

E.g.: 050 = 50 mm

General code key for CoroMill inserts

R	390	-	11	T3	12	M	-	P	L	W
1	2		3	4	5	6		7	8	9

1 Hand of insert	2 Main code	3 Insert width
R = Right hand L = Left hand	E.g.: 390= CoroMill® 390	E.g.: 11 = 11 mm

4 Insert thickness, S mm	5 Corner radius	6 Edge performance
E.g.: T3 S = 3.97 04 S = 4.76 06 S = 6.33	E.g.: 12 = 1.2 mm	M = Highest edge security E = Highest sharpness and precision H = High edge sharpness and high precision K = High cutting sharpness

7 Main ISO application area	8 Operation	9 Wiper
P M K N S H	L = Light cutting M = Medium H = Heavy T = Turn milling	W = Wiper

ENG

Code key for CoroMill® 327

CoroMill 327 insert

Grooving and chamfering

327	R	12	-	22	130	45	08	-	GC
1	2	3		4	5	9	12		7

Threading

327	R	06	-	12	100	VM	-	TH
1	2	3		4	10	11		7

Profiling

327	R	06	-	12	220	11	-	RM
1	2	3		4	5	6		7

Grooving

327	R	12	-	28	150	01	-	GM	M
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

327	-	12	B	15	S	C	-	06
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

328	R	13	-	110	45	-	GC
1	2	3		4	7		6

Threading

328	R	13	-	150	VM	-	TH
1	2	3		8	9		6

Grooving

328	R	13	-	110	01	-	GM
1	2	3		4	5		6

1 Product name
2 Right-hand insert
3 Insert size
4 Insert width
5 Radius ex 02 = radius 0.2 mm
6 Geometry
GM = Grooving
GC = Grooving and chamfering
TH = Threading
7 Chamfer 45°
8 Thread pitch mm: pitch x 100
9 Type of thread VM = V-Profile 60°

CoroMill® 328 cutters

328	-	039	B	25	-	13	M
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

SANDVIK Coromant

ENG

Code key for tool holders

Cylindrical holder

A	E12	-	A	20	-	S	S	-	140
1	2		3	4		5	6		7

Coromant Capto® holder

C3	-	A	391.EH	-	10	035
8		1	9		10	7

Solid holder

392.45EH	-	40	-	10	-	056
9		11		10		7

1	System of measurement
A =	Inch version

2	Size of interface
E12=	EH coupling size

3	Holder type
A =	Cylindrical

4	Holder diameter
E.g.:	DCON = 20 mm

5	Type of holder
S =	Straight
C =	Conical

6	Holder material
S =	Steel
E =	Solid carbide

7	Length of holder
E.g.:	140 = 140 mm

8	Coupling size
C =	Coromant Capto®

9	Family/ holder type
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

10	Size of interface
	EH coupling size

11	Taper size
	Taper size for Coromant solid holders

Code key for solid holding tools

A	A	1	B	05	–	50	32	060
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, $DCON_{WS}$

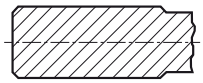
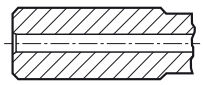
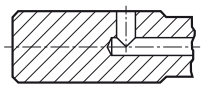
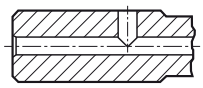
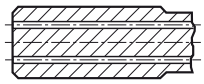
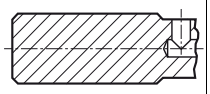
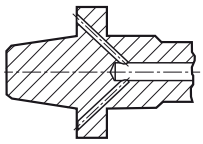
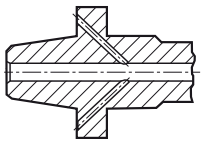
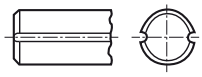
mm		
09	19	38
13	25	51
16	32	63

8 Programming length, mm

060 = 60 mm

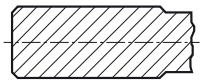
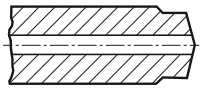
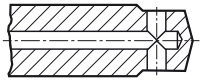
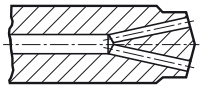
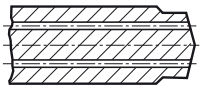
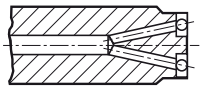
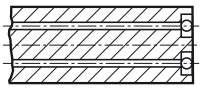
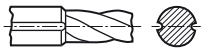
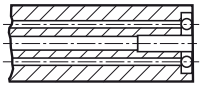
CNSC

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_n = 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^3/min
nap = number of passes	
k_c = specific cutting force	N/mm^2
R_a = surface roughness	µm

Insert size

△ = cutting edge length in mm

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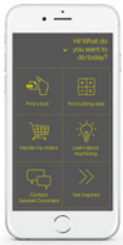

Material cross reference list

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	Unalloyed steel											
	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	-
Steel	P1.5.C.UT	01.1	GC16E	1.1142	030A04	1A	1325	1115	-	-	-	-
	Low-alloy steel											
	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 15CD4.5	14CrMo4 5	14CrMo45	-
	P2.1.Z.AN	02.1	10CrMo9 10	1.7380	1501-622 Gr.31;45	-	2218	A182 F.22	12CD9, 10	12CrMo9, 10	TU.H	-
	P2.1.Z.AN	02.1	14MoV6 3	1.7715	1503-660-440	-	-	-	-	-	13MoCrV6	-
	P2.1.Z.AN	02.1	50CoMo4	1.7228	823M30	33	2512	-	-	653M31	-	-
	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	45WCrSi8	-
	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	100Cr6	F.131	SUJ2

SANDVIK Coromant

ENG

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	-	F.520.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	-	-	-	-	-
	High-alloy steel											
	P3.0.Z.AN	03.11	X210Cr12	1.2080	BD3	-	-	D3	Z200C12	X210Cr13KU X250Cr12KU	X210Cr12	SKD1
	P3.0.Z.AN	03.11	X43Cr13	1.2083	-	-	2314	-	-	-	-	-
	P3.0.Z.AN	03.11	X40CrMoV5 1	1.2344	BH13	-	2242	H13	Z40CDV5	X35CrMoV05KU X40CrMoV511KU	X40CrMoV5	SKD61
	P3.0.Z.AN	03.11	X100CrMoV5 1	1.2363	BA2	-	2260	A2	Z100CDV5	X100CrMoV51KU	X100CrMoV5	SKD12
	P3.0.Z.AN	03.11	X210CrW12	1.2436	-	-	2312	-	-	X215CrW12 1KU	X210CrW12	SKD2
	P3.0.Z.AN	03.11	X30WCrV9 3	1.2581	BH21	-	-	H21	Z30WCV9	X28W09KU X30WCrV9 3KU	X30WCrV9	SKD5
	P3.0.Z.AN	03.11	X165CrMoV 12	1.2601	-	-	2310	-	-	X165CrMoW12KU	X160CrMoV12	-
	P3.0.Z.AN	03.21	X155CrMoV12-1	1.2379	-	-	2736	HNV3	-	-	-	-
	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	-	-	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
	Ferritic/martensitic stainless steel											
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	F3113	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	X45GrSi8	F322	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
					Trade names							
	P2.1.Z.AN	02.1			OVAKO 520M (Ovako Steel)							
	P2.2.Z.AN	02.1		1.0045	FORMAX (Uddeholm Tooling)							
	P2.2.Z.AN	02.1			IMACRO NIT (Imatra Steel)							
	P2.5.Z.HT	02.2			INEXA 482 (XM) (Inexa Profil)							
	P1.2.Z.AN				S355J2G3(XM)							
	P1.2.Z.AN				C45(XM)							
	P1.2.Z.AN				16MnCrS5(XM)							
	P2.5.Z.HT				INEXA280(XM)							
	P2.5.Z.HT	02.2			070M20(XM)							
	P2.5.Z.HT	02.2			HARDOX 500 (SSAB – Swedish Steel Corp.)							
	P2.5.Z.HT				WELDOX 700 (SSAB – Swedish Steel Corp.)							

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	**Austenitic stainless steel**											
Stainless steel	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	X53CrMnNiN21-9	1.4871	349S54	-	-	EV8	Z52CMN21.09	X53CrMnNiN21 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	Z6CNNb18.10	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 304S12	-	2352	304L	Z2CN18-10	X2CrNi18 11	-	-
	M1.1.Z.AQ	05.21/15.21	-	-	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	X8CrNiS18-9	1.4305	303S21	58M	2346	303	Z10CNF 18.09	X10CrNiS 18.09	F.3508	SUS303
	Super austenitic (Ni>20%) stainless steel											
	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	-	-	-
	Duplex (austenitic/ferritic) stainless steel											
	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	-	-	-
					Trade names							
	M1.1.Z.AQ	05.21/15.21			SANMAC 304 (Sandvik Steel)							
	M1.1.Z.AQ	05.21/15.21		1.0045	SANMAC 304L (Sandvik Steel)							
	M1.1.Z.AQ	05.21/15.21			SANMAC 316 (Sandvik Steel)							
	M1.1.Z.AQ	05.21/15.21			SANMAC 316L (Sandvik Steel)							
	M1.0.Z.AQ	05.23/15.23			254 SMO							
	M2.0.Z.AQ	05.23/15.23			654 SMO							
	M3.2.Z.AQ	05.52/15.52			SANMAC SAF 2205 (Sandvik Steel)							
	M3.2.Z.AQ	05.52/15.52			SANMAC SAF 2507 (Sandvik Steel)							

SANDVIK Coromant

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	**Malleable cast iron**											
	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
	Grey cast iron											
	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	-	-	-
Cast iron	**Nodular cast iron**											
	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	-	-	-
	Compacted graphite iron											
	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									
	Austempered ductile iron											
	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 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
N	**Aluminium based alloys**											
Non-ferrous metals	N1.3.C.AG	30.21	G-AlSI9MGWA	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-AlSi12	-	-	-	4247	A413.0	-	-	-	A6061
	N1.3.C.AG	-	GD-AlSi8Cu3	-	LM24	-	4250	A380.1	-	-	-	A7075
	N1.3.C.UT	-	G-AlSi12(Cu)	-	LM20	-	4260	A413.1	-	-	-	ADC12
	N1.3.C.UT	-	G-AlSi12	-	LM6	-	4261	A413.2	-	-	-	-
	N1.3.C.AG	-	G-AlSi10Mg(Cu)	-	LM9	-	4253	A360.2	-	-	-	-
S	**Nickel based alloys**											
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	-	-	-	-
	Cobalt alloys											
	-	-	CoCr20W15Ni	-	-	-	-	5537C, AMS	KC20WN	-	-	-
	S3.0.Z.AG	20.32	CoCr22W14Ni	LW2.4964	-	-	-	5772	KC22WN	-	-	-
	Titanium alloys											
	S4.2.Z.AN	23.22	TiAl5Sn2.5	3.7115.1	TA14/17	-	-	UNS R54520	T-A5E UNS R56400	-	-	-
	S4.2.Z.AN	23.22	TiAl6V4	3.7165.1	TA10-13/TA28	-	-	UNS R56401	T-A6V	-	-	-
	S4.3.Z.AN	23.22	TiAl5V5Mo5Cr3	-	-	-	-	-	-	-	-	-
	S4.2.Z.AN	23.22	TiAl4Mo4Sn4Si0.5	3.7185	-	-	-	-	-	-	-	-
			Trade names									
			Iron based alloys									
	S2.0.Z.UT/S2.0.Z.AN	20.11	Incoloy 800									
			Nickel based alloys									
	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									
			Cobalt alloys									
	S3.0.Z.AG	20.3	Air Resist 213									
	S3.0.Z.AG	20.3	Jetalloy 209									
H	**Hardened materials**											
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

SANDVIK Coromant

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
$CICT_{BALL}$	Cutting item count - Ball nose insert
$CICT_{E}$	Cutting item count - end position
$CICT_{P}$	Cutting item count - peripheral position
$CICT_{S}$	Cutting item count - side position
$CICT_{SP}$	Cutting item count - Shank protection insert
$CICT_{T}$	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_{MS}	Connection size code machine side
CZC_{WS}	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
$DCON_{MS}$	Connection diameter machine side
$DCON_{WS}$	Connection diameter workpiece side
$DCONN_{WS}$	Connection diameter minimum workpiece side
$DCONX_{WS}$	Connection diameter maximum workpiece side
DCPS	Data chip provision size
$DCSF_{MS}$	Contact surface diameter machine side
$DCSF_{WS}$	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
$MIID_E$	Master insert identification - end position
$MIID_S$	Master insert identification - side position
$MIID_C$	Master insert identification - central position
$MIID_P$	Master insert identification - peripheral position
$MIID_I$	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_E	Insert seat size code - end position
SSC_P	Insert seat size code - peripheral position
SSC_S	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

Code	Page
327..MM-TH	I149
327..UN-TH	I150
327..VM-TH	I149
327..WH-TH	I150
327-CH	I150
327-EHxx	L104
327-Erxx	L107
327-GC	I147
327-GM	I146
327-RM	I147
327-xxB	L100
328..Bxx	I143
328..MM-TH	I148
328..Qxx	I143
328..Sxx	I143
328..UN-TH	I148
328..VM-TH	I148
328-GC	I144
328-GM	I144
345..Axx	I7
345..Cx	I5
345..Qxx	I6
345N..E-MW8	I8
345N-KW8	I8
345N-PW5	I8
345N-PW8	I8
345R/L..E-xx	I8
345R/L..M-xx	I8
360..Qxx	I21
360R/L..M-KH	I22
360R/L..M-MH	I22
360R/L..P-MH	I22
390.140	L65
390.272	L65
390.410	L33
390.540	L45
390.558	L55
390.58	L80
390R..E-xx	I74-I76
390R..M-xx	I75-I77
392.140277	L68
392.140EH	L62
392.41005	L32
392.41005C	L32
392.41014	L40
392.41020	L34
392.41027	L36
392.410277	L36
392.41037A..A	K40
392.41037A..B	K40
392.41037B..B	K40
392.410EH	L31
392.410XL	K76
392.54005	L44
392.54005C	L44
392.54014	L49
392.54023	L46
392.55277	L81
392.55505C	L54
392.55514	L58
392.55523	L55
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392.55805C	L54
392.55823	L55
392.55EH	L76
392.58277	L81
392.644XL	K76
392.646XL	K76
392.647XL	K77
392.ER327	L107
392.EREH	L106
392.R8.05	L102
393.14	M22-M23
393.14..D	M24
393.14-xx	L97
393.15	M21
393.277	M28
393.37A	M26
393.CF	M16
393.CG	M17
393.CGP	M18
393.CGS	M15
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415..EHxx	I39
415..Txx	I40
415N..M-M30	I41
416.2-L	M20
419..Axx	I30
419..Cx	I29
419..Qxx	I29
419N/R..E-xx	I31
419N/R..M-xx	I31
425..P	I14
425..Qxx	I14
425N..E-KLW12	I15
490..Axx	I51
490..Bxx	I52
490..Cx	I48-I49
490..EH	I53
490..HAxx	I54
490..Qxx	I50
490R/L..E..xx	I55-I56
490R/L..M-xx	I55
495..Axx	I152
495..Cx	I152
495..EHxx	I153
495-MM	I153
495-PM	I153
5549 201	M27
5692	M11
690..Cx	I80
690..E-SL	I82
690..HAxx	I81
690..P-SL	I82
690..Qxx	I81
725..Cx	I43
725..Qxx	I44
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