SANDVIK
Coromant

2020

# Rotating tools

MILLING
DRILLING
BORING
ROTATING TOOL ADAPTERS

# Let us introduce our new catalogs

The catalog consists of two volumes: Rotating tools and Turning tools. In total, over 20,000 standard products released before April 2017 are included.

**Turning Tools** – General Turning, Parting and Grooving, Thread Turning, Multi-functional Tools, Tool Holding, and Turning Tool Adapters

**Rotating Tools** – Indexable Milling, Indexable Drilling, Boring, and Rotating Tool Adapters

For our offer of round tools, please see our **Solid Round Tools** catalog.

Use the product overviews to find your area of interest, and a reference will take you to the actual ordering page. The ordering page will then take you to related products, such as holders and inserts, if you follow the references at the bottom of the page.

Our total offer of approximately 55,000 standard products can be found at **www.sandvik.coromant.com**. If none of these products fit your requirements, we have a wide range of products that can be tailored upon your request.

Please note that product data can change over time. 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:

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

First Choice
Good choice
Not available

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

I Milling

J Drilling

K Boring

L Rotating tool adapters

M Accessories

N General information

# Milling


## Face milling tools I3

CoroMill® 345 I4-I9
CoroMill® 245 I10-I16
CoroMill® 425 I17-I20
CoroMill® 745 I21-I25
CoroMill® 360 I26-I28
CoroMill® 365 I29-I35

## High-feed milling tools I36

CoroMill® 419 I37-I41
CoroMill® 210 I42-I47
CoroMill® 415 I48-I52
CoroMill® 745 I53-I56

## Shoulder milling tools I57

CoroMill® 490 I58-I71
CoroMill® 390 I72-I103
CoroMill® 690 I104-I108
CoroMill® Century I109-I116

## Profile milling tools I117

CoroMill® 300 I118-I133
CoroMill® 200 I134-I142
CoroMill® 216 I143-I152

## Disc milling tools I153

CoroMill® 331 I154-I189

## Groove milling tools I190

CoroMill® QD I191-I202
CoroMill® 328 I203-I207
CoroMill® 327 I208-I212

## Thread milling tools I190

CoroMill® 328 I213
CoroMill® 327 I214-I216

## Chamfer milling tools I190

CoroMill® 327 I217
CoroMill® 495 I218-I221


For complete assortment, go to 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.

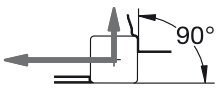
H

**Extra close pitch**

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

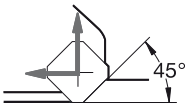
## Entering angle

**90° entering angle**



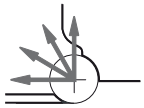

- Thin-walled components
- Weak-fixtured components
- Where 90° form is required

**45° entering angle**




- General purpose - First choice
- Reduces vibration on long overhangs
- Chip-thinning effect allows for increased productivity

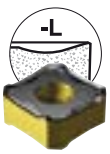
**Round insert cutters**



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

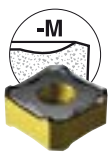
## Insert geometries

**Light**



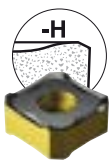

Extra positive, light machining, low cutting forces and for low feed rates.

**Medium**




For general use in most materials.

**Heavy**




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

## Explanation of application symbols

Face milling

Thin walls

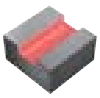
Edging

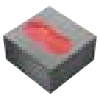
Profiling

Helical interpolation

Long overhang

Plunge milling


Slotting


Ramping

Parting

Chamfering

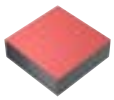
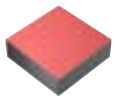
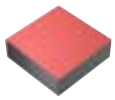
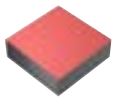
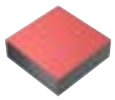
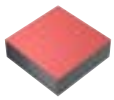
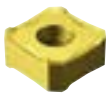
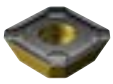
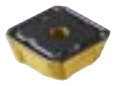
Grooving

Threading

Intermittent milling

Shoulder milling

# Face milling tools

| | CoroMill® 345 | CoroMill® 245 | CoroMill® 425 | CoroMill® 745 | CoroMill® 360 | CoroMill® 365 |
|---|---|---|---|---|---|---|
| | | | | | | |
| Page | I4 | I10 | I17 | I53 | I26 | I29 |
| 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° |
| $D_c$ mm<br>$D_c$ inch | 40 - 250<br>1.500 - 10.000 | 32 - 250<br>1.250 - 10.000 | 100 - 500<br>4 - 20 | 63 - 250<br>2.5 - 10 | 160 - 400<br>6.000 - 16.000 | 50 - 250<br>2.000 - 6.000 |
| DCX mm<br>DCX inch | 54.1 - 264.1<br>2.054 - 10.554 | 44.5 - 268.8<br>1.742 - 10.740 | 107.0 - 507.0<br>4.276 - 20.276 | 78.2 - 264.4<br>3.098 - 10.567 | 175.0 - 420.8<br>6.591 - 16.819 | 50.0 - 166.7<br>2.264 - 6.264 |
| APMX mm<br>APMX inch | 6<br>.236 | 6 - 10<br>.240 - .394 | 0.90<br>.035 | 5.20<br>.205 | 13 - 18<br>.512 - .709 | 6.0<br>.236 |
| Insert |  |  | | |  | |
| Insert sizes | 13 | 12 & 18 | 17 | 21 | 19 & 28 | 15 |
| Couplings | Coromant Capto®<br>Cylindrical shank<br>Arbor | Arbor<br>Cylindrical shank | Arbor<br>Cap coupling | Coromant Capto®<br>Arbor | Arbor | Coromant Capto®<br>Arbor |
| Internal coolant | ✓ | ✗ | ✗ | ✓ | ✓ | ✓ |
| Options | Shim protection tipseat | Shim protection tipseat | Adjustable cassettes for wiper inserts | | Exchangeable cassette design | Internal coolant on selected models |
| Other operations | | | | | | |

# CoroMill® 345

## Face mill for high productivity

### Application

- Face milling
- Roughing to finishing

### ISO application area:

P M K N S H

### Benefits and features

- Low cost per component due to eight cutting edges
- High output – with internal coolant, high productivity is also possible 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 applications

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

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

### Internal coolant

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

I5

I9

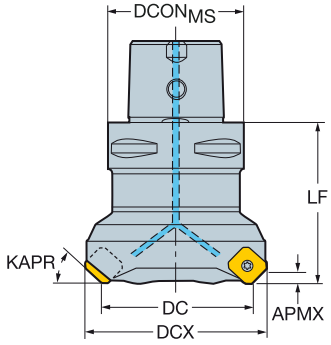


SANDVIK Coromant

# CoroMill® 345 face milling cutter

**Coromant Capto® - Internal coolant supply**

STDNO ISO26623-1
KAPR 45°




## Metric version

| DC | | CZCMS | APMX | CNSC | | | Ordering code | Dimensions, mm DCONMS | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 13 | C4 | 6.0 | 3 | | 4 | 345-040C4-13M | 40.0 | 54.1 | 60.0 | 3.0 | 0.89 | 19600 | 4 | 345R-1305 |
| 50.0 | 13 | C5 | 6.0 | 3 | | 4 | 345-050C5-13M | 50.0 | 64.1 | 60.0 | 3.0 | 1.39 | 17500 | 4 | 345R-1305 |
| | 13 | C6 | 6.0 | 3 | | 4 | 345-050C6-13M | 63.0 | 64.1 | 60.0 | 3.0 | 1.80 | 17500 | 4 | 345R-1305 |
| | 13 | C5 | 6.0 | 3 | 5 | | 345-050C5-13H | 50.0 | 64.1 | 60.0 | 3.0 | 1.48 | 17500 | 5 | 345R-1305 |
| | 13 | C6 | 6.0 | 3 | 5 | | 345-050C6-13H | 63.0 | 64.1 | 60.0 | 3.0 | 1.79 | 17500 | 5 | 345R-1305 |
| 63.0 | 13 | C5 | 6.0 | 3 | | 5 | 345-063C5-13M | 50.0 | 77.1 | 60.0 | 3.0 | 1.53 | 15500 | 5 | 345R-1305 |
| | 13 | C6 | 6.0 | 3 | | 5 | 345-063C6-13M | 63.0 | 77.1 | 60.0 | 3.0 | 1.91 | 15500 | 5 | 345R-1305 |
| | 13 | C5 | 6.0 | 3 | 6 | | 345-063C5-13H | 50.0 | 77.1 | 60.0 | 3.0 | 1.62 | 15500 | 6 | 345R-1305 |
| | 13 | C6 | 6.0 | 3 | 6 | | 345-063C6-13H | 63.0 | 77.1 | 60.0 | 3.0 | 1.97 | 15500 | 6 | 345R-1305 |
| 80.0 | 13 | C6 | 6.0 | 3 | | 6 | 345-080C6-13M | 63.0 | 94.1 | 70.0 | 3.0 | 2.46 | 13700 | 6 | 345R-1305 |
| | 13 | C8 | 6.0 | 3 | | 6 | 345-080C8-13M | 80.0 | 94.1 | 70.0 | 3.0 | 3.32 | 13700 | 6 | 345R-1305 |
| | 13 | C6 | 6.0 | 3 | 8 | | 345-080C6-13H | 63.0 | 94.1 | 70.0 | 3.0 | 2.54 | 13700 | 8 | 345R-1305 |
| 100.0 | 13 | C8 | 6.0 | 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 |

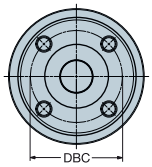
For the complete list of spare parts, visit www.sandvik.coromant.com

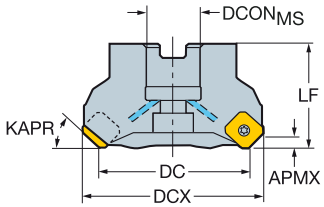
I9 L2 N22 N9 N15

# CoroMill® 345 face milling cutter

**Arbor - Internal coolant supply**

STDNO ISO6462
KAPR 45°




## Metric version

| DC | | CZCMS | APMX | CNSC | | | Ordering code | Dimensions, mm DCONMS | ISO | DBC | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 13 | 22 | 6.0 | 1 | | 3 | 345-040Q22-13L | 22.0 | A | | 54.1 | 45.0 | 3.0 | 0.68 | 19600 | 3 | 345R-1305 |
| | 13 | 22 | 6.0 | 1 | | 4 | 345-040Q22-13M | 22.0 | A | | 54.1 | 45.0 | 3.0 | 0.67 | 19600 | 4 | 345R-1305 |
| 50.0 | 13 | 22 | 6.0 | 1 | | 3 | 345-050Q22-13L | 22.0 | A | | 64.1 | 45.0 | 3.0 | 0.82 | 17500 | 3 | 345R-1305 |
| | 13 | 22 | 6.0 | 1 | | 4 | 345-050Q22-13M | 22.0 | A | | 64.1 | 45.0 | 3.0 | 0.78 | 17500 | 4 | 345R-1305 |
| | 13 | 22 | 6.0 | 1 | 5 | | 345-050Q22-13H | 22.0 | A | | 64.1 | 45.0 | 3.0 | 0.82 | 17500 | 5 | 345R-1305 |
| 63.0 | 13 | 22 | 6.0 | 1 | | 4 | 345-063Q22-13L | 22.0 | A | | 77.1 | 45.0 | 3.0 | 0.98 | 15500 | 4 | 345R-1305 |
| | 13 | 22 | 6.0 | 1 | | 5 | 345-063Q22-13M | 22.0 | A | | 77.1 | 45.0 | 3.0 | 0.94 | 15500 | 5 | 345R-1305 |
| | 13 | 22 | 6.0 | 1 | 6 | | 345-063Q22-13H | 22.0 | A | | 77.1 | 45.0 | 3.0 | 0.60 | 15500 | 6 | 345R-1305 |
| | 13 | 22 | 6.0 | 1 | 7 | | 345-063Q22-13HX | 22.0 | A | | 77.1 | 45.0 | 3.0 | 1.03 | 15500 | 7 | 345R-1305 |
| 80.0 | 13 | 27 | 6.0 | 1 | | 4 | 345-080Q27-13L | 27.0 | A | | 94.1 | 50.0 | 3.0 | 1.65 | 13700 | 4 | 345R-1305 |
| | 13 | 27 | 6.0 | 1 | | 6 | 345-080Q27-13M | 27.0 | A | | 94.1 | 50.0 | 3.0 | 1.72 | 13700 | 6 | 345R-1305 |
| | 13 | 27 | 6.0 | 1 | 8 | | 345-080Q27-13H | 27.0 | A | | 94.1 | 50.0 | 3.0 | 1.72 | 13700 | 8 | 345R-1305 |
| | 13 | 27 | 6.0 | 1 | 9 | | 345-080Q27-13HX | 27.0 | A | | 94.1 | 50.0 | 3.0 | 1.76 | 13700 | 9 | 345R-1305 |
| 100.0 | 13 | 32 | 6.0 | 1 | | 5 | 345-100Q32-13L | 32.0 | A | | 114.1 | 50.0 | 3.0 | 2.30 | 12200 | 5 | 345R-1305 |
| | 13 | 32 | 6.0 | 1 | | 7 | 345-100Q32-13M | 32.0 | A | | 114.1 | 50.0 | 3.0 | 2.29 | 12200 | 7 | 345R-1305 |
| | 13 | 32 | 6.0 | 1 | 10 | | 345-100Q32-13H | 32.0 | A | | 114.1 | 50.0 | 3.0 | 2.31 | 12200 | 10 | 345R-1305 |
| | 13 | 32 | 6.0 | 1 | 11 | | 345-100Q32-13HX | 32.0 | A | | 114.1 | 50.0 | 3.0 | 2.38 | 12200 | 11 | 345R-1305 |
| 125.0 | 13 | 40 | 6.0 | 1 | | 6 | 345-125Q40-13L | 40.0 | B | | 139.1 | 63.0 | 3.0 | 3.64 | 10900 | 6 | 345R-1305 |
| | 13 | 40 | 6.0 | 1 | | 8 | 345-125Q40-13M | 40.0 | B | | 139.1 | 63.0 | 3.0 | 3.48 | 10900 | 8 | 345R-1305 |
| | 13 | 40 | 6.0 | 1 | 12 | | 345-125Q40-13H | 40.0 | B | | 139.1 | 63.0 | 3.0 | 3.63 | 10900 | 12 | 345R-1305 |
| | 13 | 40 | 6.0 | 1 | 14 | | 345-125Q40-13HX | 40.0 | B | | 139.1 | 63.0 | 3.0 | 3.64 | 10900 | 14 | 345R-1305 |
| 160.0 | 13 | 40S | 6.0 | 0 | | 7 | 345-160Q40-13L | 40.0 | C | 66.7 | 174.1 | 63.0 | 3.0 | 4.59 | 9600 | 7 | 345R-1305 |
| | 13 | 40S | 6.0 | 0 | | 10 | 345-160Q40-13M | 40.0 | C | 66.7 | 174.1 | 63.0 | 3.0 | 4.50 | 9600 | 10 | 345R-1305 |
| | 13 | 40S | 6.0 | 0 | | 12 | 345-160Q40-13H | 40.0 | C | 66.7 | 174.1 | 63.0 | 3.0 | 4.72 | 9600 | 12 | 345R-1305 |
| | 13 | 40S | 6.0 | 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 | 6.0 | 0 | | 12 | 345-200Q60-13M | 60.0 | C | 101.6 | 214.1 | 63.0 | 3.0 | 10.60 | 8600 | 12 | 345R-1305 |
| | 13 | 60 | 6.0 | 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 | 6.0 | 0 | | 14 | 345-250Q60-13M | 60.0 | C | 101.6 | 264.1 | 63.0 | 3.0 | 10.36 | 7700 | 14 | 345R-1305 |
| | 13 | 60 | 6.0 | 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 the complete list of spare parts, visit www.sandvik.coromant.com

I9

L2

M1

N22

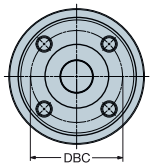
N9

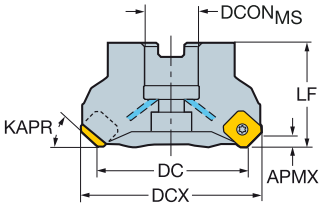
N15

# CoroMill® 345 face milling cutter

**Arbor - Internal coolant supply**

STDNO ISO6462
KAPR 45°




## Inch version

| DC | | CZC$_{MS}$ | APMX | CNSC | | | Ordering code | Dimensions, inch DCON$_{MS}$ | ISO | DBC | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.000 | 13 | 3/4 | .236 | 1 | | 3 | A345-051R19-13L | .750 | A | | 2.562 | 1.772 | 2.2 | 1.70 | 17300 | 3 | 345R-1305 |
| | 13 | 3/4 | .236 | 1 | | 4 | A345-051R19-13M | .750 | A | | 2.562 | 1.772 | 2.2 | 1.66 | 17300 | 4 | 345R-1305 |
| | 13 | 3/4 | .236 | 1 | 5 | | A345-051R19-13H | .750 | A | | 2.562 | 1.772 | 2.2 | 1.64 | 17300 | 5 | 345R-1305 |
| 2.500 | 13 | 1 | .236 | 1 | | 4 | A345-063R25-13L | 1.000 | A | | 3.054 | 1.772 | 2.2 | 2.16 | 15400 | 4 | 345R-1305 |
| | 13 | 1 | .236 | 1 | | 5 | A345-063R25-13M | 1.000 | A | | 3.054 | 1.772 | 2.2 | 2.07 | 15400 | 5 | 345R-1305 |
| | 13 | 1 | .236 | 1 | 6 | | A345-063R25-13H | 1.000 | A | | 3.054 | 1.772 | 2.2 | 2.08 | 15400 | 6 | 345R-1305 |
| | 13 | 1 | .236 | 1 | 7 | | A345-063R25-13HX | 1.000 | A | | 3.054 | 1.772 | 2.2 | 2.16 | 15400 | 7 | 345R-1305 |
| 3.000 | 13 | 1 | .236 | 1 | | 4 | A345-076R25-13L | 1.000 | A | | 3.554 | 1.772 | 2.2 | 3.13 | 14000 | 4 | 345R-1305 |
| | 13 | 1 | .236 | 1 | | 6 | A345-076R25-13M | 1.000 | A | | 3.554 | 1.772 | 2.2 | 3.18 | 14000 | 6 | 345R-1305 |
| | 13 | 1 | .236 | 1 | 8 | | A345-076R25-13H | 1.000 | A | | 3.554 | 1.772 | 2.2 | 3.26 | 14000 | 8 | 345R-1305 |
| 3.150 | 13 | 1 | .236 | 1 | | 4 | A345-080J25-13L | 1.000 | A | | 3.704 | 1.969 | 2.2 | 3.22 | 13700 | 4 | 345R-1305 |
| | 13 | 1 | .236 | 1 | | 6 | A345-080J25-13M | 1.000 | A | | 3.704 | 1.969 | 2.2 | 3.20 | 13700 | 6 | 345R-1305 |
| 3.937 | 13 | 1 1/4 | .236 | 1 | | 5 | A345-100J31-13L | 1.250 | A | | 4.491 | 1.969 | 2.2 | 5.08 | 12200 | 5 | 345R-1305 |
| | 13 | 1 1/4 | .236 | 1 | | 7 | A345-100J31-13M | 1.250 | A | | 4.491 | 1.969 | 2.2 | 5.10 | 12200 | 7 | 345R-1305 |
| | 13 | 1 1/4 | .236 | 1 | 10 | | A345-100J31-13H | 1.250 | A | | 4.491 | 1.969 | 2.2 | 5.27 | 12200 | 10 | 345R-1305 |
| 4.000 | 13 | 1 1/2 | .236 | 1 | | 5 | A345-102R38-13L | 1.500 | B | | 4.554 | 2.480 | 2.2 | 4.67 | 12100 | 5 | 345R-1305 |
| | 13 | 1 1/2 | .236 | 1 | | 7 | A345-102R38-13M | 1.500 | B | | 4.554 | 2.480 | 2.2 | 4.94 | 12100 | 7 | 345R-1305 |
| | 13 | 1 1/2 | .236 | 1 | 10 | | A345-102R38-13H | 1.500 | B | | 4.554 | 2.480 | 2.2 | 5.16 | 12100 | 10 | 345R-1305 |
| 4.921 | 13 | 1 1/2 | .236 | 1 | | 6 | A345-125J38-13L | 1.500 | B | | 5.476 | 2.756 | 2.2 | 8.99 | 10900 | 6 | 345R-1305 |
| | 13 | 1 1/2 | .236 | 1 | | 8 | A345-125J38-13M | 1.500 | B | | 5.476 | 2.756 | 2.2 | 8.22 | 10900 | 8 | 345R-1305 |
| | 13 | 1 1/2 | .236 | 1 | 12 | | A345-125J38-13H | 1.500 | B | | 5.476 | 2.756 | 2.2 | 8.38 | 10900 | 12 | 345R-1305 |
| 5.000 | 13 | 1 1/2 | .236 | 1 | | 8 | A345-127R38-13M | 1.500 | B | | 5.554 | 2.480 | 2.2 | 5.76 | 10800 | 8 | 345R-1305 |
| | 13 | 1 1/2 | .236 | 1 | 12 | | A345-127R38-13H | 1.500 | B | | 5.554 | 2.480 | 2.2 | 6.17 | 10800 | 12 | 345R-1305 |
| 6.000 | 13 | 1 1/2 | .236 | 0 | | 7 | A345-152R38-13L | 1.500 | C | 2.626 | 6.554 | 2.480 | 2.2 | 8.14 | 9900 | 7 | 345R-1305 |
| | 13 | 1 1/2 | .236 | 0 | | 10 | A345-152R38-13M | 1.500 | C | 2.626 | 6.554 | 2.480 | 2.2 | 7.92 | 9900 | 10 | 345R-1305 |
| | 13 | 1 1/2 | .236 | 0 | | 12 | A345-152R38-13H | 1.500 | C | 2.626 | 6.554 | 2.480 | 2.2 | 8.37 | 9900 | 12 | 345R-1305 |
| | 13 | 1 1/2 | .236 | 0 | 16 | | A345-152R38-13HX | 1.500 | C | 2.626 | 6.554 | 2.480 | 2.2 | 8.09 | 9900 | 16 | 345R-1305 |
| 6.299 | 13 | 2 | .236 | 0 | | 10 | A345-160J51-13M | 2.000 | C | 2.626 | 6.854 | 2.480 | 2.2 | 11.11 | 9600 | 10 | 345R-1305 |
| | 13 | 2 | .236 | 0 | | 12 | A345-160J51-13H | 2.000 | C | 2.626 | 6.854 | 2.480 | 2.2 | 11.71 | 9600 | 12 | 345R-1305 |
| 7.874 | 13 | 1 7/8 | .236 | 0 | | 12 | A345-200J47-13M | 1.875 | C | 2.626 | 8.428 | 2.480 | 2.2 | 26.72 | 8600 | 12 | 345R-1305 |
| 8.000 | 13 | 2 1/2 | .236 | 0 | | 12 | A345-203R63-13M | 2.500 | C | 4.000 | 8.546 | 2.480 | 2.2 | 17.55 | 8500 | 12 | 345R-1305 |
| | 13 | 2 1/2 | .236 | 0 | | 16 | A345-203R63-13H | 2.500 | C | 4.000 | 8.546 | 2.480 | 2.2 | 18.35 | 8500 | 16 | 345R-1305 |
| 9.843 | 13 | 1 7/8 | .236 | 0 | | 18 | A345-250J47-13H | 1.875 | C | 2.626 | 10.397 | 2.480 | 2.2 | 35.27 | 7700 | 18 | 345R-1305 |
| 10.000 | 13 | 2 1/2 | .236 | 0 | | 14 | A345-254R63-13M | 2.500 | C | 4.000 | 10.554 | 2.480 | 2.2 | 25.40 | 7600 | 14 | 345R-1305 |
| | 13 | 2 1/2 | .236 | 0 | 24 | | A345-254R63-13HX | 2.500 | C | 4.000 | 10.554 | 2.480 | 2.2 | 25.96 | 7600 | 24 | 345R-1305 |

| | Spare parts | | | |
|---|---|---|---|---|
| DC | Shower screw | Insert screw | Shim | Shim screw |
| 2.000 | - | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 2.500 | 5512 074-02 | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 3.000 | 5512 074-02 | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 4.000 | 5512 099-03 | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 5.000 | 5512 099-03 | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 6.000 | 5512 099-03 | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 8.000 | - | 416.1-834 | 5322 474-01 | 5512 090-11 |
| 10.000 | - | 416.1-834 | 5322 474-01 | 5512 090-11 |

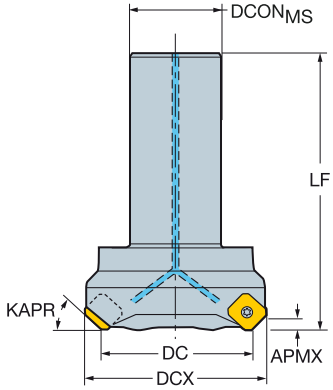
For the complete list of spare parts, visit www.sandvik.coromant.com

I9 L2 M1 N22 N9 N15

# CoroMill® 345 face milling cutter

**Cylindrical shank - Internal coolant supply**

KAPR 45°

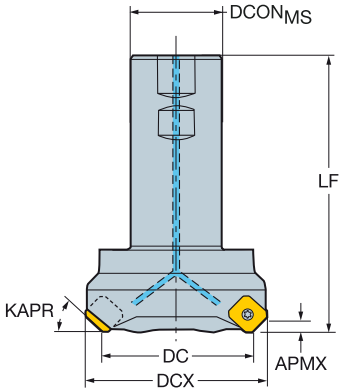



**Metric version**

| DC | | CZCMS | APMX | CNSC | | Ordering code | Dimensions, mm DCONMS | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 13 | 32 | 6.0 | 1 | 4 | 345-040A32-13M | 32.0 | 54.1 | 120.0 | 3.0 | 1.26 | 19600 | 4 | 345R-1305 |
| 50.0 | 13 | 32 | 6.0 | 1 | 3 | 345-050A32-13L | 32.0 | 64.1 | 120.0 | 3.0 | 1.41 | 17500 | 3 | 345R-1305 |
| | 13 | 32 | 6.0 | 1 | 4 | 345-050A32-13M | 32.0 | 54.1 | 120.0 | 3.0 | 1.41 | 17500 | 4 | 345R-1305 |

**Weldon – Internal coolant supply**

STDNO ISO3338-2
KAPR 45°




**Inch version**

| DC | | CZCMS | APMX | CNSC | | Ordering code | Dimensions, inch DCONMS | ISO | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.500 | 13 | 1 1/4 | .236 | 1 | 4 | A345-038M32-13M | 1.250 | WE | 2.054 | 5.865 | 2.2 | 2.65 | 20100 | 4 | 345R-1305 |
| 2.000 | 13 | 1 1/4 | .236 | 1 | 4 | A345-051M32-13M | 1.250 | WE | 2.554 | 5.865 | 2.2 | 3.53 | 17300 | 4 | 345R-1305 |

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

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

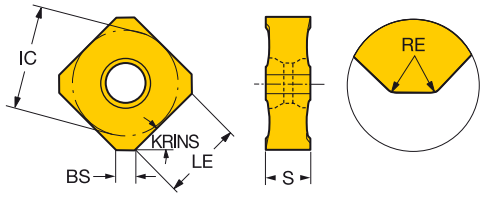
I9 L2 N22 N10 N15



SANDVIK Coromant

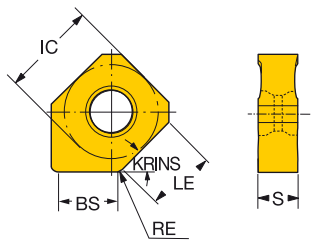
# CoroMill® 345 insert for milling

KRINS 45°




| | | | | | Ordering code | P | | | | | M | | | | | K | | | | | N | | S | | | H | | | Dimensions, mm, inch | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | RE | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3220 | 3330 | K20W | 1130 | 530 | S30T | S40T | 1010 | 1130 | 530 | IC | LE | S | BS |
| Light | KL | 13 | 0.80 | | 345R-1305E-KL | | | | | | | | | | | ★ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |
| | | | 0.80 | | 345R-1305M-KL | | ☆ | | | | | | | | | ★ | ☆ | | ☆ | ☆ | | | | | | | | 13.0 | 8.8 | 5.05 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |
| | ML | 13 | 0.80 | | 345R-13T5E-ML | ☆ | | | | | ★ | ☆ | ☆ | | ☆ | | | | | | ☆ | | ★ | ☆ | | ☆ | | 13.0 | 8.8 | 5.45 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .215 | .079 |
| | PL | 13 | 0.80 | | 345R-1305E-PL | ☆ | | ★ | ☆ | ☆ | | | | ☆ | | | | | | | | | | ★ | ☆ | ☆ | 13.0 | 8.8 | 5.05 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |
| | | | 0.80 | | 345R-1305M-PL | ☆ | ☆ | ★ | ☆ | | | | | | | | | | | | | | | ★ | ☆ | | 13.0 | 8.8 | 5.05 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |
| Medium | KM | 13 | 0.80 | | 345R-1305E-KM | | | | | ☆ | | | | ☆ | | ☆ | ☆ | | ★ | | | ☆ | | | ★ | | ☆ | 13.0 | 8.8 | 5.05 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |
| | | | 0.80 | | 345R-1305M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | ☆ | | | | | | | | 13.0 | 8.8 | 5.05 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |
| | MM | 13 | 0.80 | | 345R-13T5E-MM | ☆ | | | | | ★ | ☆ | ☆ | | ☆ | | | | | | ☆ | | ★ | ☆ | | ☆ | | 13.0 | 8.8 | 5.45 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .215 | .079 |
| | | | 0.80 | | 345R-13T5M-MM | ☆ | | | | | ★ | ☆ | ☆ | | ☆ | | | | | | ☆ | | ★ | ☆ | | ☆ | | 13.0 | 8.8 | 5.45 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .215 | .079 |
| | PM | 13 | 0.80 | | 345L-1305M-PM | ☆ | | ★ | ☆ | | | | | | | | | | | | | | | | ☆ | | 13.0 | 8.8 | 5.05 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |
| | | | 0.80 | | 345R-1305M-PM | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | | | | | | | | | ★ | ☆ | ☆ | 13.0 | 8.8 | 5.05 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |
| Heavy | KH | 13 | 0.80 | | 345R-1305M-KH | | | ☆ | | | | | | | | | ☆ | ☆ | ★ | ☆ | | | | | | | | 13.0 | 8.8 | 5.05 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |
| | PH | 13 | 0.80 | | 345R-1305M-PH | ☆ | ☆ | ★ | ☆ | | | | | | | | ★ | | | | ☆ | | | | ★ | ☆ | | 13.0 | 8.8 | 5.05 | 2.0 |
| | | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .079 |

KRINS 45°




| | | | | | Ordering code | P | | | | M | | | | | K | | | | N | | | S | | | | H | | | Dimensions, mm, inch | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | RE | | 1010 | 1130 | 4330 | 530 | 1040 | 2030 | 2040 | 530 | S30T | 1020 | 3220 | 3330 | K20W | 1130 | 530 | H13A | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | IC | LE | S | BS | BSR |
| Light | KW8 | 13 | 1.00 | | 345N-1305E-KW8 | | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | ☆ | | | | | | | | | 13.0 | 8.8 | 5.05 | 8.0 | 500.0 |
| | | | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .315 | 19.685 |
| | MW8 | 13 | 1.00 | | 345N-13T5E-MW8 | | ☆ | | | ☆ | ☆ | ☆ | | ☆ | | | | | ☆ | | | ☆ | ☆ | | ☆ | ☆ | | ☆ | | 13.0 | 8.8 | 5.45 | 8.0 | 500.0 |
| | | | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .215 | .315 | 19.685 |
| | PW5 | 13 | 1.00 | | 345N-1305E-PW5 | ☆ | ☆ | ☆ | | | | | | | | | | | ☆ | | | | | | | | ☆ | ☆ | | 13.0 | 8.8 | 5.05 | 5.0 | 500.0 |
| | | | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .197 | 19.685 |
| | PW8 | 13 | 1.00 | | 345N-1305E-PW8 | ☆ | ☆ | ☆ | ☆ | | | | ☆ | | | | | | ☆ | ☆ | | | | | | | ☆ | ☆ | ☆ | 13.0 | 8.8 | 5.05 | 8.0 | 500.0 |
| | | | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | .512 | .346 | .199 | .315 | 19.685 |

T5 Wiper insert should be used with T5 standard insert

I5 I222 I254 N9 N22 N2

# 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
- Also available in an exchangeable cassette system, a concept for rough to semi-finishing of steel

www.sandvik.coromant.com/coromill245

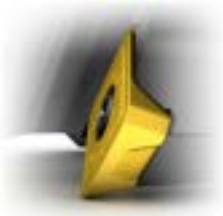
### Couplings

- Arbor
- Cylindrical shank

### Inserts

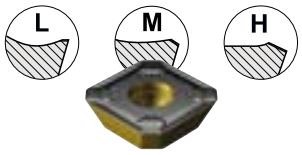
- Four cutting edges
- Wide range of grades and geometries including ceramic and CBN grades
- Wiper inserts for high feed finishing

Coarse pitch Close pitch Extra close pitch



### Light cutting action

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




I11 I15 N6

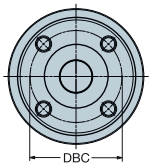


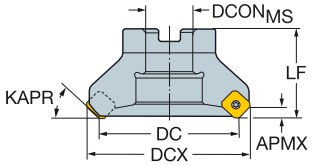
SANDVIK Coromant

# CoroMill® 245 face milling cutter

**Arbor**

STDNO ISO 6462:2011
KAPR 45°




**Metric version**

| DC | | CZCMS | APMX | | | Ordering code | Dimensions, mm DCONMS | ISO | DBC | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 12 | 22 | 6.0 | | 3 | R245-050Q22-12L | 22.0 | A | | 62.5 | 40.0 | 3.0 | 0.65 | 16250 | 3 | R245-12T3.. |
| | 12 | 22 | 6.0 | 4 | | R245-050Q22-12M | 22.0 | A | | 62.5 | 40.0 | 3.0 | 0.67 | 16250 | 4 | R245-12T3.. |
| | 12 | 22 | 6.0 | 5 | | R245-050Q22-12H | 22.0 | A | | 62.5 | 40.0 | 3.0 | 0.62 | 16250 | 5 | R245-12T3.. |
| 63.0 | 12 | 22 | 6.0 | | 4 | R245-063Q22-12L | 22.0 | A | | 75.5 | 40.0 | 3.0 | 0.89 | 14400 | 4 | R245-12T3.. |
| | 12 | 22 | 6.0 | 5 | | R245-063Q22-12M | 22.0 | A | | 75.5 | 40.0 | 3.0 | 0.84 | 14400 | 5 | R245-12T3.. |
| | 12 | 22 | 6.0 | 6 | | R245-063Q22-12H | 22.0 | A | | 75.5 | 40.0 | 3.0 | 0.87 | 14400 | 6 | R245-12T3.. |
| 80.0 | 12 | 27 | 6.0 | | 4 | R245-080Q27-12L | 27.0 | B | | 92.5 | 50.0 | 3.0 | 1.50 | 12700 | 4 | R245-12T3.. |
| | 12 | 27 | 6.0 | 6 | | R245-080Q27-12M | 27.0 | B | | 92.5 | 50.0 | 3.0 | 1.45 | 12700 | 6 | R245-12T3.. |
| | 12 | 27 | 6.0 | 8 | | R245-080Q27-12H | 27.0 | B | | 92.5 | 50.0 | 3.0 | 1.40 | 12700 | 8 | R245-12T3.. |
| | 18 | 32 | 10.0 | | 4 | R245-080Q32-18M | 32.0 | B | | 98.8 | 50.0 | 5.0 | 1.72 | 6100 | 4 | R245-18T6.. |
| | 18 | 32 | 10.0 | | 5 | R245-080Q32-18H | 32.0 | B | | 98.8 | 50.0 | 5.0 | 1.60 | 6100 | 5 | R245-18T6.. |
| 100.0 | 12 | 32 | 6.0 | | 5 | R245-100Q32-12L | 32.0 | B | | 112.5 | 50.0 | 3.0 | 1.77 | 11300 | 5 | R245-12T3.. |
| | 12 | 32 | 6.0 | 7 | | R245-100Q32-12M | 32.0 | B | | 112.5 | 50.0 | 3.0 | 1.81 | 11300 | 7 | R245-12T3.. |
| | 12 | 32 | 6.0 | 10 | | R245-100Q32-12H | 32.0 | B | | 112.5 | 50.0 | 3.0 | 1.74 | 11300 | 10 | R245-12T3.. |
| | 18 | 32 | 10.0 | | 4 | R245-100Q32-18M | 32.0 | B | | 118.8 | 50.0 | 5.0 | 2.08 | 5400 | 4 | R245-18T6.. |
| | 18 | 32 | 10.0 | | 6 | R245-100Q32-18H | 32.0 | B | | 118.8 | 50.0 | 5.0 | 1.92 | 5400 | 6 | R245-18T6.. |
| 125.0 | 12 | 40 | 6.0 | | 6 | R245-125Q40-12L | 40.0 | B | | 137.5 | 63.0 | 3.0 | 3.20 | 10100 | 6 | R245-12T3.. |
| | 12 | 40 | 6.0 | 8 | | R245-125Q40-12M | 40.0 | B | | 137.5 | 63.0 | 3.0 | 3.12 | 10100 | 8 | R245-12T3.. |
| | 12 | 40 | 6.0 | 12 | | R245-125Q40-12H | 40.0 | B | | 137.5 | 63.0 | 3.0 | 3.10 | 10100 | 12 | R245-12T3.. |
| | 18 | 40 | 10.0 | | 5 | R245-125Q40-18M | 40.0 | B | | 138.8 | 63.0 | 5.0 | 3.74 | 4900 | 5 | R245-18T6.. |
| | 18 | 40 | 10.0 | | 7 | R245-125Q40-18H | 40.0 | B | | 138.8 | 63.0 | 5.0 | 3.64 | 4900 | 7 | R245-18T6.. |
| 160.0 | 12 | 40S | 6.0 | | 7 | R245-160Q40-12L | 40.0 | C | 66.7 | 172.5 | 63.0 | 3.0 | 4.63 | 8900 | 7 | R245-12T3.. |
| | 12 | 40S | 6.0 | 10 | | R245-160Q40-12M | 40.0 | C | 66.7 | 172.5 | 63.0 | 3.0 | 4.50 | 8900 | 10 | R245-12T3.. |
| | 12 | 40S | 6.0 | 16 | | R245-160Q40-12H | 40.0 | C | 66.7 | 172.5 | 63.0 | 3.0 | 4.49 | 8900 | 16 | R245-12T3.. |
| | 18 | 40S | 10.0 | | 6 | R245-160Q40-18M | 40.0 | C | 66.7 | 178.8 | 63.0 | 5.0 | 5.11 | 4300 | 6 | R245-18T6.. |
| | 18 | 40S | 10.0 | | 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 | 6.0 | | 8 | R245-200Q60-12L | 60.0 | C | 101.6 | 212.5 | 63.0 | 3.0 | 6.43 | 7950 | 8 | R245-12T3.. |
| | 12 | 60 | 6.0 | 12 | | R245-200Q60-12M | 60.0 | C | 101.6 | 212.5 | 63.0 | 3.0 | 10.64 | 7950 | 12 | R245-12T3.. |
| | 18 | 60 | 10.0 | | 8 | R245-200Q60-18M | 60.0 | C | 101.6 | 218.8 | 63.0 | 5.0 | 6.24 | 3800 | 8 | R245-18T6.. |
| | 18 | 60 | 10.0 | | 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 | 6.0 | | 10 | R245-250Q60-12L | 60.0 | C | 101.6 | 262.5 | 63.0 | 3.0 | 9.12 | 7100 | 10 | R245-12T3.. |
| | 12 | 60 | 6.0 | 14 | | R245-250Q60-12M | 60.0 | C | 101.6 | 262.5 | 63.0 | 3.0 | 8.93 | 7100 | 14 | R245-12T3.. |
| | 12 | 60 | 6.0 | 24 | | R245-250Q60-12H | 60.0 | C | 101.6 | 262.5 | 63.0 | 3.0 | 8.74 | 7100 | 24 | R245-12T3.. |
| | 18 | 60 | 10.0 | | 10 | R245-250Q60-18M | 60.0 | C | 101.6 | 268.8 | 63.0 | 5.0 | 17.22 | 3400 | 10 | R245-18T6.. |
| | 18 | 60 | 10.0 | | 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 |

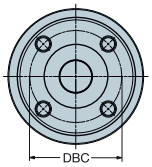
For the complete list of spare parts, visit www.sandvik.coromant.com

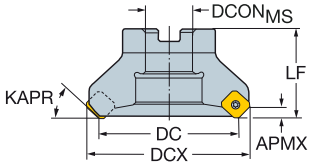
I15 L2 M1 N22 N6 N9

# CoroMill® 245 face milling cutter

**Arbor**

STDNO ISO6462
KAPR 45°




**Inch version**

| DC | | CZCMS | APMX | | | Ordering code | Dimensions, inch DCONMS | ISO | DBC | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.000 | 12 | 3/4 | .240 | | 3 | RA245-051R19-12L | .750 | A | | 2.492 | 1.575 | 2.2 | 1.41 | 16250 | 3 | R245-12T3.. |
| | 12 | 3/4 | .240 | 4 | | RA245-051R19-12M | .750 | A | | 2.492 | 1.575 | 2.2 | 1.41 | 16250 | 4 | R245-12T3.. |
| | 12 | 3/4 | .240 | 5 | | RA245-051R19-12H | .750 | A | | 2.492 | 1.575 | 2.2 | 1.72 | 16250 | 5 | R245-12T3.. |
| 2.500 | 12 | 3/4 | .240 | | 4 | RA245-063R19-12L | .750 | A | | 2.992 | 1.575 | 2.2 | 2.12 | 14400 | 4 | R245-12T3.. |
| | 12 | 3/4 | .240 | 5 | | RA245-063R19-12M | .750 | A | | 2.992 | 1.575 | 2.2 | 1.90 | 14400 | 5 | R245-12T3.. |
| | 12 | 3/4 | .240 | 6 | | RA245-063R19-12H | .750 | A | | 2.992 | 1.575 | 2.2 | 2.05 | 14400 | 6 | R245-12T3.. |
| 3.000 | 12 | 1 | .240 | | 4 | RA245-076R25-12L | 1.000 | B | | 3.492 | 1.969 | 2.2 | 3.22 | 12700 | 4 | R245-12T3.. |
| | 12 | 1 | .240 | 6 | | RA245-076R25-12M | 1.000 | B | | 3.492 | 1.969 | 2.2 | 2.89 | 12700 | 6 | R245-12T3.. |
| | 12 | 1 | .240 | 8 | | RA245-076R25-12H | 1.000 | B | | 3.492 | 1.969 | 2.2 | 3.10 | 12700 | 8 | R245-12T3.. |
| | 18 | 1 | .394 | | 4 | RA245-076R25-18M | 1.000 | B | | 3.740 | 1.969 | 3.6 | 3.27 | 6300 | 4 | R245-18T6.. |
| | 18 | 1 | .394 | | 5 | RA245-076R25-18H | 1.000 | B | | 3.740 | 1.969 | 3.6 | 3.31 | 6300 | 5 | R245-18T6.. |
| 3.150 | 12 | 1 | .236 | | 4 | RA245-080J25.4-12L | 1.000 | B | | 3.642 | 1.969 | 2.2 | 3.45 | 12700 | 4 | R245-12T3.. |
| | 12 | 1 | .236 | 6 | | RA245-080J25.4-12M | 1.000 | B | | 3.642 | 1.969 | 2.2 | 3.26 | 12700 | 6 | R245-12T3.. |
| | 12 | 1 | .236 | 8 | | RA245-080J25.4-12H | 1.000 | B | | 3.642 | 1.969 | 2.2 | 3.22 | 12700 | 8 | R245-12T3.. |
| | 18 | 1 | .394 | | 5 | RA245-080J25-18H | 1.000 | B | | 3.989 | 1.969 | 3.6 | 3.31 | 6100 | 5 | R245-18T6.. |
| 3.937 | 12 | 1 1/4 | .236 | | 5 | RA245-100J31.75-12L | 1.250 | B | | 4.429 | 2.480 | 2.2 | 5.50 | 11300 | 5 | R245-12T3.. |
| | 12 | 1 1/4 | .236 | 7 | | RA245-100J31.75-12M | 1.250 | B | | 4.429 | 2.480 | 2.2 | 5.32 | 11300 | 7 | R245-12T3.. |
| | 12 | 1 1/4 | .236 | 10 | | RA245-100J31.75-12H | 1.250 | B | | 4.429 | 2.480 | 2.2 | 4.81 | 11300 | 10 | R245-12T3.. |
| | 18 | 1 1/4 | .394 | | 4 | RA245-100J31-18M | 1.250 | B | | 4.677 | 2.480 | 3.6 | 5.91 | 5400 | 4 | R245-18T6.. |
| 4.000 | 12 | 1 1/2 | .240 | | 5 | RA245-102R38-12L | 1.500 | B | | 4.492 | 1.969 | 2.2 | 4.42 | 11300 | 5 | R245-12T3.. |
| | 12 | 1 1/2 | .240 | 7 | | RA245-102R38-12M | 1.500 | B | | 4.492 | 1.969 | 2.2 | 4.23 | 11300 | 7 | R245-12T3.. |
| | 12 | 1 1/2 | .240 | 10 | | RA245-102R38-12H | 1.500 | B | | 4.492 | 1.969 | 2.2 | 4.41 | 11300 | 10 | R245-12T3.. |
| | 18 | 1 1/2 | .394 | | 4 | RA245-102R38-18M | 1.500 | B | | 4.740 | 1.969 | 3.6 | 4.71 | 5400 | 4 | R245-18T6.. |
| | 18 | 1 1/2 | .394 | | 6 | RA245-102R38-18H | 1.500 | B | | 4.740 | 1.969 | 3.6 | 4.52 | 5400 | 6 | R245-18T6.. |
| 4.921 | 12 | 1 1/2 | .236 | | 6 | RA245-125J38.1-12L | 1.500 | B | | 5.413 | 2.480 | 2.2 | 8.07 | 10100 | 6 | R245-12T3.. |
| | 12 | 1 1/2 | .236 | 8 | | RA245-125J38.1-12M | 1.500 | B | | 5.413 | 2.480 | 2.2 | 7.87 | 10100 | 8 | R245-12T3.. |
| | 12 | 1 1/2 | .236 | 12 | | RA245-125J38.1-12H | 1.500 | B | | 5.413 | 2.480 | 2.2 | 7.78 | 10100 | 12 | R245-12T3.. |
| | 18 | 1 1/2 | .394 | | 5 | RA245-125J38-18M | 1.500 | B | | 5.661 | 2.480 | 3.6 | 8.35 | 4900 | 5 | R245-18T6.. |
| 5.000 | 12 | 1 1/2 | .240 | | 6 | RA245-127R38-12L | 1.500 | B | | 5.492 | 2.480 | 2.2 | 6.83 | 10100 | 6 | R245-12T3.. |
| | 12 | 1 1/2 | .240 | 8 | | RA245-127R38-12M | 1.500 | B | | 5.492 | 2.480 | 2.2 | 7.05 | 10100 | 8 | R245-12T3.. |
| | 12 | 1 1/2 | .240 | 12 | | RA245-127R38-12H | 1.500 | B | | 5.492 | 2.480 | 2.2 | 6.88 | 10100 | 12 | R245-12T3.. |
| | 18 | 1 1/2 | .394 | | 5 | RA245-127R38-18M | 1.500 | B | | 5.740 | 2.480 | 3.6 | 7.94 | 4800 | 5 | R245-18T6.. |
| | 18 | 1 1/2 | .394 | | 7 | RA245-127R38-18H | 1.500 | B | | 5.740 | 2.480 | 3.6 | 7.77 | 4800 | 7 | R245-18T6.. |
| 6.000 | 12 | 1 1/2 | .240 | | 7 | RA245-152R38-12L | 1.500 | B | | 6.492 | 2.480 | 2.2 | 9.79 | 8900 | 7 | R245-12T3.. |
| | 12 | 1 1/2 | .240 | 10 | | RA245-152R38-12M | 1.500 | B | | 6.492 | 2.480 | 2.2 | 9.57 | 8900 | 10 | R245-12T3.. |
| | 12 | 1 1/2 | .240 | 15 | | RA245-152R38-12H | 1.500 | B | | 6.492 | 2.480 | 2.2 | 9.44 | 8900 | 15 | R245-12T3.. |
| | 18 | 1 1/2 | .394 | | 6 | RA245-152R38-18M | 1.500 | B | | 6.740 | 2.480 | 3.6 | 12.39 | 4400 | 6 | R245-18T6.. |
| | 18 | 1 1/2 | .394 | | 9 | RA245-152R38-18H | 1.500 | B | | 6.740 | 2.480 | 3.6 | 12.08 | 4400 | 9 | R245-18T6.. |
| 6.299 | 12 | 2 | .236 | | 7 | RA245-160J50.8-12L | 2.000 | C | 2.626 | 6.791 | 2.480 | 2.2 | 11.52 | 8900 | 7 | R245-12T3.. |
| | 12 | 2 | .236 | 10 | | RA245-160J50.8-12M | 2.000 | C | 2.626 | 6.791 | 2.480 | 2.2 | 10.71 | 8900 | 10 | R245-12T3.. |
| | 18 | 2 | .394 | | 6 | RA245-160J51-18M | 2.000 | C | 2.626 | 7.039 | 2.480 | 3.6 | 20.33 | 4300 | 6 | R245-18T6.. |
| | 18 | 2 | .394 | | 9 | RA245-160J51-18H | 2.000 | C | 2.626 | 7.039 | 2.480 | 3.6 | 11.73 | 4300 | 9 | R245-18T6.. |
| 7.874 | 12 | 1 7/8 | .236 | 12 | | RA245-200J47.625-12M | 1.875 | C | 2.626 | 8.366 | 2.480 | 2.2 | 25.85 | 7950 | 12 | R245-12T3.. |
| 8.000 | 12 | 2 1/2 | .240 | | 8 | RA245-203R63-12L | 2.500 | C | 4.000 | 8.492 | 2.480 | 2.2 | 23.90 | 7950 | 8 | R245-12T3.. |
| | 12 | 2 1/2 | .240 | 12 | | RA245-203R63-12M | 2.500 | C | 4.000 | 8.492 | 2.480 | 2.2 | 23.53 | 7950 | 12 | R245-12T3.. |
| | 12 | 2 1/2 | .240 | 20 | | RA245-203R63-12H | 2.500 | C | 4.000 | 8.492 | 2.480 | 2.2 | 22.99 | 7950 | 20 | R245-12T3.. |
| | 18 | 2 1/2 | .394 | | 8 | RA245-203R63-18M | 2.500 | C | 4.000 | 8.740 | 2.480 | 3.6 | 25.77 | 3800 | 8 | R245-18T6.. |
| 9.843 | 12 | 1 7/8 | .236 | 14 | | RA245-250J47.625-12M | 1.875 | C | 2.626 | 10.335 | 2.480 | 2.2 | 34.41 | 7100 | 14 | R245-12T3.. |
| | 18 | 1 7/8 | .394 | | 10 | RA245-250J47-18M | 1.875 | C | 2.626 | 10.583 | 2.480 | 3.6 | 40.79 | 3400 | 10 | R245-18T6.. |
| 10.000 | 12 | 2 1/2 | .240 | | 10 | RA245-254R63-12L | 2.500 | C | 4.000 | 10.492 | 2.480 | 2.2 | 30.07 | 7100 | 10 | R245-12T3.. |
| | 12 | 2 1/2 | .240 | 14 | | RA245-254R63-12M | 2.500 | C | 4.000 | 10.492 | 2.480 | 2.2 | 32.58 | 7100 | 14 | R245-12T3.. |
| | 18 | 2 1/2 | .394 | | 10 | RA245-254R63-18M | 2.500 | C | 4.000 | 10.740 | 2.480 | 3.6 | 36.82 | 3400 | 10 | R245-18T6.. |

| | | Spare parts | | |
|---|---|---|---|---|
| DC" | | Insert screw | Shim | Shim screw |
| 2.000-10.000 | 12 | 5513 020-01 | 5322 472-01 | 5512 090-09 |
| 3.000-4.000 | 18 | 5513 020-55 | | |
| 4.921-10.000 | 18 | 5513 020-26 | 5322 472-03 | 5512 090-10 |

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

I15 L2 M1 N22 N6 N9

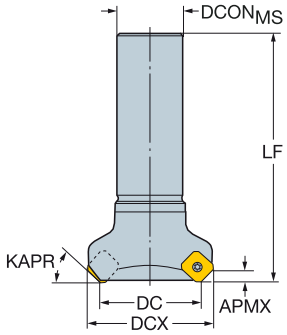


SANDVIK Coromant

# CoroMill® 245 face milling cutter

**Cylindrical shank**

KAPR 45°




**Metric version**

| DC | | CZCMS | APMX | | | Ordering code | Dimensions, mm DCONMS | DCX | LB | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 32.0 | 12 | 32 | 6.0 | 3 | | R245-032A32-12M | 32.0 | 44.5 | 39.0 | 117.0 | 3.0 | 0.97 | 18250 | 3 | R245-12T3.. |
| 40.0 | 12 | 32 | 6.0 | | 3 | R245-040A32-12L | 32.0 | 52.5 | 39.0 | 120.0 | 3.0 | 1.06 | 18250 | 3 | R245-12T3.. |
| 50.0 | 12 | 32 | 6.0 | | 3 | R245-050A32-12L | 32.0 | 62.5 | 39.0 | 120.0 | 3.0 | 1.28 | 16250 | 3 | R245-12T3.. |
| | 12 | 32 | 6.0 | 4 | | R245-050A32-12M | 32.0 | 62.5 | 39.0 | 120.0 | 3.0 | 1.33 | 16250 | 4 | R245-12T3.. |
| 63.0 | 12 | 32 | 6.0 | | 4 | R245-063A32-12L | 32.0 | 75.5 | 39.0 | 120.0 | 3.0 | 1.48 | 14400 | 4 | R245-12T3.. |
| | 12 | 32 | 6.0 | 5 | | R245-063A32-12M | 32.0 | 75.5 | 39.0 | 120.0 | 3.0 | 1.49 | 14400 | 5 | R245-12T3.. |
| 80.0 | 12 | 32 | 6.0 | | 4 | R245-080A32-12L | 32.0 | 92.5 | 39.0 | 120.0 | 3.0 | 1.80 | 12700 | 4 | R245-12T3.. |
| | 12 | 32 | 6.0 | 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 |

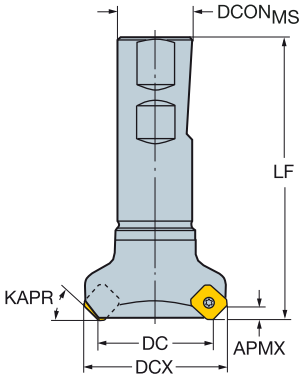
For the complete list of spare parts, visit www.sandvik.coromant.com

I15 L2 N22 N6 N9

# CoroMill® 245 face milling cutter

**Whistle notch / Weldon**

KAPR 45°




## Inch version

| DC | | CZCMS | APMX | | | Ordering code | Dimensions, inch DCONMS | DCX | LB | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.250 | 12 | 1 | .240 | | 2 | RA245-032MN25-12L | 1.000 | 1.742 | .236 | 3.858 | 2.2 | 1.46 | 18250 | 2 | R245-12T3.. |
| | 12 | 1 | .240 | 3 | | RA245-032MN25-12M | 1.000 | 1.742 | 1.575 | 3.858 | 2.2 | 1.47 | 18250 | 3 | R245-12T3.. |
| 1.500 | 12 | 1 1/4 | .240 | | 3 | RA245-038MN32-12L | 1.250 | 1.992 | .236 | 3.858 | 2.2 | 1.98 | 18250 | 3 | R245-12T3.. |
| | 12 | 1 1/4 | .240 | 4 | | RA245-038MN32-12M | 1.250 | 1.992 | 1.575 | 3.858 | 2.2 | 1.81 | 18250 | 4 | R245-12T3.. |
| 2.000 | 12 | 1 1/4 | .240 | 4 | | RA245-051MN32-12M | 1.250 | 2.492 | .236 | 3.976 | 2.2 | 2.65 | 16250 | 4 | R245-12T3.. |
| 2.500 | 12 | 1 1/4 | .240 | 5 | | RA245-063MN32-12M | 1.250 | 2.992 | .236 | 3.976 | 2.2 | 3.00 | 14400 | 5 | R245-12T3.. |

| | | Spare parts | | |
|---|---|---|---|---|
| DC" | | Insert screw | Shim | Shim screw |
| 1.250 | 12 | 5513 020-01 | | |
| 1.500-2.500 | 12 | 5513 020-01 | 5322 472-01 | 5512 090-09 |

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

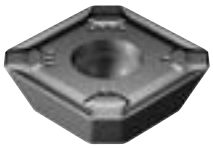
I15 L2 N22 N6 N9

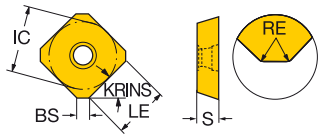


SANDVIK Coromant

# CoroMill® 245 insert for milling

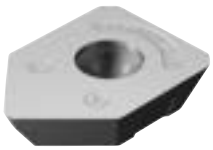
KRINS 45°

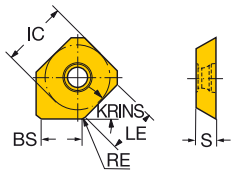





| | | RE | Ordering code | P | | | | | M | | | | | K | | | | | | N | | | | S | | | | H | | | Dimensions, mm, inch | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3220 | 3330 | K15W | K20W | 1130 | 530 | H10 | H13A | 1130 | H13A | S30T | S40T | 1010 | 1130 | 530 | IC | LE | S | BS |
| Light | AL | 12 | R245-12 T3 E-AL | | | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | | | |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | 13.4 | 10.0 | 3.97 | 2.3 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .091 |
| | KL | 12 | R245-12 T3 E-KL | | | | | | | | | | | ★ | | ☆ | ☆ | ☆ | | | | ★ | | ☆ | | | | | | | 13.4 | 10.0 | 3.97 | 2.1 |
| | | .059 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .083 |
| | | 1.50 | R245-12 T3 M-KL | | | | | | | | | | | ★ | ☆ | ☆ | ☆ | | ☆ | | | | | | | | | | | | 13.4 | 10.0 | 3.97 | 2.0 |
| | | .059 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .079 |
| | ML | 12 | R245-12 T3 E-ML | ☆ | | | | | ★ | | | | | | | | | | | ☆ | | | | ★ | | | | | ☆ | | 13.4 | 10.0 | 3.97 | 2.1 |
| | | .059 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .083 |
| | PL | 12 | R245-12 T3 E-PL | ☆ | | ★ | | ☆ | | | | ☆ | ☆ | | | | | | | ☆ | ☆ | | | ☆ | | ★ | ☆ | ★ | ☆ | ☆ | 13.4 | 10.0 | 3.97 | 2.1 |
| | | .059 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .083 |
| | | 1.50 | R245-12 T3 M-PL | ☆ | ☆ | ★ | ☆ | | | | | ☆ | | | | | | | | ☆ | | | | ☆ | | ★ | ☆ | ★ | ☆ | | 13.4 | 10.0 | 3.97 | 2.0 |
| | | .059 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .080 |
| Medium | KM | 12 | R245-12 T3 M-KM | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | ☆ | | | | ★ | | ☆ | | | | | | 13.4 | 10.0 | 3.97 | 2.0 |
| | | .059 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .079 |
| | | 18 | R245-18 T6 M-KM | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | ☆ | | | | | | | | | | | | 18.0 | 13.9 | 6.10 | 1.5 |
| | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .709 | .547 | .240 | .059 |
| | MM | 12 | R245-12 T3 K-MM | | | | | | ★ | | | ☆ | | | | | | | ☆ | | | | | | | ★ | ☆ | | | | 13.4 | 10.0 | 3.97 | 2.1 |
| | | .059 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .083 |
| | | 18 | R245-18 T6 M-MM | | | | | | | ☆ | ★ | | | | | | | | | | | | | | | | | | | | 18.0 | 13.9 | 6.10 | 1.5 |
| | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .709 | .547 | .240 | .059 |
| | PM | 12 | R245-12 T3 M-PM | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | | | | | | | ☆ | ☆ | | | ☆ | | | | ★ | ☆ | ☆ | 13.4 | 10.0 | 3.97 | 2.0 |
| | | .059 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .080 |
| | | 18 | R245-18 T6 M-PM | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | | | | | ☆ | | | | ☆ | | | | ★ | ☆ | | 18.0 | 13.9 | 6.10 | 1.5 |
| | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .709 | .547 | .240 | .059 |
| Heavy | KH | 12 | R245-12 T3 M-KH | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | ☆ | | | | | | | | | | | | 13.4 | 10.0 | 3.97 | 2.0 |
| | | .059 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .394 | .156 | .079 |
| | PH | 12 | R245-12 T3 M-PH | | | ☆ | ★ | ☆ | | | | | | | | | | | | | | | | | | | | | | | 13.4 | 9.8 | 3.97 | 1.5 |
| | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .528 | .386 | .156 | .060 |

KRINS 45°





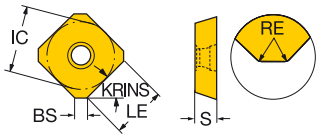

| | | RE | Ordering code | P | | | M | K | | | | | N | | | | S | | H | | | | Dimensions, mm, inch | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1010 | 1130 | 530 | 530 | 1020 | 3220 | 3330 | CB50 | H13A | K15W | H10 | 1130 | 530 | H13A | 1130 | H13A | 1010 | 1130 | 530 | CB50 | IC | LE | S | BS | BSR |
| Light | W | 12 | 2.50 | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 13.4 | 3.5 | 3.97 | 6.4 | 400.0 |
| | | .098 | R245-12 T3 E-W | | | | | | | | | | | | | | | | | | | | | .528 | .138 | .156 | .252 | 15.748 |
| | | 18 | 1.00 | | ☆ | | | ☆ | | | | | | | ☆ | | | ☆ | | | ☆ | | | 18.0 | 13.9 | 6.10 | 10.8 | 500.0 |
| | | .039 | R245-18 T6 E-W | | | | | | | | | | | | | | | | | | | | | .709 | .547 | .240 | .425 | 19.685 |

I11 I222 I254 N22 N10 N2

# CoroMill® 245 insert for milling

**Advanced cutting materials**

KRINS 45°




| | RE | | Ordering code | K 6190 | K CB50 | N CD10 | H 6190 | H CB50 | Dimensions, mm, inch IC | LE | S | BS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Light | 12 | 1.50 | R245-12 T3 E | | ☆ | ★ | | ☆ | 13.4 | 3.5 | 3.97 | 1.4 |
| | | .059 | | | | | | | .528 | .138 | .156 | .055 |
| | | 2.50 | R245-12 T3 E1 | ☆ | | | ☆ | | 13.4 | 10.0 | 3.97 | 0.4 |
| | | .098 | | | | | | | .528 | .394 | .156 | .016 |

I11 I222 I254 N22 N10



SANDVIK Coromant

# 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

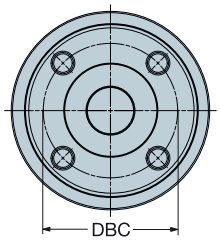
CoroMill® 425 is designed to allow for easily adjustable wiper inserts. You can adjust the wiper insert up and down without loosening the cartridge clamping screw.
Thanks to the design, the adjustment system is very stable and accurate.

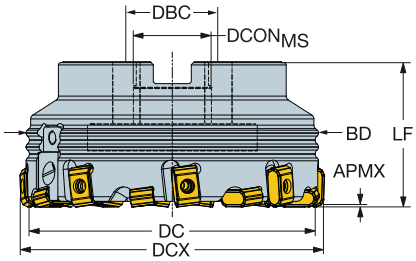
I18 I20

# CoroMill® 425 face milling cutter

**Arbor**

KAPR 25°




## Metric version

| 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 |

## Inch version

| DC | | CZC$_{MS}$ | APMX | ZADJ | | Ordering code | Dimensions, inch DCON$_{MS}$ | ISO | DBC | DCX | BD | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 4.000 | 17 | 1 1/2 | .035 | 2 | 12 | **A425-102R38-17H** | 1.500 | A | | 4.276 | 4.075 | 2.480 | 2.2 | 7.23 | 4700 | 12 | 425N-1707 |
| 5.000 | 17 | 1 1/2 | .035 | 2 | 16 | **A425-127R38-17H** | 1.500 | B | | 5.276 | 5.063 | 2.480 | 2.2 | 7.88 | 3760 | 16 | 425N-1707 |
| 6.000 | 17 | 1 1/2 | .035 | 3 | 18 | **A425-152R38-17H** | 1.500 | B | | 6.276 | 6.055 | 2.480 | 2.2 | 10.04 | 3130 | 18 | 425N-1707 |
| 8.000 | 17 | 2 1/2 | .035 | 3 | 24 | **A425-203R63-17H** | 2.500 | C | 4.000 | 8.276 | 8.043 | 2.480 | 2.2 | 17.48 | 2350 | 24 | 425N-1707 |
| 10.000 | 17 | 2 1/2 | .035 | 6 | 30 | **A425-254R63-17H** | 2.500 | C | 4.000 | 10.276 | 10.043 | 2.480 | 2.2 | 29.54 | 1880 | 30 | 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 the complete list of spare parts, visit www.sandvik.coromant.com

I20

L2

M1

N22

N9

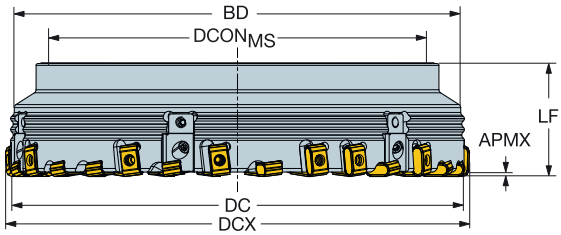


SANDVIK Coromant

# CoroMill® 425 face milling cutter

## Cap coupling

KAPR 25°




### Metric version

| 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 |

### Inch version

| DC | | CZC$_{MS}$ | APMX | ZADJ | | Ordering code | Dimensions, inch DCON$_{MS}$ | DCX | BD | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 10.000 | 17 | 250 | .035 | 6 | 30 | A425-254P-17H | 8.018 | 10.276 | 10.043 | 2.480 | 2.2 | 22.21 | 1880 | 30 | 425N-1707 |
| | 17 | 250 | .035 | 6 | 30 | LA425-254P-17H | 8.018 | 10.276 | 10.043 | 2.480 | 2.2 | 22.21 | 1880 | 30 | 425N-1707 |
| 12.000 | 17 | 315 | .035 | 6 | 36 | A425-305P-17H | 10.577 | 12.276 | 12.043 | 2.480 | 2.2 | 26.84 | 1570 | 36 | 425N-1707 |
| | 17 | 315 | .035 | 6 | 36 | LA425-305P-17H | 10.577 | 12.276 | 12.043 | 2.480 | 2.2 | 26.84 | 1570 | 36 | 425N-1707 |
| 16.000 | 17 | 400 | .035 | 9 | 54 | A425-406P-17H | 13.923 | 16.276 | 16.043 | 2.480 | 2.2 | 46.90 | 1170 | 54 | 425N-1707 |
| | 17 | 400 | .035 | 9 | 54 | LA425-406P-17H | 13.923 | 16.276 | 16.043 | 2.480 | 2.2 | 46.90 | 1170 | 54 | 425N-1707 |
| 20.000 | 17 | 500 | .035 | 9 | 54 | A425-508P-17M | 17.860 | 20.276 | 20.043 | 2.480 | 2.2 | 72.34 | 940 | 54 | 425N-1707 |
| | 17 | 500 | .035 | 9 | 54 | LA425-508P-17M | 17.860 | 20.276 | 20.043 | 2.480 | 2.2 | 72.34 | 940 | 54 | 425N-1707 |

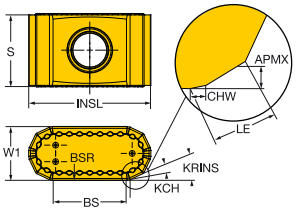
| Spare parts | | | | | |
|---|---|---|---|---|---|
| Clamping screw | Wedge | Screw | Screw | Insert screw | Cassette |
| 3212 012-260 | 5332 010-09 | 5516 035-09 | 5513 014-75 | 5513 020-13 | R425-CA-17-2 |

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

I20 L2 N22 N9

# CoroMill® 425 insert for milling

KRINS 25°




| | | | | | | K | | | | | Dimensions, mm, inch | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | KCH | CHW | Ordering code | 1010 | 1020 | 3220 | 3330 | K20W | W1 | LE | S | BS | BSR |
| Light | KLW | 17 | 14° | 0.4 | 425N-1707E-KLW12 | ★ | ☆ | ☆ | ☆ | ☆ | 7.5 | 2.1 | 10.00 | 10.4 | 1250.0 |
| | | | | *.015* | | | | | | | *.295* | *.083* | *.394* | *.411* | *49.213* |

I18 I222 I254 N22 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 (.205 inch)
- 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 (.110 inch)
- Great problem-solving abilities when machining vibration-sensitive components and in weak setups with unique differential MD pitch

**CoroMill® 745 face milling cutter See page I54**

**CoroMill® 745 high-feed face milling cutter See page I22**

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

### Differential MD pitch

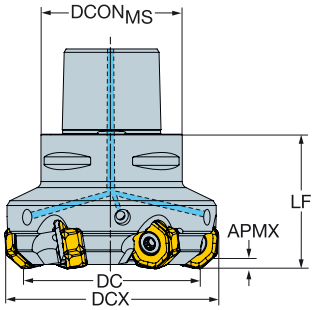
The unique differential MD pitch is First Choice in roughing operations where light cutting action is required, e.g., in vibration-sensitive and weak setups. It is a perfect problem-solver when vibration is a limitation in the production. The length and weight of the cutter body has been reduced in order 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.

I22 I56

# CoroMill® 745 face milling cutter

**Coromant Capto® - Internal coolant supply**

KAPR 42°




**Metric version**

| DC | | CZC$_{MS}$ | APMX | CNSC | | Ordering code | Dimensions, mm DCON$_{MS}$ | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 21 | C5 | 5.2 | 3 | 5 | **745-063C5-21M** | 50.0 | 78.2 | 60.0 | 12.0 | 1.30 | 5894 | 5 | 745R-2109 |
| | 21 | C6 | 5.2 | 3 | 5 | **745-063C6-21M** | 63.0 | 78.2 | 60.0 | 12.0 | 1.84 | 5894 | 5 | 745R-2109 |
| | 21 | C5 | 5.2 | 3 | 7 | **745-063C5-21H** | 50.0 | 78.2 | 60.0 | 12.0 | 1.34 | 5894 | 7 | 745R-2109 |
| | 21 | C6 | 5.2 | 3 | 7 | **745-063C6-21H** | 63.0 | 78.2 | 60.0 | 12.0 | 1.66 | 5894 | 7 | 745R-2109 |
| 80.0 | 21 | C6 | 5.2 | 3 | 6 | **745-080C6-21M** | 63.0 | 95.2 | 60.0 | 12.0 | 2.21 | 5324 | 6 | 745R-2109 |
| | 21 | C8 | 5.2 | 3 | 6 | **745-080C8-21M** | 80.0 | 95.2 | 65.0 | 12.0 | 3.12 | 5324 | 6 | 745R-2109 |
| | 21 | C6 | 5.2 | 3 | 9 | **745-080C6-21H** | 63.0 | 95.2 | 60.0 | 12.0 | 2.09 | 5324 | 9 | 745R-2109 |
| | 21 | C8 | 5.2 | 3 | 9 | **745-080C8-21H** | 80.0 | 95.2 | 65.0 | 12.0 | 3.23 | 5324 | 9 | 745R-2109 |
| 100.0 | 21 | C8 | 5.2 | 3 | 7 | **745-100C8-21M** | 80.0 | 115.2 | 65.0 | 12.0 | 3.66 | 4765 | 7 | 745R-2109 |
| | 21 | C8 | 5.2 | 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 | |

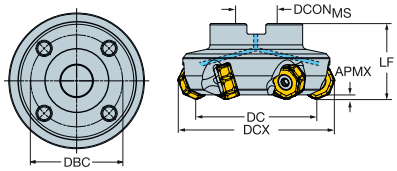
For the complete list of spare parts, visit www.sandvik.coromant.com

I56 L2 N22 N9 N15

# CoroMill® 745 face milling cutter

**Arbor - Internal coolant supply**

STDNO ISO 6462:2011
KAPR 42°




## Metric version

| DC | | CZC$_{MS}$ | APMX | CNSC | | | Ordering code | Dimensions, mm DCON$_{MS}$ | ISO | DBC | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 21 | 22 | 5.2 | 3 | 5 | | 745-063Q22-21M | 22.0 | A | | 78.2 | 50.0 | 12.0 | 0.80 | 5894 | 5 | 745R-2109 |
| | 21 | 22 | 5.2 | 3 | | 5 | 745-063Q22-21MD | 22.0 | A | | 78.2 | 46.0 | 12.0 | 0.83 | 5894 | 5 | 745R-2109 |
| | 21 | 22 | 5.2 | 3 | 7 | | 745-063Q22-21H | 22.0 | A | | 78.2 | 50.0 | 12.0 | 0.98 | 5894 | 7 | 745R-2109 |
| 80.0 | 21 | 27 | 5.2 | 3 | 6 | | 745-080Q27-21M | 27.0 | A | | 95.2 | 50.0 | 12.0 | 1.48 | 5324 | 6 | 745R-2109 |
| | 21 | 27 | 5.2 | 3 | | 6 | 745-080Q27-21MD | 27.0 | A | | 95.2 | 48.0 | 12.0 | 1.38 | 5324 | 6 | 745R-2109 |
| | 21 | 27 | 5.2 | 3 | 9 | | 745-080Q27-21H | 27.0 | A | | 95.2 | 50.0 | 12.0 | 1.37 | 5324 | 9 | 745R-2109 |
| 100.0 | 21 | 32 | 5.2 | 3 | 7 | | 745-100Q32-21M | 32.0 | A | | 115.2 | 50.0 | 12.0 | 2.19 | 4765 | 7 | 745R-2109 |
| | 21 | 32 | 5.2 | 3 | | 7 | 745-100Q32-21MD | 32.0 | A | | 115.2 | 50.0 | 12.0 | 2.12 | 4765 | 7 | 745R-2109 |
| | 21 | 32 | 5.2 | 3 | 11 | | 745-100Q32-21H | 32.0 | A | | 115.2 | 50.0 | 12.0 | 2.01 | 4765 | 11 | 745R-2109 |
| 125.0 | 21 | 40 | 5.2 | 3 | 8 | | 745-125Q40-21M | 40.0 | B | | 140.2 | 63.0 | 12.0 | 3.75 | 4216 | 8 | 745R-2109 |
| | 21 | 40 | 5.2 | 3 | | 8 | 745-125Q40-21MD | 40.0 | B | | 140.2 | 54.0 | 12.0 | 2.95 | 4216 | 8 | 745R-2109 |
| | 21 | 40 | 5.2 | 3 | 14 | | 745-125Q40-21H | 40.0 | B | | 140.2 | 63.0 | 12.0 | 3.53 | 4216 | 14 | 745R-2109 |
| 160.0 | 21 | 40 | 5.2 | 3 | 10 | | 745-160Q40-21M | 40.0 | B | | 175.2 | 63.0 | 12.0 | 5.26 | 3675 | 10 | 745R-2109 |
| | 21 | 40 | 5.2 | 3 | | 10 | 745-160Q40-21MD | 40.0 | B | | 175.2 | 60.0 | 12.0 | 4.70 | 3675 | 10 | 745R-2109 |
| | 21 | 40 | 5.2 | 3 | 16 | | 745-160Q40-21H | 40.0 | B | | 175.2 | 63.0 | 12.0 | 4.75 | 3675 | 16 | 745R-2109 |
| 200.0 | 21 | 60 | 5.2 | 0 | 14 | | 745-200Q60-21M | 60.0 | C | 101.6 | 215.2 | 63.0 | 12.0 | 6.31 | 3292 | 14 | 745R-2109 |
| | 21 | 60 | 5.2 | 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 | 5.2 | 0 | 16 | | 745-250Q60-21M | 60.0 | C | 101.6 | 264.4 | 63.0 | 12.0 | 9.40 | 2998 | 16 | 745R-2109 |
| | 21 | 60 | 5.2 | 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 |

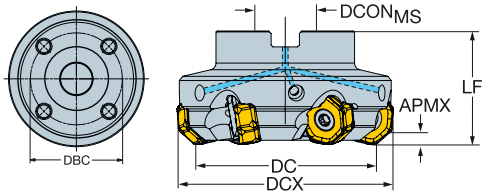
For the complete list of spare parts, visit www.sandvik.coromant.com

I56 L2 M1 N22 N9 N15

# CoroMill® 745 face milling cutter

**Arbor - Internal coolant supply**

STDNO ISO 6462:2011
KAPR 42°




## Inch version

| DC | | CZC$_{MS}$ | APMX | CNSC | | | Ordering code | Dimensions, inch DCON$_{MS}$ | ISO | DBC | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.500 | 21 | 1 | .205 | 3 | 5 | | A745-063R25-21M | 1.000 | A | | 3.098 | 1.969 | 8.8 | 2.68 | 5875 | 5 | 745R-2109 |
| | 21 | 1 | .205 | 3 | | 5 | A745-063R25-21MD | 1.000 | A | | 3.098 | 1.811 | 8.8 | 1.85 | 5875 | 5 | 745R-2109 |
| | 21 | 1 | .205 | 3 | 7 | | A745-063R25-21H | 1.000 | A | | 3.098 | 1.969 | 8.8 | 2.34 | 5875 | 7 | 745R-2109 |
| 3.000 | 21 | 1 | .205 | 3 | 6 | | A745-076R25-21M | 1.000 | A | | 3.598 | 1.969 | 8.8 | 3.21 | 5443 | 6 | 745R-2109 |
| | 21 | 1 | .205 | 3 | | 6 | A745-076R25-21MD | 1.000 | A | | 3.598 | 1.969 | 8.8 | 3.01 | 5443 | 6 | 745R-2109 |
| | 21 | 1 | .205 | 3 | 9 | | A745-076R25-21H | 1.000 | A | | 3.598 | 1.969 | 8.8 | 2.73 | 5443 | 9 | 745R-2109 |
| 3.150 | 21 | 1 | .205 | 3 | 6 | | A745-080J25-21M | 1.000 | A | | 3.748 | 1.969 | 8.8 | 3.20 | 5324 | 6 | 745R-2109 |
| | 21 | 1 | .205 | 3 | 9 | | A745-080J25-21H | 1.000 | A | | 3.748 | 1.969 | 8.8 | 2.77 | 5324 | 9 | 745R-2109 |
| 3.937 | 21 | 1 1/4 | .205 | 3 | 7 | | A745-100J31-21M | 1.250 | A | | 4.535 | 2.244 | 8.8 | 5.05 | 4765 | 7 | 745R-2109 |
| | 21 | 1 1/4 | .205 | 3 | 11 | | A745-100J31-21H | 1.250 | A | | 4.535 | 2.244 | 8.8 | 4.70 | 4765 | 11 | 745R-2109 |
| 4.000 | 21 | 1 1/2 | .205 | 3 | 7 | | A745-102R38-21M | 1.500 | A | | 4.598 | 2.480 | 8.8 | 6.08 | 4725 | 7 | 745R-2109 |
| | 21 | 1 1/2 | .205 | 3 | | 7 | A745-102R38-21MD | 1.500 | A | | 4.598 | 2.362 | 8.8 | 4.76 | 4725 | 7 | 745R-2109 |
| | 21 | 1 1/2 | .205 | 3 | 11 | | A745-102R38-21H | 1.500 | A | | 4.598 | 2.480 | 8.8 | 5.67 | 4725 | 11 | 745R-2109 |
| 4.921 | 21 | 1 1/2 | .205 | 0 | 8 | | A745-125J38-21M | 1.500 | B | | 5.520 | 2.480 | 8.8 | 8.27 | 4216 | 8 | 745R-2109 |
| | 21 | 1 1/2 | .205 | 0 | 14 | | A745-125J38-21H | 1.500 | B | | 5.520 | 2.480 | 8.8 | 8.02 | 4216 | 14 | 745R-2109 |
| 5.000 | 21 | 1 1/2 | .205 | 3 | 8 | | A745-127R38-21M | 1.500 | B | | 5.598 | 2.480 | 8.8 | 7.34 | 4178 | 8 | 745R-2109 |
| | 21 | 1 1/2 | .205 | 3 | | 8 | A745-127R38-21MD | 1.500 | B | | 5.598 | 2.126 | 8.8 | 7.36 | 4178 | 8 | 745R-2109 |
| | 21 | 1 1/2 | .205 | 3 | 14 | | A745-127R38-21H | 1.500 | B | | 5.598 | 2.480 | 8.8 | 7.72 | 4178 | 14 | 745R-2109 |
| 6.000 | 21 | 1 1/2 | .205 | 3 | 10 | | A745-152R38-21M | 1.500 | B | | 6.591 | 2.480 | 8.8 | 9.35 | 3773 | 10 | 745R-2109 |
| | 21 | 1 1/2 | .205 | 3 | | 10 | A745-152R38-21MD | 1.500 | B | | 6.598 | 2.362 | 8.8 | 9.35 | 3773 | 10 | 745R-2109 |
| | 21 | 1 1/2 | .205 | 3 | 16 | | A745-152R38-21H | 1.500 | B | | 6.598 | 2.480 | 8.8 | 8.71 | 3773 | 16 | 745R-2109 |
| 6.299 | 21 | 2 | .205 | 0 | 10 | | A745-160J51-21M | 2.000 | B | | 6.898 | 2.480 | 8.8 | 11.79 | 3675 | 10 | 745R-2109 |
| | 21 | 2 | .205 | 0 | 16 | | A745-160J51-21H | 2.000 | B | | 6.898 | 2.480 | 8.8 | 11.30 | 3675 | 16 | 745R-2109 |
| 7.874 | 21 | 1 7/8 | .205 | 0 | 14 | | A745-200J47-21M | 1.875 | C | 2.626 | 8.472 | 2.480 | 8.8 | 16.42 | 3292 | 14 | 745R-2109 |
| | 21 | 1 7/8 | .205 | 0 | 21 | | A745-200J47-21H | 1.875 | C | 2.626 | 8.472 | 2.480 | 8.8 | 15.81 | 3292 | 21 | 745R-2109 |
| 8.000 | 21 | 2 1/2 | .205 | 0 | 14 | | A745-203R63-21M | 2.500 | C | 4.000 | 8.598 | 2.480 | 8.8 | 13.85 | 3296 | 14 | 745R-2109 |
| | 21 | 2 1/2 | .205 | 0 | 21 | | A745-203R63-21H | 2.500 | C | 4.000 | 8.598 | 2.480 | 8.8 | 13.21 | 3296 | 21 | 745R-2109 |
| 9.843 | 21 | 1 7/8 | .205 | 0 | 16 | | A745-250J47-21M | 1.875 | C | 2.626 | 10.409 | 2.480 | 8.8 | 31.35 | 2998 | 16 | 745R-2109 |
| | 21 | 1 7/8 | .205 | 0 | 26 | | A745-250J47-21H | 1.875 | C | 2.626 | 10.409 | 2.480 | 8.8 | 31.04 | 2998 | 26 | 745R-2109 |
| 10.000 | 21 | 2 1/2 | .205 | 0 | 16 | | A745-254R63-21M | 2.500 | C | 4.000 | 10.567 | 2.480 | 8.8 | 21.30 | 2997 | 16 | 745R-2109 |
| | 21 | 2 1/2 | .205 | 0 | 26 | | A745-254R63-21H | 2.500 | C | 4.000 | 10.567 | 2.480 | 8.8 | 30.16 | 2997 | 26 | 745R-2109 |

| | Spare parts | |
|---|---|---|
| DC | Shower screw | Insert screw |
| 2.500 | 5512 074-02 | 5513 020-80 |
| 3.000 | 5513-074-02 | 5513 020-80 |
| 4.000 | 5512-074-05 | 5513 020-80 |
| 5.000-6.000 | 5512-099-03 | 5513 020-80 |
| 8.000-10.000 | | 5513 020-80 |

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

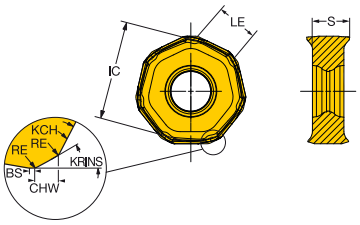
I56 L2 M1 N22 N9 N15



SANDVIK Coromant

# CoroMill® 745 insert for milling

KRINS 42°




| | | | RE | KCH | CHW | Ordering code | P 1130 | P 4220 | P 4230 | P 4240 | K 1020 | K 3040 | K 20D | K 20W | 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 |
| | | | .039 | | .051 | | | | | | | | | | .827 | .350 | .354 | .012 | .984 |
| | M50 | 21 | 1.00 | 17° | 1.3 | 745L-2109E-M50 | | | ★ | | | | ☆ | ☆ | 21.0 | 8.5 | 9.00 | 0.3 | 25.0 |
| | | | .039 | | .051 | | | | | | | | | | .827 | .335 | .354 | .013 | .984 |
| | | | 1.00 | 17° | 1.3 | 745R-2109E-M50 | ★ | ☆ | ★ | ☆ | | ★ | ☆ | ☆ | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| | | | .039 | | .051 | | | | | | | | | | .827 | .350 | .354 | .012 | .984 |
| Heavy | H50 | 21 | 1.00 | 17° | 1.3 | 745R-2109E-H50 | | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| | | | .039 | | .051 | | | | | | | | | | .827 | .350 | .354 | .012 | .984 |

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

I54 I222 I254 N22 N10

# CoroMill® 360

## Heavy duty face mill

**ISO application area:**

P M K

### Application

- Heavy-duty face milling

### Benefits and features

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

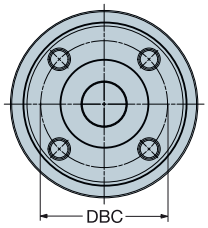
The unique cassette solution with wedge-clamped inserts ensures high security and easy handling when indexing inserts. The same body is used for both cassette sizes. There are separate wedges and cassettes for each insert size. During replacement, ensure you have the correct sizes of both.

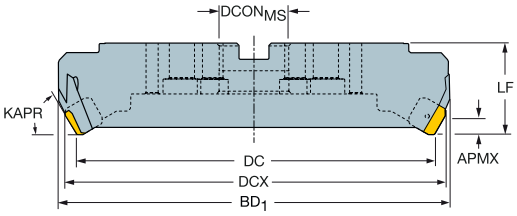
I27

# CoroMill® 360 face milling cutter

**Arbor**

STDNO ISO6462
KAPR 60°




## Metric version

| DC | | CZC$_{MS}$ | APMX | ZADJ | | | Ordering code | Dimensions, mm DCON$_{MS}$ | ISO | DBC | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 |

## Inch version

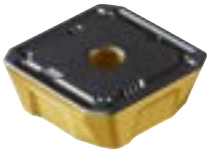
| DC | | CZC$_{MS}$ | APMX | ZADJ | | | Ordering code | Dimensions, inch DCON$_{MS}$ | ISO | DBC | DCX | BD | LB | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6.000 | 19 | 1 1/2 | .512 | 6 | | 6 | A360-152R38-Z6D19 | 1.500 | B | | 6.591 | 7.047 | .512 | 3.150 | 11.8 | 10.80 | 840 | 6 | 360R-1906 |
| | 19 | 1 1/2 | .512 | 8 | 8 | | A360-152R38-Z8E19 | 1.500 | B | | 6.591 | 7.047 | .512 | 3.150 | 11.8 | 21.52 | 840 | 8 | 360R-1906 |
| | 28 | 1 1/2 | .709 | 8 | 8 | | A360-152R38-Z8E28 | 1.500 | B | | 6.819 | 7.032 | .709 | 3.150 | 11.8 | 20.68 | 840 | 8 | 360R-2807 |
| 8.000 | 19 | 2 1/2 | .512 | 8 | | 8 | A360-203R63-Z8D19 | 2.500 | C | 4.000 | 8.591 | 9.047 | .512 | 3.150 | 11.8 | 42.15 | 630 | 8 | 360R-1906 |
| | 19 | 2 1/2 | .512 | 10 | 10 | | A360-203R63-Z10E19 | 2.500 | C | 4.000 | 8.591 | 9.047 | .512 | 3.150 | 11.8 | 41.62 | 630 | 10 | 360R-1906 |
| | 28 | 2 1/2 | .709 | 10 | 10 | | A360-203R63-Z10E28 | 2.500 | C | 4.000 | 8.819 | 9.032 | .709 | 3.150 | 11.8 | 41.23 | 630 | 10 | 360R-2807 |
| 10.000 | 19 | 2 1/2 | .512 | 10 | | 10 | A360-254R63-Z10D19 | 2.500 | C | 4.000 | 10.591 | 11.047 | .512 | 3.150 | 11.8 | 55.60 | 500 | 10 | 360R-1906 |
| | 19 | 2 1/2 | .512 | 12 | 12 | | A360-254R63-Z12E19 | 2.500 | C | 4.000 | 10.591 | 11.047 | .512 | 3.150 | 11.8 | 57.06 | 500 | 12 | 360R-1906 |
| | 28 | 2 1/2 | .709 | 10 | | 10 | A360-254R63-Z10D28 | 2.500 | C | 4.000 | 10.819 | 11.032 | .709 | 3.150 | 11.8 | 57.32 | 500 | 10 | 360R-2807 |
| | 28 | 2 1/2 | .709 | 12 | 12 | | A360-254R63-Z12E28 | 2.500 | C | 4.000 | 10.819 | 11.032 | .709 | 3.150 | 11.8 | 55.56 | 500 | 12 | 360R-2807 |
| 12.000 | 19 | 2 1/2 | .512 | 15 | 15 | | A360-305R63-Z15E19 | 2.500 | C | | 12.591 | 13.047 | .512 | 3.150 | 11.8 | 82.06 | 420 | 15 | 360R-1906 |
| | 28 | 2 1/2 | .709 | 12 | | 12 | A360-305R63-Z12D28 | 2.500 | C | | 12.819 | 13.032 | .709 | 3.150 | 11.8 | 82.23 | 420 | 12 | 360R-2807 |
| 16.000 | 19 | 2 1/2 | .512 | 15 | | 15 | A360-406R63-Z15D19 | 2.500 | C | | 16.591 | 17.047 | .512 | 3.150 | 11.8 | 126.26 | 315 | 15 | 360R-1906 |
| | 28 | 2 1/2 | .709 | 15 | | 15 | A360-406R63-Z15D28 | 2.500 | C | | 16.819 | 17.032 | .709 | 3.150 | 11.8 | 110.89 | 315 | 15 | 360R-2807 |

| | | | Spare parts | | | | |
|---|---|---|---|---|---|---|---|
| DC | DC" | SSC | Cassette | Insert wedge | Insert wedge screw | Cassette wedge | Cassette wedge screw |
| 152.00-315.00 | 6.000-12.401 | 19 | 360R-CA-19 | 360R-IW-19 | 267.21-830 | 5431 105-08 | 5516 010-06 |
| 152.00-400.00 | 6.000-15.748 | 28 | 360R-CA-28 | 360R-IW-28 | 267.21-830 | 5431 105-08 | 5516 010-06 |

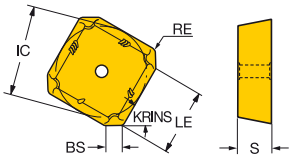
For the complete list of spare parts, visit www.sandvik.coromant.com

I28 L2 M1 N22 N9

# CoroMill® 360 insert for milling



KRINS 60°




| | | SSC | RE | Ordering code | P 4220 | P 4330 | P 4340 | M 2030 | M 2040 | K 3040 | K 3330 | Dimensions, mm, inch IC | LE | S | BS | BSR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Heavy | KH | 19 | 1.60 | 360R-19 06M-KH | | | | | | ☆ | ★ | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 |
| | | | .063 | | | | | | | | | .746 | .591 | .250 | .087 | 7.874 |
| | | 28 | 1.70 | 360L-2807M-KH | | | | | | ★ | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | | | .067 | | | | | | | | | 1.121 | .787 | .313 | .181 | 7.874 |
| | | | 1.70 | 360R-28 07M-KH | | | | | | ☆ | ★ | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | | | .067 | | | | | | | | | 1.121 | .787 | .313 | .181 | 7.874 |
| | MH | 19 | 1.60 | 360L-1906M-MH | | | | | ★ | | | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 |
| | | | .063 | | | | | | | | | .746 | .591 | .250 | .087 | 7.874 |
| | | | 1.60 | 360R-19 06M-MH | | | | ☆ | ★ | | | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 |
| | | | .063 | | | | | | | | | .746 | .591 | .250 | .087 | 7.874 |
| | | 28 | 1.70 | 360L-2807M-MH | | | | | ★ | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | | | .067 | | | | | | | | | 1.121 | .787 | .313 | .181 | 7.874 |
| | | | 1.70 | 360R-28 07M-MH | | | | | ★ | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | | | .067 | | | | | | | | | 1.121 | .787 | .313 | .181 | 7.874 |
| | PH | 19 | 1.60 | 360L-1906M-PH | | ★ | | | | | | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 |
| | | | .063 | | | | | | | | | .746 | .591 | .250 | .087 | 7.874 |
| | | | 1.60 | 360R-19 06M-PH | ☆ | ★ | ☆ | | | | | 18.9 | 15.0 | 6.35 | 2.2 | 200.0 |
| | | | .063 | | | | | | | | | .746 | .591 | .250 | .087 | 7.874 |
| | | 28 | 1.70 | 360L-2807M-PH | | ★ | | | | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | | | .067 | | | | | | | | | 1.121 | .787 | .313 | .181 | 7.874 |
| | | | 1.70 | 360R-28 07M-PH | | ★ | ☆ | | | | | 28.5 | 20.0 | 7.94 | 4.6 | 200.0 |
| | | | .067 | | | | | | | | | 1.121 | .787 | .313 | .181 | 7.874 |

I27 I222 I254 N22 N10

# 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, achieving low cost per component
- Multi-edge, self-located insert enables 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 a high metal removal rate is critical.

### Inserts

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

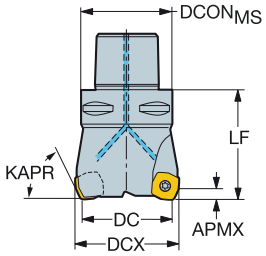
I30

# CoroMill® 365 face milling cutter

**Coromant Capto®**

**Screw clamp design**

STDNO ISO26623-1
KAPR 65°




## Metric version

| 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 |

## Inch version

| DC | | CZCMS | APMX | CNSC | | Ordering code | Dimensions, inch DCONMS | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.000 | 15 | C5 | .236 | 3 | 4 | RA365-051C5-S15M | 1.969 | 2.264 | 2.362 | 2.2 | 2.87 | 15700 | 4 | R365-1505ZNE |

| Spare parts | |
|---|---|
| Screw | |
| 5513 020-29 | |

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

I34 L2 N22 N15 N9

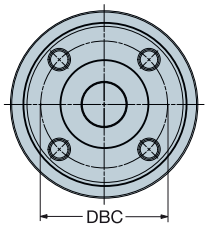
# CoroMill® 365 face milling cutter

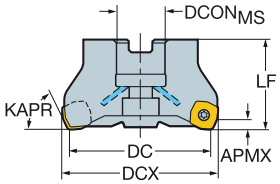
**Arbor**

**Screw clamp design**

STDNO
KAPR

ISO6462
65°




## Metric version

| DC | | $CZC_{MS}$ | APMX | CNSC | | | Ordering code | $DCON_{MS}$ | ISO | DBC | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Dimensions, mm | | | | | | | | | |
| 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 |

## Inch version

| DC | | $CZC_{MS}$ | APMX | CNSC | | | Ordering code | $DCON_{MS}$ | ISO | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | Dimensions, inch | | | | | | | | |
| 2.000 | 15 | 3/4 | .236 | 1 | 5 | | RA365-051R19-S15H | .750 | A | 2.264 | 1.969 | 2.2 | 1.73 | 15700 | 5 | R365-1505ZNE |
| 2.500 | 15 | 3/4 | .236 | 1 | | 5 | RA365-063R19-S15M | .750 | A | 2.764 | 1.969 | 2.2 | 2.30 | 13500 | 5 | R365-1505ZNE |
| | 15 | 3/4 | .236 | 1 | 6 | | RA365-063R19-S15H | .750 | A | 2.764 | 1.969 | 2.2 | 2.16 | 13500 | 6 | R365-1505ZNE |
| 3.000 | 15 | 1 | .236 | 1 | | 6 | RA365-076R25-S15M | 1.000 | A | 3.264 | 1.969 | 2.2 | 3.51 | 11900 | 6 | R365-1505ZNE |
| | 15 | 1 | .236 | 1 | 8 | | RA365-076R25-S15H | 1.000 | A | 3.264 | 1.969 | 2.2 | 3.46 | 11900 | 8 | R365-1505ZNE |
| 4.000 | 15 | 1 1/2 | .236 | 1 | | 7 | RA365-102R38-S15M | 1.500 | A | 4.264 | 1.969 | 2.2 | 4.67 | 9900 | 7 | R365-1505ZNE |
| | 15 | 1 1/2 | .236 | 1 | 10 | | RA365-102R38-S15H | 1.500 | A | 4.264 | 1.969 | 2.2 | 4.54 | 9900 | 10 | R365-1505ZNE |
| 5.000 | 15 | 1 1/2 | .236 | 0 | | 8 | RA365-127R38-S15M | 1.500 | B | 5.264 | 2.480 | 2.2 | 8.88 | 8800 | 8 | R365-1505ZNE |
| | 15 | 1 1/2 | .236 | 0 | 12 | | RA365-127R38-S15H | 1.500 | B | 5.264 | 2.480 | 2.2 | 8.69 | 8800 | 12 | R365-1505ZNE |
| 6.000 | 15 | 1 1/2 | .236 | 0 | | 10 | RA365-152R38-S15M | 1.500 | B | 6.264 | 2.480 | 2.2 | 13.27 | 7900 | 10 | R365-1505ZNE |
| | 15 | 1 1/2 | .236 | 0 | 14 | | RA365-152R38-S15H | 1.500 | B | 6.264 | 2.480 | 2.2 | 13.25 | 7900 | 14 | R365-1505ZNE |

| Spare parts |
|---|
| Screw |
| 5513 020-29 |

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

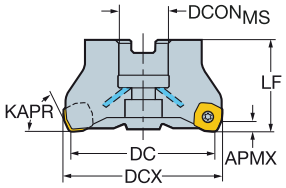
I34 L2 N22 N15 N9

# CoroMill® 365 face milling cutter

**Arbor**

**Screw clamp design**

KAPR 65°




**CIS version**

| DC | | CZC$_{MS}$ | APMX | CNSC | | | Ordering code | Dimensions, mm DCON$_{MS}$ | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 80.0 | 15 | 1 | 6.0 | 1 | 8 | | RA365-080J25-S15H | 25.4 | 86.7 | 50.0 | 3.0 | 1.65 | 11500 | 8 | R365-1505ZNE |
| 100.0 | 15 | 1 1/4 | 6.0 | 0 | | 7 | RA365-100J31-S15M | 31.8 | 106.7 | 63.0 | 3.0 | 2.81 | 9900 | 7 | R365-1505ZNE |
| | 15 | 1 1/4 | 6.0 | 1 | 10 | | RA365-100J31-S15H | 31.8 | 106.7 | 63.0 | 3.0 | 2.76 | 9900 | 10 | R365-1505ZNE |
| 125.0 | 15 | 1 1/2 | 6.0 | 0 | | 8 | RA365-125J38-S15M | 38.1 | 131.7 | 63.0 | 3.0 | 4.19 | 8500 | 8 | R365-1505ZNE |
| | 15 | 1 1/2 | 6.0 | 1 | 12 | | RA365-125J38-S15H | 38.1 | 131.4 | 63.0 | 3.0 | 4.05 | 8500 | 12 | R365-1505ZNE |
| 160.0 | 15 | 2 | 6.0 | 0 | | 10 | RA365-160J51-S15M | 50.8 | 166.7 | 63.0 | 3.0 | 6.21 | 7500 | 10 | R365-1505ZNE |
| | 15 | 2 | 6.0 | 0 | 14 | | RA365-160J51-S15H | 50.8 | 166.7 | 63.0 | 3.0 | 6.17 | 7500 | 14 | R365-1505ZNE |

| Spare parts |
|---|
| Screw |
| 5513 020-29 |

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

I34 L2 N22 N15 N9



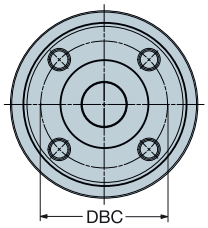
SANDVIK Coromant

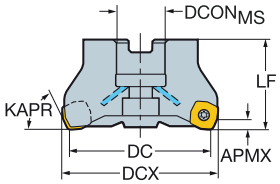
# CoroMill® 365 face milling cutter

**Arbor**

**Wedge clamp design**

STDNO ISO6462
KAPR 65°




## Metric version

| 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 |

## Inch version

| DC | | CZCMS | APMX | | Ordering code | Dimensions, inch DCONMS | ISO | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 3.000 | 15 | 1 | .236 | 10 | **RA365-076R25-W15H** | 1.000 | A | 3.264 | 1.969 | 4.4 | 3.66 | 11600 | 10 | R365-1505ZNE |
| 4.000 | 15 | 1 1/2 | .236 | 14 | **RA365-102R38-W15H** | 1.500 | A | 4.264 | 1.969 | 4.4 | 4.72 | 9800 | 14 | R365-1505ZNE |
| 5.000 | 15 | 1 1/2 | .236 | 18 | **RA365-127R38-W15H** | 1.500 | B | 5.264 | 2.480 | 4.4 | 9.14 | 8700 | 18 | R365-1505ZNE |

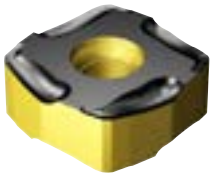
| Spare parts | |
|---|---|
| Wedge screw | Wedge |
| 339-831 | 5431 058-01 |

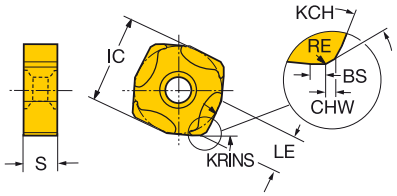
For the complete list of spare parts, visit www.sandvik.coromant.com

I34 L2 N22 N15 N9

# CoroMill® 365 insert for milling

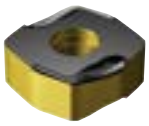
KRINS 65°



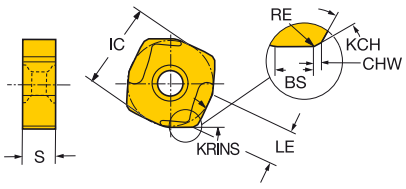



| | | | | RE | KCH | CHW | Ordering code | P | | | | M | K | | | | N | S | H | | Dimensions, mm, inch | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | 1130 | 4220 | 4330 | 1130 | 1130 | 1020 | 3330 | K20D | K20W | 1130 | 1130 | 1010 | 1130 | IC | LE | S | BS | BSR |
| Light | K | L | 15 | | 30° | 0.7 | R/L365-1505ZNE-KL | | | | | | ★ | ☆ | | | | | | | 15.0 | 6.4 | 5.66 | 1.5 | |
| | K | L | | | | .026 | | | | | | | | | | | | | | | .591 | .252 | .223 | .059 | |
| | K | L | | 0.30 | 35° | 0.7 | R365-1505ZNE-KL | | | | | | ★ | ☆ | ☆ | ☆ | | | | | 15.0 | 6.4 | 5.66 | 1.5 | 150.0 |
| | K | L | | .012 | | .028 | | | | | | | | | | | | | | | .591 | .252 | .223 | .059 | 5.906 |
| | P | L | 15 | 0.30 | 35° | 0.7 | R365-1505ZNE-PL | ☆ | | | ☆ | | | | | | ☆ | ☆ | | ☆ | 15.0 | 6.4 | 5.66 | 1.5 | 150.0 |
| | P | L | | .012 | | .028 | | | | | | | | | | | | | | | .591 | .252 | .223 | .059 | 5.906 |
| Medium | K | M | 15 | 0.30 | 35° | 0.7 | L365-1505ZNE-KM | | | | | | ☆ | ★ | ☆ | ☆ | | | | | 15.0 | 6.4 | 5.66 | 1.5 | |
| | K | M | | .012 | | .028 | | | | | | | | | | | | | | | .591 | .252 | .223 | .059 | |
| | K | M | | 0.30 | 35° | 0.7 | R365-1505ZNE-KM | | | | | | ☆ | ★ | ☆ | ☆ | | | | | 15.0 | 6.4 | 5.66 | 1.5 | 150.0 |
| | K | M | | .012 | | .028 | | | | | | | | | | | | | | | .591 | .252 | .223 | .059 | 5.906 |
| | P | M | 15 | 0.30 | 35° | 0.7 | R365-1505ZNE-PM | ☆ | ☆ | ★ | ☆ | | | | | | ☆ | ☆ | ★ | ☆ | 15.0 | 6.4 | 5.66 | 1.5 | 150.0 |
| | P | M | | .012 | | .028 | | | | | | | | | | | | | | | .591 | .252 | .223 | .059 | 5.906 |

KRINS 65°



Wiper TECHNOLOGY




| | | | RE | KCH | CHW | Ordering code | P | | M | | K | | | | H | | Dimensions, mm, inch | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | 1030 | 1130 | 1030 | 1130 | 1020 | K20W | 3220 | 3330 | 1030 | 1130 | 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 |
| | KW4 | | .022 | | .030 | | | | | | | | | | | | .591 | .252 | .223 | .157 | 7.874 |
| | KW8 | 15 | 0.20 | 35° | 0.8 | N365-1505ZNE-KW8 | | | | | ☆ | ☆ | ☆ | ☆ | | | 15.0 | 6.4 | 5.66 | 8.0 | 431.0 |
| | KW8 | | .022 | | .030 | | | | | | | | | | | | .591 | .252 | .223 | .157 | 7.874 |
| | PW4 | 15 | 0.55 | 35° | 0.8 | N365-1505ZNE-PW4 | ☆ | | ☆ | | | | | | ☆ | | 15.0 | 6.4 | 5.66 | 4.0 | 200.0 |
| | PW4 | | .008 | | .030 | | | | | | | | | | | | .591 | .252 | .223 | .315 | 16.969 |
| | PW8 | 15 | 0.20 | 35° | 0.8 | N365-1505ZNE-PW8 | | ☆ | | ☆ | | | | | | ☆ | 15.0 | 6.4 | 5.66 | 8.0 | 431.0 |
| | PW8 | | .008 | | .030 | | | | | | | | | | | | .591 | .252 | .223 | .315 | 16.969 |

I30 I222 I254 N22 N10

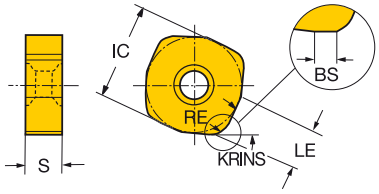


SANDVIK Coromant

# CoroMill® 365 insert for milling

**Advanced cutting materials**

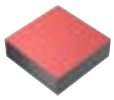
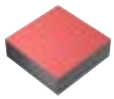
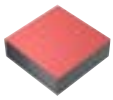
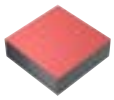
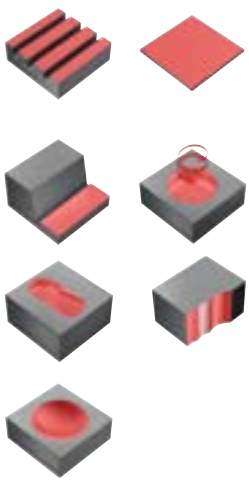
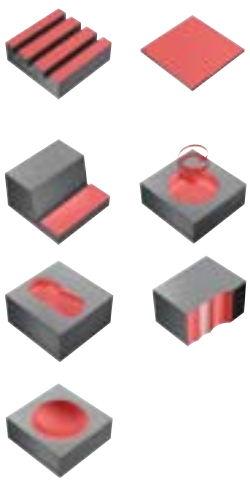
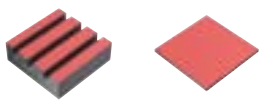
KRINS 65°




| | | RE | Ordering code | K 6190 | H 6190 | Dimensions, mm, inch IC | LE | S | BS | BSR |
|---|---|---|---|---|---|---|---|---|---|---|
| Light | 15 | 3.60 | N365-1505ZNE | ☆ | ☆ | 15.0 | 6.4 | 5.66 | 1.2 | 150.0 |
| | | *.142* | | | | *.591* | *.252* | *.223* | *.047* | *5.906* |
| Medium | 15 | 3.60 | N365-150536E | ☆ | ☆ | 15.0 | 6.4 | 5.66 | | |
| | | *.142* | | | | *.591* | *.252* | *.223* | | |

I222 I254 N22 N10

# High-feed milling tools

| | CoroMill® 419 | CoroMill® 210 | CoroMill® 415 | CoroMill® 745 |
|---|---|---|---|---|
| | | | | |
| Page | I37 | I42 | I48 | I53 |
| Material | P M K S H | P M K S H | P M S H | P K |
| Main operation |  |  |  |  |
| KAPR | 19° | 10° | 15° | 25° |
| $D_c$ mm<br>$D_c$ inch | 17.4 - 85.3<br>.673 - 3.421 | 10.9 - 136<br>.445- 5.055 | 4.6 - 23.6<br>.169 - .917 | 63 - 160<br>2.5 - 6.0 |
| DCX mm<br>DCX inch | 32.0 - 100.0<br>1.250 - 4.000 | 25 - 160<br>1000 - 6000 | 13 - 32<br>.500 - 1.250 | 86.4 - 183.4<br>3.421 - 6.921 |
| APMX mm<br>APMX inch | 2<br>.079 | 1.2 - 2<br>.047 - .079 | 0.85 - 1.2<br>.033 - .047 | 2.80<br>.110 |
| Insert | | | | |
| Insert sizes | 14 | 09 & 14 | 05 & 07 | 21 |
| Couplings | Coromant Capto®<br>Cylindrical shank<br>Arbor | Coromant Capto®<br>Cylindrical shank<br>Arbor<br>Threaded coupling<br>Weldon | Cylindrical shank<br>Coromant EH<br>Threaded coupling | Coromant Capto®<br>Arbor |
| Internal coolant | ✓ | ✓ | ✓ | ✓ |
| Options | | | iLock | |
| Other operations | |  |  |  |



SANDVIK Coromant

# CoroMill® 419

## High-feed milling cutter

### Application

- High feed facemilling
- 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 milling and radius inserts for pocketing
- Wide range of grades and geometries

Coarse pitch Close pitch Extra close pitch

Face milling

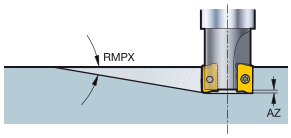
Face and Profile Milling

I38 I41 N6

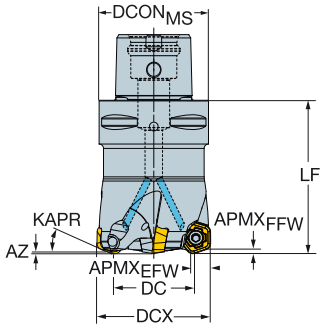
# CoroMill® 419 face milling cutter

**Coromant Capto® - Internal coolant supply**

**High-feed milling cutter**




KAPR 19°




## Metric version

| 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 |

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | Ordering code | Dimensions, inch DCONMS | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .925 | 14 | C3 | .315 | .079 | 9° | .079 | 3 | 3 | A419-038C3-14M | 1.260 | 1.500 | 1.969 | 3.6 | 0.86 | 21400 | 3 | 419R-1405 |
| 1.421 | 14 | C5 | .315 | .079 | 8° | .079 | 3 | 4 | A419-051C5-14M | 1.969 | 2.000 | 2.756 | 3.6 | 2.55 | 17300 | 4 | 419R-1405 |
| 1.902 | 14 | C5 | .315 | .079 | 7° | .079 | 3 | 5 | A419-063C5-14M | 1.969 | 2.500 | 2.756 | 3.6 | 2.63 | 15100 | 5 | 419R-1405 |

| Spare parts |
|---|
| Insert screw |
| 5513 020-78 |

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

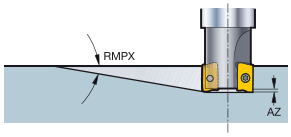
I41 L2 N22 N6 N9 N15

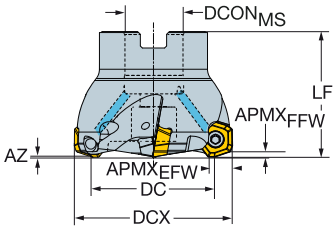
# CoroMill® 419 face milling cutter

**Arbor - Internal coolant supply**

**High-feed milling cutter**

KAPR 19°




## Metric version

| 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 |

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | ISO | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.421 | 14 | 3/4 | .315 | .079 | 8° | .079 | 1 | | 4 | A419-051R19-14M | .750 | A | 2.000 | 1.750 | 3.6 | 1.02 | 17300 | 4 | 419R-1405 |
| 1.902 | 14 | 3/4 | .315 | .079 | 7° | .079 | 1 | | 4 | A419-063R19-14L | .750 | A | 2.500 | 1.969 | 3.6 | 1.47 | 15100 | 4 | 419R-1405 |
| | 14 | 3/4 | .315 | .079 | 7° | .079 | 1 | | 5 | A419-063R19-14M | .750 | A | 2.500 | 1.969 | 3.6 | 1.66 | 15100 | 5 | 419R-1405 |
| 2.421 | 14 | 1 | .315 | .079 | 5° | .079 | 1 | | 5 | A419-076R25-14M | 1.000 | A | 3.000 | 1.969 | 3.6 | 2.26 | 13400 | 5 | 419R-1405 |
| | 14 | 1 | .315 | .079 | 5° | .079 | 1 | 6 | | A419-076R25-14H | 1.000 | A | 3.000 | 1.969 | 3.6 | 2.22 | 13400 | 6 | 419R-1405 |
| 3.421 | 14 | 1 1/2 | .315 | .079 | 0° | .039 | 1 | | 6 | A419-102R38-14M | 1.500 | B | 4.000 | 1.969 | 3.6 | 3.46 | 11300 | 6 | 419R-1405 |
| | 14 | 1 1/2 | .315 | .079 | 0° | .039 | 1 | 7 | | A419-102R38-14H | 1.500 | B | 4.000 | 1.969 | 3.6 | 3.13 | 11300 | 7 | 419R-1405 |

| Spare parts | |
|---|---|
| Insert screw | |
| 5513 020-78 | |

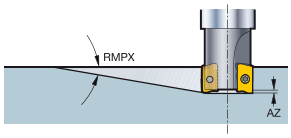
For the complete list of spare parts, visit www.sandvik.coromant.com

I41 L2 M1 N22 N6 N9 N15

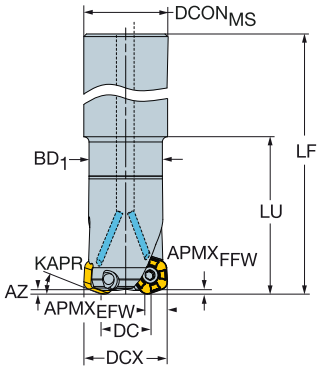
# CoroMill® 419 face milling cutter

**Cylindrical shank - Internal coolant supply**

**High-feed milling cutter**




KAPR 19°




## Metric version

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

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | DCX | BD | LB | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .673 | 14 | 1 1/4 | .315 | .079 | 10° | .079 | 1 | 2 | | A419-032O32-14L | 1.250 | 1.250 | 1.098 | 2.362 | 10.000 | 2.500 | 3.6 | 3.35 | 24700 | 2 | 419R-1405 |
| .925 | 14 | 1 1/4 | .315 | .079 | 9° | .079 | 1 | | 3 | A419-038O32-14M | 1.250 | 1.500 | 1.098 | | 10.000 | | 3.6 | 3.51 | 21400 | 3 | 419R-1405 |

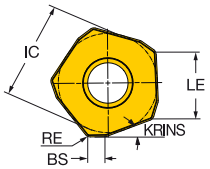
| Spare parts |
|---|
| Insert screw |
| 5513 020-78 |

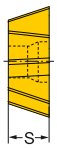
For the complete list of spare parts, visit www.sandvik.coromant.com

I41 L2 N22 N6 N9 N15

# CoroMill® 419 insert for milling

KRINS 19°




| | | RE | Ordering code | P | | | | M | | | | K | | | N | S | | | H | | Dimensions, mm, inch | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1130 | 4220 | 4330 | 4340 | 1040 | 1130 | 2040 | S30T | 1020 | 3040 | 3330 | 1130 | 1130 | S30T | S40T | 1010 | 1130 | IC | LE | S | BS | REEQ |
| Medium | PM | 14 | 0.80 | 419R-1405M-PM | ☆ | ☆ | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | | ★ | ☆ | ☆ | ★ | ☆ | | ☆ | 13.5 | 9.0 | 5.47 | 2.0 | 4.50 |
| | | | .031 | | | | | | | | | | | | | | | | | | | .531 | .354 | .215 | .079 | .177 |
| | MM | 14 | 0.80 | 419R-1405E-MM | ☆ | | ★ | | ★ | ☆ | ☆ | ☆ | | | | ☆ | ☆ | ★ | ☆ | ★ | ☆ | 13.5 | 9.0 | 5.47 | 2.0 | 4.50 |
| | | | .031 | | | | | | | | | | | | | | | | | | | .531 | .354 | .215 | .079 | .177 |
| | SM | 14 | 3.00 | 419N-140530E-SM | ☆ | | ★ | ☆ | ★ | ☆ | ☆ | ☆ | | | | ☆ | ☆ | ★ | ☆ | | ☆ | 13.5 | 9.0 | 5.47 | | 4.50 |
| | | | .118 | | | | | | | | | | | | | | | | | | | .531 | .354 | .215 | | .177 |
| Heavy | PH | 14 | 0.80 | 419R-1405M-PH | | | ☆ | ★ | | | | | | ★ | | | | | ★ | | | 13.5 | 9.0 | 5.47 | 2.0 | 4.50 |
| | | | .031 | | | | | | | | | | | | | | | | | | | .531 | .354 | .215 | .079 | .177 |
| | KH | 14 | 3.00 | 419N-140530M-KH | | ☆ | ★ | | | | | ☆ | ☆ | ★ | | | | | | | | 13.5 | 9.0 | 5.47 | | 4.50 |
| | | | .118 | | | | | | | | | | | | | | | | | | | .531 | .354 | .215 | | .177 |

I38 I222 I254 N22 N10

# CoroMill® 210

## High feed face and plunge milling

### Application

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

### ISO application area:

P M K N S H

### Benefits and features

- High table feed as a result of the chip thinning effect – high productivity
- First Choice face milling cutter in long overhang machining
- Multi-purpose tool. Face milling, boring possibilities, ramping and plunge milling
- Internal coolant

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

Close pitch Extra close pitch

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

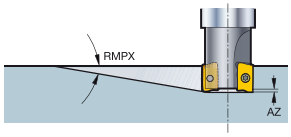
Recommended feed per tooth ($f_z$) 1.5 mm (.059 inch) for size 09 inserts and 2 mm (.079 inch) feed per tooth ($f_z$) for size 14 inserts.

I43 I47

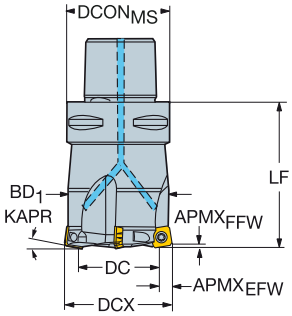
# CoroMill® 210 face milling cutter

**Coromant Capto® - Internal coolant supply**

**High-feed milling cutter**




KAPR 10°




## Metric version

| 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 | 0.90 | 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 | 1.64 | 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- |

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | DCX | BD | LB | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .945 | 09 | C3 | .315 | .047 | 6° | .071 | 3 | | 3 | RA210-038C3-09M | 1.260 | 1.500 | 1.258 | | 1.969 | 2.2 | 0.75 | 29600 | 3 | R210-090412M- |
| 1.055 | 14 | C5 | .512 | .079 | 5° | .079 | 3 | | 3 | RA210-051C5-14M | 1.969 | 2.000 | 1.829 | 2.756 | 2.756 | 3.6 | 2.63 | 20800 | 3 | R210-140512M- |
| | 14 | C5 | .512 | .079 | 5° | .079 | 3 | 4 | | RA210-051C5-14H | 1.969 | 2.000 | 1.829 | 2.756 | 2.756 | 3.6 | 2.60 | 20800 | 4 | R210-140512M- |
| 1.445 | 09 | C5 | .315 | .047 | 3° | .071 | 3 | | 4 | RA210-051C5-09M | 1.969 | 2.000 | 1.880 | 2.756 | 2.756 | 2.2 | 2.65 | 24800 | 4 | R210-090412M- |
| | 09 | C5 | .315 | .047 | 3° | .071 | 3 | 5 | | RA210-051C5-09H | 1.969 | 2.000 | 1.880 | 2.756 | 2.756 | 2.2 | 2.65 | 24800 | 5 | R210-090412M- |
| 1.555 | 14 | C5 | .512 | .079 | 3° | .079 | 3 | | 4 | RA210-063C5-14M | 1.969 | 2.500 | 2.329 | 2.756 | 2.756 | 3.6 | 3.66 | 18200 | 4 | R210-140512M- |
| | 14 | C5 | .512 | .079 | 3° | .079 | 3 | 5 | | RA210-063C5-14H | 1.969 | 2.500 | 2.329 | 2.756 | 2.756 | 3.6 | 3.44 | 18200 | 5 | R210-140512M- |
| 1.945 | 09 | C5 | .315 | .047 | 2° | .071 | 3 | | 5 | RA210-063C5-09M | 1.969 | 2.500 | 2.380 | 2.756 | 2.756 | 2.2 | 3.53 | 21700 | 5 | R210-090412M- |

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

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

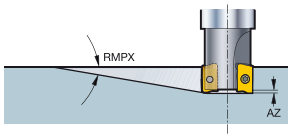
I47 L2 N22 N9 N15

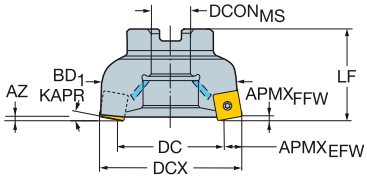
# CoroMill® 210 face milling cutter

**Arbor - Internal coolant supply**

**High-feed milling cutter**

KAPR 10°




## Metric version

| 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- |

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | ISO | DCX | BD | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.445 | 09 | 3/4 | .315 | .047 | 3° | .071 | 1 | | 4 | RA210-051R19-09M | .750 | A | 2.000 | 1.880 | 1.969 | 2.2 | 1.54 | 24800 | 4 | R210-090412M- |
| | 09 | 3/4 | .315 | .047 | 3° | .071 | 1 | 5 | | RA210-051R19-09H | .750 | A | 2.000 | 1.880 | 1.969 | 2.2 | 1.46 | 24800 | 5 | R210-090412M- |
| 1.555 | 14 | 3/4 | .512 | .079 | 3° | .039 | 1 | | 4 | RA210-063R19-14M | .750 | A | 2.500 | 2.329 | 1.969 | 3.6 | 1.68 | 18200 | 4 | R210-140512M- |
| | 14 | 3/4 | .512 | .079 | 3° | .039 | 1 | 5 | | RA210-063R19-14H | .750 | A | 2.500 | 2.329 | 1.969 | 3.6 | 2.14 | 18200 | 5 | R210-140512M- |
| 1.945 | 09 | 3/4 | .315 | .047 | 2° | .071 | 1 | | 5 | RA210-063R19-09M | .750 | A | 2.500 | 2.380 | 1.969 | 2.2 | 1.85 | 21700 | 5 | R210-090412M- |
| 2.055 | 14 | 1 | .512 | .079 | 2° | .039 | 1 | | 5 | RA210-076R25-14M | 1.000 | A | 3.000 | 2.829 | 1.969 | 3.6 | 2.52 | 15900 | 5 | R210-140512M- |
| | 14 | 1 | .512 | .079 | 2° | .039 | 1 | 6 | | RA210-076R25-14H | 1.000 | A | 3.000 | 2.829 | 1.969 | 3.6 | 2.21 | 15900 | 6 | R210-140512M- |
| 3.055 | 14 | 1 1/2 | .512 | .079 | 1° | .079 | 1 | | 6 | RA210-102R38-14M | 1.500 | B | 4.000 | 3.829 | 2.362 | 3.6 | 5.07 | 13300 | 6 | R210-140512M- |
| | 14 | 1 1/2 | .512 | .079 | 1° | .079 | 1 | 7 | | RA210-102R38-14H | 1.500 | B | 4.000 | 3.829 | 2.362 | 3.6 | 5.54 | 13300 | 7 | R210-140512M- |
| 4.055 | 14 | 1 1/2 | .512 | .079 | 1° | .079 | 1 | | 7 | RA210-127R38-14M | 1.500 | B | 5.000 | 4.829 | 2.480 | 3.6 | 6.92 | 11300 | 7 | R210-140512M- |
| 5.055 | 14 | 1 1/2 | .512 | .079 | 1° | .079 | 1 | | 8 | RA210-152R38-14M | 1.500 | B | 6.000 | 5.829 | 2.480 | 3.6 | 10.05 | 10600 | 8 | R210-140512M- |

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

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

I47

L2

M1

N22

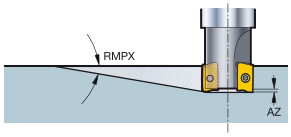
N9

N15

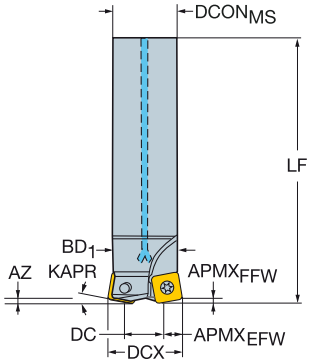
# CoroMill® 210 face milling cutter

**Cylindrical shank - Internal coolant supply**

**High-feed milling cutter**




KAPR 10°




## Metric version

| 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 | 1.54 | 8000 | 4 | R210-090412M- |

## Inch version

| DC | | CZC$_{MS}$ | APMX$_{EFW}$ | APMX$_{FFW}$ | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCON$_{MS}$ | DCX | BD | LB | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .445 | 09 | 1 | .315 | .047 | 14° | .071 | 1 | 2 | | RA210-025O25-09M | 1.000 | 1.000 | .880 | 2.500 | 10.000 | 2.2 | 2.65 | 7400 | 2 | R210-090412M- |
| .695 | 09 | 1 | .315 | .047 | 8° | .071 | 1 | 2 | | RA210-032O25-09M | 1.000 | 1.250 | 1.130 | 2.000 | 10.000 | 2.2 | 2.73 | 7400 | 2 | R210-090412M- |
| | 09 | 1 | .315 | .047 | 8° | .071 | 1 | 3 | | RA210-032O25-09H | 1.000 | 1.250 | 1.130 | 2.000 | 10.000 | 2.2 | 2.70 | 7400 | 3 | R210-090412M- |
| .823 | 09 | 1 1/4 | .315 | .047 | 7° | .071 | 1 | 3 | | RA210-035O32-09H | 1.250 | 1.378 | 1.258 | 2.000 | 10.000 | 2.2 | 4.14 | 7400 | 3 | R210-090412M- |
| .945 | 09 | 1 1/4 | .315 | .047 | 6° | .071 | 1 | | 3 | RA210-038O32-09M | 1.250 | 1.500 | 1.380 | 2.000 | 10.000 | 2.2 | 3.88 | 7400 | 3 | R210-090412M- |
| | 09 | 1 1/4 | .315 | .047 | 7° | .071 | 1 | 4 | | RA210-038O32-09H | 1.250 | 1.500 | 1.380 | 2.000 | 10.000 | 2.2 | 3.79 | 7400 | 4 | R210-090412M- |

| Spare parts | |
|---|---|
| Insert screw | |
| 5513 020-02 | |

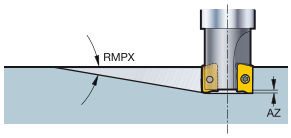
For the complete list of spare parts, visit www.sandvik.coromant.com

I47 L2 N22 N9 N15

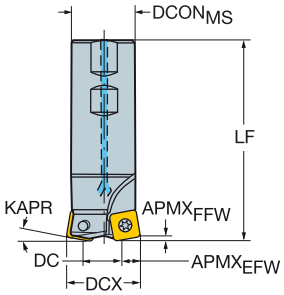
# CoroMill® 210 face milling cutter

**Weldon – Internal coolant supply**

**High-feed milling cutter**



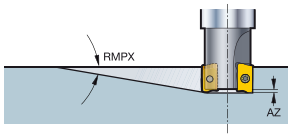

KAPR 10°



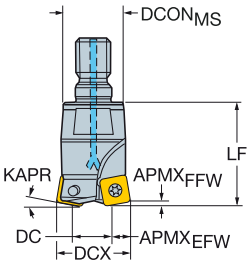

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | ISO | DCX | BD | LB | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .445 | 09 | 1 | .315 | .047 | 14° | .071 | 1 | 2 | | RA210-025M25-09M | 1.000 | WE | 1.000 | .880 | 2.000 | 5.141 | 2.2 | 1.23 | 40200 | 2 | R210-090412M- |
| .695 | 09 | 1 1/4 | .315 | .047 | 8° | .071 | 1 | 2 | | RA210-032M32-09M | 1.250 | WE | 1.250 | 1.132 | 2.000 | 4.282 | 2.2 | 1.10 | 33900 | 2 | R210-090412M- |
| .823 | 09 | 1 1/4 | .315 | .047 | 7° | .071 | 1 | 3 | | RA210-035M32-09H | 1.250 | WE | 1.378 | 1.258 | 2.000 | 4.282 | 2.2 | 1.48 | 33900 | 3 | R210-090412M- |
| .945 | 09 | 1 1/4 | .315 | .047 | 6° | .071 | 1 | | 3 | RA210-038M32-09M | 1.250 | WE | 1.500 | 1.380 | 2.500 | 5.141 | 2.2 | 2.16 | 28500 | 3 | R210-090412M- |

## Threaded coupling – Internal coolant supply




KAPR 10°




## Metric version

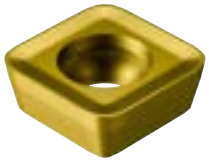
| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | Ordering code | Dimensions, mm DCONMS | DCX | BD | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 10.9 | 09 | M12 | 8.0 | 1.20 | 14° | 1.8 | 1 | 2 | R210-025T12-09M | 20.8 | 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 the complete list of spare parts, visit www.sandvik.coromant.com

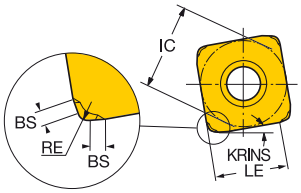
I47 L2 N22 N9 N15

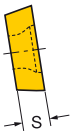
# CoroMill® 210 insert for milling



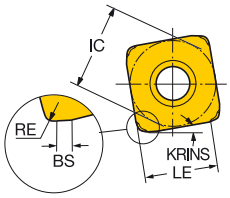
KRINS

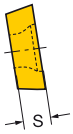
10°
R210..E-KM




10°
R210..M-PM




| | | RE | Ordering code | P 1130 | P 4220 | P 4330 | P 4340 | M 1040 | M 1130 | M 2030 | M 2040 | M S30T | K 1020 | K 3040 | K 3330 | N 1130 | S 1130 | S S30T | S S40T | H 1010 | H 1130 | Dimensions, mm, inch IC | LE | S | BS | BSR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Medium | KM | 09 1.00 | R210-09 04 12M-KM | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | 9.4 | 6.2 | 4.00 | 0.8 | |
| | | .039 | | | | | | | | | | | | | | | | | | | | .370 | .244 | .157 | .030 | |
| | | 1.40 | R210-09 04 14E-KM | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | 9.5 | 5.7 | 4.50 | 0.7 | 50.0 |
| | | .055 | | | | | | | | | | | | | | | | | | | | .374 | .227 | .177 | .026 | 1.969 |
| | | 14 1.00 | R210-14 05 12M-KM | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | 14.5 | 11.3 | 4.76 | 0.8 | |
| | | .039 | | | | | | | | | | | | | | | | | | | | .571 | .445 | .188 | .030 | |
| | | 1.40 | R210-14 05 14E-KM | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | 14.6 | 10.8 | 5.26 | 0.7 | 50.0 |
| | | .055 | | | | | | | | | | | | | | | | | | | | .575 | .426 | .207 | .028 | 1.969 |
| | MM | 09 1.00 | R210-09 04 12M-MM | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | 9.4 | 6.2 | 4.00 | 0.8 | |
| | | .039 | | | | | | | | | | | | | | | | | | | | .370 | .244 | .157 | .030 | |
| | | 1.40 | R210-09 04 14E-MM | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | 9.5 | 5.7 | 4.50 | 0.7 | 50.0 |
| | | .055 | | | | | | | | | | | | | | | | | | | | .374 | .227 | .177 | .026 | 1.969 |
| | | 14 1.00 | R210-14 05 12M-MM | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | 14.5 | 11.3 | 4.76 | 0.8 | |
| | | .039 | | | | | | | | | | | | | | | | | | | | .571 | .445 | .188 | .030 | |
| | | 1.40 | R210-14 05 14E-MM | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | 14.6 | 10.8 | 5.26 | 0.7 | 50.0 |
| | | .055 | | | | | | | | | | | | | | | | | | | | .575 | .426 | .207 | .028 | 1.969 |
| | PM | 09 1.00 | R210-09 04 12M-PM | ★ | ☆ | ☆ | ☆ | | ☆ | | | ☆ | | | | ☆ | ☆ | ★ | ☆ | ★ | ☆ | 9.4 | 6.2 | 4.00 | 0.8 | |
| | | .039 | | | | | | | | | | | | | | | | | | | | .370 | .244 | .157 | .030 | |
| | | 1.40 | R210-09 04 14E-PM | ★ | ☆ | ☆ | ☆ | | ☆ | | | ☆ | | | | | ☆ | ★ | ☆ | | | 9.5 | 5.7 | 4.50 | 0.7 | 50.0 |
| | | .055 | | | | | | | | | | | | | | | | | | | | .374 | .227 | .177 | .026 | 1.969 |
| | | 14 1.00 | R210-14 05 12M-PM | ☆ | ☆ | ★ | ☆ | | ☆ | | | ☆ | | | | ☆ | ☆ | ★ | ☆ | ★ | ☆ | 14.5 | 11.3 | 4.76 | 0.8 | |
| | | .039 | | | | | | | | | | | | | | | | | | | | .571 | .445 | .188 | .030 | |
| | | 1.40 | R210-14 05 14E-PM | ☆ | ☆ | ★ | ☆ | | ☆ | | | ☆ | | | | ☆ | ☆ | ★ | ☆ | ★ | ☆ | 14.6 | 10.8 | 5.26 | 0.7 | 50.0 |
| | | .055 | | | | | | | | | | | | | | | | | | | | .575 | .426 | .207 | .028 | 1.969 |

I43 I222 I254 N22 N10

# CoroMill® 415

## Small diameter, high feed face milling cutter

### Application

- High feed facemilling
- 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 adapters 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

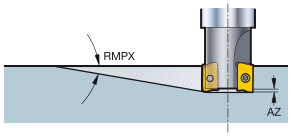
- Four cutting edges
- The unique iLock™ solution provides easy and accurate insert indexing, increased reliability, and improved tool life.

I49 I52

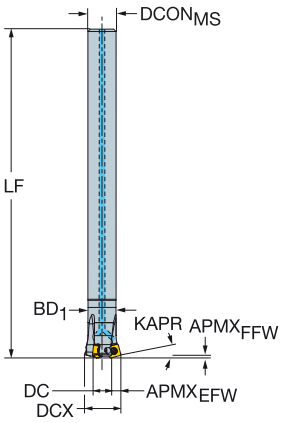
# CoroMill® 415 face milling cutter

**Cylindrical shank - Internal coolant supply**

**High-feed milling cutter**




KAPR 15°




## Metric version

| 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 1 | 5 | 415-032A25-07H | 25.0 | 32.0 | 26.0 | 15.0 | 250.0 | 1.2 | 0.95 | 13900 | 5 | 415N-070310M |

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | CNSC | | Ordering code | Dimensions, inch DCONMS | DCX | BD | LB | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .169 | 05 | 1/2 | .118 | .033 | 0° | 1 | 2 | A415-013O13-05H | .500 | .500 | .433 | .591 | 6.000 | .4 | 0.48 | 23600 | 2 | 415N-050206M |
| .295 | 05 | 1/2 | .118 | .033 | 0° | 1 | 3 | A415-016O13-05H | .500 | .625 | .468 | .591 | 6.000 | .4 | 0.49 | 21300 | 3 | 415N-050206M |
| .417 | 05 | 5/8 | .118 | .033 | 0° | 1 | 4 | A415-019O16-05H | .625 | .750 | .593 | .591 | 8.000 | .4 | 0.79 | 19000 | 4 | 415N-050206M |
| .551 | 07 | 3/4 | .177 | .047 | 0° | 1 | 4 | A415-025O19-07H | .750 | 1.000 | .764 | .591 | 9.000 | .8 | 1.50 | 15700 | 4 | 415N-070310M |
| .669 | 05 | 3/4 | .118 | .033 | 0° | 1 | 5 | A415-025O19-05M | .750 | 1.000 | .843 | .591 | 9.000 | .4 | 1.46 | 17000 | 5 | 415N-050206M |

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

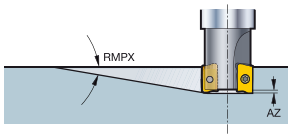
For the complete list of spare parts, visit www.sandvik.coromant.com

I52 L2 N22 N9 N15

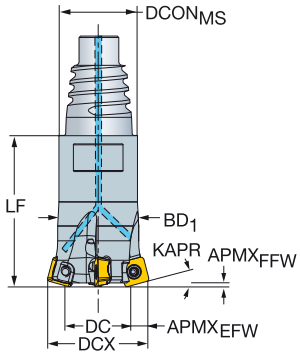
# CoroMill® 415 face milling cutter

## Coromant EH – Internal coolant supply

**High-feed milling cutter**




KAPR 15°




**Metric version**

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | CNSC | | Ordering code | Dimensions, mm DCONMS | DCX | BD | LB | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 4.6 | 05 | E12 | 3.0 | 0.85 | 0° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 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° | 1 | 7 | 415-32EH25-05H | 24.2 | 32.0 | 28.0 | 15.0 | 35.0 | 0.6 | 0.16 | 15000 | 7 | 415N-050206M |

**Inch version**

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | CNSC | | Ordering code | Dimensions, inch DCONMS | DCX | BD | LB | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .169 | 05 | E12 | .118 | .033 | 0° | 1 | 2 | A415-13EH12-05H | .484 | .500 | .433 | .394 | .984 | .4 | 0.30 | 23600 | 2 | 415N-050206M |
| .295 | 05 | E16 | .118 | .033 | 0° | 1 | 3 | A415-16EH16-05H | .610 | .625 | .468 | .472 | 1.181 | .4 | 0.34 | 21300 | 3 | 415N-050206M |
| .299 | 07 | E20 | .177 | .047 | 0° | 1 | 2 | A415-19EH20-07H | .728 | .750 | .514 | .591 | 1.378 | .8 | 0.13 | 17500 | 2 | 415N-070310M |
| .417 | 05 | E20 | .118 | .033 | 0° | 1 | 3 | A415-19EH20-05M | .728 | .750 | .593 | .512 | 1.260 | .4 | 0.13 | 19000 | 3 | 415N-050206M |
| | 05 | E20 | .118 | .033 | 0° | 1 | 4 | A415-19EH20-05H | .728 | .750 | .593 | .512 | 1.260 | .4 | 0.40 | 19000 | 4 | 415N-050206M |
| .551 | 07 | E25 | .177 | .047 | 0° | 1 | 3 | A415-25EH25-07M | .965 | 1.000 | .764 | .709 | 1.575 | .8 | 0.57 | 15700 | 3 | 415N-070310M |
| | 07 | E25 | .177 | .047 | 0° | 1 | 4 | A415-25EH25-07H | .965 | 1.000 | .764 | .709 | 1.575 | .8 | 0.54 | 15700 | 4 | 415N-070310M |
| .669 | 05 | E25 | .118 | .033 | 0° | 1 | 5 | A415-25EH25-05M | .965 | 1.000 | .843 | .591 | 1.378 | .4 | 0.29 | 17000 | 5 | 415N-050206M |
| | 05 | E25 | .118 | .033 | 0° | 1 | 6 | A415-25EH25-05H | .965 | 1.000 | .843 | .591 | 1.378 | .4 | 0.53 | 17000 | 6 | 415N-050206M |
| .799 | 07 | E25 | .177 | .047 | 0° | 1 | 4 | A415-32EH25-07M | .965 | 1.250 | 1.014 | .709 | 1.575 | .8 | 0.41 | 13900 | 4 | 415N-070310M |
| .917 | 05 | E25 | .118 | .033 | 0° | 1 | 6 | A415-32EH25-05M | .965 | 1.250 | 1.093 | .591 | 1.378 | .4 | 0.35 | 15000 | 6 | 415N-050206M |

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

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

I52 L2 N22 N9 N15 N3

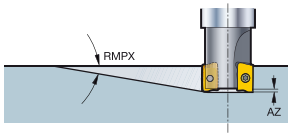


SANDVIK Coromant

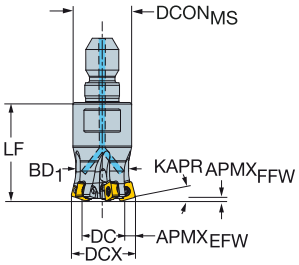
# CoroMill® 415 face milling cutter

**Threaded coupling – Internal coolant supply**

**High-feed milling cutter**




KAPR 15°




## Metric version

| 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° | 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° | 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° | 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° | 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° | 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° | 1 | 5 | **415-32T16-07H** | 28.8 | 32.0 | 26.0 | 15.0 | 40.0 | 1.2 | 0.19 | 13900 | 5 | 415N-070310M |

## Inch version

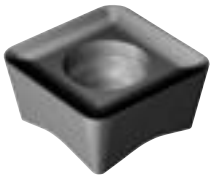
| DC | SSC | CZCMS | APMXEFW | APMXFFW | RMPX | CNSC | | Ordering code | Dimensions, inch DCONMS | DCX | BD | LB | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .169 | 05 | M8 | .118 | .033 | 0° | 1 | 2 | **A415-13T08-05H** | .504 | .500 | .433 | .394 | .984 | .4 | 0.04 | 23600 | 2 | 415N-050206M |
| .295 | 05 | M8 | .118 | .033 | 0° | 1 | 3 | **A415-16T08-05H** | .504 | .625 | .468 | .394 | .984 | .4 | 0.07 | 21300 | 3 | 415N-050206M |
| .417 | 05 | M10 | .118 | .033 | 0° | 1 | 4 | **A415-19T10-05H** | .701 | .750 | .593 | .472 | 1.181 | .4 | 0.11 | 19000 | 4 | 415N-050206M |
| .551 | 07 | M12 | .177 | .047 | 0° | 1 | 4 | **A415-25T12-07H** | .819 | 1.000 | .764 | .591 | 1.496 | .8 | 0.20 | 15700 | 4 | 415N-070310M |
| .669 | 05 | M12 | .118 | .033 | 0° | 1 | 6 | **A415-25T12-05H** | .819 | 1.000 | .843 | .591 | 1.378 | .4 | 0.22 | 17000 | 6 | 415N-050206M |
| .799 | 07 | M16 | .177 | .047 | 0° | 1 | 5 | **A415-32T16-07H** | 1.134 | 1.250 | 1.014 | .591 | 1.575 | .8 | 0.42 | 13900 | 5 | 415N-070310M |

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

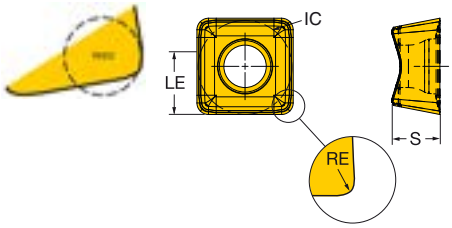
For the complete list of spare parts, visit www.sandvik.coromant.com

I52 L2 N22 N9 N15

# CoroMill® 415 insert for milling



KRINS 15°




| | | | | | P | | M | | | S | | | | H | | Dimensions, mm | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | RE | Ordering code | 1130 | 4340 | 1040 | 1130 | S30T | 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 |
| | | | .024 | | | | | | | | | | | | | .197 | .150 | .087 | .059 |
| | | 05 | 1.20 | 415N-05 02 12E-M30 | ★ | | ★ | | ☆ | ☆ | | ★ | ☆ | | ☆ | 5.0 | 3.0 | 2.21 | 2.00 |
| | | | .047 | | | | | | | | | | | | | .197 | .118 | .087 | .079 |
| | | 05 | 1.20 | 415N-05 02 12M-M30 | ★ | | ★ | ☆ | ☆ | ☆ | | ★ | ☆ | ★ | ☆ | 5.0 | 3.0 | 2.21 | 2.00 |
| | | | .047 | | | | | | | | | | | | | .197 | .118 | .087 | .079 |
| | | 07 | 1.00 | 415N-07 03 10M-M30 | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ★ | ☆ | 7.0 | 5.0 | 3.07 | 2.20 |
| | | | .039 | | | | | | | | | | | | | .276 | .197 | .121 | .087 |
| | | 07 | 2.00 | 415N-07 03 20E-M30 | ★ | | ★ | | ☆ | ☆ | | ★ | ☆ | | ☆ | 7.0 | 3.0 | 3.07 | 2.20 |
| | | | .079 | | | | | | | | | | | | | .276 | .118 | .121 | .087 |
| | | 07 | 2.00 | 415N-07 03 20M-M30 | ★ | | ★ | ☆ | ☆ | ☆ | | ★ | ☆ | ★ | ☆ | 7.0 | 3.0 | 3.07 | 2.80 |
| | | | .079 | | | | | | | | | | | | | .276 | .118 | .121 | .110 |

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
(compared to using the tool with MIID)

I49 I222 I254 N22 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 (.205 inch)
- 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 (.110 inch)
- Great problem-solving abilities when machining vibration-sensitive components and in weak setups with unique differential MD pitch

**CoroMill® 745 face milling cutter See page I54**

**CoroMill® 745 high-feed face milling cutter See page I22**

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 a 42° entering angle for larger cutting depths, and as a high feed version with a 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 setups. 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.

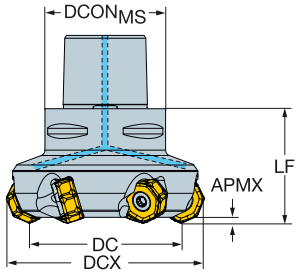
I54 I56

# CoroMill® 745 face milling cutter

**Coromant Capto® - Internal coolant supply**

**High-feed milling cutter**

KAPR 25°




**Metric version**

| DC | | CZC$_{MS}$ | APMX | CNSC | | Ordering code | Dimensions, mm DCON$_{MS}$ | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 21 | C5 | 2.8 | 3 | 5 | **725-063C5-21M** | 50.0 | 86.4 | 60.0 | 12.0 | 1.30 | 5894 | 5 | 745R-2109 |
| | 21 | C6 | 2.8 | 3 | 5 | **725-063C6-21M** | 63.0 | 86.4 | 60.0 | 12.0 | 1.70 | 5894 | 5 | 745R-2109 |
| | 21 | C5 | 2.8 | 3 | 7 | **725-063C5-21H** | 50.0 | 86.4 | 60.0 | 12.0 | 1.20 | 5894 | 7 | 745R-2109 |
| | 21 | C6 | 2.8 | 3 | 7 | **725-063C6-21H** | 63.0 | 86.4 | 60.0 | 12.0 | 1.60 | 5894 | 7 | 745R-2109 |
| 80.0 | 21 | C6 | 2.8 | 3 | 5 | **725-080C6-21M** | 63.0 | 103.4 | 65.0 | 12.0 | 2.06 | 5324 | 5 | 745R-2109 |
| | 21 | C8 | 2.8 | 3 | 6 | **725-080C8-21M** | 80.0 | 103.4 | 65.0 | 12.0 | 3.04 | 5324 | 6 | 745R-2109 |
| | 21 | C6 | 2.8 | 3 | 9 | **725-080C6-21H** | 63.0 | 103.4 | 65.0 | 12.0 | 1.93 | 5324 | 9 | 745R-2109 |
| | 21 | C8 | 2.8 | 3 | 9 | **725-080C8-21H** | 80.0 | 103.4 | 65.0 | 12.0 | 2.91 | 5324 | 9 | 745R-2109 |
| 100.0 | 21 | C8 | 2.8 | 3 | 7 | **725-100C8-21M** | 80.0 | 123.4 | 65.0 | 12.0 | 3.67 | 4765 | 7 | 745R-2109 |
| | 21 | C8 | 2.8 | 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 the complete list of spare parts, visit www.sandvik.coromant.com

I56 L2 N22 N9 N15



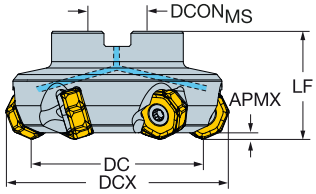
SANDVIK Coromant

# CoroMill® 745 face milling cutter

**Arbor - Internal coolant supply**

**High-feed milling cutter**

STDNO ISO6462
KAPR 25°




## Metric version

| DC | | CZCMS | APMX | CNSC | | Ordering code | Dimensions, mm DCONMS | ISO | DCX | LF | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 21 | 22 | 2.8 | 3 | 5 | 725-063Q22-21M | 22.0 | A | 86.4 | 50.0 | 12.0 | 0.90 | 5894 | 5 | 745R-2109 |
| | 21 | 22 | 2.8 | 3 | 7 | 725-063Q22-21H | 22.0 | A | 86.4 | 50.0 | 12.0 | 0.81 | 5894 | 7 | 745R-2109 |
| 80.0 | 21 | 27 | 2.8 | 3 | 6 | 725-080Q27-21M | 27.0 | A | 103.4 | 50.0 | 12.0 | 1.36 | 5324 | 6 | 745R-2109 |
| | 21 | 27 | 2.8 | 3 | 9 | 725-080Q27-21H | 27.0 | A | 103.4 | 50.0 | 12.0 | 1.23 | 5324 | 9 | 745R-2109 |
| 100.0 | 21 | 32 | 2.8 | 3 | 7 | 725-100Q32-21M | 32.0 | A | 123.4 | 50.0 | 12.0 | 2.33 | 4765 | 7 | 745R-2109 |
| | 21 | 32 | 2.8 | 3 | 11 | 725-100Q32-21H | 32.0 | A | 123.4 | 50.0 | 12.0 | 2.18 | 4765 | 11 | 745R-2109 |
| 125.0 | 21 | 40 | 2.8 | 3 | 8 | 725-125Q40-21M | 40.0 | B | 148.4 | 63.0 | 12.0 | 3.97 | 4216 | 8 | 745R-2109 |
| | 21 | 40 | 2.8 | 3 | 14 | 725-125Q40-21H | 40.0 | B | 148.4 | 63.0 | 12.0 | 3.17 | 4216 | 14 | 745R-2109 |
| 160.0 | 21 | 40 | 2.8 | 3 | 10 | 725-160Q40-21M | 40.0 | B | 183.4 | 63.0 | 12.0 | 4.86 | 3675 | 10 | 745R-2109 |
| | 21 | 40 | 2.8 | 3 | 16 | 725-160Q40-21H | 40.0 | B | 183.4 | 63.0 | 12.0 | 5.31 | 3675 | 16 | 745R-2109 |

## Inch version

| DC | | CZCMS | APMX | CNSC | | Ordering code | Dimensions, inch DCONMS | ISO | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.500 | 21 | 1 | .110 | 3 | 5 | A725-063R25-21M | 1.000 | A | 3.421 | 1.969 | 8.8 | 1.98 | 5894 | 5 | 745R-2109 |
| | 21 | 1 | .110 | 3 | 7 | A725-063R25-21H | 1.000 | A | 3.421 | 1.969 | 8.8 | 1.76 | 5894 | 7 | 745R-2109 |
| 3.000 | 21 | 1 | .110 | 3 | 6 | A725-076R25-21M | 1.000 | A | 3.921 | 1.969 | 8.8 | 2.07 | 5324 | 6 | 745R-2109 |
| | 21 | 1 | .110 | 3 | 9 | A725-076R25-21H | 1.000 | A | 3.921 | 1.969 | 8.8 | 1.90 | 5324 | 9 | 745R-2109 |
| 4.000 | 21 | 1 1/2 | .110 | 3 | 7 | A725-102R38-21M | 1.500 | A | 4.921 | 2.240 | 8.8 | 2.89 | 4765 | 7 | 745R-2109 |
| | 21 | 1 1/2 | .110 | 3 | 11 | A725-102R38-21H | 1.500 | A | 4.921 | 2.240 | 8.8 | 5.95 | 4765 | 11 | 745R-2109 |
| 5.000 | 21 | 1 1/2 | .110 | 3 | 8 | A725-127R38-21M | 1.500 | B | 5.921 | 2.480 | 8.8 | 5.71 | 4216 | 8 | 745R-2109 |
| | 21 | 1 1/2 | .110 | 3 | 14 | A725-127R38-21H | 1.500 | B | 5.921 | 2.480 | 8.8 | 5.34 | 4216 | 14 | 745R-2109 |
| 6.000 | 21 | 1 1/2 | .110 | 3 | 10 | A725-152R38-21M | 1.500 | B | 6.921 | 2.480 | 8.8 | 7.74 | 3675 | 10 | 745R-2109 |
| | 21 | 1 1/2 | .110 | 3 | 16 | A725-152R38-21H | 1.500 | B | 6.921 | 2.480 | 8.8 | 10.41 | 3675 | 16 | 745R-2109 |

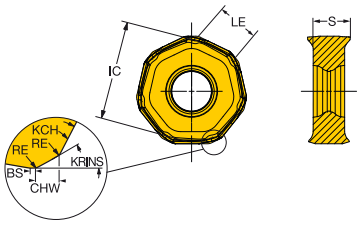
| Spare parts |
|---|
| Insert screw |
| 5513 020-80 |

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

I56 L2 M1 N22 N9 N15

# CoroMill® 745 insert for milling

KRINS 42°




| | | | RE | KC H | CH W | Ordering code | P 1130 | P 4220 | P 4230 | P 4240 | K 1020 | K 3040 | K K20D | K K20W | IC | LE | S | BS | BSR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Medium | M30 | 21 | 1.00 | 17° | 1.3 | 745R-2109E-M30 | ★ | ☆ | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| | | | .039 | | .051 | | | | | | | | | | .827 | .350 | .354 | .012 | .984 |
| | M31 | 21 | 1.00 | | | 745R-2109E-M31 | ★ | ☆ | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 21.0 | 7.1 | 9.00 | 1.9 | 150.0 |
| | | | .039 | | | | | | | | | | | | .827 | .280 | .354 | .075 | 5.906 |
| | M50 | 21 | 1.00 | 17° | 1.3 | 745R/L-2109E-M50 | | | ★ | | | | ☆ | ☆ | 21.0 | 8.5 | 9.00 | 0.3 | 25.0 |
| | | | .039 | | .051 | | | | | | | | | | .827 | .335 | .354 | .013 | .984 |
| | | | 1.00 | 17° | 1.3 | 745R-2109E-M50 | ★ | ☆ | | ☆ | | ★ | | | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| | | | .039 | | .051 | | | | | | | | | | .827 | .350 | .354 | .012 | .984 |
| Heavy | H50 | 21 | 1.00 | 17° | 1.3 | 745R-2109E-H50 | | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | 21.0 | 8.9 | 9.00 | 0.3 | 25.0 |
| | | | .039 | | .051 | | | | | | | | | | .827 | .350 | .354 | .012 | .984 |

Dimensions, mm, inch

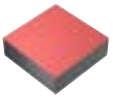
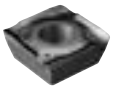
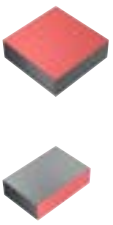
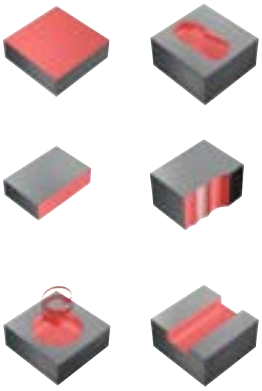
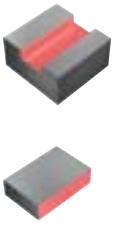
745R-2109E-M31 not recommended for CoroMill® 745 high feed cutter with 25° entering angle.

I54 I222 I254 N22 N10



SANDVIK Coromant

# Shoulder milling tools

| | CoroMill® 490 | CoroMill® 390 | CoroMill® 690 | CoroMill® Century |
|---|---|---|---|---|
| | | | | |
| Page | I58 | I72 | I104 | I109 |
| Material | P M K N S H | P M K N S H | S | P M K N S H |
| Main operations | | | |  |
| KAPR | 90° | 90° | 90° | 90° |
| $D_c$ mm<br>$D_c$ inch | 20 - 250<br>.750 - 10.000 | 9.7 - 200<br>.375 - 8.000 | 40 - 100<br>1.500 - 4.000 | 40 - 200<br>2.000 - 8.000 |
| APMX mm<br>APMX inch | 5.5 - 10.0<br>.216 - .394 | 5.8 - 85<br>.228 - 3.900 | 46 - 108<br>1.811 - 4.252 | 11<br>.433 |
| Insert |  | | | |
| Insert sizes | 08 & 14 | 07,11,17 & 18 | 10 & 14 | 11 |
| Couplings | Coromant Capto®<br>Coromant EH<br>Cylindrical shank<br>Weldon<br>HSK<br>Arbor | Coromant Capto®<br>Coromant EH<br>Cylindrical shank<br>Arbor<br>Weldon<br>Threaded coupling | Coromant Capto®<br>HSK<br>Arbor | Coromant Capto®<br>HSK<br>Arbor |
| Internal coolant | ✓ | ✓ | ✓ | ✓ |
| Options | | Damped cutter bodies available | | Exchangeable cassette design |
| Other operations |  |  |  | |

# CoroMill® 490

## Face and shoulder mill for precise profiles

### Application

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

### ISO application area:

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 the use of the cutter on extended tool assemblies.
- Undersized shanks for larger diameter cutters, using 8 mm (.315 inch) 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.

I59 I69 N6

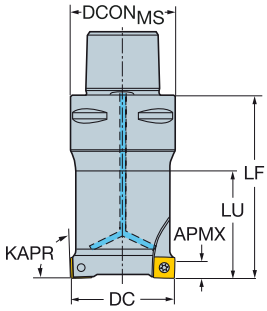


SANDVIK Coromant

# CoroMill® 490 square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

STDNO ISO26623-1
KAPR 90°




## Metric version

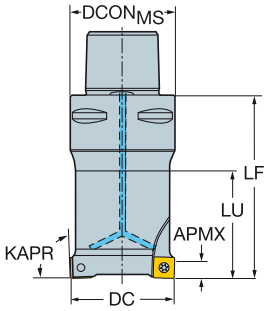
| DC | | CZC$_{MS}$ | APMX$_{FFW}$ | CNSC | | | Ordering code | Dimensions, mm DCON$_{MS}$ | LF | LU | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20.0 | 08 | C3 | 5.50 | 3 | 2 | | 490-020C3-08L | 32.0 | 80.0 | 40.0 | 1.2 | 0.37 | 48500 | 2 | 490R-08T308 |
| | 08 | C4 | 5.50 | 3 | 2 | | 490-020C4-08L | 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 | 80.0 | 60.0 | 1.2 | 0.39 | 40400 | 3 | 490R-08T308 |
| | 08 | C4 | 5.50 | 3 | 3 | | 490-025C4-08M | 40.0 | 70.0 | 45.0 | 1.2 | 0.43 | 39000 | 3 | 490R-08T308 |
| | 08 | C5 | 5.50 | 3 | 3 | | 490-025C5-08M | 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 | 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 | 80.0 | 60.0 | 1.2 | 0.50 | 33900 | 4 | 490R-08T308 |
| | 08 | C4 | 5.50 | 3 | 4 | | 490-032C4-08M | 40.0 | 70.0 | 45.0 | 1.2 | 0.75 | 33900 | 4 | 490R-08T308 |
| | 08 | C5 | 5.50 | 3 | 4 | | 490-032C5-08M | 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 | 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 | 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 | 70.0 | 45.0 | 1.2 | 0.82 | 29300 | 4 | 490R-08T308 |
| | 08 | C5 | 5.50 | 3 | | 4 | 490-040C5-08M | 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 | 70.0 | 45.0 | 1.2 | 0.88 | 29300 | 6 | 490R-08T308 |
| | 08 | C5 | 5.50 | 3 | 6 | | 490-040C5-08H | 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 | 80.0 | 53.0 | 1.2 | 1.62 | 20000 | 6 | 490R-08T308 |
| | 14 | C4 | 10.00 | 3 | | 3 | 490-040C4-14M | 40.0 | 70.0 | 45.0 | 3.0 | 0.82 | 26400 | 3 | 490R-1404 |
| | 14 | C5 | 10.00 | 3 | | 3 | 490-040C5-14M | 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 | 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 | 45.0 | 3.0 | 0.82 | 26400 | 4 | 490R-1404 |
| | 14 | C5 | 10.00 | 3 | 4 | | 490-040C5-14H | 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 | 80.0 | 53.0 | 3.0 | 1.24 | 20000 | 4 | 490R-1404 |
| 44.0 | 08 | C4 | 5.50 | 3 | | 5 | 490-044C4-08M | 40.0 | 60.0 | 60.0 | 1.2 | 0.83 | 27600 | 5 | 490R-08T308 |
| | 08 | C4 | 5.50 | 3 | 6 | | 490-044C4-08H | 40.0 | 60.0 | 60.0 | 1.2 | 0.79 | 27600 | 6 | 490R-08T308 |
| | 14 | C4 | 10.00 | 3 | | 3 | 490-044C4-14M | 40.0 | 70.0 | 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 | 75.0 | 50.0 | 1.2 | 1.28 | 25500 | 5 | 490R-08T308 |
| | 08 | C6 | 5.50 | 3 | | 5 | 490-050C6-08M | 63.0 | 80.0 | 53.0 | 1.2 | 1.84 | 20000 | 5 | 490R-08T308 |
| | 08 | C5 | 5.50 | 3 | 7 | | 490-050C5-08H | 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 | 80.0 | 53.0 | 1.2 | 1.86 | 20000 | 7 | 490R-08T308 |
| | 14 | C5 | 10.00 | 3 | | 4 | 490-050C5-14M | 50.0 | 75.0 | 50.0 | 3.0 | 1.26 | 13700 | 4 | 490R-1404 |
| | 14 | C6 | 10.00 | 3 | | 4 | 490-050C6-14M | 63.0 | 80.0 | 53.0 | 3.0 | 1.80 | 13700 | 4 | 490R-1404 |
| | 14 | C5 | 10.00 | 3 | 5 | | 490-050C5-14H | 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 | 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 | 60.0 | 60.0 | 1.2 | 1.34 | 24300 | 5 | 490R-08T308 |
| | 08 | C5 | 5.50 | 3 | 7 | | 490-054C5-08H | 50.0 | 60.0 | 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 | 50.0 | 23.0 | 1.2 | 1.69 | 20000 | 6 | 490R-08T308 |
| | 08 | C6 | 5.50 | 3 | 8 | | 490-063C6-08H | 63.0 | 50.0 | 23.0 | 1.2 | 1.67 | 20000 | 8 | 490R-08T308 |
| | 14 | C6 | 10.00 | 3 | | 5 | 490-063C6-14M | 63.0 | 80.0 | 53.0 | 3.0 | 2.18 | 11700 | 5 | 490R-1404 |
| | 14 | C6 | 10.00 | 3 | 6 | | 490-063C6-14H | 63.0 | 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 | 50.0 | 50.0 | 1.2 | 1.70 | 20000 | 6 | 490R-08T308 |
| | 08 | C6 | 5.50 | 3 | | 8 | 490-066C6-08H | 63.0 | 50.0 | 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 |

I69 L2 N22 N6 N9 N15

# CoroMill® 490 square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

STDNO ISO26623-1
KAPR 90°




## Metric version

| DC | | CZCMS | APMXFFW | CNSC | | | Ordering code | Dimensions, mm DCONMS | 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 | 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 | 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 | 60.0 | 1.2 | 3.13 | 14000 | 8 | 490R-08T308 |
| | 08 | C8 | 5.50 | 3 | | 10 | 490-084C8-08H | 80.0 | 60.0 | 60.0 | 1.2 | 3.19 | 14000 | 10 | 490R-08T308 |
| | 14 | C8 | 10.00 | 3 | | 6 | 490-084C8-14M | 80.0 | 70.0 | 70.0 | 3.0 | 3.39 | 9800 | 6 | 490R-1404 |
| | 14 | C8 | 10.00 | 3 | 8 | | 490-084C8-14H | 80.0 | 70.0 | 70.0 | 3.0 | 3.39 | 9800 | 8 | 490R-1404 |

| | | Spare parts | | |
|---|---|---|---|---|
| DC | | Insert screw | Shim | Shim screw |
| 20.00-84.00 | 08 | 5513 020-35 | | |
| 40.00-44.00 | 14 | 5513 020-72 | | |
| 50.00-84.00 | 14 | 5513 020-72 | 5322 471-01 | 5512 090-01 |

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

I69 L2 N22 N6 N9 N15

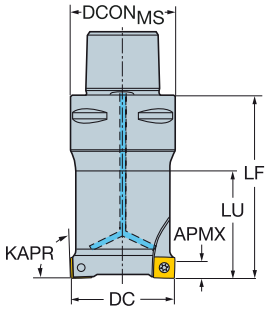


SANDVIK Coromant

# CoroMill® 490 square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

STDNO ISO26623-1
KAPR 90°




## Inch version

| DC | | CZCMS | APMXFFW | CNSC | | | Ordering code | Dimensions, inch DCONMS | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .750 | 08 | C5 | .217 | 3 | 2 | | A490-019C5-08L | 1.969 | 3.000 | 1.500 | .8 | 1.76 | 28000 | 2 | 490R-08T308 |
| 1.000 | 08 | C5 | .217 | 3 | 3 | | A490-025C5-08M | 1.969 | 3.000 | 2.015 | .8 | 1.76 | 28000 | 3 | 490R-08T308 |
| | 08 | C6 | .217 | 3 | 3 | | A490-025C6-08M | 2.480 | 3.000 | 1.937 | .8 | 2.87 | 20000 | 3 | 490R-08T308 |
| 1.250 | 08 | C6 | .217 | 3 | 4 | | A490-032C6-08M | 2.480 | 3.000 | 1.937 | .8 | 3.04 | 20000 | 4 | 490R-08T308 |
| 1.500 | 08 | C5 | .217 | 3 | 5 | | A490-038C5-08H | 1.969 | 3.000 | 2.015 | .8 | 2.25 | 28000 | 5 | 490R-08T308 |
| | 14 | C5 | .394 | 3 | 3 | | A490-038C5-14M | 1.969 | 3.000 | 2.015 | 2.2 | 2.25 | 27400 | 3 | 490R-1404 |
| | 14 | C6 | .394 | 3 | 3 | | A490-038C6-14M | 2.480 | 3.000 | 1.937 | 2.2 | 3.00 | 20000 | 3 | 490R-1404 |
| 2.000 | 08 | C5 | .217 | 3 | | 5 | A490-051C5-08M | 1.969 | 3.000 | 3.000 | .8 | 3.26 | 25200 | 5 | 490R-08T308 |
| | 14 | C5 | .394 | 3 | | 4 | A490-051C5-14M | 1.969 | 3.000 | 3.000 | 2.2 | 2.95 | 13600 | 4 | 490R-1404 |
| | 14 | C5 | .394 | 3 | 5 | | A490-051C5-14H | 1.969 | 3.000 | 3.000 | 2.2 | 2.73 | 22200 | 5 | 490R-1404 |
| 2.500 | 08 | C6 | .217 | 3 | | 6 | A490-063C6-08M | 2.480 | 2.000 | 2.000 | .8 | 3.81 | 20000 | 6 | 490R-08T308 |
| | 08 | C6 | .217 | 3 | 8 | | A490-063C6-08H | 2.480 | 2.000 | 2.000 | .8 | 3.62 | 20000 | 8 | 490R-08T308 |
| | 14 | C6 | .394 | 3 | | 5 | A490-063C6-14M | 2.480 | 2.500 | 2.500 | 2.2 | 4.20 | 11700 | 5 | 490R-1404 |
| | 14 | C6 | .394 | 3 | 6 | | A490-063C6-14H | 2.480 | 2.500 | 2.500 | 2.2 | 3.79 | 11700 | 6 | 490R-1404 |

| | | Spare parts | | |
|---|---|---|---|---|
| DC" | | Insert screw | Shim | Shim screw |
| .750 | 08 | 5513 020-36 | | |
| 1.000-2.500 | 08 | 5513 020-35 | | |
| 1.500 | 14 | 5513 020-72 | | |
| 2.000-2.500 | 14 | 5513 020-72 | 5322 471-01 | 5512 090-01 |

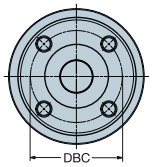
For the complete list of spare parts, visit www.sandvik.coromant.com

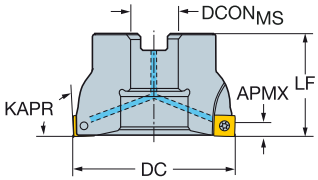
I69 L2 N22 N6 N9 N15

# CoroMill® 490 square shoulder milling cutter

**Arbor - Internal coolant supply**

STDNO ISO6462
KAPR 90°




## Metric version

| DC | | CZCMS | APMXFFW | CNSC | | | Ordering code | Dimensions, mm DCONMS | 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 | 0.22 | 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 | 0.37 | 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 | 0.50 | 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

I69 L2 M1 N22 N6 N9 N15

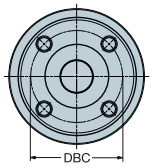


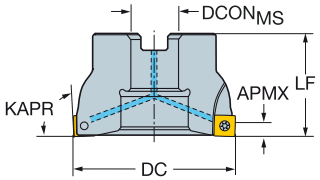
SANDVIK Coromant

# CoroMill® 490 square shoulder milling cutter

**Arbor - Internal coolant supply**

STDNO ISO6462
KAPR 90°




## Inch version

| DC | | CZCMS | APMX | CNSC | | | Ordering code | Dimensions, inch DCONMS | ISO | DBC | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.500 | 08 | 3/4 | .217 | 1 | | 4 | A490-038R19-08M | .750 | A | | 1.575 | .8 | 1.15 | 30200 | 4 | 490R-08T308 |
| | 08 | 3/4 | .217 | 1 | 5 | | A490-038R19-08H | .750 | A | | 1.575 | .8 | 1.00 | 30200 | 5 | 490R-08T308 |
| 2.000 | 08 | 3/4 | .217 | 1 | | 4 | A490-051R19-08L | .750 | A | | 1.575 | .8 | 1.23 | 25200 | 4 | 490R-08T308 |
| | 08 | 3/4 | .217 | 1 | | 5 | A490-051R19-08M | .750 | A | | 1.575 | .8 | 1.51 | 25200 | 5 | 490R-08T308 |
| | 08 | 3/4 | .217 | 1 | 7 | | A490-051R19-08H | .750 | A | | 1.575 | .8 | 1.49 | 25200 | 7 | 490R-08T308 |
| | 14 | 3/4 | .394 | 1 | | 4 | A490-051R19-14M | .750 | A | | 1.575 | 2.2 | 1.40 | 13600 | 4 | 490R-1404 |
| | 14 | 3/4 | .394 | 1 | 5 | | A490-051R19-14H | .750 | A | | 1.575 | 2.2 | 0.66 | 22200 | 5 | 490R-1404 |
| 2.500 | 08 | 1 | .217 | 1 | | 5 | A490-063R25-08L | 1.000 | A | | 1.969 | .8 | 2.50 | 22100 | 5 | 490R-08T308 |
| | 08 | 1 | .217 | 1 | | 6 | A490-063R25-08M | 1.000 | A | | 1.969 | .8 | 2.45 | 22100 | 6 | 490R-08T308 |
| | 08 | 1 | .217 | 1 | 8 | | A490-063R25-08H | 1.000 | A | | 1.969 | .8 | 2.50 | 22100 | 8 | 490R-08T308 |
| | 14 | 1 | .394 | 1 | | 5 | A490-063R25-14M | 1.000 | A | | 1.969 | 2.2 | 2.03 | 11700 | 5 | 490R-1404 |
| | 14 | 1 | .394 | 1 | 6 | | A490-063R25-14H | 1.000 | A | | 1.969 | 2.2 | 2.08 | 11700 | 6 | 490R-1404 |
| 3.000 | 08 | 1 | .217 | 1 | | 6 | A490-076R25-08L | 1.000 | A | | 1.969 | .8 | 2.91 | 19900 | 6 | 490R-08T308 |
| | 08 | 1 | .217 | 1 | | 8 | A490-076R25-08M | 1.000 | A | | 1.969 | .8 | 3.57 | 19900 | 8 | 490R-08T308 |
| | 08 | 1 | .217 | 1 | 10 | | A490-076R25-08H | 1.000 | A | | 1.969 | .8 | 3.68 | 19900 | 10 | 490R-08T308 |
| | 14 | 1 | .394 | 1 | | 6 | A490-076R25-14M | 1.000 | A | | 1.969 | 2.2 | 2.72 | 10400 | 6 | 490R-1404 |
| | 14 | 1 | .394 | 1 | 7 | | A490-076R25-14H | 1.000 | A | | 1.969 | 2.2 | 2.76 | 10400 | 7 | 490R-1404 |
| 3.150 | 08 | 1 | .217 | 1 | | 6 | A490-080J25.4-08L | 1.000 | A | | 1.969 | .8 | 2.65 | 19400 | 6 | 490R-08T308 |
| | 08 | 1 | .217 | 1 | | 8 | A490-080J25.4-08M | 1.000 | A | | 1.969 | .8 | 3.73 | 19400 | 8 | 490R-08T308 |
| | 08 | 1 | .217 | 1 | | 10 | A490-080J25.4-08H | 1.000 | A | | 1.969 | .8 | 3.68 | 19400 | 10 | 490R-08T308 |
| | 14 | 1 | .394 | 1 | | 4 | A490-080J25.4-14L | 1.000 | A | | 1.969 | 2.2 | 2.20 | 10100 | 4 | 490R-1404 |
| | 14 | 1 | .394 | 1 | | 6 | A490-080J25.4-14M | 1.000 | A | | 1.969 | 2.2 | 2.76 | 10100 | 6 | 490R-1404 |
| | 14 | 1 | .394 | 1 | 8 | | A490-080J25.4-14H | 1.000 | A | | 1.969 | 2.2 | 2.73 | 10100 | 8 | 490R-1404 |
| 3.937 | 08 | 1 1/4 | .217 | 0 | | 6 | A490-100J31.75-08L | 1.250 | B | | 2.480 | .8 | 5.73 | 17100 | 6 | 490R-08T308 |
| | 08 | 1 1/4 | .217 | 0 | | 8 | A490-100J31.75-08M | 1.250 | B | | 2.480 | .8 | 5.57 | 17100 | 8 | 490R-08T308 |
| | 14 | 1 1/4 | .394 | 1 | | 5 | A490-100J31.75-14L | 1.250 | B | | 2.480 | 2.2 | 5.51 | 8900 | 5 | 490R-1404 |
| | 14 | 1 1/4 | .394 | 1 | | 7 | A490-100J31.75-14M | 1.250 | B | | 2.480 | 2.2 | 5.34 | 8900 | 7 | 490R-1404 |
| | 14 | 1 1/4 | .394 | 1 | 10 | | A490-100J31.75-14H | 1.250 | B | | 2.480 | 2.2 | 5.38 | 8900 | 10 | 490R-1404 |
| 4.000 | 08 | 1 1/2 | .217 | 0 | | 6 | A490-102R38-08L | 1.500 | B | | 1.969 | .8 | 4.85 | 17000 | 6 | 490R-08T308 |
| | 08 | 1 1/2 | .217 | 0 | | 8 | A490-102R38-08M | 1.500 | B | | 1.969 | .8 | 4.63 | 17000 | 8 | 490R-08T308 |
| | 08 | 1 1/2 | .217 | 0 | | 10 | A490-102R38-08H | 1.500 | B | | 1.969 | .8 | 4.67 | 17000 | 10 | 490R-08T308 |
| | 14 | 1 1/2 | .394 | 1 | | 5 | A490-102R38-14L | 1.500 | B | | 1.969 | 2.2 | 4.50 | 8800 | 5 | 490R-1404 |
| | 14 | 1 1/2 | .394 | 1 | | 7 | A490-102R38-14M | 1.500 | B | | 1.969 | 2.2 | 4.09 | 8800 | 7 | 490R-1404 |
| | 14 | 1 1/2 | .394 | 1 | 10 | | A490-102R38-14H | 1.500 | B | | 1.969 | 2.2 | 4.23 | 8800 | 10 | 490R-1404 |
| 4.921 | 08 | 1 1/2 | .217 | 0 | | 8 | A490-125J38.1-08L | 1.500 | B | | 2.480 | .8 | 7.83 | 15200 | 8 | 490R-08T308 |
| | 08 | 1 1/2 | .217 | 0 | | 10 | A490-125J38.1-08M | 1.500 | B | | 2.480 | .8 | 7.56 | 15200 | 10 | 490R-08T308 |
| | 14 | 1 1/2 | .394 | 1 | | 6 | A490-125J38.1-14L | 1.500 | B | | 2.480 | 2.2 | 7.67 | 7800 | 6 | 490R-1404 |
| | 14 | 1 1/2 | .394 | 1 | | 8 | A490-125J38.1-14M | 1.500 | B | | 2.480 | 2.2 | 7.05 | 7800 | 8 | 490R-1404 |
| 5.000 | 08 | 1 1/2 | .217 | 0 | | 10 | A490-127R38-08M | 1.500 | B | | 2.480 | .8 | 7.85 | 15100 | 10 | 490R-08T308 |

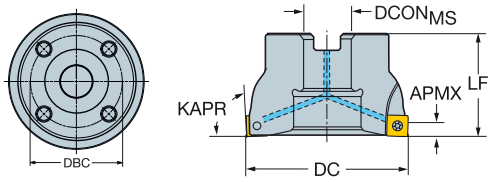
For spare parts, visit www.sandvik.coromant.com

I69 L2 M1 N22 N6 N9 N15

# CoroMill® 490 square shoulder milling cutter

**Arbor - Internal coolant supply**

STDNO ISO6462
KAPR 90°




**Inch version**

| DC | | CZC$_{MS}$ | APMX | CNSC | | | Ordering code | Dimensions, inch DCON$_{MS}$ | ISO | DBC | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | 14 | 1 1/2 | .394 | 1 | | 6 | A490-127R38-14L | 1.500 | B | | 2.480 | 2.2 | 7.58 | 7700 | 6 | 490R-1404 |
| | 14 | 1 1/2 | .394 | 1 | | 8 | A490-127R38-14M | 1.500 | B | | 2.480 | 2.2 | 7.89 | 7700 | 8 | 490R-1404 |
| 6.000 | 14 | 1 1/2 | .394 | 0 | | 8 | A490-152R38-14L | 1.500 | C | 2.626 | 2.480 | 2.2 | 9.66 | 7000 | 8 | 490R-1404 |
| | 14 | 1 1/2 | .394 | 0 | | 12 | A490-152R38-14M | 1.500 | C | 2.626 | 2.480 | 2.2 | 10.08 | 7000 | 12 | 490R-1404 |
| | 14 | 1 1/2 | .394 | 0 | 14 | | A490-152R38-14H | 1.500 | C | 2.626 | 2.480 | 2.2 | 10.14 | 7000 | 14 | 490R-1404 |
| 6.299 | 14 | 2 | .394 | 0 | | 12 | A490-160J50.8-14M | 2.000 | C | 2.626 | 2.480 | 2.2 | 12.26 | 6800 | 12 | 490R-1404 |
| 7.874 | 14 | 1 7/8 | .394 | 0 | | 16 | A490-200J47.625-14M | 1.875 | C | 2.626 | 2.480 | 2.2 | 32.10 | 6000 | 16 | 490R-1404 |
| 8.000 | 14 | 2 1/2 | .394 | 0 | | 10 | A490-203R63-14L | 2.500 | C | 4.000 | 2.480 | 2.2 | 25.97 | 6000 | 10 | 490R-1404 |
| | 14 | 2 1/2 | .394 | 0 | | 16 | A490-203R63-14M | 2.500 | C | 4.000 | 2.480 | 2.2 | 25.97 | 6000 | 16 | 490R-1404 |
| 10.000 | 14 | 2 1/2 | .394 | 0 | | 12 | A490-254R63-14L | 2.500 | C | 4.000 | 2.480 | 2.2 | 35.19 | 5300 | 12 | 490R-1404 |
| | 14 | 2 1/2 | .394 | 0 | | 18 | A490-254R63-14M | 2.500 | C | 4.000 | 2.480 | 2.2 | 37.48 | 5300 | 18 | 490R-1404 |

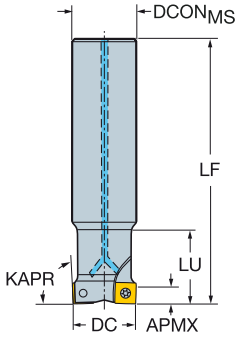
For spare parts, visit www.sandvik.coromant.com

I69 L2 M1 N22 N6 N9 N15

# CoroMill® 490 square shoulder milling cutter

**Cylindrical shank - Internal coolant supply**

KAPR 90°




## Metric version

| DC | | CZCMS | APMXFFW | CNSC | | | Ordering code | Dimensions, mm DCONMS | 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 | 0.20 | 40400 | 3 | 490R-08T308 |
| | 08 | 25 | 5.50 | 1 | 3 | | 490-025A25-08M | 25.0 | 120.0 | 32.0 | 1.2 | 0.40 | 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 |

## Inch version

| DC | | CZCMS | APMXFFW | CNSC | | Ordering code | Dimensions, inch DCONMS | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .750 | 08 | 3/4 | .217 | 1 | 2 | A490-019O19L-08L | .750 | 6.500 | 1.625 | .8 | 0.89 | 22100 | 2 | 490R-08T308 |
| 1.000 | 08 | 1 | .217 | 1 | 2 | A490-025O25L-08L | 1.000 | 8.000 | 2.125 | .8 | 1.74 | 12100 | 2 | 490R-08T308 |
| | 08 | 1 | .217 | 1 | 3 | A490-025O25L-08M | 1.000 | 8.000 | 2.125 | .8 | 1.71 | 12100 | 3 | 490R-08T308 |
| 1.500 | 14 | 1 1/4 | .394 | 1 | 3 | A490-038O32L-14M | 1.250 | 10.000 | | 2.2 | 3.88 | 7400 | 3 | 490R-1404 |

| | | | Spare parts | | |
|---|---|---|---|---|---|
| DC | DC" | | Insert screw | Shim | Shim screw |
| 19.00 | .750 | 08 | 5513 020-36 | | |
| 20.00-40.00 | .787-1.574 | 08 | 5513 020-35 | | |
| 38.00-40.00 | 1.500-1.574 | 14 | 5513 020-72 | | |
| 50.00-63.00 | 1.968-2.480 | 14 | 5513 020-72 | 5322 471-01 | 5512 090-01 |

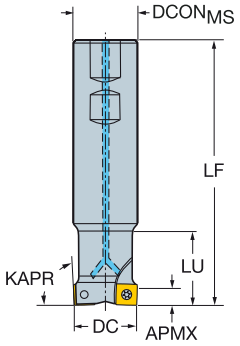
For the complete list of spare parts, visit www.sandvik.coromant.com

I69 L2 N22 N6 N9 N15

# CoroMill® 490 square shoulder milling cutter

**Weldon – Internal coolant supply**

STDNO ISO3338-2
KAPR 90°




## Metric version

| 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 |

## Inch version

| DC | | CZC$_{MS}$ | APMX$_{FFW}$ | CNSC | | Ordering code | Dimensions, inch DCON$_{MS}$ | ISO | LB | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .750 | 08 | 3/4 | .217 | 1 | 2 | A490-019M19-08L | .750 | WE | 1.020 | 3.350 | 1.020 | .8 | 0.55 | 50600 | 2 | 490R-08T308 |
| 1.000 | 08 | 3/4 | .217 | 1 | 2 | A490-025M19-08L | .750 | WE | 1.468 | 3.500 | | .8 | 0.71 | 40000 | 2 | 490R-08T308 |
| | 08 | 1 | .217 | 1 | 2 | A490-025M25-08L | 1.000 | WE | 1.250 | 3.750 | 1.250 | .8 | 0.84 | 40000 | 2 | 490R-08T308 |
| | 08 | 3/4 | .217 | 1 | 3 | A490-025M19-08M | .750 | WE | 1.468 | 3.500 | | .8 | 0.56 | 40000 | 3 | 490R-08T308 |
| | 08 | 1 | .217 | 1 | 3 | A490-025M25-08M | 1.000 | WE | 1.250 | 3.750 | 1.250 | .8 | 0.90 | 40000 | 3 | 490R-08T308 |
| 1.250 | 08 | 1 1/4 | .217 | 1 | | 3 A490-032M32-08L | 1.250 | WE | 1.350 | 3.750 | 1.350 | .8 | 1.32 | 34100 | 3 | 490R-08T308 |
| | 08 | 1 1/4 | .217 | 1 | 4 | A490-032M32-08M | 1.250 | WE | 1.350 | 3.750 | 1.350 | .8 | 1.32 | 34100 | 4 | 490R-08T308 |
| 1.500 | 08 | 1 1/4 | .217 | 1 | | 4 A490-038M32-08M | 1.250 | WE | 1.350 | 4.000 | | .8 | 1.45 | 30200 | 4 | 490R-08T308 |
| | 08 | 1 1/4 | .217 | 1 | 5 | A490-038M32-08H | 1.250 | WE | 1.719 | 4.000 | | .8 | 1.40 | 30200 | 5 | 490R-08T308 |
| | 14 | 1 1/4 | .394 | 1 | 3 | A490-038M32-14M | 1.250 | WE | 1.719 | 4.000 | | 2.2 | 1.39 | 27400 | 3 | 490R-1404 |

| | | | Spare parts |
|---|---|---|---|
| DC | DC" | | Insert screw |
| 19.00 | .750 | 08 | 5513 020-36 |
| 20.00-40.00 | .787-1.574 | 08 | 5513 020-35 |
| 38.00-40.00 | 1.500-1.574 | 14 | 5513 020-72 |

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

I69 L2 N22 N6 N9 N15

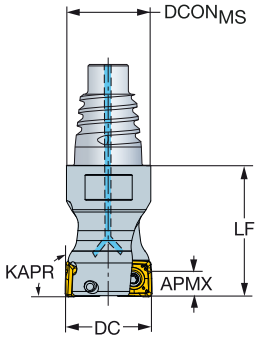


SANDVIK Coromant

# CoroMill® 490 square shoulder milling cutter

**Coromant EH – Internal coolant supply**

KAPR 90°




## Metric version

| DC | | CZCMS | APMXFFW | CNSC | | | Ordering code | Dimensions, mm DCONMS | 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 |

## Inch version

| DC | | CZCMS | APMXFFW | CNSC | | | Ordering code | Dimensions, inch DCONMS | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .750 | 08 | E20 | .216 | 1 | 2 | | A490-019EH20-08L | .728 | 1.181 | .8 | 0.12 | 50600 | 2 | 490R-08T308 |
| 1.000 | 08 | E25 | .216 | 1 | 3 | | A490-025EH25-08M | .965 | 1.378 | .8 | 0.43 | 40000 | 3 | 490R-08T308 |
| 1.250 | 08 | E25 | .216 | 1 | | 3 | A490-032EH25-08L | .965 | 1.378 | .8 | 0.31 | 34100 | 3 | 490R-08T308 |
| | 08 | E25 | .216 | 1 | 4 | | A490-032EH25-08M | .965 | 1.378 | .8 | 0.31 | 34100 | 4 | 490R-08T308 |

| | | | Spare parts |
|---|---|---|---|
| DC | DC" | | Insert screw |
| 19.00-20.00 | .750-.787 | 08 | 5513 020-36 |
| 25.00-32.00 | .984-1.259 | 08 | 5513 020-35 |

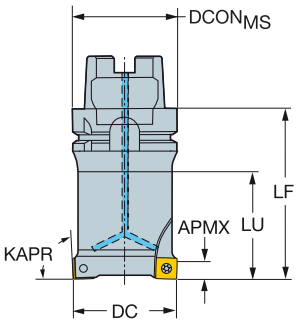
For the complete list of spare parts, visit www.sandvik.coromant.com

I69 L2 N22 N6 N9 N15 N3

# CoroMill® 490 square shoulder milling cutter

**HSK – Internal coolant supply**

STDNO ISO12164-1
KAPR 90°




## Metric version

| DC | | CZCMS | APMXFFW | CNSC | | Ordering code | Dimensions, mm DCONMS | 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 |

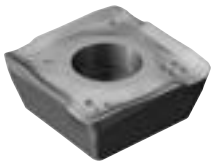
For the complete list of spare parts, visit www.sandvik.coromant.com

I69 L2 N22 N6 N9 N15

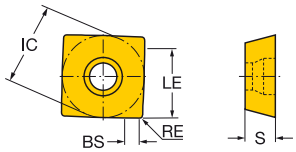


SANDVIK Coromant

# CoroMill® 490 insert for milling



KRINS 90°

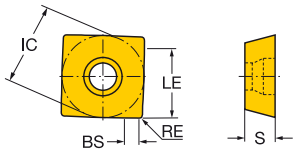



| | | | RE | Ordering code | P | | | | | M | | | | | | K | | | | N | | S | | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3220 | 3330 | 1130 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | IC | LE | S | BS |
| Light | KL | 08 | 0.40 | 490R-08T304M-KL | | | | | | | | | | | | ★ | ☆ | | ☆ | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.5 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .059 |
| | | | 0.80 | 490R-08T308M-KL | | | | | | | | | | | | ★ | ☆ | | ☆ | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .047 |
| | ML | 08 | 0.40 | 490R-08T304E-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | ★ | | ★ | ☆ | ☆ | | | | | | 8.5 | 5.6 | 3.30 | 1.5 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .059 |
| | | | 0.80 | 490R-08T308E-ML | ★ | | | | | ★ | ☆ | ☆ | ☆ | | ☆ | | | | | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | | ☆ | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .047 |
| | | 14 | 0.80 | 490R-140408E-ML | | | | | | ★ | | | ☆ | | ☆ | | | | | | ★ | | | ☆ | ☆ | ★ | ☆ | | | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .079 |
| | PL | 08 | 0.40 | 490R-08T304M-PL | ★ | | ★ | ☆ | | | ☆ | | | | | | | | | | | ☆ | | | | | | | ☆ | | 8.5 | 5.6 | 3.30 | 1.5 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .059 |
| | | | 0.80 | 490R-08T308M-PL | ★ | ☆ | ★ | ☆ | ☆ | | ☆ | | | ☆ | | | | | | | | ☆ | | | | | | ★ | ☆ | ☆ | 8.5 | 5.6 | 3.30 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .047 |
| | | 14 | 0.80 | 490R-140408M-PL | ★ | | ★ | ☆ | | | ☆ | | | | | ★ | ☆ | | ☆ | ☆ | | ☆ | | | | | | | ☆ | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .079 |
| Medium | KM | 08 | 0.80 | 490R-08T308M-KM | | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .047 |
| | | | 1.20 | 490R-08T312M-KM | | | | | | | | | | | | ☆ | ☆ | | ★ | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.9 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .033 |
| | | | 1.60 | 490R-08T316M-KM | | | | | | | | | | | | ☆ | | | ★ | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.6 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .024 |
| | MM | 08 | 0.80 | 490R-08T308E-MM | ★ | | | | | ★ | ☆ | ☆ | ☆ | | ☆ | | | | | | | ☆ | ☆ | ☆ | | ★ | ☆ | | | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .047 |
| | | | 0.80 | 490R-08T308M-MM | | | | | | ★ | | ☆ | ☆ | | ☆ | | | | | | | | ☆ | ☆ | | ★ | ☆ | | | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .047 |
| | | | 1.20 | 490R-08T312E-MM | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 8.5 | 5.6 | 3.30 | 0.9 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .033 |
| | | | 1.60 | 490R-08T316E-MM | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 8.5 | 5.6 | 3.30 | 0.6 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .024 |
| | | 14 | 0.80 | 490R-140408E-MM | | | | | | ★ | | | ☆ | | | | | | | | | | | ★ | | | | | | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .079 |
| | | | 0.80 | 490R-140408M-MM | | | | | | ★ | | | ☆ | | ☆ | | | | | | | | | ☆ | | | ★ | ☆ | | | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .079 |
| | | | 1.20 | 490R-140412E-MM | | | | | | ★ | | | ☆ | | ☆ | | | | | | | | | ☆ | | | ★ | ☆ | | | | 13.8 | 10.3 | 3.90 | 1.6 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .063 |
| | | | 1.60 | 490R-140416E-MM | | | | | | ★ | | | ☆ | | | | | | | | | | | ★ | | | | | | | | 13.8 | 10.3 | 3.90 | 1.2 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .047 |
| | | | 2.00 | 490R-140420E-MM | | | | | | ★ | | | ☆ | | | | | | | | | | | ★ | | | | | | | | 13.8 | 10.3 | 3.90 | 0.9 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .035 |
| | | | 2.00 | 490R-140420M-MM | | | | | | ★ | | | ☆ | | | | | | | | | | | ★ | | | | | | | | 13.8 | 10.3 | 3.90 | 0.9 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .035 |

I59 I222 I254 N22 N10

# CoroMill® 490 insert for milling

KRINS 90°



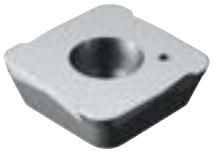

| | | | RE | Ordering code | P 1130 | P 4220 | P 4330 | P 4340 | P 530 | M 1040 | M 1130 | M 2030 | M 2040 | M 530 | M S30T | K 1020 | K 3040 | K 3220 | K 3330 | N 1130 | N H13A | S 1130 | S 2030 | S 2040 | S H13A | S S30T | S S40T | H 1010 | H 1130 | H 530 | Dimensions, mm, inch IC | LE | S | BS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Medium | PM | 08 | 0.80 | 490R-08T308M-PM | ★ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | | | | ☆ | | | | | | ★ | ☆ | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .047 |
| | | | 1.20 | 490R-08T312M-PM | ★ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | | | | ☆ | | | | | | ★ | ☆ | | 8.5 | 5.6 | 3.30 | 0.9 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .033 |
| | | | 1.60 | 490R-08T316M-PM | ★ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | | | | ☆ | | | | | | ★ | ☆ | | 8.5 | 5.6 | 3.30 | 0.6 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .024 |
| | | 14 | 0.80 | 490R/L-140408M-PM | | | ★ | | | | | | | | | | ☆ | ☆ | | | | | | | | | | | | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .079 |
| | | | 0.80 | 490R-140408M-PM | ★ | ☆ | | ☆ | | | ☆ | | | | | ☆ | | | ★ | ☆ | | ☆ | | | | | | | ☆ | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .079 |
| | | | 1.20 | 490R-140412M-PM | ★ | | ★ | ☆ | | | ☆ | | | | | ☆ | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | ☆ | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .079 |
| | | | 1.60 | 490R-140416M-PM | ★ | | ★ | ☆ | | | ☆ | | | | | ☆ | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | ☆ | | 13.8 | 10.3 | 3.90 | 1.2 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .047 |
| | | | 2.00 | 490R-140420M-PM | ★ | ☆ | ★ | ☆ | | | ☆ | | | | | ☆ | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | ☆ | | 13.8 | 10.3 | 3.90 | 0.9 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .035 |
| Heavy | KH | 08 | 0.80 | 490R-08T308M-KH | | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .047 |
| | | | 1.60 | 490R-08T316M-KH | | | | | | | | | | | | ☆ | | | ★ | | | | | | | | | | | | 8.5 | 5.6 | 3.30 | 0.6 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .024 |
| | PH | 08 | 0.80 | 490R-08T308M-PH | ☆ | ☆ | ☆ | ★ | | | ☆ | | | | | | | | | | | ☆ | | | | | | | ☆ | | 8.5 | 5.6 | 3.30 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .047 |
| | | | 1.60 | 490R-08T316M-PH | ☆ | ☆ | ☆ | ★ | | | ☆ | | | | | | | | | | | ☆ | | | | | | | ☆ | | 8.5 | 5.6 | 3.30 | 0.6 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .335 | .220 | .130 | .024 |
| | | 14 | 0.80 | 490R-140408M-PH | ☆ | ☆ | ☆ | ★ | | | ☆ | | | | | ☆ | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | ☆ | | 13.8 | 10.3 | 3.90 | 2.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .079 |
| | | | 2.00 | 490R-140420M-PH | ☆ | ☆ | ☆ | ★ | | | ☆ | | | | | ☆ | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | ☆ | | 13.8 | 10.3 | 3.90 | 0.9 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .543 | .406 | .154 | .035 |

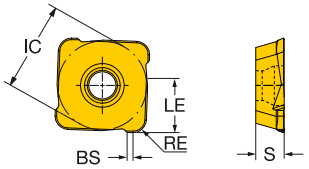
I59 I222 I254 N22 N10

# CoroMill® 490 insert for milling

**Advanced cutting materials**

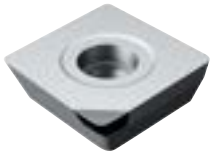
KRINS 90°

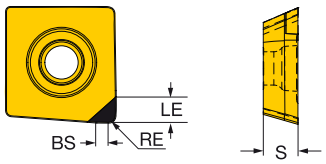





| | | RE | Ordering code | K 6190 | H 6190 | Dimensions, mm, inch IC | LE | S | BS |
|---|---|---|---|---|---|---|---|---|---|
| Medium | PO | 14 2.00 | 490R-140420E | ★ | ☆ | 13.8 | 5.0 | 3.90 | 0.8 |
| | | .079 | | | | .543 | .197 | .154 | .031 |
| | | 2.00 | 490R-140408E | ★ | | 13.8 | 5.0 | 3.90 | 0.8 |
| | | .079 | | | | .543 | .197 | .154 | .031 |

KRINS 90°






| | | RE | Ordering code | K CB50 | H CB50 | Dimensions, mm, inch IC | LE | S | BS |
|---|---|---|---|---|---|---|---|---|---|
| Medium | PO | 14 0.80 | 490R-140408E | ☆ | ★ | 13.8 | 2.0 | 3.90 | 1.5 |
| | | .031 | | | | .543 | .079 | .154 | .059 |

I59 I222 I254 N22 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 centers
- 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 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 adapters boost productivity with long overhangs

I73 I94 N6

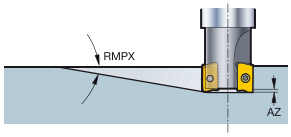


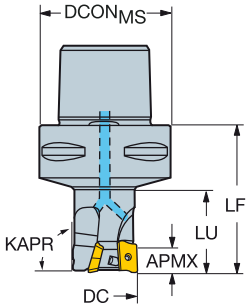
SANDVIK Coromant

# CoroMill® 390 square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

STDNO ISO26623-1
KAPR 90°




## Metric version

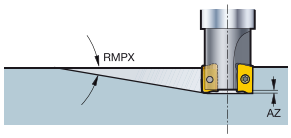
| DC | | CZC$_{MS}$ | APMX$_{EFW}$ | APMX$_{FFW}$ | RMPX | AZ | CNSC | | | Ordering code | Dimensions, mm DCON$_{MS}$ | LF | LU | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 16.0 | 11 | C3 | 5.5 | 10.00 | 10° | 1.0 | 3 | 2 | | R390-016C3-11L050 | 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.. |

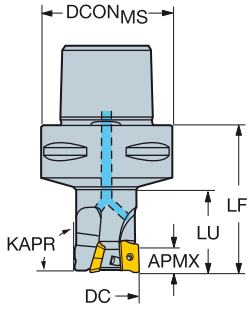
I94 L2 N22 N6 N9 N15

# CoroMill® 390 square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

STDNO ISO26623-1
KAPR 90°




## Metric version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | Ordering code | Dimensions, mm DCONMS | 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 the complete list of spare parts, visit www.sandvik.coromant.com

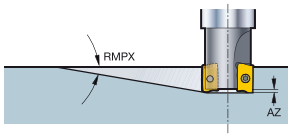
I94 L2 N22 N6 N9 N15

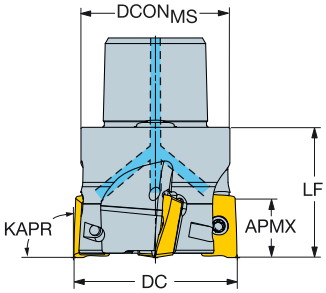
# CoroMill® 390 square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

**Short version without gripper grooves**

STDNO ISO26623-1
KAPR 90°




## Metric version

| 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 the complete list of spare parts, visit www.sandvik.coromant.com

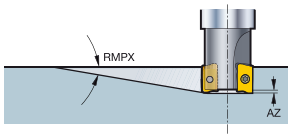
I94 L2 N22 N6 N9 N15

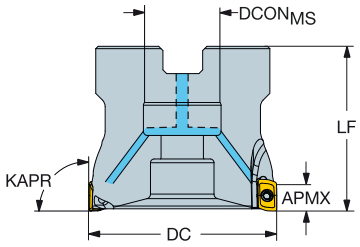
# CoroMill® 390 square shoulder milling cutter

**Arbor - Internal coolant supply**

**Lightweight shoulder milling cutter**

KAPR 90°




## Metric version

| 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.. |

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | Ordering code | Dimensions, inch DCONMS | ISO | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.000 | 11 | 3/4 | .217 | .394 | 1° | .039 | 1 | 3 | **RA390-051R19LW-11L** | .750 | A | 1.181 | .8 | 0.15 | 10000 | 3 | R390-11.. |
| | 11 | 3/4 | .217 | .394 | 1° | .039 | 1 | 4 | **RA390-051R19LW-11M** | .750 | A | 1.181 | .8 | 0.15 | 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 |
| 2.000 | 11 | 5513 020-35 | 3213 030-606 |

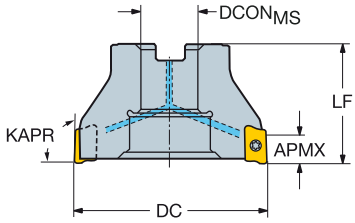
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 N22 N15

# CoroMill® 390 square shoulder milling cutter

**Arbor - Internal coolant supply**

STDNO ISO6462
KAPR 90°



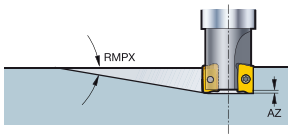

**Metric version**

| 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 | 0.23 | 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 | 0.24 | 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 | 0.20 | 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 | | 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 | | 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 | 0.51 | 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 | | 5 | 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.. |

I94 L2 M1 N22 N6 N9 N15

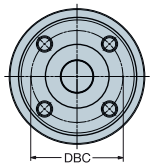
# CoroMill® 390 square shoulder milling cutter

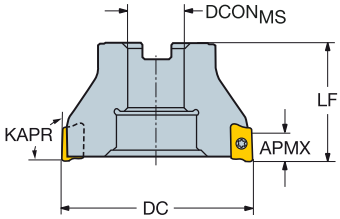
**Arbor**




STDNO
KAPR

ISO 6462:2011
90°




**Metric version**

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

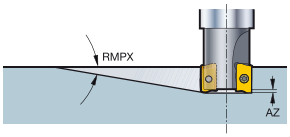
| | Spare parts |
|---|---|
| | Insert screw |
| 07 | 5513 020-82 |
| 11 | 5513 020-35 |
| 17 | 5513 020-39 |
| 18 | 5513 020-29 |

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

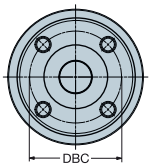
I94 L2 M1 N22 N6 N9

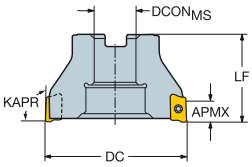
# CoroMill® 390 square shoulder milling cutter

**Arbor**




KAPR 90°




## Inch version

| DC | | CZC$_{MS}$ | APMX$_{FFW}$ | APMX$_{EFW}$ | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCON$_{MS}$ | DBC | DCX | LF | FT/LBS | LBS | RPMX | MIID$_{E}$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.500 | 11 | 3/4 | .394 | .217 | 2° | .039 | 1 | 6 | | RA390-038R19-11H | .750 | | 1.500 | 1.575 | .8 | 1.01 | 22700 | R390-11.. |
| | 11 | 3/4 | .394 | .217 | 2° | .039 | 1 | 4 | | RA390-038R19-11M | .750 | | 1.500 | 1.575 | .8 | 1.10 | 22700 | R390-11.. |
| 2.000 | 11 | 3/4 | .394 | .217 | 1° | .039 | 1 | 5 | | RA390-051R19-11M | .750 | | 2.000 | 1.575 | .8 | 1.47 | 23500 | R390-11.. |
| | 11 | 3/4 | .394 | .217 | 1° | .039 | 1 | 7 | | RA390-051R19-11H | .750 | | 2.000 | 1.575 | .8 | 1.32 | 23500 | R390-11.. |
| | 18 | 3/4 | .606 | .043 | 5° | .000 | 1 | | 3 | RA390-051R19-18L | .750 | | 2.000 | 1.575 | 2.2 | 1.32 | 7800 | R390-18.. |
| | 18 | 3/4 | .606 | .043 | 5° | .000 | 1 | 5 | | RA390-051R19-18H | .750 | | 2.000 | 1.575 | 2.2 | 1.28 | 7800 | R390-18.. |
| | 18 | 3/4 | .606 | .043 | 5° | .000 | 1 | | 4 | RA390-051R19-18M | .750 | | 2.000 | 1.575 | 2.2 | 1.23 | 7800 | R390-18.. |
| | 17 | 3/4 | .618 | .335 | 2° | .059 | 1 | 3 | | RA390-051R19-17L | .750 | | 2.000 | 1.575 | 2.2 | 1.32 | 18800 | R390-17.. |
| | 17 | 3/4 | .618 | .335 | 2° | .059 | 1 | 4 | | RA390-051R19-17M | .750 | | 2.000 | 1.575 | 2.2 | 1.19 | 18800 | R390-17.. |
| | 17 | 3/4 | .618 | .335 | 2° | .059 | 1 | 5 | | RA390-051R19-17H | .750 | | 2.000 | 1.575 | 2.2 | 1.28 | 18800 | R390-17.. |
| 2.500 | 11 | 3/4 | .394 | .217 | 1° | .039 | 1 | 8 | | RA390-063R19-11H | .750 | | 2.500 | 1.575 | .8 | 1.46 | 20700 | R390-11.. |
| | 11 | 3/4 | .394 | .217 | 1° | .039 | 1 | 6 | | RA390-063R19-11M | .750 | | 2.500 | 1.575 | .8 | 1.59 | 20700 | R390-11.. |
| | 18 | 3/4 | .606 | .043 | 4° | .000 | 1 | 6 | | RA390-063R19-18H | .750 | | 2.500 | 1.575 | 2.2 | 1.72 | 6800 | R390-18.. |
| | 18 | 3/4 | .606 | .043 | 4° | .000 | 1 | | 4 | RA390-063R19-18L | .750 | | 2.500 | 1.575 | 2.2 | 1.63 | 6800 | R390-18.. |
| | 18 | 3/4 | .606 | .043 | 4° | .000 | 1 | | 5 | RA390-063R19-18M | .750 | | 2.500 | 1.575 | 2.2 | 1.59 | 6800 | R390-18.. |
| | 17 | 3/4 | .618 | .335 | 2° | .059 | 1 | 6 | | RA390-063R19-17H | .750 | | 2.500 | 1.575 | 2.2 | 1.50 | 16500 | R390-17.. |
| | 17 | 3/4 | .618 | .335 | 2° | .059 | 1 | 5 | | RA390-063R19-17M | .750 | | 2.500 | 1.575 | 2.2 | 1.57 | 16500 | R390-17.. |
| | 17 | 3/4 | .618 | .335 | 2° | .059 | 1 | 4 | | RA390-063R19-17L | .750 | | 2.500 | 1.575 | 2.2 | 1.63 | 16500 | R390-17.. |
| 3.000 | 11 | 1 | .394 | .217 | 1° | .039 | 1 | 7 | | RA390-076R25-11M | 1.000 | | 3.000 | 1.969 | .8 | 2.95 | 18700 | R390-11.. |
| | 11 | 1 | .394 | .217 | 1° | .039 | 1 | 9 | | RA390-076R25-11H | 1.000 | | 3.000 | 1.969 | .8 | 4.85 | 18700 | R390-11.. |
| | 18 | 1 | .606 | .043 | 3° | .000 | 1 | | 6 | RA390-076R25-18M | 1.000 | | 3.000 | 1.969 | 2.2 | 2.63 | 6100 | R390-18.. |
| | 18 | 1 | .606 | .043 | 3° | .000 | 1 | | 4 | RA390-076R25-18L | 1.000 | | 3.000 | 1.969 | 2.2 | 2.38 | 6100 | R390-18.. |
| | 17 | 1 | .618 | .335 | 1° | .059 | 1 | 6 | | RA390-076R25-17M | 1.000 | | 3.000 | 1.969 | 2.2 | 2.21 | 14800 | R390-17.. |
| | 17 | 1 | .618 | .335 | 1° | .059 | 1 | 7 | | RA390-076R25-17H | 1.000 | | 3.000 | 1.969 | 2.2 | 2.16 | 14800 | R390-17.. |
| | 17 | 1 | .618 | .335 | 1° | .059 | 1 | 4 | | RA390-076R25-17L | 1.000 | | 3.000 | 1.969 | 2.2 | 2.34 | 14800 | R390-17.. |
| 3.150 | 18 | 1 | .606 | .043 | 3° | .000 | 1 | | 6 | RA390-080J25.4-18M | 1.000 | | 3.150 | 1.969 | 2.2 | 2.65 | 5900 | R390-18.. |
| | 17 | 1 | .618 | .335 | 1° | .059 | 1 | | 8 | RA390-080J25.4-17H | 1.000 | | 3.150 | 1.968 | 2.2 | 1.96 | 14400 | R390-17.. |
| | 17 | 1 | .618 | .335 | 1° | .059 | 1 | | 4 | RA390-080J25.4-17L | 1.000 | | 3.150 | 1.968 | 2.2 | 2.20 | 14400 | R390-17.. |
| | 17 | 1 | .618 | .335 | 1° | .059 | 1 | | 6 | RA390-080J25.4-17M | 1.000 | | 3.150 | 1.968 | 2.2 | 2.47 | 14400 | R390-17.. |
| 3.937 | 18 | 1 1/4 | .606 | .043 | 0° | .000 | 1 | | 7 | RA390-100J31.75-18M | 1.250 | | 3.937 | 1.969 | 2.2 | 4.63 | 5200 | R390-18.. |
| 4.000 | 18 | 1 1/2 | .606 | .043 | 2° | .000 | 1 | | 5 | RA390-102R38-18L | 1.500 | | 4.000 | 1.969 | 2.2 | 4.63 | 5200 | R390-18.. |
| | 18 | 1 1/2 | .606 | .043 | 2° | .000 | 1 | | 7 | RA390-102R38-18M | 1.500 | | 4.000 | 1.969 | 2.2 | 3.31 | 5200 | R390-18.. |
| | 17 | 1 1/2 | .618 | .335 | 0° | .059 | 1 | 9 | | RA390-102R38-17H | 1.500 | | 4.000 | 1.969 | 2.2 | 4.27 | 12600 | R390-17.. |
| | 17 | 1 1/2 | .618 | .335 | 0° | .059 | 1 | 5 | | RA390-102R38-17L | 1.500 | | 4.000 | 1.969 | 2.2 | 3.98 | 12600 | R390-17.. |
| | 17 | 1 1/2 | .618 | .335 | 0° | .059 | 1 | 7 | | RA390-102R38-17M | 1.500 | | 4.000 | 1.969 | 2.2 | 4.46 | 12600 | R390-17.. |
| 4.921 | 18 | 1 1/2 | .606 | .043 | 0° | .000 | 1 | | 8 | RA390-125J38.1-18M | 1.500 | | 4.921 | 2.480 | 2.2 | 6.61 | 4600 | R390-18.. |
| 5.000 | 18 | 1 1/2 | .606 | .043 | 1° | .000 | 1 | | 6 | RA390-127R38-18L | 1.500 | | 5.000 | 2.480 | 2.2 | 6.66 | 4600 | R390-18.. |
| | 18 | 1 1/2 | .606 | .043 | 1° | .000 | 1 | | 8 | RA390-127R38-18M | 1.500 | | 5.000 | 2.480 | 2.2 | 6.61 | 4600 | R390-18.. |
| | 17 | 1 1/2 | .618 | .335 | 0° | .059 | 1 | 6 | | RA390-127R38-17L | 1.500 | | 5.000 | 2.480 | 2.2 | 6.44 | 11200 | R390-17.. |
| | 17 | 1 1/2 | .618 | .335 | 0° | .059 | 1 | 11 | | RA390-127R38-17H | 1.500 | | 5.000 | 2.480 | 2.2 | 6.57 | 11200 | R390-17.. |
| | 17 | 1 1/2 | .618 | .335 | 0° | .059 | 1 | 8 | | RA390-127R38-17M | 1.500 | | 5.000 | 2.480 | 2.2 | 6.64 | 11200 | R390-17.. |
| 6.000 | 18 | 1 1/2 | .606 | .043 | 1° | .000 | 1 | | 8 | RA390-152R38-18L | 1.500 | | 6.000 | 2.480 | 2.2 | 9.30 | 4100 | R390-18.. |
| | 18 | 1 1/2 | .606 | .043 | 1° | .000 | 1 | | 12 | RA390-152R38-18M | 1.500 | | 6.000 | 2.480 | 2.2 | 9.52 | 4100 | R390-18.. |
| 6.299 | 18 | 2 | .606 | .043 | 0° | .000 | 0 | | 12 | RA390-160J50.8-18M | 2.000 | | 6.299 | 2.480 | 2.2 | 10.54 | 4000 | R390-18.. |
| 8.000 | 18 | 2 1/2 | .606 | .043 | 1° | .000 | 0 | | 10 | RA390-203R63-18L | 2.500 | 4.000 | 8.000 | 2.480 | 2.2 | 12.52 | 3500 | R390-18.. |

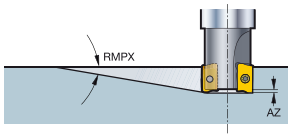
| | Spare parts |
|---|---|
| | Insert screw |
| 11 | 5513 020-35 |
| 17 | 5513 020-39 |
| 18 | 5513 020-29 |

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

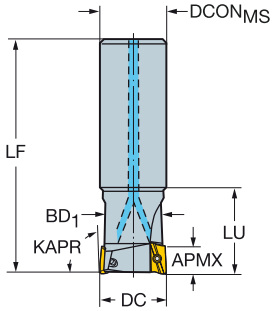
I94 L2 M1 N22 N9 N6

# CoroMill® 390 square shoulder milling cutter

**Cylindrical shank - Internal coolant supply**




KAPR 90°




## Metric version

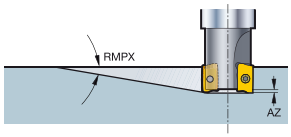
| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, mm DCONMS | BD | LF | LU | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 9.7 | 07 | 10 | 2.0 | 5.80 | 7° | 0.5 | 1 | 2 | | R390-0097A10-07L | 10.0 | 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 | 0.10 | 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 | 0.26 | 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 | 1.48 | 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.. |

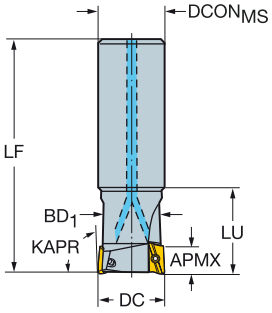
I94 L2 N22 N6 N9 N15

# CoroMill® 390 square shoulder milling cutter

**Cylindrical shank - Internal coolant supply**

KAPR 90°




## Metric version

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

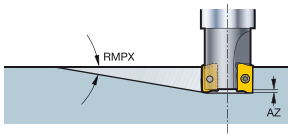
| | Spare parts | |
|---|---|---|
| DC | | Insert screw |
| 10.00-25.00 | 07 | 5513 020-82 |
| 12.00-22.00 | 11 | 5513 020-36 |
| 25.00-40.00 | 11 | 5513 020-35 |
| 25.00 | 17 | 5513 020-37 |
| 32.00-40.00 | 17 | 5513 020-39 |

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

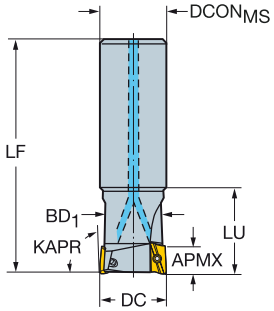
I94 L2 N22 N6 N9 N15

# CoroMill® 390 square shoulder milling cutter

**Cylindrical shank - Internal coolant supply**




KAPR 90°




## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | BD | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .375 | 07 | 5/16 | .079 | .228 | 7° | .020 | 1 | 2 | | RA390-010O08L-07L | .313 | .355 | 3.937 | | .3 | 0.16 | 56600 | 2 | 390R-07.. |
| | 07 | 3/8 | .079 | .228 | 7° | .020 | 1 | 2 | | RA390-010O10-07L | .375 | .355 | 2.362 | .591 | .3 | 0.15 | 56600 | 2 | 390R-07.. |
| .500 | 07 | 3/8 | .079 | .228 | 4° | .020 | 1 | 2 | | RA390-013O10L-07L | .375 | .472 | 4.724 | | .3 | 0.23 | 44500 | 2 | 390R-07.. |
| | 07 | 1/2 | .079 | .228 | 4° | .020 | 1 | 2 | | RA390-013O13-07L | .500 | .472 | 2.756 | .709 | .3 | 0.22 | 44500 | 2 | 390R-07.. |
| | 07 | 1/2 | .079 | .228 | 4° | .020 | 1 | | 3 | RA390-013O13-07M | .500 | .472 | 2.756 | .709 | .3 | 0.21 | 44500 | 3 | 390R-07.. |
| .625 | 07 | 9/16 | .079 | .228 | 3° | .020 | 1 | | 3 | RA390-016O14L-07M | .563 | .586 | 6.299 | | .3 | 0.50 | 24100 | 3 | 390R-07.. |
| | 07 | 5/8 | .079 | .228 | 3° | .020 | 1 | | 3 | RA390-016O16-07M | .625 | .586 | 3.543 | .984 | .3 | 0.35 | 37800 | 3 | 390R-07.. |
| | 07 | 5/8 | .079 | .228 | 3° | .020 | 1 | | 4 | RA390-016O16-07H | .625 | .586 | 3.543 | .984 | .3 | 0.35 | 37800 | 4 | 390R-07.. |
| | 11 | 5/8 | .217 | .394 | 10° | .039 | 1 | 2 | | RA390-016O16L-11L | .625 | | 5.700 | 1.375 | .8 | 0.71 | 31000 | 2 | R390-11.. |
| .750 | 07 | 3/4 | .079 | .228 | 2° | .020 | 1 | | 4 | RA390-019O19-07M | .750 | .711 | 4.331 | .984 | .3 | 0.57 | 33500 | 4 | 390R-07.. |
| | 07 | 3/4 | .079 | .228 | 2° | .020 | 1 | | 5 | RA390-019O19-07H | .750 | .711 | 4.331 | .984 | .3 | 0.55 | 33500 | 5 | 390R-07.. |
| | 11 | 3/4 | .217 | .394 | 5° | .039 | 1 | 2 | | RA390-019O19L-11L | .750 | | 6.500 | 1.625 | .8 | 1.46 | 22100 | 2 | R390-11.. |
| 1.000 | 07 | 1 | .079 | .228 | 1° | .020 | 1 | | 5 | RA390-025O25-07M | 1.000 | .961 | 4.724 | 1.260 | .3 | 1.04 | 28000 | 5 | 390R-07.. |
| | 07 | 1 | .079 | .228 | 1° | .020 | 1 | | 7 | RA390-025O25-07H | 1.000 | .961 | 4.724 | 1.260 | .3 | 1.05 | 28000 | 7 | 390R-07.. |
| | 11 | 1 | .217 | .394 | 4° | .039 | 1 | 2 | | RA390-025O25L-11L | 1.000 | | 8.000 | 2.125 | .8 | 1.77 | 12100 | 2 | R390-11.. |
| | 11 | 1 | .217 | .394 | 4° | .039 | 1 | 3 | | RA390-025O25L-11M | 1.000 | | 8.000 | 2.125 | .8 | 1.78 | 12100 | 3 | R390-11.. |
| | 17 | 1 | .335 | .618 | 15° | .059 | 1 | 2 | | RA390-025O25L-17L | 1.000 | | 8.000 | 2.125 | 2.2 | 2.03 | 12100 | 2 | R390-17.. |
| 1.250 | 17 | 1 1/4 | .335 | .618 | 6° | .059 | 1 | 2 | | RA390-032O32L-17L | 1.250 | | 9.000 | 2.625 | 2.2 | 3.51 | 9000 | 2 | R390-17.. |
| | 17 | 1 1/4 | .335 | .618 | 6° | .059 | 1 | | 3 | RA390-032O32L-17M | 1.250 | | 9.000 | 2.625 | 2.2 | 3.26 | 9000 | 3 | R390-17.. |
| 1.500 | 17 | 1 1/4 | .335 | .618 | 4° | .059 | 1 | 2 | | RA390-038O32L-17L | 1.250 | | 9.000 | | 2.2 | 3.78 | 9000 | 2 | R390-17.. |
| | 17 | 1 1/4 | .335 | .618 | 4° | .059 | 1 | | 3 | RA390-038O32L-17M | 1.250 | | 9.000 | | 2.2 | 3.70 | 9000 | 3 | R390-17.. |

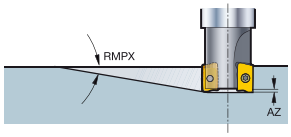
| | | Spare parts |
|---|---|---|
| DC" | | Insert screw |
| .375-1.000 | 07 | 5513 020-82 |
| .625-.750 | 11 | 5513 020-36 |
| 1.000 | 11 | 5513 020-35 |
| 1.000 | 17 | 5513 020-37 |
| 1.250-1.500 | 17 | 5513 020-39 |

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

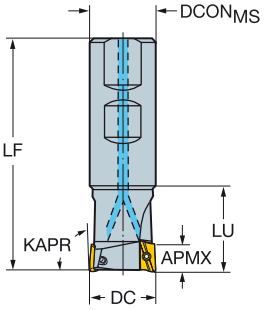
I94 L2 N22 N6 N9 N15

# CoroMill® 390 square shoulder milling cutter

**Weldon – Internal coolant supply**




STDNO ISO3338-2
KAPR 90°




## Metric version

| DC | | CZC$_{MS}$ | APMX$_{EFW}$ | APMX$_{FFW}$ | RMPX | AZ | CNSC | | | Ordering code | Dimensions, mm DCON$_{MS}$ | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 110.0 | | 3.0 | 0.80 | 21900 | 4 | R390-17.. |

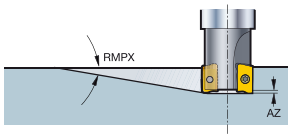
| | | Spare parts |
|---|---|---|
| DC | | Insert screw |
| 12.00-20.00 | 11 | 5513 020-36 |
| 25.00-40.00 | 11 | 5513 020-35 |
| 25.00 | 17 | 5513 020-37 |
| 32.00-40.00 | 17 | 5513 020-39 |

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

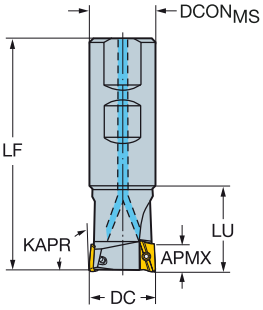
I94 L2 N22 N6 N9 N15

# CoroMill® 390 square shoulder milling cutter

**Weldon – Internal coolant supply**




STDNO ISO3338-2
KAPR 90°




## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .500 | 11 | 5/8 | .217 | .394 | 5° | .039 | 1 | 1 | | RA390-013M16-11L | .625 | 2.882 | .715 | .8 | 0.37 | 64400 | 1 | R390-11.. |
| .625 | 11 | 3/4 | .217 | .394 | 10° | .039 | 1 | 2 | | RA390-016M19-11L | .750 | 3.250 | 1.020 | .8 | 0.50 | 41800 | 2 | R390-11.. |
| .750 | 11 | 3/4 | .217 | .394 | 5° | .039 | 1 | 2 | | RA390-019M19-11L | .750 | 3.351 | 1.020 | .8 | 0.49 | 35900 | 2 | R390-11.. |
| | 11 | 3/4 | .217 | .394 | 5° | .039 | 1 | 3 | | RA390-019M19-11M | .750 | 3.351 | 1.020 | .8 | 0.53 | 35900 | 3 | R390-11.. |
| 1.000 | 11 | 3/4 | .217 | .394 | 4° | .039 | 1 | 2 | | RA390-025M19-11L | .750 | 3.501 | | .8 | 0.69 | 36100 | 2 | R390-11.. |
| | 11 | 1 | .217 | .394 | 4° | .039 | 1 | 2 | | RA390-025M25-11L | 1.000 | 3.751 | 1.250 | .8 | 0.96 | 36100 | 2 | R390-11.. |
| | 11 | 3/4 | .217 | .394 | 4° | .039 | 1 | 3 | | RA390-025M19-11M | .750 | 3.501 | | .8 | 0.69 | 36100 | 3 | R390-11.. |
| | 11 | 1 | .217 | .394 | 4° | .039 | 1 | 3 | | RA390-025M25-11M | 1.000 | 3.751 | 1.250 | .8 | 0.84 | 36100 | 3 | R390-11.. |
| | 11 | 3/4 | .217 | .394 | 4° | .039 | 1 | 4 | | RA390-025M19-11H | .750 | 3.501 | | .8 | 0.65 | 36100 | 4 | R390-11.. |
| | 11 | 1 | .217 | .394 | 4° | .039 | 1 | 4 | | RA390-025M25-11H | 1.000 | 3.751 | 1.250 | .8 | 0.96 | 36100 | 4 | R390-11.. |
| | 17 | 1 | .335 | .618 | 14° | .059 | 1 | 2 | | RA390-025M25-17L | 1.000 | 4.001 | 1.500 | 2.2 | 1.04 | 30500 | 2 | R390-17.. |
| 1.250 | 11 | 1 1/4 | .217 | .394 | 3° | .039 | 1 | 2 | | RA390-032M32-11L | 1.250 | 3.751 | 1.350 | .8 | 1.37 | 31200 | 2 | R390-11.. |
| | 11 | 1 1/4 | .217 | .394 | 3° | .039 | 1 | | 3 | RA390-032M32-11M | 1.250 | 3.751 | 1.350 | .8 | 1.23 | 31200 | 3 | R390-11.. |
| | 11 | 1 1/4 | .217 | .394 | 3° | .039 | 1 | | 5 | RA390-032M32-11H | 1.250 | 3.751 | 1.350 | .8 | 1.23 | 31200 | 5 | R390-11.. |
| | 17 | 1 1/4 | .335 | .618 | 6° | .059 | 1 | 2 | | RA390-032M32-17L | 1.250 | 4.001 | 1.580 | 2.2 | 1.45 | 25700 | 2 | R390-17.. |
| | 17 | 1 1/4 | .335 | .618 | 6° | .059 | 1 | | 3 | RA390-032M32-17M | 1.250 | 4.001 | 1.580 | 2.2 | 1.23 | 25700 | 3 | R390-17.. |
| 1.500 | 11 | 1 1/4 | .217 | .394 | 2° | .039 | 1 | 2 | | RA390-038M32-11L | 1.250 | 4.001 | | .8 | 1.70 | 27800 | 2 | R390-11.. |
| | 11 | 1 1/4 | .217 | .394 | 2° | .039 | 1 | | 4 | RA390-038M32-11M | 1.250 | 4.001 | | .8 | 1.70 | 27800 | 4 | R390-11.. |
| | 11 | 1 1/4 | .217 | .394 | 2° | .039 | 1 | | 6 | RA390-038M32-11H | 1.250 | 4.001 | | .8 | 1.50 | 27800 | 6 | R390-11.. |
| | 17 | 1 1/4 | .335 | .618 | 4° | .059 | 1 | 2 | | RA390-038M32-17L | 1.250 | 4.501 | | 2.2 | 1.72 | 22700 | 2 | R390-17.. |
| | 17 | 1 1/4 | .335 | .618 | 4° | .059 | 1 | | 3 | RA390-038M32-17M | 1.250 | 4.501 | | 2.2 | 1.69 | 22700 | 3 | R390-17.. |
| | 17 | 1 1/4 | .335 | .618 | 4° | .059 | 1 | | 4 | RA390-038M32-17H | 1.250 | 4.501 | | 2.2 | 1.70 | 22700 | 4 | R390-17.. |

| | | Spare parts |
|---|---|---|
| DC" | | Insert screw |
| .500-.750 | 11 | 5513 020-36 |
| 1.000-1.500 | 11 | 5513 020-35 |
| 1.000 | 17 | 5513 020-37 |
| 1.250-1.500 | 17 | 5513 020-39 |

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

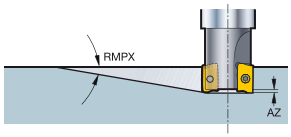
I94 L2 N22 N6 N9 N15



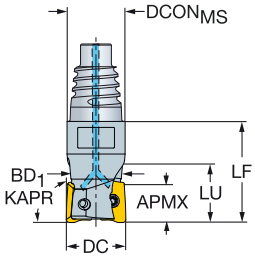
SANDVIK Coromant

# CoroMill® 390 square shoulder milling cutter

**Coromant EH – Internal coolant supply**




KAPR 90°




## Metric version

| DC | | CZC$_{MS}$ | APMX$_{EFW}$ | APMX$_{FFW}$ | RMPX | AZ | CNSC | | Ordering code | Dimensions, mm DCON$_{MS}$ | BD | 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 | 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 | 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 | 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 | 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 | 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 | | 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 | | 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 | | 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 | 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 | 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 | 25.0 | 15.7 | 0.5 | 0.06 | 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 | | 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 | 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 | 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 | 0.09 | 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 | | 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 | 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 | | 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 | 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 | 0.14 | 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 | | 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 | | 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 | 0.17 | 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.. |

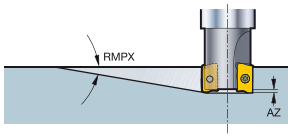
| | | Spare parts |
|---|---|---|
| DC | | Insert screw |
| 10.00-25.00 | 07 | 5513 020-82 |
| 16.00-22.00 | 11 | 5513 020-36 |
| 25.00-32.00 | 11 | 5513 020-35 |
| 25.00 | 17 | 5513 020-37 |
| 32.00 | 17 | 5513 020-39 |

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

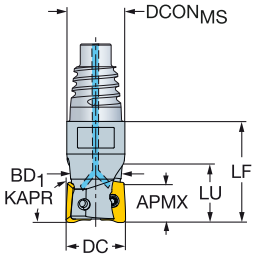
I94 L2 N22 N6 N9 N15 N3

# CoroMill® 390 square shoulder milling cutter

**Coromant EH – Internal coolant supply**




KAPR 90°




## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | BD | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .375 | 07 | E10 | .079 | .228 | 7° | .020 | 1 | 2 | | RA390-010EH10-07L | .364 | .355 | .787 | .492 | .3 | 0.17 | 56600 | 2 | 390R-07.. |
| .500 | 07 | E12 | .079 | .228 | 4° | .020 | 1 | 2 | | RA390-013EH12-07L | .484 | .472 | .787 | .469 | .3 | 0.27 | 44500 | 2 | 390R-07.. |
| | 07 | E12 | .079 | .228 | 4° | .020 | 1 | | 3 | RA390-013EH12-07M | .484 | .472 | .787 | .469 | .3 | 0.27 | 44500 | 3 | 390R-07.. |
| .625 | 07 | E16 | .079 | .228 | 3° | .020 | 1 | | 3 | RA390-016EH16-07M | .610 | .586 | .984 | .618 | .3 | 0.30 | 37800 | 3 | 390R-07.. |
| | 07 | E16 | .079 | .228 | 3° | .020 | 1 | | 4 | RA390-016EH16-07H | .610 | .586 | .984 | .618 | .3 | 0.30 | 37800 | 4 | 390R-07.. |
| | 11 | E16 | .217 | .394 | 10° | .039 | 1 | 2 | | RA390-016EH16-11L | .610 | | 1.063 | | .8 | 0.25 | 41800 | 2 | R390-11.. |
| .750 | 07 | E20 | .079 | .228 | 2° | .020 | 1 | | 4 | RA390-019EH20-07M | .728 | .711 | .984 | .567 | .3 | 0.27 | 33500 | 4 | 390R-07.. |
| | 07 | E20 | .079 | .228 | 2° | .020 | 1 | | 5 | RA390-019EH20-07H | .728 | .711 | .984 | .567 | .3 | 0.27 | 33500 | 5 | 390R-07.. |
| | 11 | E20 | .217 | .394 | 5° | .039 | 1 | 2 | | RA390-019EH20-11L | .728 | | 1.181 | | .8 | 0.31 | 35900 | 2 | R390-11.. |
| | 11 | E20 | .217 | .394 | 5° | .039 | 1 | 3 | | RA390-019EH20-11M | .728 | | 1.181 | | .8 | 0.28 | 35900 | 3 | R390-11.. |
| 1.000 | 07 | E25 | .079 | .228 | 1° | .020 | 1 | | 5 | RA390-025EH25-07M | .965 | .961 | .984 | .547 | .3 | 0.45 | 28000 | 5 | 390R-07.. |
| | 07 | E25 | .079 | .228 | 1° | .020 | 1 | | 7 | RA390-025EH25-07H | .965 | .961 | .984 | .547 | .3 | 0.45 | 28000 | 7 | 390R-07.. |
| | 11 | E25 | .217 | .394 | 4° | .039 | 1 | 2 | | RA390-025EH25-11L | .965 | | 1.378 | | .8 | 0.46 | 36100 | 2 | R390-11.. |
| | 11 | E25 | .217 | .394 | 4° | .039 | 1 | 3 | | RA390-025EH25-11M | .965 | | 1.378 | | .8 | 0.44 | 36100 | 3 | R390-11.. |
| | 11 | E25 | .217 | .394 | 4° | .039 | 1 | 4 | | RA390-025EH25-11H | .965 | | 1.378 | | .8 | 0.26 | 36100 | 4 | R390-11.. |
| | 17 | E25 | .335 | .618 | 14° | .059 | 1 | 2 | | RA390-025EH25-17L | .965 | | 1.575 | | 2.2 | 0.26 | 30500 | 2 | R390-17.. |
| 1.250 | 11 | E25 | .217 | .394 | 3° | .039 | 1 | | 3 | RA390-032EH25-11M | .965 | | 1.378 | | .8 | 0.29 | 31200 | 3 | R390-11.. |
| | 11 | E25 | .217 | .394 | 3° | .039 | 1 | | 5 | RA390-032EH25-11H | .965 | | 1.378 | | .8 | 0.29 | 31200 | 5 | R390-11.. |
| | 17 | E25 | .335 | .618 | 6° | .059 | 1 | 2 | | RA390-032EH25-17L | .965 | | 1.575 | | 2.2 | 0.50 | 25700 | 2 | R390-17.. |
| | 17 | E25 | .335 | .618 | 6° | .059 | 1 | | 3 | RA390-032EH25-17M | .965 | | 1.575 | | 2.2 | 0.49 | 25700 | 3 | R390-17.. |

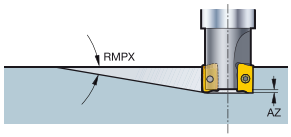
| | Spare parts |
|---|---|
| DC" | Insert screw |
| .375-1.000 | 5513 020-82 |
| .625-.750 | 5513 020-36 |
| 1.000-1.250 | 5513 020-35 |
| 1.000 | 5513 020-37 |
| 1.250 | 5513 020-39 |

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

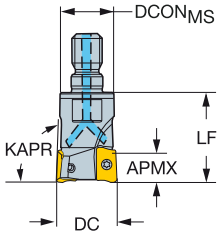
I94 L2 N22 N6 N9 N15 N3

# CoroMill® 390 square shoulder milling cutter

**Threaded coupling – Internal coolant supply**




KAPR 90°




## Metric version

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

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | Ordering code | Dimensions, inch DCONMS | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .625 | 11 | M8 | .217 | .394 | 10° | .039 | 0 | 2 | RA390-16T08-11L | .504 | .906 | .8 | 0.29 | 10900 | 2 | R390-11.. |
| .750 | 11 | M10 | .217 | .394 | 5° | .039 | 1 | 2 | RA390-19T10-11L | .701 | 1.181 | .8 | 0.34 | 9900 | 2 | R390-11.. |
| 1.000 | 11 | M12 | .217 | .394 | 4° | .039 | 1 | 3 | RA390-25T12-11M | .819 | 1.378 | .8 | 0.43 | 8100 | 3 | R390-11.. |
| 1.250 | 11 | M16 | .217 | .394 | 3° | .039 | 1 | 3 | RA390-32T16-11M | 1.134 | 1.693 | .8 | 0.80 | 9100 | 3 | R390-11.. |
| 1.500 | 11 | M16 | .217 | .394 | 2° | .039 | 1 | 4 | RA390-38T16-11M | 1.134 | 1.693 | .8 | 0.79 | 9100 | 4 | R390-11.. |

| | | | Spare parts |
|---|---|---|---|
| DC | DC" | | Insert screw |
| 16.00-20.00 | .625-.787 | 11 | 5513 020-36 |
| 25.00-42.00 | .984-1.653 | 11 | 5513 020-35 |

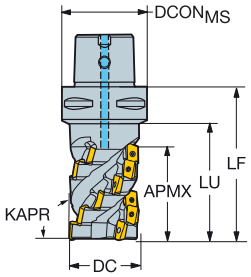
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 L2 N22 N6 N9 N15

# CoroMill® 390 long edge square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

KAPR 90°




**Metric version**

| 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 | 80.5 | 1.2 | 0.97 | 17800 | 15 | R390-11.. |
| | 18 | C4 | 43.00 | 3 | 2 | | R390-044C4-43L | 40.0 | 78.6 | 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 | 0.90 | 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 | 1.60 | 7900 | 10 | R390-18.. |
| | 18 | C8 | 57.00 | 3 | | 3 | R390-050C8-57M | 80.0 | 102.6 | 67.0 | 3.0 | 2.40 | 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 | 89.4 | 1.2 | 1.70 | 16000 | 24 | R390-11.. |
| | 18 | C5 | 43.00 | 3 | | 3 | R390-054C5-43M | 50.0 | 78.6 | 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 | 82.5 | 1.2 | 2.00 | 13900 | 20 | R390-11.. |
| | 18 | C6 | 57.00 | 3 | | 3 | R390-066C6-57L | 63.0 | 94.6 | 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 | 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 | 102.6 | 3.0 | 5.46 | 5200 | 16 | R390-18.. |
| | 18 | C8 | 71.00 | 3 | | 4 | R390-100C8-71M | 80.0 | 116.7 | 116.7 | 3.0 | 6.01 | 5200 | 20 | R390-18.. |
| | 18 | C8 | 57.00 | 3 | 6 | | R390-100C8-57H | 80.0 | 102.6 | 102.6 | 3.0 | 5.08 | 5200 | 24 | R390-18.. |

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

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

I94 L2 N22 N6 N9 N15

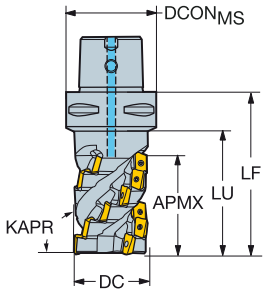


SANDVIK Coromant

# CoroMill® 390 long edge square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

KAPR 90°




**Inch version**

| DC | | CZC$_{MS}$ | APMX$_{FFW}$ | CNSC | | | Ordering code | Dimensions, inch DCON$_{MS}$ | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.250 | 11 | C5 | 1.420 | 3 | | 3 | RA390-032C5-36M | 1.969 | 2.820 | 1.810 | .8 | 2.48 | 21700 | 12 | R390-11.. |
| | 11 | C5 | 2.130 | 3 | 2 | | RA390-032C5-54L | 1.969 | 3.517 | 2.480 | .8 | 2.51 | 21700 | 12 | R390-11.. |
| | 11 | C6 | 2.480 | 3 | 2 | | RA390-032C6-63L | 2.480 | 3.944 | 2.480 | .8 | 3.31 | 21700 | 14 | R390-11.. |
| | 11 | C6 | 1.770 | 3 | 3 | | RA390-032C6-45M | 2.480 | 3.247 | 2.130 | .8 | 3.22 | 21700 | 15 | R390-11.. |
| | 11 | C5 | 2.130 | 3 | | 3 | RA390-032C5-54M | 1.969 | 3.517 | 2.480 | .8 | 2.49 | 21700 | 18 | R390-11.. |
| 1.500 | 11 | C6 | 1.770 | 3 | | 3 | RA390-038C6-45M | 2.480 | 3.247 | 2.130 | .8 | 3.52 | 19500 | 15 | R390-11.. |
| | 11 | C6 | 3.150 | 3 | | 2 | RA390-038C6-80L | 2.480 | 4.641 | 3.550 | .8 | 3.88 | 19500 | 18 | R390-11.. |
| | 11 | C5 | 2.480 | 3 | | 3 | RA390-038C5-63M | 1.969 | 3.865 | 2.840 | .8 | 2.91 | 19500 | 21 | R390-11.. |
| | 11 | C6 | 2.480 | 3 | | 3 | RA390-038C6-63M | 2.480 | 3.944 | 2.840 | .8 | 3.68 | 19500 | 21 | R390-11.. |
| | 11 | C6 | 3.150 | 3 | | 3 | RA390-038C6-80M | 2.480 | 4.641 | 3.550 | .8 | 3.88 | 19500 | 27 | R390-11.. |
| | 11 | C5 | 2.480 | 3 | | 4 | RA390-038C5-63H | 1.969 | 3.865 | 2.840 | .8 | 2.92 | 19500 | 28 | R390-11.. |
| 2.000 | 11 | C5 | 1.770 | 3 | | 4 | RA390-051C5-45M | 1.969 | 3.168 | | .8 | 3.43 | 16600 | 20 | R390-11.. |
| | 11 | C5 | 1.770 | 3 | | 5 | RA390-051C5-45H | 1.969 | 3.168 | | .8 | 3.28 | 16600 | 25 | R390-11.. |
| | 11 | C5 | 2.480 | 3 | | 4 | RA390-051C5-63M | 1.969 | 3.865 | | .8 | 3.81 | 16600 | 28 | R390-11.. |
| | 11 | C6 | 3.500 | 3 | | 3 | RA390-051C6-98L | 2.480 | 5.338 | 4.250 | .8 | 5.25 | 16600 | 33 | R390-11.. |
| | 18 | C5 | 1.720 | 3 | | 3 | RA390-051C5-43M | 1.969 | 3.093 | | 2.2 | 3.18 | 7800 | 9 | R390-18.. |
| | 18 | C6 | 1.720 | 3 | | 3 | RA390-051C6-43M | 2.480 | 3.172 | 2.110 | 2.2 | 3.75 | 7800 | 9 | R390-18.. |
| | 18 | C6 | 2.820 | 3 | | 2 | RA390-051C6-71L | 2.480 | 4.278 | 3.210 | 2.2 | 4.45 | 7800 | 10 | R390-18.. |
| | 18 | C8 | 2.270 | 3 | | 3 | RA390-051C8-57M | 3.150 | 4.040 | 2.660 | 2.2 | 6.04 | 7800 | 12 | R390-18.. |
| | 18 | C6 | 3.930 | 3 | | 2 | RA390-051C6-99L | 2.480 | 5.384 | 4.320 | 2.2 | 4.98 | 7800 | 14 | R390-18.. |
| 2.500 | 18 | C6 | 1.720 | 3 | | 4 | RA390-063C6-43M | 2.480 | 3.172 | | 2.2 | 4.65 | 6800 | 12 | R390-18.. |
| | 18 | C6 | 2.270 | 3 | | 3 | RA390-063C6-57L | 2.480 | 3.725 | | 2.2 | 5.18 | 6800 | 12 | R390-18.. |
| | 18 | C6 | 2.820 | 3 | | 3 | RA390-063C6-71L | 2.480 | 4.278 | | 2.2 | 5.70 | 6800 | 15 | R390-18.. |
| | 18 | C6 | 2.270 | 3 | | 4 | RA390-063C6-57M | 2.480 | 3.725 | | 2.2 | 5.11 | 6800 | 16 | R390-18.. |
| | 18 | C6 | 2.820 | 3 | | 4 | RA390-063C6-71M | 2.480 | 4.278 | | 2.2 | 5.51 | 6800 | 20 | R390-18.. |
| | 18 | C6 | 3.930 | 3 | | 3 | RA390-063C6-99L | 2.480 | 5.384 | | 2.2 | 6.56 | 6800 | 21 | R390-18.. |
| 3.000 | 18 | C8 | 2.820 | 3 | | 3 | RA390-076C8-71L | 3.150 | 4.593 | 3.210 | 2.2 | 9.58 | 6100 | 15 | R390-18.. |

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

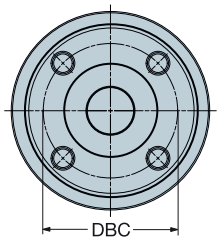
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 L2 N22 N6 N9 N15

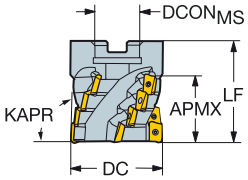
# CoroMill® 390 long edge square shoulder milling cutter

**Arbor**

STDNO
KAPR




ISO6462
90°




## Metric version

| 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 | 0.50 | 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.. |

## Inch version

| DC | | CZCMS | APMXFFW | | | Ordering code | Dimensions, inch DCONMS | ISO | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.000 | 11 | 3/4 | 1.420 | | 4 | RA390-051R19-36M | .750 | A | 2.229 | .8 | 2.20 | 16600 | 16 | R390-11.. |
| | 11 | 3/4 | 2.130 | | 3 | RA390-051R19-54M | .750 | A | 2.926 | .8 | 2.48 | 16600 | 18 | R390-11.. |
| | 11 | 3/4 | 1.420 | 5 | | RA390-051R19-36H | .750 | A | 2.229 | .8 | 2.27 | 16600 | 20 | R390-11.. |
| | 18 | 3/4 | 1.720 | | 3 | RA390-051R19-43M | .750 | A | 2.699 | 2.2 | 2.30 | 7800 | 9 | R390-18.. |
| | 18 | 3/4 | 2.270 | | 3 | RA390-051R19-57M | .750 | A | 3.252 | 2.2 | 2.49 | 7800 | 12 | R390-18.. |
| 2.500 | 18 | 1 | 2.270 | | 3 | RA390-063R25-57L | 1.000 | B | 3.252 | 2.2 | 3.40 | 6800 | 12 | R390-18.. |
| | 18 | 1 | 1.720 | | 4 | RA390-063R25-43M | 1.000 | B | 2.699 | 2.2 | 3.00 | 6800 | 16 | R390-18.. |
| 3.000 | 18 | 1 1/4 | 1.720 | | 4 | RA390-076R32-43H | 1.250 | B | 2.699 | 2.2 | 4.06 | 6100 | 12 | R390-18.. |
| 4.000 | 18 | 1 1/2 | 2.270 | | 4 | RA390-102R38-57M | 1.500 | B | 3.252 | 2.2 | 7.61 | 5200 | 16 | R390-18.. |
| | 18 | 1 1/2 | 2.270 | | 6 | RA390-102R38-57H | 1.500 | B | 3.252 | 2.2 | 4.29 | 5200 | 24 | R390-18.. |

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

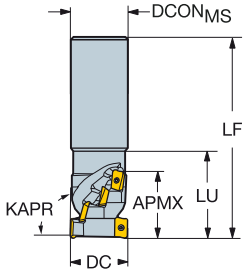
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 L2 M1 N22 N6 N9

# CoroMill® 390 long edge square shoulder milling cutter

## Cylindrical shank

KAPR 90°

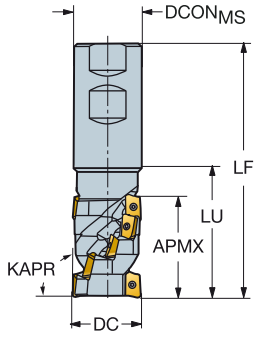



### Metric version

| 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.. |

## Weldon

STDNO ISO3338-2
KAPR 90°




### Inch version

| DC | | CZC$_{MS}$ | APMX$_{FFW}$ | | | Ordering code | Dimensions, inch DCON$_{MS}$ | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.250 | 11 | 1 1/4 | 1.770 | 2 | | RA390-032M32-45L | 1.250 | 4.663 | 2.259 | .8 | 1.61 | 21700 | 10 | R390-11.. |
| 1.500 | 11 | 1 1/2 | 2.130 | 2 | | RA390-038M38-54L | 1.500 | 5.418 | 2.633 | .8 | 2.59 | 19500 | 12 | R390-11.. |
| | 11 | 1 1/2 | 2.130 | | 3 | RA390-038M38-54M | 1.500 | 5.418 | 2.633 | .8 | 2.59 | 19500 | 18 | R390-11.. |

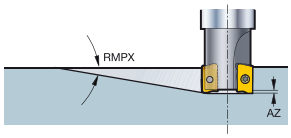
| Spare parts |
|---|
| Insert screw |
| 5513 024-01 |

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

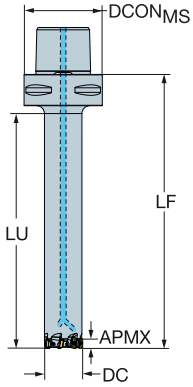
I94 L2 N22 N6 N9

# CoroMill® 390 damped square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**




STDNO ISO26623-1
KAPR 90°




**Metric version**

| 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 | 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 |

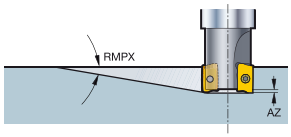
For the complete list of spare parts, visit www.sandvik.coromant.com

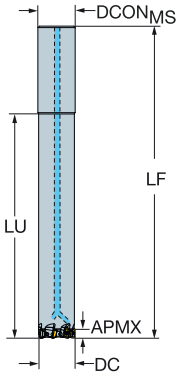
I94 L2 N22 N6 N9 N15 L167

# CoroMill® 390 damped square shoulder milling cutter

**Cylindrical shank - Internal coolant supply**

KAPR 90°




## Metric version

| 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.. |

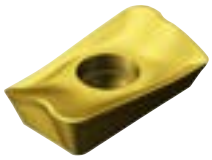
| | | Spare parts |
|---|---|---|
| DC | | Insert screw |
| 20.00-32.00 | 07 | 5513 020-82 |
| 20.00 | 11 | 5513 020-36 |
| 25.00-32.00 | 11 | 5513 020-35 |

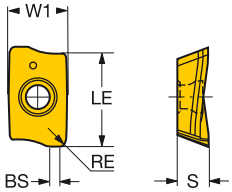
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 L2 N22 N6 N9 N15 L167

# CoroMill® 390 insert for milling

KRINS 90°






| | | | RE | Ordering code | P | | | | | M | | | | | | K | | | N | | | S | | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1130 | 4220 | 4230 | 4340 | 530 | 1040 | 1130 | 2050 | 2040 | 530 | S30T | 1020 | 3040 | 3330 | 1130 | 530 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS |
| Light | KL | 07 | 0.40 | 390R-070204E-KL | | | | | | | | | | | | ★ | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.80 | 390R-070208E-KL | | | | | | | | | | | | ★ | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | 11 | 0.80 | R390-11 T3 08E-KL | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .059 |
| | | | 0.80 | R390-11 T3 08M-KL | | | | | | | | | | | | ★ | ☆ | ☆ | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .047 |
| | | 17 | 0.80 | R390-17 04 08E-KL | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | | | 0.80 | R390-17 04 08M-KL | | | | | | | | | | | | ★ | ☆ | ☆ | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | | 18 | 0.80 | R390-18 06 08H-KL | | | | | | | | | | | | ★ | ☆ | ☆ | | | | | | | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 1.20 | R390-18 06 12H-KL | | | | | | | | | | | | ★ | ☆ | ☆ | | | | | | | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 3.10 | R390-18 06 31H-KL | | | | | | | | | | | | ★ | ☆ | ☆ | | | | | | | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | ML | 07 | 0.20 | 390R-070202E-ML | | | | | | ★ | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .008 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.40 | 390R-070204E-ML | | | | | | ★ | | | | | ☆ | | | | | | | | | | ★ | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.80 | 390R-070208E-ML | | | | | | ★ | | | | | ☆ | | | | | | | | | | ★ | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 1.20 | 390R-070212E-ML | | | | | | ★ | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 1.60 | 390R-070216E-ML | | | | | | ★ | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.2 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .008 |

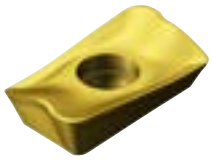
I73 I222 I254 N22 N10

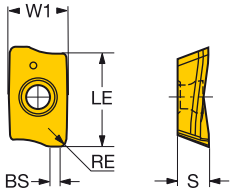


SANDVIK Coromant

# CoroMill® 390 insert for milling

KRINS 90°



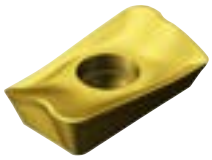


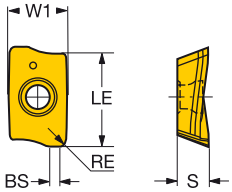

| | | | RE | Ordering code | P | | | | | M | | | | | | K | | | N | | | S | | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3330 | 1130 | 530 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS |
| Light | ML | 11 | 0.80 | R390-11 T3 08E-ML | | | | | | ★ | | ☆ | ☆ | | ☆ | | | | | | | | ☆ | ☆ | | ★ | ☆ | | | | 6.8 | 10.0 | 3.59 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .059 |
| | | | 1.60 | R390-11 T3 16E-ML | | | | | | ★ | | ☆ | ☆ | | ☆ | | | | | | | | ☆ | ☆ | | ★ | ☆ | | | | 6.8 | 10.0 | 3.59 | 0.8 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .031 |
| | | | 2.40 | R390-11 T3 24E-ML | | | | | | ★ | | ☆ | ☆ | | ☆ | | | | | | | | ☆ | ☆ | | ★ | ☆ | | | | 6.8 | 10.0 | 3.59 | |
| | | | .094 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | | 3.10 | R390-11 T3 31E-ML | | | | | | ★ | | ☆ | ☆ | | ☆ | | | | | | | | ☆ | ☆ | | ★ | ☆ | | | | 6.8 | 10.0 | 3.59 | |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | 17 | 0.80 | R390-17 04 08E-ML | | | | | | ★ | | ☆ | ☆ | | ☆ | | | | | | | | ☆ | ☆ | | ★ | ☆ | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | | 18 | 0.80 | R390-18 06 08H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 1.20 | R390-18 06 12H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 1.60 | R390-18 06 16H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 2.00 | R390-18 06 20H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 2.40 | R390-18 06 24H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .094 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 3.10 | R390-18 06 31H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 4.00 | R390-18 06 40H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .157 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 5.00 | R390-18 06 50H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 6.00 | R390-18 06 60H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 6.40 | R390-18 06 64H-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .252 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | NL | 07 | 0.20 | 390R-070202E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .008 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.40 | 390R-070204E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.80 | 390R-070208E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | 11 | 0.40 | R390-11 T3 04E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 6.8 | 10.0 | 3.59 | 0.9 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .035 |
| | | | 0.80 | R390-11 T3 08E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 6.8 | 10.0 | 3.59 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .059 |
| | | | 2.00 | R390-11 T3 20E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 6.8 | 10.0 | 3.59 | |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | | 3.10 | R390-11 T3 31E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 6.8 | 10.0 | 3.59 | |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | 17 | 0.80 | R390-17 04 08E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | | | 2.00 | R390-17 04 20E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 9.6 | 15.7 | 4.76 | 0.3 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .012 |
| | | | 3.10 | R390-17 04 31E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | | 4.00 | R390-17 04 40E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .157 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | | 5.00 | R390-17 04 50E-NL | | | | | | | | | | | | | | | | | ★ | | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |

I73 I222 I254 N22 N10

# CoroMill® 390 insert for milling

KRINS 90°






| | | RE | Ordering code | P | | | | | M | | | | | | K | | | N | | | S | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2050 | 2040 | 530 | S30T | 1020 | 3040 | 3330 | 1130 | 530 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS |
| Light | PL | 07 | 0.20 | 390R-070202E-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | | | | |
| | | | .008 | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.40 | 390R-070204E-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | | | | |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.80 | 390R-070208E-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | | | | |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 1.20 | 390R-070212E-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | | | | |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 1.60 | 390R-070216E-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | | | | |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .008 |
| | | 11 | 0.40 | R390-11 T3 04E-PL | ★ | | | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | | | | | |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .035 |
| | | | 0.80 | R390-11 T3 08E-PL | ★ | | | | ☆ | ☆ | | | ☆ | | | | | ☆ | ☆ | | ☆ | | | | | | ★ | ☆ | ☆ | 6.8 | 10.0 | 3.59 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .059 |
| | | | 0.80 | R390-11 T3 08M-PL | ★ | ☆ | ★ | ☆ | ☆ | ☆ | | | ☆ | ☆ | | | | ☆ | ☆ | | ☆ | | | | ★ | ☆ | ★ | ☆ | ☆ | 6.8 | 10.0 | 3.59 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .047 |
| | | 17 | 0.80 | R390-17 04 08E-PL | ★ | | | ★ | ☆ | ☆ | | | ☆ | | | | | ☆ | ☆ | | ☆ | | | | | | ★ | ☆ | ☆ | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | | | 0.80 | R390-17 04 08M-PL | ★ | ☆ | ★ | ☆ | ☆ | ☆ | | | ☆ | ☆ | | | | ☆ | ☆ | | ☆ | | | | ★ | ☆ | ★ | ☆ | ☆ | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | | 18 | 0.80 | R390-18 06 08H-PL | ★ | | ★ | ☆ | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 1.20 | R390-18 06 12H-PL | ★ | ☆ | ★ | ☆ | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 1.60 | R390-18 06 16H-PL | ★ | | | ★ | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 2.00 | R390-18 06 20H-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 2.40 | R390-18 06 24H-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .094 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 3.10 | R390-18 06 31H-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 4.00 | R390-18 06 40H-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .157 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 5.00 | R390-18 06 50H-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | ★ | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 6.00 | R390-18 06 60H-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | ★ | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |
| | | | 6.40 | R390-18 06 64H-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | ★ | ☆ | | 11.0 | 15.4 | 6.33 | 1.0 |
| | | | .252 | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .039 |

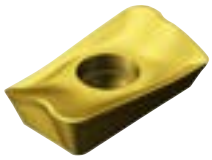
I73 I222 I254 N22 N10

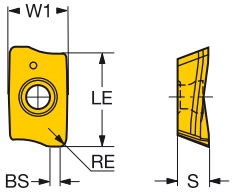


SANDVIK Coromant

# CoroMill® 390 insert for milling

KRINS 90°



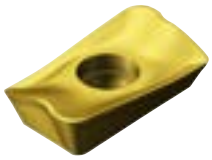


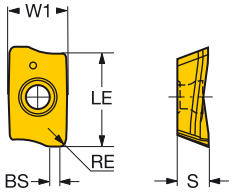

| | | | | | P | | | | | M | | | | | | K | | | N | | | S | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | RE | Ordering code | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3330 | 1130 | 530 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS |
| Medium | KM | 07 | 0.40 | 390R-070204M-KM | | | | | | | | | | | | ☆ | | ★ | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.80 | 390R-070208M-KM | | | | | | | | | | | | ☆ | | ★ | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 1.60 | 390R-070216M-KM | | | | | | | | | | | | ★ | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.2 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .008 |
| | | 11 | 0.20 | R390-11 T3 02E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | 0.7 |
| | | | .008 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .028 |
| | | | 0.40 | R390-11 T3 04M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | 0.9 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .035 |
| | | | 0.80 | R390-11 T3 08M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .047 |
| | | | 1.20 | R390-11 T3 12E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | 0.8 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .031 |
| | | | 1.60 | R390-11 T3 16E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | 0.8 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .031 |
| | | | 1.60 | R390-11 T3 16M-KM | | | | | | | | | | | | ☆ | | ★ | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | 0.4 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .016 |
| | | | 2.00 | R390-11 T3 20E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | 0.4 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .016 |
| | | | 2.40 | R390-11 T3 24E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | |
| | | | .094 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | | 3.10 | R390-11 T3 31E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | | 3.10 | R390-11 T3 31M-KM | | | | | | | | | | | | ☆ | | ★ | | | ★ | | | | ☆ | | | | | | 6.8 | 10.0 | 3.59 | |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | 17 | 0.40 | R390-17 04 04E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | 1.0 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .039 |

I73 I222 I254 N22 N10

# CoroMill® 390 insert for milling

KRINS 90°






| | | | RE | Ordering code | P | | | | | M | | | | | | K | | | N | | | S | | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2050 | 2040 | 530 | S30T | 1020 | 3040 | 3330 | 1130 | 530 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS |
| Medium | KM | 17 | 0.40 | R390-17 04 04M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | 1.0 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | *.039* |
| | | | 0.80 | R390-17 04 08M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | *.059* |
| | | | 1.20 | R390-17 04 12E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | 1.1 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | *.043* |
| | | | 1.60 | R390-17 04 16E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | 0.7 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | *.028* |
| | | | 1.60 | R390-17 04 16M-KM | | | | | | | | | | | | ☆ | | ★ | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | 0.7 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | *.028* |
| | | | 2.00 | R390-17 04 20E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | 0.3 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | *.012* |
| | | | 2.40 | R390-17 04 24E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .094 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | |
| | | | 3.10 | R390-17 04 31E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | |
| | | | 3.10 | R390-17 04 31M-KM | | | | | | | | | | | | ☆ | | ★ | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | |
| | | | 4.00 | R390-17 04 40E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .157 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | |
| | | | 4.80 | R390-17 04 48E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .189 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | |
| | | | 5.00 | R390-17 04 50E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | |
| | | | 6.00 | R390-17 04 60E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | |
| | | | 6.35 | R390-17 04 64E-KM | | | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.378* | *.618* | *.188* | |
| | | 18 | 0.80 | R390-18 06 08M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | | 11.0 | 15.4 | 6.33 | 1.1 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.433* | *.606* | *.249* | *.043* |
| | | | 1.20 | R390-18 06 12M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | | 11.0 | 15.4 | 6.33 | 1.1 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.433* | *.606* | *.249* | *.043* |
| | | | 1.60 | R390-18 06 16M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | | 11.0 | 15.4 | 6.33 | 1.1 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.433* | *.606* | *.249* | *.043* |
| | | | 2.00 | R390-18 06 20M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | | 11.0 | 15.4 | 6.33 | 0.5 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.433* | *.606* | *.249* | *.020* |
| | | | 3.10 | R390-18 06 31M-KM | | | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | | 11.0 | 15.4 | 6.33 | 0.5 |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.433* | *.606* | *.249* | *.020* |
| | KMR | 18 | 1.20 | R390-18 06 12M-KMR | | | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | | 11.0 | 15.4 | 6.33 | 0.3 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.433* | *.606* | *.249* | *.010* |

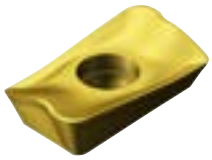
I73 I222 I254 N22 N10

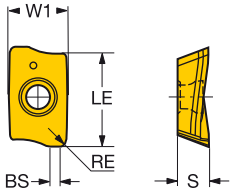


SANDVIK Coromant

# CoroMill® 390 insert for milling

KRINS 90°

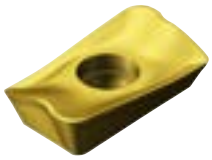


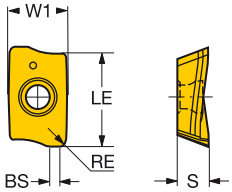



| | | | | | P | | | | | M | | | | | | K | | | N | | | S | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | RE | Ordering code | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3330 | 1130 | 530 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS |
| Medium | MM | 07 | 0.20 | 390R-070202M-MM | | | | | | ★ | | | | | | | | | | | | | | | | | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .008 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.40 | 390R-070204E-MM | | | | | | ★ | | | | | ☆ | | | | | | | | | | | ★ | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.40 | 390R-070204M-MM | | | | | | ★ | | | | | ☆ | | | | | | | | | | | ★ | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.80 | 390R-070208E-MM | | | | | | ★ | | | | | ☆ | | | | | | | | | | | ★ | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 0.80 | 390R-070208M-MM | | | | | | ★ | | | | | ☆ | | | | | | | | | | | ★ | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 1.20 | 390R-070212M-MM | | | | | | ★ | | | | | ☆ | | | | | | | | | | | ★ | | | | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .028 |
| | | | 1.60 | 390R-070216M-MM | | | | | | ★ | | | | | ☆ | | | | | | | | | | | ★ | | | | | 4.0 | 5.9 | 2.40 | 0.2 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .160 | .232 | .094 | .008 |
| | | 11 | 0.20 | R390-11 T3 02E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | 6.8 | 10.0 | 3.59 | 0.7 |
| | | | .008 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .028 |
| | | | 0.80 | R390-11 T3 08M-MM | | | | | | ★ | | ☆ | ☆ | | ☆ | | | | | | | | ☆ | ☆ | | ★ | ☆ | | | | 6.8 | 10.0 | 3.59 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .047 |
| | | | 1.20 | R390-11 T3 12E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | 6.8 | 10.0 | 3.59 | 0.8 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .031 |
| | | | 1.60 | R390-11 T3 16E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | 6.8 | 10.0 | 3.59 | 0.4 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .016 |
| | | | 2.00 | R390-11 T3 20E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | 6.8 | 10.0 | 3.59 | |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | | 2.40 | R390-11 T3 24E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | 6.8 | 10.0 | 3.59 | |
| | | | .094 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | | 3.10 | R390-11 T3 31E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | 6.8 | 10.0 | 3.59 | |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |

# CoroMill® 390 insert for milling

KRINS 90°






| | | | RE | Ordering code | P | | | | | M | | | | | | K | | | | N | | | S | | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3330 | 1130 | 530 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS |
| Medium | MM | 17 | 0.40 | R390-17 04 04E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.0 |
| | | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .039 |
| | | | 0.80 | R390-17 04 08M-MM | | | | | | ★ | | ☆ | ☆ | | ☆ | | | | | | | | ☆ | ☆ | | ★ | ☆ | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | | | 1.20 | R390-17 04 12E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.1 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .043 |
| | | | 1.60 | R390-17 04 16E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | 0.7 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .028 |
| | | | 2.00 | R390-17 04 20E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | 0.3 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .012 |
| | | | 2.40 | R390-17 04 24E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .094 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | | 3.10 | R390-17 04 31E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | | 4.00 | R390-17 04 40E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .157 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | | 4.80 | R390-17 04 48E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .189 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | | 5.00 | R390-17 04 50E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | | 6.00 | R390-17 04 60E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | | 6.35 | R390-17 04 64E-MM | | | | | | ★ | | ☆ | | | | | | | | | | | ★ | | | | | | | | | 9.6 | 15.7 | 4.76 | |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | 18 | 0.80 | R390-18 06 08M-MM | | | | | | ★ | | | ☆ | | | | | | | | | | | ★ | | | | | | | | 11.0 | 15.4 | 6.33 | 1.1 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .043 |
| | | | 1.20 | R390-18 06 12M-MM | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | | 11.0 | 15.4 | 6.33 | 1.1 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .043 |
| | | | 1.60 | R390-18 06 16M-MM | | | | | | ★ | | | ☆ | | | | | | | | | | | ★ | | | | | | | | 11.0 | 15.4 | 6.33 | 1.1 |
| | | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .043 |
| | | | 2.00 | R390-18 06 20M-MM | | | | | | ★ | | | ☆ | | | | | | | | | | | ★ | | | | | | | | 11.0 | 15.4 | 6.33 | 0.5 |
| | | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .020 |
| | | | 3.10 | R390-18 06 31M-MM | | | | | | ★ | | | ☆ | | | | | | | | | | | ★ | | | | | | | | 11.0 | 15.4 | 6.33 | 0.5 |
| | | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .020 |
| | MMR | 18 | 1.20 | R390-18 06 12M-MMR | | | | | | ★ | | | ☆ | | | | | | | | | | | ★ | | | | | | | | 11.0 | 15.4 | 6.33 | 0.3 |
| | | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .010 |

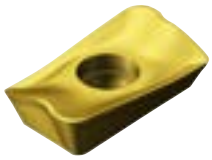
I73 I222 I254 N22 N10

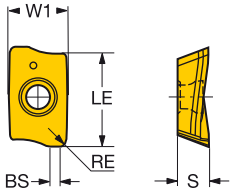


SANDVIK Coromant

# CoroMill® 390 insert for milling

KRINS 90°



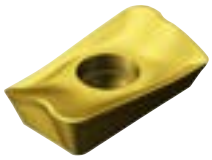


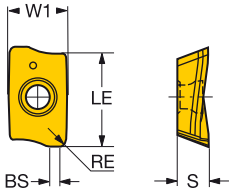

| | | | | | Ordering code | P | | | | | M | | | | | | K | | | N | | | S | | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | RE | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3330 | 1130 | 530 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS |
| Medium | PM | 07 | 0.20 | | 390R-070202M-PM | ★ | | | ★ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | *.008* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.160* | *.232* | *.094* | *.028* |
| | | | 0.40 | | 390R-070204M-PM | ★ | | ★ | ☆ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | *.016* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.160* | *.232* | *.094* | *.028* |
| | | | 0.80 | | 390R-070208M-PM | ★ | | ★ | ☆ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | *.031* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.160* | *.232* | *.094* | *.028* |
| | | | 1.20 | | 390R-070212M-PM | ★ | | | ★ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 4.0 | 5.9 | 2.40 | 0.7 |
| | | | *.047* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.160* | *.232* | *.094* | *.028* |
| | | | 1.60 | | 390R-070216M-PM | ★ | | | ★ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 4.0 | 5.9 | 2.40 | 0.2 |
| | | | *.063* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.160* | *.232* | *.094* | *.008* |
| | | 11 | 0.20 | | R390-11 T3 02E-PM | ★ | | | ★ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 6.8 | 10.0 | 3.59 | 0.7 |
| | | | *.008* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.268* | *.394* | *.141* | *.028* |
| | | | 0.40 | | R390-11 T3 04M-PM | ★ | ☆ | | ★ | ☆ | | ☆ | | | ☆ | | | | | ☆ | ☆ | | ☆ | | | | | | | ☆ | ☆ | 6.8 | 10.0 | 3.59 | 0.9 |
| | | | *.016* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.268* | *.394* | *.141* | *.035* |
| | | | 0.80 | | R390-11 T3 08M-PM | ★ | ☆ | ★ | ☆ | ☆ | | ☆ | | | ☆ | ☆ | | | | ☆ | ☆ | | ☆ | | | | ★ | ☆ | ★ | ☆ | ☆ | 6.8 | 10.0 | 3.59 | 1.2 |
| | | | *.031* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.268* | *.394* | *.141* | *.047* |
| | | | 1.20 | | R390-11 T3 12E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 6.8 | 10.0 | 3.59 | 0.8 |
| | | | *.047* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.268* | *.394* | *.141* | *.031* |
| | | | 1.60 | | R390-11 T3 16E-PM | ★ | | | ★ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | ★ | ☆ | | 6.8 | 10.0 | 3.59 | 0.4 |
| | | | *.063* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.268* | *.394* | *.141* | *.016* |
| | | | 1.60 | | R390-11 T3 16M-PM | ★ | ☆ | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 6.8 | 10.0 | 3.59 | 0.4 |
| | | | *.063* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.268* | *.394* | *.141* | *.016* |
| | | | 2.00 | | R390-11 T3 20E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 6.8 | 10.0 | 3.59 | |
| | | | *.079* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.268* | *.394* | *.141* | |
| | | | 2.40 | | R390-11 T3 24E-PM | ★ | | | ★ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 6.8 | 10.0 | 3.59 | |
| | | | *.094* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.268* | *.394* | *.141* | |
| | | | 3.10 | | R390-11 T3 31E-PM | ★ | | | ★ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | ★ | ☆ | | 6.8 | 10.0 | 3.59 | |
| | | | *.122* | | | | | | | | | | | | | | | | | | | | | | | | | | | | *.268* | *.394* | *.141* | |

I73 I222 I254 N22 N10

# CoroMill® 390 insert for milling

KRINS 90°






| | | RE | Ordering code | P | | | | | M | | | | | | K | | | N | | | S | | | | | | H | | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3330 | 1130 | 530 | H13A | 1130 | 2030 | 2040 | H13A | S30T | S40T | 1010 | 1130 | 530 | W1 | LE | S | BS |
| Medium | PM | 11 | R390-11 T3 31M-PM | ★ | ☆ | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 6.8 | 10.0 | 3.59 | |
| | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | |
| | | 17 0.40 | R390-17 04 04E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | | 9.6 | 15.7 | 4.76 | 1.0 |
| | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .039 |
| | | 0.40 | R390-17 04 04M-PM | ★ | ☆ | | ★ | ☆ | | ☆ | | | ☆ | | | | | ☆ | ☆ | | ☆ | | | | | | | ☆ | ☆ | 9.6 | 15.7 | 4.76 | 1.0 |
| | | .016 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .039 |
| | | 0.80 | R390-17 04 08M-PM | ★ | ☆ | ★ | ☆ | ☆ | | ☆ | | | ☆ | ☆ | | | | ☆ | ☆ | | ☆ | | | | ★ | ☆ | ★ | ☆ | ☆ | 9.6 | 15.7 | 4.76 | 1.5 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | | 1.20 | R390-17 04 12E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | 1.1 |
| | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .043 |
| | | 1.60 | R390-17 04 16E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | 0.7 |
| | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .028 |
| | | 1.60 | R390-17 04 16M-PM | ★ | ☆ | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | | 9.6 | 15.7 | 4.76 | 0.7 |
| | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .028 |
| | | 2.00 | R390-17 04 20E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | 0.3 |
| | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .012 |
| | | 2.40 | R390-17 04 24E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | |
| | | .094 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | 3.10 | R390-17 04 31E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | |
| | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | 3.10 | R390-17 04 31M-PM | ★ | ☆ | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | | 9.6 | 15.7 | 4.76 | |
| | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | 4.00 | R390-17 04 40E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | |
| | | .157 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | 4.80 | R390-17 04 48E-PM | ★ | | | | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | |
| | | .189 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | 5.00 | R390-17 04 50E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | |
| | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | 6.00 | R390-17 04 60E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | |
| | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | 6.35 | R390-17 04 64E-PM | ★ | | | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 9.6 | 15.7 | 4.76 | |
| | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | |
| | | 18 0.80 | R390-18 06 08M-PM | ★ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 11.0 | 15.4 | 6.33 | 1.1 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .043 |
| | | 1.20 | R390-18 06 12M-PM | ★ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | ★ | ☆ | ★ | ☆ | | 11.0 | 15.4 | 6.33 | 1.1 |
| | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .043 |
| | | 1.60 | R390-18 06 16M-PM | ★ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | | 11.0 | 15.4 | 6.33 | 1.1 |
| | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .043 |
| | | 2.00 | R390-18 06 20M-PM | ★ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | | 11.0 | 15.4 | 6.33 | 0.5 |
| | | .079 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .020 |
| | | 3.10 | R390-18 06 31M-PM | ★ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | | 11.0 | 15.4 | 6.33 | 0.5 |
| | | .122 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .020 |
| | PMR | 18 1.20 | R390-18 06 12M-PMR | ★ | | ★ | ☆ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | | 11.0 | 15.4 | 6.33 | 0.3 |
| | | .047 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .433 | .606 | .249 | .010 |
| Heavy | KH | 11 1.00 | R390-11 T3 10M-KH | | | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | | 6.8 | 10.0 | 3.59 | 1.0 |
| | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .040 |
| | | 17 0.80 | R390-17 04 08M-KH | | | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | MH | 11 1.00 | R390-11 T3 10M-MH | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | ☆ | | | | | | | 6.8 | 10.0 | 3.59 | 1.0 |
| | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .040 |
| | PH | 11 1.00 | R390-11 T3 10M-PH | ☆ | ☆ | ☆ | ★ | | | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | | 6.8 | 10.0 | 3.59 | 1.0 |
| | | .039 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .268 | .394 | .141 | .040 |
| | | 17 0.80 | R390-17 04 08M-PH | | ☆ | | ★ | | | | | | | | | | | | | | | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |
| | | 1.60 | R390-17 04 16M-PH | | | ☆ | ★ | | | | | | | | | | | | | | | | | | | | | | | 9.6 | 15.7 | 4.76 | 1.5 |
| | | .063 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .378 | .618 | .188 | .059 |

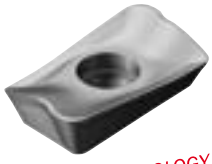
I73 I222 I254 N22 N10

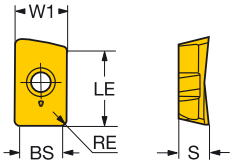


SANDVIK Coromant

# CoroMill® 390 insert for milling

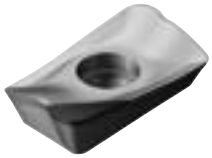
KRINS 90°

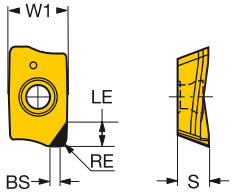





| | | | RE | Ordering code | P | | M | | K | | N | | S | | H | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1025 | 1130 | 1025 | 1130 | 1020 | 1025 | 1025 | 1130 | 1025 | 1130 | 1025 | 1130 | W1 | LE | S | BS |
| Light | KTW | 18 | 1.60 | R390-18 06 16H-KTW | | | | | ★ | | | | | | | | 11.0 | 15.4 | 6.33 | 8.6 |
| | | | .063 | | | | | | | | | | | | | | .433 | .606 | .249 | .339 |
| | PLW | 11 | 0.80 | R390-11 T3 08E-PLW | ☆ | ★ | ☆ | ☆ | | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6.8 | 10.0 | 3.59 | 5.0 |
| | | | .031 | | | | | | | | | | | | | | .268 | .394 | .141 | .197 |
| | | 18 | 1.60 | R390-18 06 16H-PTW | | ★ | | ☆ | | | | | | ☆ | | ☆ | 11.0 | 15.4 | 6.33 | 8.6 |
| | | | .063 | | | | | | | | | | | | | | .433 | .606 | .249 | .339 |

KRINS 90°






## Advanced cutting materials

| | | | RE | Ordering code | N | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|
| | | | | | CD10 | W1 | LE | S | BS |
| Light | NL | 11 | 0.40 | R390-11T304E-P4-NL | ★ | 6.8 | 4.0 | 3.59 | 2.2 |
| | | | .016 | | | .268 | .157 | .141 | .087 |
| | | 17 | 0.80 | R390-170408E-P6-NL | ★ | 9.6 | 6.0 | 4.76 | 1.8 |
| | | | .031 | | | .378 | .236 | .188 | .071 |

I73 I222 I254 N22 N10 N2

# CoroMill® 690

## The cutting edge for titanium milling

### Application

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

### ISO application area:

S

### Benefits and features

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

www.sandvik.coromant.com/coromill690

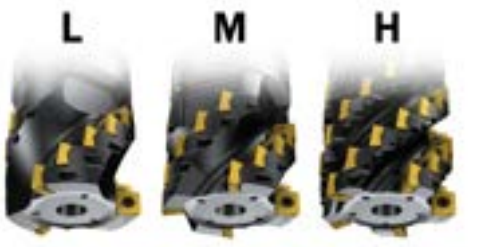
### Couplings

- 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

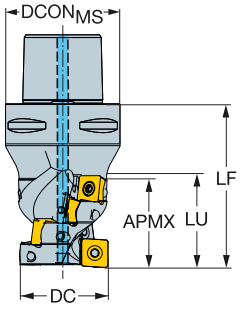
During cutting, the chips can be prone to sticking to the cutting edge. This means that the next cutter rotation is re-cutting the chip. By equipping every insert pocket with threaded coolant holes with nozzles for high pressure coolant delivery, you can apply maximum coolant where required. This effectively 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.

I105 I108

# CoroMill® 690 long edge square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

STDNO ISO26623-1
KAPR 90°




## Metric version

| DC | APMXFFW | | | CZCMS | CNSC | | | Ordering code | Dimensions, mm DCONMS | DCX | LF | LU | NM | KG | RPMX | CICTE | MIIDE | CICTP | MIIDP |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | 2 | 690-100508M-E-SL | 10 | 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 | 3 | 690-100508M-E-SL | 15 | 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 | 18 | 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 | 18 | 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 | 12 | 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 | 21 | 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 | 12 | 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 | 4 | 690-100508M-E-SL | 56 | 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 | 9 | 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 | 4 | 690-100508M-E-SL | 24 | 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 | 4 | 690-100508M-E-SL | 52 | 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 | 20 | 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 | 16 | 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 | 12 | 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 | 30 | 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 | 32 | 690-140610M-P-SL |

## Inch version

| DC | APMXFFW | | | CZCMS | CNSC | | Ordering code | Dimensions, inch DCONMS | DCX | LF | LU | FT/LBS | LBS | RPMX | CICTE | MIIDE | CICTP | MIIDP |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.500 | 1.811 | 10E | 10P | C6 | 3 | 2 | A690-038C6-1046H | 2.480 | 1.500 | 3.268 | 1.890 | 2.2 | 3.17 | 5000 | 2 | 690-100508M-E-SL | 10 | 690-100510M-P-SL |
| 2.000 | 2.362 | 10E | 10P | C5 | 3 | 3 | A690-051C5-1060H | 1.969 | 2.000 | 3.937 | | 2.2 | 2.90 | 5000 | 3 | 690-100508M-E-SL | 21 | 690-100510M-P-SL |
| | 4.134 | 10E | 10P | C6 | 3 | 3 | A690-051C6-10105H | 2.480 | 2.000 | 5.906 | 4.213 | 2.2 | 5.34 | 5000 | 3 | 690-100508M-E-SL | 39 | 690-100510M-P-SL |
| 2.500 | 2.402 | 14E | 14P | C6 | 3 | 3 | A690-063C6-1461H | 2.480 | 2.500 | 4.016 | 2.953 | 3.6 | 3.64 | 5000 | 3 | 690-140608M-E-SL | 12 | 690-140610M-P-SL |
| 3.000 | 2.874 | 14E | 14P | C6 | 3 | 4 | A690-076C6-1473H | 2.480 | 3.000 | 4.803 | | 3.6 | 6.26 | 5000 | 4 | 690-140608M-E-SL | 20 | 690-140610M-P-SL |

| | | | Spare parts | |
|---|---|---|---|---|
| DC | DC" | | Insert screw | Plug screw |
| 38.00 | 1.500 | 10E | 5513 020-68 | 3214 010-202 |
| 40.00 | 1.574 | 10E | 5513 020-68 | 3214 010-202 |
| 44.00 | 1.732 | 10E | 5513 020-68 | 3214 010-202 |
| 50.00-66.00 | 1.968-2.598 | 10E | 5513 020-68 | 3214 010-253 |
| 54.00-100.00 | 2.125-3.937 | 14E | 5513 020-55 | 3214 010-253 |

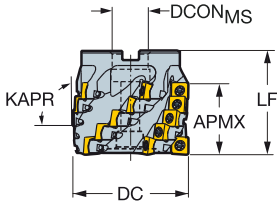
For the complete list of spare parts, visit www.sandvik.coromant.com

I108 L2 N22 N9 N15

# CoroMill® 690 long edge square shoulder milling cutter

**Arbor**

STDNO ISO6462
KAPR 90°




## Metric version

| DC | APMXFFW | | | CZCMS | | | Ordering code | Dimensions, mm DCONMS | ISO | DCX | LF | NM | KG | RPMX | CICTE | MIIDE | CICTP | MIIDP |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | 15 | 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 | 15 | 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 | 3 | 690-140608M-E-SL | 9 | 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 | 12 | 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 | 20 | 690-140610M-P-SL |

## Inch version

| DC | APMXFFW | | | CZCMS | | Ordering code | Dimensions, inch DCONMS | DCX | LF | FT/LBS | LBS | RPMX | CICTE | MIIDE | CICTP | MIIDP |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.000 | 1.811 | 10E | 10P | 3/4 | 3 | A690-051R19-1046H | .750 | 2.000 | 2.992 | 2.2 | 2.20 | 5000 | 3 | 690-100508M-E-SL | 15 | 690-100510M-P-SL |

| | Spare parts | |
|---|---|---|
| | Insert screw | Plug screw |
| 10E | 5513 020-68 | 3214 010-253 |
| 14E | 5513 020-55 | 3214 010-253 |

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

I108 L2 M1 N22 N9

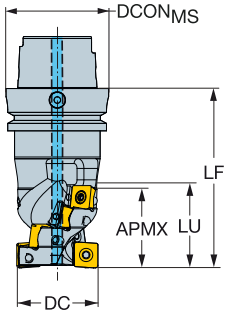


SANDVIK Coromant

# CoroMill® 690 long edge square shoulder milling cutter

**HSK – Internal coolant supply**

STDNO ISO12164-1
KAPR 90°




## Metric version

| DC | APMXFFW | | | CZCMS | CNSC | | Ordering code | Dimensions, mm DCONMS | ISO | DCX | LF | LU | NM | KG | RPMX | CICTE | MIIDE | CICTP | MIIDP |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 105.0 | 10E | 10P | 125 | 1 | 4 | **690-063HA12-10105H** | 125.0 | A | 63.0 | 180.0 | 110.0 | 3.0 | 7.51 | 5000 | 4 | 690-100508M-E-SL | 52 | 690-100510M-P-SL |

## Inch version

| DC | APMXFFW | | | CZCMS | CNSC | | Ordering code | Dimensions, inch DCONMS | DCX | LF | LU | FT/LBS | LBS | RPMX | CICTE | MIIDE | CICTP | MIIDP |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 3.000 | 4.134 | 10E | 10P | 100 | 1 | 4 | **A690-076HA10-10105M** | 3.937 | 3.000 | 7.087 | 4.331 | 2.2 | 14.07 | 5000 | 4 | 690-100508M-E-SL | 52 | 690-100510M-P-SL |

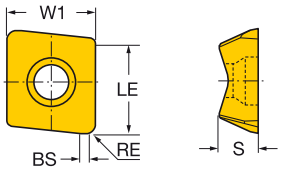
| | | Spare parts | |
|---|---|---|---|
| DC | | Insert screw | Plug screw |
| 63.00-76.00 | 10E | 5513 020-68 | 3214 010-253 |

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

I108 L2 N22 N9 N15

# CoroMill® 690 insert for milling

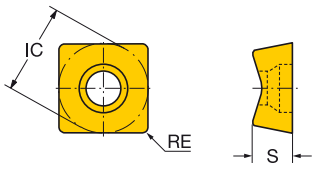
KRINS 90°




## End insert

| | | RE | Ordering code | S 1030 | S 2040 | S 330T | S 340T | Dimensions, mm, inch W1 | LE | S | BS |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Light | SL | 10E 0.80 | 690-100508M-E-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | | .031 | | | | | | .394 | .394 | .205 | .039 |
| | | 1.20 | 690-100512M-E-SL | ☆ | | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | | .047 | | | | | | .394 | .394 | .205 | .039 |
| | | 1.60 | 690-100516M-E-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | | .063 | | | | | | .394 | .394 | .205 | .039 |
| | | 2.00 | 690-100520M-E-SL | ☆ | | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | | .079 | | | | | | .394 | .394 | .205 | .039 |
| | | 3.10 | 690-100531M-E-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 10.0 | 5.20 | 1.0 |
| | | .122 | | | | | | .394 | .394 | .205 | .039 |
| | | 14E 0.80 | 690-140608M-E-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | .031 | | | | | | .571 | .581 | .250 | .039 |
| | | 1.20 | 690-140612M-E-SL | ☆ | | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | .047 | | | | | | .571 | .581 | .250 | .039 |
| | | 1.60 | 690-140616M-E-SL | ☆ | | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | .063 | | | | | | .571 | .581 | .250 | .039 |
| | | 2.00 | 690-140620M-E-SL | | | | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | .079 | | | | | | .571 | .581 | .250 | .039 |
| | | 2.40 | 690-140624M-E-SL | | | | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | .094 | | | | | | .571 | .581 | .250 | .039 |
| | | 3.10 | 690-140631M-E-SL | ☆ | | ★ | ☆ | 14.5 | 14.7 | 6.35 | 1.0 |
| | | .122 | | | | | | .571 | .581 | .250 | .039 |
| | | 5.00 | 690-140650M-E-SL | | | ★ | | 14.5 | 15.7 | 6.35 | 1.0 |
| | | .197 | | | | | | .571 | .620 | .250 | .039 |
| | | 6.00 | 690-140660M-E-SL | ☆ | | ★ | | 14.5 | 16.5 | 6.35 | 1.0 |
| | | .236 | | | | | | .571 | .650 | .250 | .039 |
| | | 6.35 | 690-140664M-E-SL | | | ★ | | 14.5 | 16.7 | 6.35 | 1.0 |
| | | .250 | | | | | | .571 | .659 | .250 | .039 |

KRINS 90°




## Peripheral insert

| | | RE | Ordering code | S 1030 | S 2040 | S 330T | S 340T | Dimensions, mm, inch IC | LE | S |
|---|---|---|---|---|---|---|---|---|---|---|
| Light | SL | 10P 1.00 | 690-100510M-P-SL | ☆ | ☆ | ★ | ☆ | 10.0 | 9.0 | 5.20 |
| | | .039 | | | | | | .394 | .354 | .205 |
| | | 14P 1.00 | 690-140610M-P-SL | ☆ | ☆ | ★ | ☆ | 14.5 | 13.5 | 6.35 |
| | | .039 | | | | | | .571 | .531 | .250 |

I105 I222 I254 N22 N10



SANDVIK Coromant

# 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 (.039 inch) setting range
- High-alloy aluminum 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 (.0039 inch) setting range.

### Macro setting

Macro setting of insert within 1 mm (.039 inch) setting range.

### Insert setting

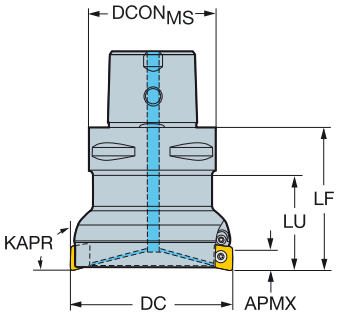
Serrated insert location gives very high security against insert movement.

I110 I114 N6

# CoroMill® Century square shoulder milling cutter

**Coromant Capto® - Internal coolant supply**

STDNO ISO26623-1
KAPR 90°




**Metric version**

| 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 |

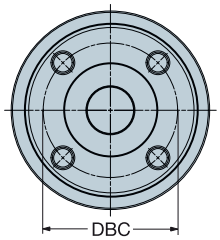
For the complete list of spare parts, visit www.sandvik.coromant.com

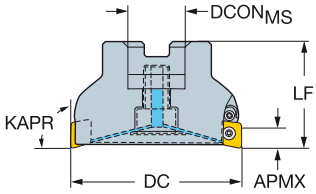
I114 L2 N22 N9 N15

# CoroMill® Century square shoulder milling cutter

**Arbor - Internal coolant supply**

KAPR 90°




**Metric version**

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

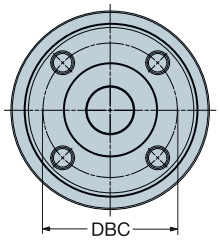
For the complete list of spare parts, visit www.sandvik.coromant.com

I114 L2 M1 N22 N9 N15

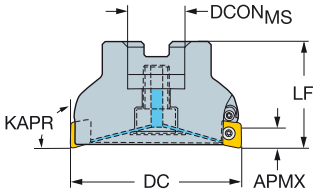
# CoroMill® Century square shoulder milling cutter

**Arbor - Internal coolant supply**

KAPR




90°




**Inch version**

| DC | | CZC$_{MS}$ | APMX$_{FFW}$ | CNSC | ZADJ | | Ordering code | Dimensions, inch DCON$_{MS}$ | ISO | DBC | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.000 | 11 | 3/4 | .433 | 1 | 4 | 4 | RA590-051R19S-11M | .750 | A | | 1.575 | 2.2 | 1.55 | 41100 | 4 | R590-1105.. |
| 2.500 | 11 | 3/4 | .433 | 1 | 5 | 5 | RA590-063R19S-11M | .750 | A | | 1.575 | 2.2 | 1.81 | 34900 | 5 | R590-1105.. |
| 3.000 | 11 | 1 | .433 | 1 | 6 | 6 | RA590-076R25A-11M | 1.000 | A | | 1.969 | 2.2 | 2.26 | 28400 | 6 | R590-1105.. |
| | 11 | 1 | .433 | 1 | 6 | 6 | RA590-076R25S-11M | 1.000 | A | | 1.969 | 2.2 | 3.34 | 28400 | 6 | R590-1105.. |
| 3.150 | 11 | 1 | .433 | 1 | 6 | 6 | RA590-080J25A-11M | 1.000 | A | | 1.969 | 2.2 | 2.31 | 27500 | 6 | R590-1105.. |
| | 11 | 1 | .433 | 1 | 6 | 6 | RA590-080J25S-11M | 1.000 | A | | 1.969 | 2.2 | 3.33 | 27500 | 6 | R590-1105.. |
| 3.937 | 11 | 1 1/4 | .433 | 1 | 6 | 6 | RA590-100J31A-11M | 1.250 | A | | 2.480 | 2.2 | 2.51 | 23800 | 6 | R590-1105.. |
| | 11 | 1 1/4 | .433 | 1 | 6 | 6 | RA590-100J31S-11M | 1.250 | A | | 2.480 | 2.2 | 4.78 | 23800 | 6 | R590-1105.. |
| 4.000 | 11 | 1 1/2 | .433 | 1 | 6 | 6 | RA590-102R38A-11M | 1.500 | A | | 2.480 | 2.2 | 3.31 | 23500 | 6 | R590-1105.. |
| | 11 | 1 1/2 | .433 | 1 | 6 | 6 | RA590-102R38S-11M | 1.500 | A | | 2.480 | 2.2 | 6.13 | 23500 | 6 | R590-1105.. |
| 4.921 | 11 | 1 1/2 | .433 | 1 | 8 | 8 | RA590-125J38A-11M | 1.500 | B | | 2.480 | 2.2 | 4.41 | 20700 | 8 | R590-1105.. |
| | 11 | 1 1/2 | .433 | 1 | 8 | 8 | RA590-125J38S-11M | 1.500 | B | | 2.480 | 2.2 | 8.36 | 20700 | 8 | R590-1105.. |
| 5.000 | 11 | 1 1/2 | .433 | 1 | 8 | 8 | RA590-127R38A-11M | 1.500 | B | | 2.480 | 2.2 | 3.97 | 20500 | 8 | R590-1105.. |
| | 11 | 1 1/2 | .433 | 1 | 8 | 8 | RA590-127R38S-11M | 1.500 | B | | 2.480 | 2.2 | 7.42 | 20500 | 8 | R590-1105.. |
| 6.000 | 11 | 1 1/2 | .433 | 1 | 10 | 10 | RA590-152R38A-11M | 1.500 | B | | 2.480 | 2.2 | 5.41 | 18400 | 10 | R590-1105.. |
| | 11 | 1 1/2 | .433 | 1 | 10 | 10 | RA590-152R38S-11M | 1.500 | B | | 2.480 | 2.2 | 10.87 | 18400 | 10 | R590-1105.. |
| 6.299 | 11 | 1 1/2 | .433 | 1 | 10 | 10 | RA590-160J38A-11M | 1.500 | B | | 2.480 | 2.2 | 5.29 | 17900 | 10 | R590-1105.. |
| 8.000 | 11 | 2 1/2 | .433 | 0 | 16 | 16 | RA590-203R63A-11M | 2.500 | C | 4.000 | 2.480 | 2.2 | 15.77 | 15600 | 16 | R590-1105.. |
| | 11 | 2 1/2 | .433 | 0 | 16 | 16 | RA590-203R63S-11M | 2.500 | C | 4.000 | 2.480 | 2.2 | 26.15 | 15600 | 16 | R590-1105.. |

| | | Spare parts | | | |
|---|---|---|---|---|---|
| DC" | | Insert screw | Shower screw | Setting device | Setting device screw |
| 2.000-2.500 | 11 | 5513 020-25 | 5512 088-01 | 5513 014-021 | 5513 014-02 |
| 3.000 | 11 | 5513 020-25 | 5512 088-02 | 5513 014-021 | 5513 014-02 |
| 3.149 | 11 | 5513 020-25 | 5512 087-02 | 5513 014-021 | 5513 014-02 |
| 3.937 | 11 | 5513 020-25 | 5512 087-04 | 5513 014-021 | 5513 014-02 |
| 4.000 | 11 | 5513 020-25 | 5512 088-03 | 5513 014-021 | 5513 014-02 |
| 4.921-6.299 | 11 | 5513 020-25 | 5512 099-03 | 5513 014-021 | 5513 014-02 |
| 8.000 | 11 | 5513 020-25 | | 5513 014-021 | 5513 014-02 |

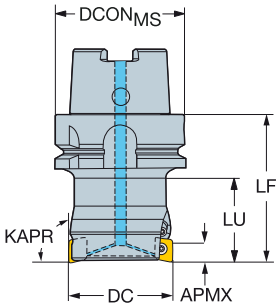
For the complete list of spare parts, visit www.sandvik.coromant.com

I114 L2 M1 N22 N9 N15

# CoroMill® Century square shoulder milling cutter

**HSK – Internal coolant supply**

STDNO ISO12164-1
KAPR 90°




## Metric version

| DC | | CZC$_{MS}$ | APMX$_{FFW}$ | CNSC | ZADJ | | Ordering code | Dimensions, mm DCON$_{MS}$ | 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.. |
| 63.0 | 11 | 63 | 11.00 | 1 | 5 | 5 | **R590-063HA06-11M** | 63.0 | A | 71.0 | 40.0 | 3.0 | 1.62 | 25000 | 5 | R590-1105.. |
| 80.0 | 11 | 63 | 11.00 | 1 | 6 | 6 | **R590-080HA06-11M** | 63.0 | A | 71.0 | | 3.0 | 1.46 | 20000 | 6 | R590-1105.. |
| 100.0 | 11 | 63 | 11.00 | 1 | 6 | 6 | **R590-100HA06-11M** | 63.0 | A | 80.0 | | 3.0 | 2.56 | 20000 | 6 | R590-1105.. |

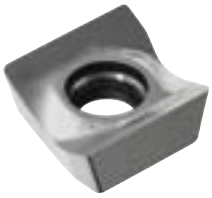
| Spare parts | | |
|---|---|---|
| Insert screw | Setting device | Setting device screw |
| 5513 020-25 | 5513 014-021 | 5513 014-02 |

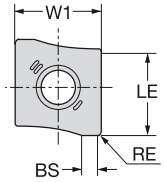
For the complete list of spare parts, visit www.sandvik.coromant.com

I114 L2 N22 N10 N15

# CoroMill® Century insert for milling

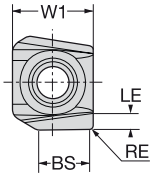
KRINS 90°






| | | RE | Ordering code | K 1020 | K H10 | N 1130 | H 1130 | W1 | LE | S | BS | BSR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Light | KL | 11 0.80 | R590-110508H-KL | ★ | | | | 11.5 | 11.0 | 5.00 | 1.7 | 200.0 |
| | | .031 | | | | | | .453 | .433 | .197 | .067 | 7.874 |
| | NL | 11 0.40 | R590-110504H-NL | | ☆ | ★ | | 11.5 | 11.0 | 5.00 | 2.0 | 200.0 |
| | | .016 | | | | | | .453 | .433 | .197 | .079 | 7.874 |
| | PL | 11 0.80 | R590-110508H-PL | | | | ☆ | 11.5 | 11.0 | 5.00 | 1.7 | 200.0 |
| | | .031 | | | | | | .453 | .433 | .197 | .067 | 7.874 |

KRINS 90°




TECHNOLOGY Wiper

| | | RE | Ordering code | P 1130 | M 1130 | K 1020 | N 1130 | N H10 | S 1130 | H 1130 | W1 | LE | S | BS | BSR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Light | KTW | 11 0.40 | R590-110504H-KTW | | | ☆ | | | | | 11.5 | 2.0 | 5.00 | 7.0 | |
| | | .016 | | | | | | | | | .453 | .079 | .197 | .276 | |
| | KW | 11 0.80 | R590-110508H-KW | | | | | | | ☆ | 11.5 | 2.0 | 5.00 | 7.0 | 500.0 |
| | | .031 | | | | | | | | | .453 | .079 | .197 | .276 | 19.685 |
| | NW | 11 0.40 | R590-110504H-NW | | | | | ☆ | | ☆ | 11.5 | 2.0 | 5.00 | 7.0 | 500.0 |
| | | .016 | | | | | | | | | .453 | .079 | .197 | .276 | 19.685 |
| | PTW | 11 0.40 | R590-110504H-PTW | ☆ | ☆ | | ☆ | | ☆ | ☆ | 11.5 | 2.0 | 5.00 | 7.0 | |
| | | .016 | | | | | | | | | .453 | .079 | .197 | .276 | |
| | PW | 11 0.80 | R590-110508H-PW | ☆ | ☆ | | ☆ | | ☆ | ☆ | 11.5 | 2.0 | 5.00 | 7.0 | 500.0 |
| | | .031 | | | | | | | | | .453 | .079 | .197 | .276 | 19.685 |

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

I110 I222 I254 N22 N6 N10 N2

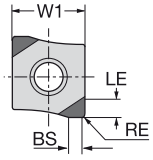


SANDVIK Coromant

# CoroMill® Century insert for milling

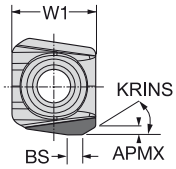
**Advanced cutting materials**

KRINS 90°

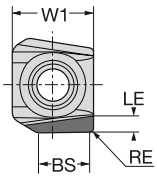



| | | | RE | KCH | CHW | Ordering code | K CB50 | H CB50 | Dimensions, mm, inch W1 | LE | S | BS | BSR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Light | KL | 11 | | 30° | 1.0 | L590-1105H-ZC2-KL | ☆ | ☆ | 11.5 | 3.0 | 5.00 | 2.3 | 200.0 |
| | | | | | .039 | | | | .453 | .118 | .197 | .092 | 7.874 |
| | | | | 60° | 1.5 | R590-1105H-ZC2-KL | ☆ | ☆ | 11.5 | 3.0 | 5.00 | 2.3 | 200.0 |
| | | | | | .059 | | | | .453 | .118 | .197 | .092 | 7.874 |
| Medium | KM | 11 | 0.80 | | | R590-110508H-PR2-KM | ☆ | ☆ | 11.5 | 2.0 | 5.00 | 1.5 | 25.0 |
| | | | .031 | | | | | | .453 | .079 | .197 | .059 | .984 |

KRINS 90°
R/L590..H-Z..-KW




90°
R590..PR2-KW




| | | | RE | KCH | CHW | Ordering code | K CB50 | H CB50 | Dimensions, mm, inch W1 | LE | S | BS | BSR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Light | KL | 11 | | 30° | 1.0 | R/L590-1105H-ZC2-KL | ☆ | ☆ | 11.5 | 3.0 | 5.00 | 2.3 | 200.0 |
| | | | | | .039 | | | | .453 | .118 | .197 | .092 | 7.874 |
| | KW | 11 | | 30° | 1.0 | R/L590-1105H-ZC2-KW | ☆ | ☆ | 11.5 | 3.0 | 5.00 | 5.9 | 390.0 |
| | | | | | .039 | | | | .453 | .118 | .197 | .233 | 15.354 |
| | NW | 11 | 0.80 | | | R590-110508H-PR2-KW | ☆ | ☆ | 11.5 | 2.0 | 5.00 | 7.1 | 393.0 |
| | | | .031 | | | | | | .453 | .079 | .197 | .280 | 15.472 |
| Medium | KM | 11 | 0.80 | | | R590-110508H-PR2-KM | ☆ | ☆ | 11.5 | 2.0 | 5.00 | 1.5 | 25.0 |
| | | | .031 | | | | | | .453 | .079 | .197 | .059 | .984 |

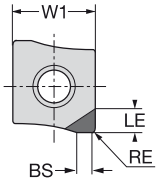
Make sure to choose working insert and wiper insert with the same RE/KCH values

I110 I222 I254 N22 N6 N10 N2

# CoroMill® Century insert for milling

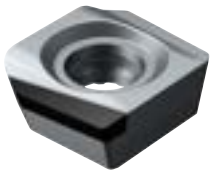
**Advanced cutting materials**

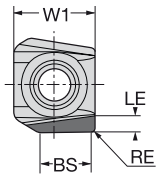
KRINS 90°




| | | RE | KCH | CHW | Ordering code | N / CD10 | Dimensions, mm, inch 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 |
| | | | | .039 | | | .453 | .118 | .197 | .059 | 7.874 |
| | | | 45° | 1.0 | R590-1105H-PC5-NL | ★ | 11.5 | 6.0 | 5.00 | 1.5 | 200.0 |
| | | | | .039 | | | .453 | .236 | .197 | .059 | 7.874 |
| | | 0.40 | | | R590-1105H-PR2-NL | ★ | 11.5 | 3.0 | 5.00 | 2.2 | 200.0 |
| | | .016 | | | | | .453 | .118 | .197 | .087 | 7.874 |
| | | 0.40 | | | R590-1105H-PR5-NL | ★ | 11.5 | 6.0 | 5.00 | 2.2 | 200.0 |
| | | .016 | | | | | .453 | .236 | .197 | .087 | 7.874 |
| | | | 45° | 0.3 | R590-1105H-PS2-NL | ★ | 11.5 | 3.0 | 5.00 | 2.2 | 200.0 |
| | | | | .010 | | | .453 | .118 | .197 | .087 | 7.874 |
| | | | 45° | 0.1 | R590-1105H-PS5-NL | ★ | 11.5 | 6.0 | 5.00 | 2.2 | 200.0 |
| | | | | .004 | | | .453 | .236 | .197 | .087 | 7.874 |

KRINS 90°






TECHNOLOGY Wiper

| | | RE | KCH | CHW | Ordering code | N / CD10 | Dimensions, mm, inch 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 |
| | | | | .047 | | | .453 | .118 | .197 | .236 | 19.685 |
| | | 0.40 | | | R590-1105H-RR2-NW | ☆ | 11.5 | 3.0 | 5.00 | 6.8 | 500.0 |
| | | .016 | | | | | .453 | .118 | .197 | .268 | 19.685 |
| | | | 45° | 0.3 | R590-1105H-RS2-NW | ☆ | 11.5 | 3.0 | 5.00 | 7.0 | 500.0 |
| | | | | .010 | | | .453 | .118 | .197 | .276 | 19.685 |

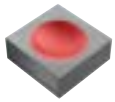
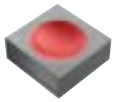
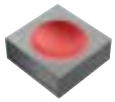
Make sure to choose working insert and wiper insert with the same RE/KCH values

I110 I222 I254 N22 N6 N10 N2



SANDVIK Coromant

# Profile milling tools

| | CoroMill® 300 | CoroMill® 200 | CoroMill® 216 |
|---|---|---|---|
| | | | |
| Page | I118 | I134 | I143 |
| Material | P M K N S H | P M K N S H | P M S |
| Main operations |  |  |  |
| KAPR | 0° | 0° | 90° |
| $D_c$ mm<br>$D_c$ inch | 5 - 180<br>.178 - 7.213 | 15 - 140<br>.625 - 9.250 | 10 - 50<br>.375 - 2.000 |
| DCX mm<br>DCX inch | 10 - 200<br>.375 - 8000 | 25 - 140<br>1000 - 10000 | |
| APMX mm<br>APMX inch | 2.5 - 10<br>.098 - .492 | 5 - 10<br>.187 - .375 | 8.6 - 44.6<br>.0310 - 1.791 |
| Insert | | | |
| Insert sizes | 05,07,08,09,10,13,16,20 & 25 | 09,10,12,13,16,19 & 20 | 10,12,13,16,19,20,25,30,32,<br>38,40,50,51 |
| Couplings | Coromant Capto®<br>Coromant EH<br>Cylindrical<br>Arbor<br>Weldon<br>Threaded coupling | Cylindrical shank<br>Whistle notch / Weldon<br>Arbor | Coromant Capto®<br>Cylindrical shank<br>Coromant EH<br>Threaded coupling<br>Weldon |
| Internal coolant | ✓ | | ✓ |
| Options | | | |
| Other operations | | | |

# 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 generate 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 couplings and grades for all materials

### Inserts

- Insert geometries and grades for all materials

Coarse pitch Close pitch Extra close pitch

Specific insert indexing solution for size 20 and 25.4 inserts prevents insert movement and enables all cutting edges to be utilized.

I119 I131 N6

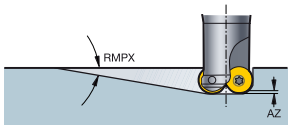


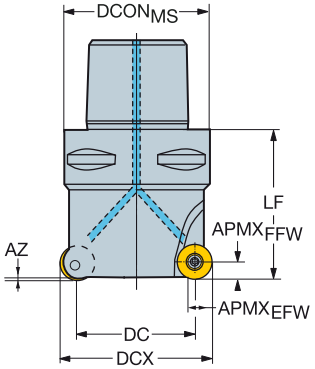
SANDVIK Coromant

# CoroMill® 300 face milling cutter

**Coromant Capto® - Internal coolant supply**

**Positive design**




## Metric version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, mm DCONMS | DCX | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 60.0 | 5.0 | 1.39 | 17600 | 5 | R300-1648.. |
| | 16 | C6 | 12.0 | 8.00 | 4° | 3.8 | 3 | 6 | | R300-066C6-16H | 63.0 | 66.0 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 |

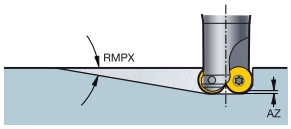
For the complete list of spare parts, visit www.sandvik.coromant.com

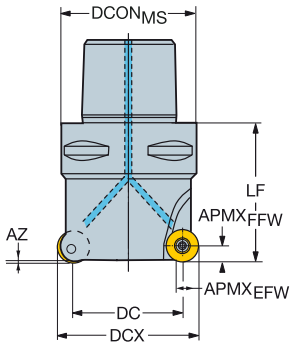
I131 L2 N22 N6 N9 N15

# CoroMill® 300 face milling cutter

**Coromant Capto® - Internal coolant supply**

**Positive design**




**Inch version**

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.547 | 13 | C5 | .375 | .248 | 5° | .110 | 3 | | 4 | RA300-052C5-13M | 1.969 | 2.047 | 2.000 | 2.2 | 2.20 | 16600 | 4 | R300-1340.. |
| | 13 | C5 | .375 | .248 | 5° | .110 | 3 | | 5 | RA300-052C5-13H | 1.969 | 2.047 | 2.000 | 2.2 | 2.20 | 16900 | 5 | R300-1340.. |
| 2.000 | 25 | C6 | .750 | .492 | 0° | .236 | 3 | 4 | | RA300-076C6-25M | 2.480 | 3.000 | 3.150 | 7.5 | 4.52 | 18214 | 4 | R300-2570.. |
| 2.098 | 13 | C6 | .375 | .248 | 3° | .110 | 3 | | 5 | RA300-066C6-13M | 2.480 | 2.598 | 2.000 | 2.2 | 3.67 | 14300 | 5 | R300-1340.. |
| | 13 | C6 | .375 | .248 | 3° | .110 | 3 | 7 | | RA300-066C6-13H | 2.480 | 2.598 | 2.000 | 2.2 | 3.63 | 14300 | 7 | R300-1340.. |
| 2.370 | 16 | C6 | .472 | .315 | 2° | .150 | 3 | | 7 | RA300-076C6-16H | 2.480 | 2.992 | 2.362 | 3.6 | 4.28 | 16000 | 7 | R300-1648.. |
| 3.000 | 25 | C8 | .750 | .492 | 0° | .276 | 3 | 6 | | RA300-102C8-25H | 3.150 | 4.000 | 3.150 | 7.5 | 7.58 | 13498 | 6 | R300-2570.. |

| | Spare parts |
|---|---|
| | Insert screw |
| 13 | 5513 020-09 |
| 16 | 5513 020-50 |
| 25 | 5513 020-71 |

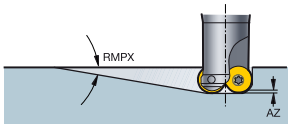
For the complete list of spare parts, visit www.sandvik.coromant.com

I131 L2 N22 N6 N9 N15

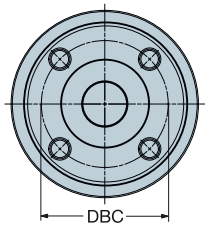
# CoroMill® 300 face milling cutter

**Arbor - Internal coolant supply**

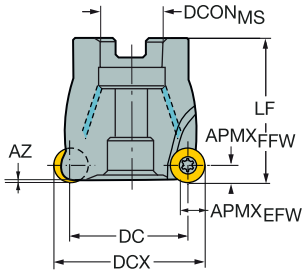
**Positive design**




STDNO




ISO6462




## Metric version

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

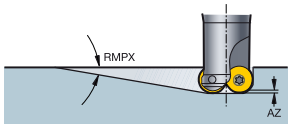
For spare parts, visit www.sandvik.coromant.com

I131 L2 M1 N22 N6 N9 N15

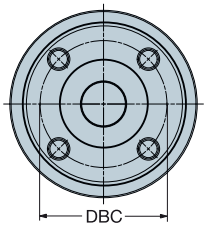
# CoroMill® 300 face milling cutter

**Arbor - Internal coolant supply**

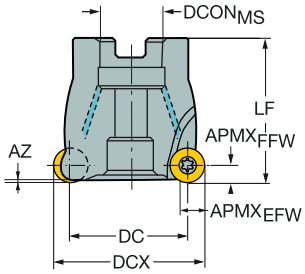
**Positive design**




STDNO




ISO6462




## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | ISO | DBC | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.500 | 13 | 3/4 | .375 | .248 | 5° | .110 | 1 | | 4 | RA300-051R19-13M | .750 | A | | 2.000 | 1.969 | 2.2 | 1.66 | 16900 | 4 | R300-1340.. |
| | 13 | 3/4 | .375 | .248 | 5° | .110 | 1 | 5 | | RA300-051R19-13H | .750 | A | | 2.000 | 1.969 | 2.2 | 1.51 | 16900 | 5 | R300-1340.. |
| 1.870 | 16 | 3/4 | .472 | .315 | 5° | .150 | 1 | | 4 | RA300-063R19-16M | .750 | A | | 2.500 | 1.969 | 3.6 | 2.17 | 18200 | 4 | R300-1648.. |
| | 16 | 3/4 | .472 | .315 | 5° | .150 | 1 | 6 | | RA300-063R19-16H | .750 | A | | 2.500 | 1.969 | 3.6 | 2.01 | 18200 | 6 | R300-1648.. |
| 2.000 | 13 | 3/4 | .375 | .248 | 3° | .110 | 1 | | 5 | RA300-063R19-13M | .750 | A | | 2.500 | 1.969 | 2.2 | 1.87 | 14700 | 5 | R300-1340.. |
| | 13 | 3/4 | .375 | .248 | 3° | .110 | 1 | 6 | | RA300-063R19-13H | .750 | A | | 2.500 | 1.969 | 2.2 | 1.37 | 14700 | 6 | R300-1340.. |
| | 25 | 1 | .750 | .492 | 0° | .236 | 1 | 4 | | RA300-076R25-25M | 1.000 | A | | 3.000 | 1.969 | 7.5 | 2.54 | 18214 | 4 | R300-2570.. |
| 2.213 | 20 | 1 | .591 | .394 | 7° | .236 | 1 | | 4 | RA300-076R25-20M | 1.000 | A | | 3.000 | 1.969 | 5.5 | 2.52 | 16311 | 4 | R300-2060.. |
| | 20 | 1 | .591 | .394 | 7° | .236 | 1 | 5 | | RA300-076R25-20H | 1.000 | A | | 3.000 | 1.969 | 5.5 | 2.43 | 16311 | 5 | R300-2060.. |
| 2.370 | 16 | 1 | .472 | .315 | 4° | .150 | 1 | | 5 | RA300-076R25-16M | 1.000 | A | | 3.000 | 1.969 | 3.6 | 2.27 | 16000 | 5 | R300-1648.. |
| | 16 | 1 | .472 | .315 | 4° | .150 | 1 | 7 | | RA300-076R25-16H | 1.000 | A | | 3.000 | 1.969 | 3.6 | 2.65 | 16000 | 7 | R300-1648.. |
| 2.500 | 13 | 1 | .375 | .248 | 2° | .110 | 1 | | 5 | RA300-076R25-13L | 1.000 | A | | 3.000 | 1.969 | 2.2 | 2.73 | 13500 | 5 | R300-1340.. |
| | 13 | 1 | .375 | .248 | 2° | .110 | 1 | | 6 | RA300-076R25-13M | 1.000 | A | | 3.000 | 1.969 | 2.2 | 2.82 | 13500 | 6 | R300-1340.. |
| | 13 | 1 | .375 | .248 | 2° | .110 | 1 | 7 | | RA300-076R25-13H | 1.000 | A | | 3.000 | 1.969 | 2.2 | 2.47 | 13500 | 7 | R300-1340.. |
| 3.000 | 25 | 1 1/2 | .750 | .492 | 0° | .276 | 1 | 6 | | RA300-102R38-25H | 1.500 | A | | 4.000 | 2.480 | 7.5 | 4.67 | 13498 | 6 | R300-2570.. |
| 3.213 | 20 | 1 1/2 | .591 | .394 | 4° | .236 | 1 | | 6 | RA300-102R38-20M | 1.500 | A | | 4.000 | 2.480 | 5.5 | 5.16 | 12672 | 6 | R300-2060.. |
| 3.370 | 16 | 1 1/2 | .472 | .315 | 2° | .150 | 1 | | 6 | RA300-102R38-16M | 1.500 | A | | 4.000 | 2.480 | 3.6 | 4.92 | 13200 | 6 | R300-1648.. |
| | 16 | 1 1/2 | .472 | .315 | 2° | .150 | 1 | 8 | | RA300-102R38-16H | 1.500 | A | | 4.000 | 2.480 | 3.6 | 4.88 | 13200 | 8 | R300-1648.. |
| 4.000 | 25 | 1 1/2 | .750 | .492 | 0° | .276 | 1 | 7 | | RA300-127R38-25H | 1.500 | B | | 5.000 | 2.480 | 7.5 | 6.35 | 10994 | 7 | R300-2570.. |
| 4.213 | 20 | 1 1/2 | .591 | .394 | 3° | .236 | 1 | | 7 | RA300-127R38-20M | 1.500 | B | | 5.000 | 2.480 | 5.5 | 6.83 | 10645 | 7 | R300-2060.. |
| 5.000 | 25 | 1 1/2 | .750 | .492 | 0° | .276 | 1 | | 7 | RA300-152R38-25M | 1.500 | B | | 6.000 | 2.480 | 7.5 | 9.28 | 9576 | 7 | R300-2570.. |
| 5.213 | 20 | 1 1/2 | .591 | .394 | 2° | .236 | 1 | | 9 | RA300-152R38-20M | 1.500 | B | | 6.000 | 2.480 | 5.5 | 9.68 | 9404 | 9 | R300-2060.. |
| 7.000 | 25 | 2 1/2 | .750 | .492 | 0° | .276 | 0 | | 8 | RA300-203R63-25M | 2.500 | C | 4.000 | 8.000 | 2.480 | 7.5 | 24.80 | 7726 | 8 | R300-2570.. |

| | | Spare parts | |
|---|---|---|---|
| DC" | | Insert screw | Screw |
| 1.500 | 13 | 5513 020-09 | 5512 065-01 |
| 2.000 | 13 | 5513 020-09 | |
| 2.500 | 13 | 5513 020-09 | |
| 1.870 | 16 | 5513 020-50 | |
| 2.370 | 16 | 5513 020-50 | |
| 3.370 | 16 | 5513 020-50 | |
| 2.212 | 20 | 5513 020-31 | |
| 3.212 | 20 | 5513 020-31 | |
| 4.212-5.212 | 20 | 5513 020-31 | |
| 2.000 | 25 | 5513 020-71 | |
| 3.000 | 25 | 5513 020-71 | |
| 4.000-7.000 | 25 | 5513 020-71 | |

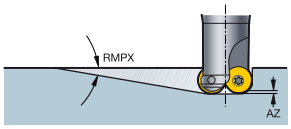
For the complete list of spare parts, visit www.sandvik.coromant.com

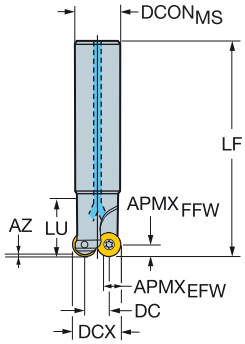
I131 L2 M1 N22 N6 N9 N15

# CoroMill® 300 face milling cutter

**Cylindrical shank - Internal coolant supply**

**Positive design**




## Metric version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, mm DCONMS | DCX | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 150.0 | 3.0 | 1.01 | 2850 | 4 | R300-1240.. |

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .625 | 09 | 1 | .281 | .177 | 8° | .079 | 1 | | 2 | RA300-025O25-09M | 1.000 | 1.000 | 7.500 | 2.2 | 1.71 | 14500 | 2 | R300-0932.. |
| | 09 | 1 | .281 | .177 | 8° | .079 | 1 | 3 | | RA300-025O25-09H | 1.000 | 1.000 | 6.000 | 2.2 | 1.35 | 27400 | 3 | R300-0932.. |
| .750 | 13 | 1 1/4 | .375 | .248 | 12° | .110 | 1 | | 2 | RA300-032O32-13M | 1.250 | 1.250 | 10.000 | 2.2 | 3.76 | 7400 | 2 | R300-1340.. |
| | 13 | 1 1/4 | .375 | .248 | 12° | .110 | 1 | 3 | | RA300-032O32-13H | 1.250 | 1.250 | 6.000 | 2.2 | 1.99 | 25100 | 3 | R300-1340.. |
| .875 | 09 | 1 1/4 | .281 | .177 | 5° | .079 | 1 | | 3 | RA300-032O32-09M | 1.250 | 1.250 | 10.000 | 2.2 | 3.81 | 7400 | 3 | R300-0932.. |
| 1.000 | 13 | 1 1/4 | .375 | .248 | 8° | .110 | 1 | | 3 | RA300-038O32-13M | 1.250 | 1.500 | 10.000 | 2.2 | 3.82 | 7400 | 3 | R300-1340.. |
| | 13 | 1 1/4 | .375 | .248 | 8° | .110 | 1 | 4 | | RA300-038O32-13H | 1.250 | 1.500 | 6.000 | 2.2 | 2.16 | 21600 | 4 | R300-1340.. |
| 1.125 | 09 | 1 1/4 | .281 | .187 | 7° | .079 | 1 | 4 | | RA300-038O32-09H | 1.250 | 1.500 | 6.000 | 2.2 | 2.40 | 27400 | 4 | R300-0932.. |

## Metric version

| | | 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 |

## Inch version

| | | Spare parts |
|---|---|---|
| DC" | | Insert screw |
| .625 | 09 | 5513 020-43 |
| .875-1.125 | 09 | 5513 020-09 |
| .750-1.000 | 13 | 5513 020-09 |

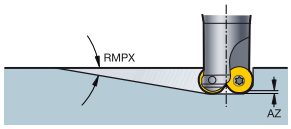
For the complete list of spare parts, visit www.sandvik.coromant.com

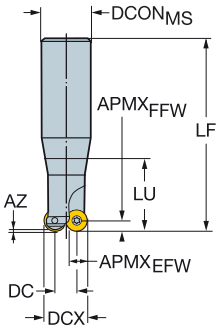
I131 L2 N22 N6 N9 N15

# CoroMill® 300 face milling cutter

**Cylindrical shank**

**Neutral design**




## Metric version

| DC | | CZC$_{MS}$ | APMX$_{EFW}$ | APMX$_{FFW}$ | RMPX | AZ | | Ordering code | Dimensions, mm DCON$_{MS}$ | DCX | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 250.0 | 72.2 | 5.0 | 1.76 | 8700 | 2 | R300-1648.. |

## Inch version

| DC | | CZC$_{MS}$ | APMX$_{EFW}$ | APMX$_{FFW}$ | RMPX | AZ | | Ordering code | Dimensions, inch DCON$_{MS}$ | DCX | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .224 | 07 20 | 5/8 | .207 | .138 | 20° | .055 | 2 | RA300-013O16L-07L | .625 | .500 | 8.000 | 1.815 | .6 | 0.79 | 8500 | 2 | R300-0720.. |
| .310 | 08 | 3/4 | .236 | .157 | 20° | .039 | 2 | RA300-016O19L-08L | .750 | .625 | 9.000 | 2.268 | .8 | 1.68 | 8300 | 2 | R300-0828.. |
| .356 | 10 | 3/4 | .295 | .197 | 20° | .110 | 2 | RA300-019O19L-10L | .750 | .750 | 9.000 | 2.843 | 2.2 | 1.74 | 8300 | 2 | R300-1032.. |
| .500 | 13 | 1 | .375 | .250 | 20° | .118 | 2 | RA300-025O25L-13L | 1.000 | 1.000 | 10.000 | 2.843 | 3.6 | 2.80 | 8800 | 2 | R300-1340.. |
| .620 | 16 | 1 1/4 | .472 | .315 | 20° | .197 | 2 | RA300-032O32L-16L | 1.250 | 1.250 | 10.000 | 2.843 | 3.6 | 3.84 | 8700 | 2 | R300-1648.. |

## Metric version

| | 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 |

## Inch version

| | Spare parts |
|---|---|
| DC" | Insert screw |
| .224 | 07 20 5513 020-41 |
| .310 | 08 5513 020-36 |
| .356 | 10 5513 020-43 |
| .500 | 13 5513 020-39 |
| .620 | 16 5513 020-50 |

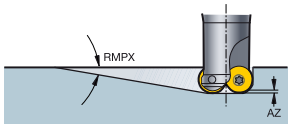
For the complete list of spare parts, visit www.sandvik.coromant.com

I131 L2 N22 N6 N9

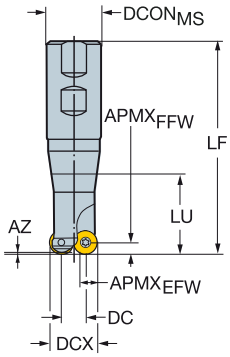
# CoroMill® 300 face milling cutter

**Weldon – Internal coolant supply**

**Positive design**




STDNO ISO3338-2




## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | | Ordering code | Dimensions, inch DCONMS | ISO | DCX | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .625 | 09 | 1 | .281 | .177 | 13° | .079 | 1 | | 2 | RA300-025M25-09M | 1.000 | WE | 1.000 | 5.281 | 2.2 | 1.10 | 14500 | 2 | R300-0932.. |
| | 09 | 1 | .281 | .177 | 13° | .079 | 1 | 3 | | RA300-025M25-09H | 1.000 | WE | 1.000 | 5.281 | 2.2 | 1.15 | 27400 | 3 | R300-0932.. |
| .750 | 13 | 1 1/4 | .375 | .248 | 12° | .110 | 1 | | 2 | RA300-032M32-13M | 1.250 | WE | 1.250 | 5.949 | 2.2 | 1.72 | 25100 | 2 | R300-1340.. |
| | 13 | 1 1/4 | .375 | .248 | 12° | .110 | 1 | 3 | | RA300-032M32-13H | 1.250 | WE | 1.250 | 5.949 | 2.2 | 1.39 | 25100 | 3 | R300-1340.. |
| .875 | 09 | 1 1/4 | .281 | .177 | 7° | .079 | 1 | | 4 | RA300-032M32-09H | 1.250 | WE | 1.250 | 5.949 | 2.2 | 1.85 | 27400 | 4 | R300-0932.. |
| 1.000 | 13 | 1 1/4 | .375 | .248 | 8° | .110 | 1 | | 3 | RA300-038M32-13M | 1.250 | WE | 1.500 | 6.281 | 2.2 | 2.16 | 21600 | 3 | R300-1340.. |
| | 13 | 1 1/4 | .375 | .248 | 8° | .110 | 1 | 4 | | RA300-038M32-13H | 1.250 | WE | 1.500 | 6.281 | 2.2 | 2.25 | 21600 | 4 | R300-1340.. |

| | | Spare parts |
|---|---|---|
| DC" | | Insert screw |
| .625 | 09 | 5513 020-43 |
| .875 | 09 | 5513 020-09 |
| .750-1.000 | 13 | 5513 020-09 |

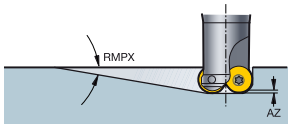
For the complete list of spare parts, visit www.sandvik.coromant.com

I131 L2 N22 N6 N9 N15

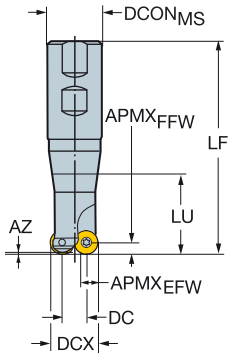
# CoroMill® 300 face milling cutter

**Weldon**

**Neutral design**




STDNO ISO3338-2




## Metric version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | | Ordering code | Dimensions, mm DCONMS | ISO | DCX | 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 | 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 | 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 | 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 | 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 | 141.0 | 42.8 | 3.0 | 0.82 | 20200 | 2 | R300-1240.. |

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | | Ordering code | Dimensions, inch DCONMS | ISO | DCX | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .310 | 08 | 3/4 | .236 | .157 | 20° | .039 | 2 | RA300-016M19-08L | .750 | WE | .625 | 4.282 | 1.717 | .8 | 0.65 | 24900 | 2 | R300-0828.. |
| .356 | 10 | 1 | .295 | .197 | 20° | .110 | 2 | RA300-019M25-10L | 1.000 | WE | .750 | 4.781 | 1.539 | 2.2 | 1.08 | 35900 | 2 | R300-1032.. |

| | Spare parts |
|---|---|
| | Insert screw |
| 07 20 | 5513 020-41 |
| 07 24 | 5513 020-42 |
| 08 | 5513 020-36 |
| 10 | 5513 020-43 |
| 12 | 5513 020-39 |

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

I131 L2 N22 N6 N9

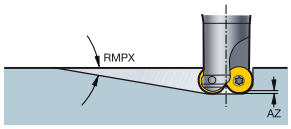


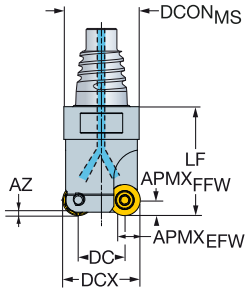
SANDVIK Coromant

# CoroMill® 300 face milling cutter

**Coromant EH – Internal coolant supply**

**Neutral design**




## Metric version

| DC | | CZC$_{MS}$ | APMX$_{EFW}$ | APMX$_{FFW}$ | RMPX | AZ | CNSC | | Ordering code | Dimensions, mm DCON$_{MS}$ | DCX | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 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 | 35.0 | 3.0 | 0.23 | 15000 | 4 | R300-1032.. |

| | Spare parts |
|---|---|
| | Insert screw |
| 07 20 | 5513 020-41 |
| 07 24 | 5513 020-42 |
| 05 | 5513 020-40 |
| 08 | 5513 020-36 |
| 10 | 5513 020-43 |
| 12 | 5513 020-39 |
| 16 | 5513 020-50 |

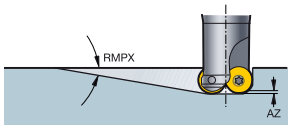
For the complete list of spare parts, visit www.sandvik.coromant.com

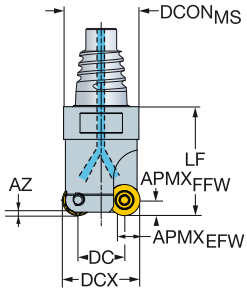
I131 L2 N22 N6 N9 N15 N3

# CoroMill® 300 face milling cutter

**Coromant EH – Internal coolant supply**

**Positive design**




## Metric version

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

| | Spare parts |
|---|---|
| | Insert screw |
| 08 | 5513 020-56 |

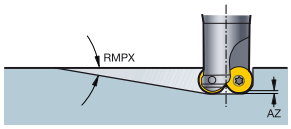
For the complete list of spare parts, visit www.sandvik.coromant.com

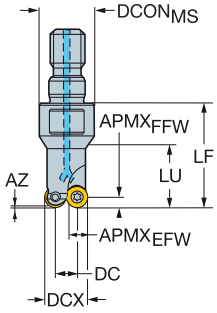
I131 L2 N22 N6 N9 N15 N3

# CoroMill® 300 face milling cutter

**Threaded coupling – Internal coolant supply**

**Neutral design**




## Metric version

| 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 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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.. |

| | Spare parts |
|---|---|
| | Insert screw |
| 07 20 | 5513 020-41 |
| 07 24 | 5513 020-42 |
| 05 | 5513 020-40 |
| 08 | 5513 020-36 |
| 10 | 5513 020-43 |
| 12 | 5513 020-39 |

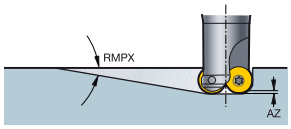
For the complete list of spare parts, visit www.sandvik.coromant.com

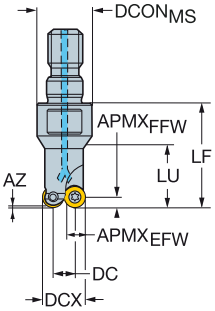
I131 L2 N22 N6 N9 N15

# CoroMill® 300 face milling cutter

**Threaded coupling – Internal coolant supply**

**Positive design**




## Metric version

| 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.. |

| | Spare parts |
|---|---|
| | Insert screw |
| 08 | 5513 020-56 |

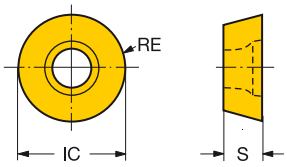
For the complete list of spare parts, visit www.sandvik.coromant.com

I131 L2 N22 N6 N9 N15



SANDVIK Coromant

# CoroMill® 300 insert for milling

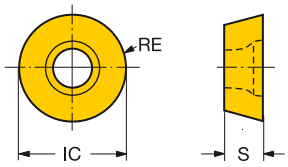



## Metric version

| | RE | Ordering code | P | | | | M | | | | K | | | | N | | S | | | | H | Dimensions, mm, inch | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | 1130 | 4220 | 4330 | 4340 | 1040 | 1130 | 2030 | 2040 | S30T | 1020 | 3040 | 3330 | 4340 | H13A | 1130 | H13A | 1130 | H13A | S30T | S40T | 1025 | IC | S |
| Light | 08 | 4.00 | | | | | | | | | | | | | | ☆ | | ★ | | ☆ | | | | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | 08 | 4.00 | ★ | | | | | ☆ | | | ☆ | | | | | | ☆ | | ☆ | | ★ | ☆ | | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | 10 | 5.00 | | | | | | | | | | | | | | ☆ | | ★ | | ☆ | | | | 10.0 | 3.18 |
| | | .197 | | | | | | | | | | | | | | | | | | | | | | .394 | .125 |
| | 10 | 5.00 | ★ | | | | | ☆ | | | ☆ | | | | | | ☆ | | ☆ | | ★ | ☆ | | 10.0 | 3.18 |
| | | .197 | | | | | | | | | | | | | | | | | | | | | | .394 | .125 |
| | 12 | 6.00 | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | | .472 | .156 |
| | 12 | 6.00 | ☆ | | | ★ | | ☆ | | | ☆ | | | | ☆ | | ☆ | | ☆ | | ★ | ☆ | | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | | .472 | .156 |
| | 16 | 8.00 | | | | | ★ | | | ☆ | | | | | | | | | | | | | | 16.0 | 4.76 |
| | | .315 | | | | | | | | | | | | | | | | | | | | | | .630 | .188 |
| | 16 | 8.00 | ☆ | | | | | ☆ | | | ☆ | | | | | | ☆ | | ☆ | | ★ | ☆ | | 16.0 | 4.76 |
| | | .315 | | | | | | | | | | | | | | | | | | | | | | .630 | .188 |
| | 20 | 10.00 | | | | | ★ | | | ☆ | | | | | | | | | | | | | | 20.0 | 6.48 |
| | | .394 | | | | | | | | | | | | | | | | | | | | | | .787 | .255 |
| | 20 | 10.00 | ☆ | | | | | ☆ | | | | | | | | | ☆ | | ☆ | | | ★ | | 20.0 | 6.48 |
| | | .394 | | | | | | | | | | | | | | | | | | | | | | .787 | .255 |
| Medium | 05 | 2.50 | ★ | | | ☆ | | ☆ | | | | ★ | | | ★ | | ☆ | | ☆ | | | | | 5.0 | 1.70 |
| | | .098 | | | | | | | | | | | | | | | | | | | | | | .197 | .197 |
| | 07 20 | 3.50 | | | | | | | | ★ | | | | | | | | | | | | | | 7.0 | 1.99 |
| | | .138 | | | | | | | | | | | | | | | | | | | | | | .276 | .078 |
| | 07 20 | 3.50 | ★ | | | ☆ | | | | | | | | | ★ | | ☆ | | ☆ | | | | ☆ | 7.0 | 1.99 |
| | | .138 | | | | | | | | | | | | | | | | | | | | | | .276 | .078 |
| | 07 24 | 3.50 | | | | | | | | ★ | | | | | | | | | | | | | | 7.0 | 2.38 |
| | | .138 | | | | | | | | | | | | | | | | | | | | | | .276 | .094 |
| | | 3.50 | ★ | | | ☆ | | | | | | | | | ★ | | ☆ | | ☆ | | | | ☆ | 7.0 | 2.38 |
| | | .138 | | | | | | | | | | | | | | | | | | | | | | .276 | .094 |
| | 08 | 4.00 | | | | | | | | | | ★ | | | | | | | | | | | | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | 08 | 4.00 | | | | | ★ | | | ☆ | | | | | | | | | | | | | | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | 08 | 4.00 | ☆ | | | ★ | | ☆ | | | ☆ | | | | ☆ | | ☆ | | ☆ | | ★ | ☆ | ☆ | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | | 4.00 | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | | 4.00 | ☆ | | | ★ | | ☆ | | | ☆ | | | | ☆ | | ☆ | | ☆ | | ★ | ☆ | | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | 10 | 5.00 | | | | | ★ | | | ☆ | | | | | | | | | | | | | | 10.0 | 3.18 |
| | | .197 | | | | | | | | | | | | | | | | | | | | | | .394 | .125 |
| | 10 | 5.00 | ☆ | | | ★ | | ☆ | | | ☆ | | | | ☆ | | ☆ | | ☆ | | ★ | ☆ | ☆ | 10.0 | 3.18 |
| | | .197 | | | | | | | | | | | | | | | | | | | | | | .394 | .125 |
| | | 5.00 | ☆ | | ★ | ☆ | | ☆ | | | ☆ | | | | ☆ | | ☆ | | ☆ | | ★ | ☆ | | 10.0 | 3.18 |
| | | .197 | | | | | | | | | | | | | | | | | | | | | | .394 | .125 |
| | | 5.00 | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | 10.0 | 3.18 |
| | | .197 | | | | | | | | | | | | | | | | | | | | | | .394 | .125 |
| | 12 | 6.00 | | | | | | | | | | ☆ | | ★ | | | | | | | | | | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | | .472 | .156 |
| | 12 | 6.00 | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | | .472 | .156 |
| | 12 | 6.00 | ☆ | | | ★ | | ☆ | | | ☆ | | | | ☆ | | ☆ | | ☆ | | ★ | ☆ | ☆ | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | | .472 | .156 |
| | | 6.00 | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | | .472 | .156 |
| | | 6.00 | ☆ | ☆ | ★ | ☆ | | ☆ | | | ☆ | | | | ☆ | | ☆ | | ☆ | | ★ | ☆ | | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | | .472 | .156 |

I119 I222 I254 N22 N10

# CoroMill® 300 insert for milling




## Metric version

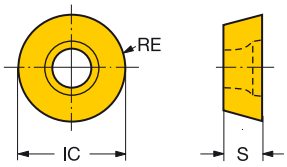
| | RE | Ordering code | P | | | | M | | | | K | | | | | N | | S | | | | H | Dimensions, mm, inch | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | 1130 | 4220 | 4330 | 4340 | 1040 | 1130 | 2030 | 2040 | S30T | 1020 | 3040 | 3330 | 4340 | H13A | 1130 | H13A | 1130 | H13A | S30T | S40T | 1025 | IC | S |
| Medium | 16 | 8.00 | | | | ★ | | | ☆ | | | | | | | | | | | | | | 16.0 | 4.76 |
| | | .315 | | | | | | | | | | | | | | | | | | | | | .630 | .188 |
| | 16 | 8.00 | ☆ | | | ★ | | ☆ | | | ☆ | | | | ☆ | | ☆ | | ☆ | | ★ | ☆ | 16.0 | 4.76 |
| | | .315 | | | | | | | | | | | | | | | | | | | | | .630 | .188 |
| | | 8.00 | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | 16.0 | 4.76 |
| | | .315 | | | | | | | | | | | | | | | | | | | | | .630 | .188 |
| | | 8.00 | ☆ | | ★ | ☆ | | ☆ | | | ☆ | | | | ☆ | | ☆ | | ☆ | | ★ | ☆ | 16.0 | 4.76 |
| | | .315 | | | | | | | | | | | | | | | | | | | | | .630 | .188 |
| | 20 | 10.00 | | | | | | | | ☆ | | | | | | | | | | | | | 20.0 | 6.48 |
| | | .394 | | | | | | | | | | | | | | | | | | | | | .787 | .255 |
| | 20 | 10.00 | ☆ | | | | | ☆ | | | | | | | | | ☆ | | ☆ | | | ★ | 20.0 | 6.48 |
| | | .394 | | | | | | | | | | | | | | | | | | | | | .787 | .255 |
| | | 10.00 | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | 20.0 | 6.48 |
| | | .394 | | | | | | | | | | | | | | | | | | | | | .787 | .255 |
| | | 10.00 | ☆ | | ★ | ☆ | | ☆ | | | | | | | ☆ | | ☆ | | ☆ | | | ★ | 20.0 | 6.48 |
| | | .394 | | | | | | | | | | | | | | | | | | | | | .787 | .255 |
| | 07 20 | 3.50 | ☆ | | | ★ | | ☆ | | | | | | | ☆ | | ☆ | | ☆ | | | ☆ | 7.0 | 1.99 |
| | | .138 | | | | | | | | | | | | | | | | | | | | | .276 | .078 |
| | 07 24 | 3.50 | ☆ | | | ★ | | ☆ | | | | | | | ☆ | | ☆ | | ☆ | | | ☆ | 7.0 | 2.38 |
| | | .138 | | | | | | | | | | | | | | | | | | | | | .276 | .094 |
| | 05 | 2.50 | ☆ | | | ★ | | ☆ | | | | | | | ☆ | | ☆ | | ☆ | | | | 5.0 | 1.70 |
| | | .098 | | | | | | | | | | | | | | | | | | | | | .197 | .067 |
| Heavy | 08 | 4.00 | | | | | | | | | | ☆ | ★ | | | | | | | | | | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | 08 | 4.00 | | | | | | | | ★ | | | | | | | | | | | | | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | 08 | 4.00 | ☆ | | ★ | ☆ | | ☆ | | | | | | | ☆ | | ☆ | | ☆ | | | | 8.0 | 2.78 |
| | | .157 | | | | | | | | | | | | | | | | | | | | | .315 | .109 |
| | 10 | 5.00 | | | | | | | | | | | ★ | | | | | | | | | | 10.0 | 3.18 |
| | | .197 | | | | | | | | | | | | | | | | | | | | | .394 | .125 |
| | 10 | 5.00 | | | | | | | ☆ | ★ | | | | | | | | | | | | | 10.0 | 3.18 |
| | | .197 | | | | | | | | | | | | | | | | | | | | | .394 | .125 |
| | 10 | 5.00 | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | ☆ | | ☆ | | ☆ | | | | 10.0 | 3.18 |
| | | .197 | | | | | | | | | | | | | | | | | | | | | .394 | .125 |
| | 12 | 6.00 | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | .472 | .156 |
| | 12 | 6.00 | | | | | | | ☆ | ★ | | | | | | | | | | | | | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | .472 | .156 |
| | 12 | 6.00 | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | ☆ | | ☆ | | ☆ | | | ★ | 12.0 | 3.97 |
| | | .236 | | | | | | | | | | | | | | | | | | | | | .472 | .156 |
| | 16 | 8.00 | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | 16.0 | 4.76 |
| | | .315 | | | | | | | | | | | | | | | | | | | | | .630 | .188 |
| | 16 | 8.00 | | | | | | | ☆ | ★ | | | | | | | | | | | | | 16.0 | 4.76 |
| | | .315 | | | | | | | | | | | | | | | | | | | | | .630 | .188 |
| | 16 | 8.00 | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | ☆ | | ☆ | | ☆ | | | ★ | 16.0 | 4.76 |
| | | .315 | | | | | | | | | | | | | | | | | | | | | .630 | .188 |
| | 20 | 10.00 | | | | | | | | | | | ☆ | ★ | | | | | | | | | 20.0 | 6.48 |
| | | .394 | | | | | | | | | | | | | | | | | | | | | .787 | .255 |
| | 20 | 10.00 | | | | | | | ☆ | ★ | | | | | | | | | | | | | 20.0 | 6.48 |
| | | .394 | | | | | | | | | | | | | | | | | | | | | .787 | .255 |
| | 20 | 10.00 | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | ☆ | | ☆ | | ☆ | | | | 20.0 | 6.48 |
| | | .394 | | | | | | | | | | | | | | | | | | | | | .787 | .255 |

I119 I222 I254 N22 N10



SANDVIK Coromant

# CoroMill® 300 insert for milling




## Inch version

| | | RE | Ordering code | P | | | M | | | | | K | | | | N | S | | | H | | Dimensions, mm, inch | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1130 | 4330 | 4340 | 1040 | 1130 | 2030 | 2040 | S30T | 3040 | 3330 | 4330 | 4340 | 1130 | 1130 | S30T | S40T | 1010 | 1130 | IC | S |
| Light | 13 | 6.35 | R300-1340E-PL | ☆ | | | | ☆ | | | ☆ | | | | | ☆ | ☆ | ★ | ☆ | | ☆ | 12.7 | 3.97 |
| | | .250 | | | | | | | | | | | | | | | | | | | | .500 | .156 |
| | | 6.35 | R300-1340E-ML | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | 12.7 | 3.97 |
| | | .250 | | | | | | | | | | | | | | | | | | | | .500 | .156 |
| | 25 | 12.70 | R300-2570E-PL | ☆ | | | | ☆ | | | | | | | | ☆ | ☆ | | ★ | ★ | ☆ | 25.4 | 7.94 |
| | | .500 | | | | | | | | | | | | | | | | | | | | 1.000 | .313 |
| | | 12.70 | R300-2570E-ML | | | | | | | ☆ | | | | | | | | | | | | 25.4 | 7.94 |
| | | .500 | | | | | | | | | | | | | | | | | | | | 1.000 | .313 |
| Medium | 07 20 | 3.50 | R300-0720E-MM | | | | | | | ☆ | | | | | | | | | | | | 7.0 | 1.99 |
| | | .138 | | | | | | | | | | | | | | | | | | | | .276 | .078 |
| | 07 24 | 3.50 | R300-0724E-MM | | | | | | | ☆ | | | | | | | | | | | | 7.0 | 2.38 |
| | | .138 | | | | | | | | | | | | | | | | | | | | .276 | .094 |
| | 09 | 4.76 | R300-0932E-PM | ★ | | | | ☆ | | | | | | | | ☆ | ☆ | | | ★ | ☆ | 9.5 | 3.18 |
| | | .188 | | | | | | | | | | | | | | | | | | | | .375 | .125 |
| | | 4.76 | R300-0932M-PM | ☆ | | | | ☆ | | | | | | | | ☆ | ☆ | | | | ☆ | 9.5 | 3.18 |
| | | .188 | | | | | | | | | | | | | | | | | | | | .375 | .125 |
| | 13 | 6.35 | R300-1340E-PM | ★ | | | | ☆ | | | ☆ | | | | | ☆ | ☆ | ★ | ☆ | ★ | ☆ | 12.7 | 3.97 |
| | | .250 | | | | | | | | | | | | | | | | | | | | .500 | .156 |
| | | 6.35 | R300-1340M-PM | ☆ | ★ | ☆ | | ☆ | | | ☆ | | | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | | ☆ | 12.7 | 3.97 |
| | | .250 | | | | | | | | | | | | | | | | | | | | .500 | .156 |
| | | 6.35 | R300-1340E-MM | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | 12.7 | 3.97 |
| | | .250 | | | | | | | | | | | | | | | | | | | | .500 | .156 |
| | | 6.35 | R300-1340M-MM | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | 12.7 | 3.97 |
| | | .250 | | | | | | | | | | | | | | | | | | | | .500 | .156 |
| | 25 | 12.70 | R300-2570M-PM | ☆ | ★ | ☆ | | ☆ | | | | | | ☆ | ☆ | ☆ | ☆ | | ★ | | ☆ | 25.4 | 7.94 |
| | | .500 | | | | | | | | | | | | | | | | | | | | 1.000 | .313 |
| | | 12.70 | R300-2570M-MM | | | | | | | ☆ | | | | | | | | | | | | 25.4 | 7.94 |
| | | .500 | | | | | | | | | | | | | | | | | | | | 1.000 | .313 |
| Heavy | 09 | 4.76 | R300-0932M-PH | | | ★ | | | | | | | | | ★ | | | | | | | 9.5 | 3.18 |
| | | .188 | | | | | | | | | | | | | | | | | | | | .375 | .125 |
| | 13 | 6.35 | R300-1340M-PH | ☆ | ★ | ☆ | | ☆ | | | | | | ★ | ☆ | ☆ | ☆ | | | | ☆ | 12.7 | 3.97 |
| | | .250 | | | | | | | | | | | | | | | | | | | | .500 | .156 |
| | | 6.35 | R300-1340M-MH | | | | | | | ★ | | | | | | | | | | | | 12.7 | 3.97 |
| | | .250 | | | | | | | | | | | | | | | | | | | | .500 | .156 |
| | | 6.35 | R300-1340M-KH | | | | | | | | | ☆ | | | | | | | | | | 12.7 | 3.97 |
| | | .250 | | | | | | | | | | | | | | | | | | | | .500 | .156 |
| | 25 | 12.70 | R300-2570M-PH | ☆ | ★ | ☆ | | ☆ | | | | | | ☆ | ☆ | ☆ | ☆ | | | | ☆ | 25.4 | 7.94 |
| | | .500 | | | | | | | | | | | | | | | | | | | | 1.000 | .313 |
| | | 12.70 | R300-2570M-KH | | | | | | | | | | ★ | | | | | | | | | 25.4 | 7.94 |
| | | .500 | | | | | | | | | | | | | | | | | | | | 1.000 | .313 |

I119 I222 I254 N22 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
- Whistle notch/Weldon

### Inserts

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

Coarse pitch Close pitch Extra close pitch

### Reliability and process security

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

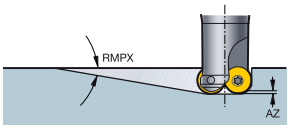
I135 I139



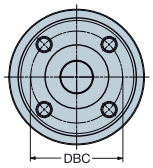
SANDVIK Coromant

# CoroMill® 200 face milling cutter

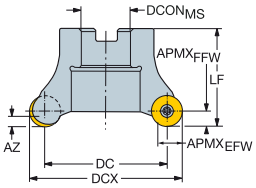
**Arbor**




STDNO




ISO6462




**Metric version**

| 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 |

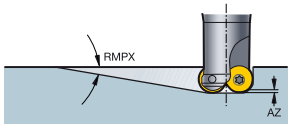
| | Spare parts | | |
|---|---|---|---|
| Ordering code | Insert screw | Shim | Shim screw |
| R200-038Q22-12H | 5513 020-09 | | |
| R200-038Q22-12L | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-038Q22-12M | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-040Q22-12H | 5513 020-09 | | |
| R200-040Q22-12L | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-040Q22-12M | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-051Q22-12H | 5513 020-09 | | |
| R200-051Q22-12L | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-051Q22-12M | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-068Q27-12L | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-068Q27-12M | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-088Q32-12L | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-088Q32-12M | 5513 020-01 | 5322 110-02 | 5512 090-09 |
| R200-047Q22-16M | 5513 020-07 | | |
| R200-050Q27-16H | 5513 020-07 | | |
| R200-050Q27-16M | 5513 020-07 | | |
| R200-064Q27-16H | 5513 020-07 | | |
| R200-064Q27-16L | 5513 020-26 | 5322 110-03 | 5512 090-06 |
| R200-064Q27-16M | 5513 020-26 | 5322 110-03 | 5512 090-06 |
| R200-084Q32-16M | 5513 020-26 | 5322 110-03 | 5512 090-06 |
| R200-109Q32-16L | 5513 020-26 | 5322 110-03 | 5512 090-06 |
| R200-109Q32-16M | 5513 020-26 | 5322 110-03 | 5512 090-06 |
| R200-060Q27-20L | 5513 020-14 | 5322 110-04 | 5512 090-08 |
| R200-060Q27-20M | 5513 020-08 | | |
| R200-080Q32-20L | 5513 020-14 | 5322 110-04 | 5512 090-08 |
| R200-080Q32-20M | 5513 020-08 | | |
| R200-105Q32-20L | 5513 020-14 | 5322 110-04 | 5512 090-08 |
| R200-105Q32-20M | 5513 020-08 | | |
| R200-140Q40-20L | 5513 020-14 | 5322 110-04 | 5512 090-08 |
| R200-140Q40-20M | 5513 020-08 | | |

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

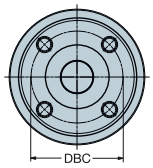
I139 L2 M1 N22 N9

# CoroMill® 200 face milling cutter

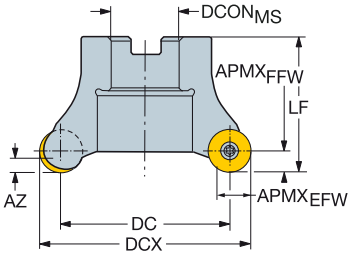
**Arbor**




STDNO




ISO6462




## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | | | Ordering code | Dimensions, inch DCONMS | ISO | DBC | DCX | BD | LB | LF | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.500 | 13 | 3/4 | .375 | .250 | 6° | .138 | | 3 | RA200-038R19-13L | .750 | A | | 2.000 | 2.000 | 1.969 | 1.969 | 2.2 | 1.63 | 18800 | 3 | RCKT 13 04 00 |
| | 13 | 3/4 | .375 | .250 | 6° | .138 | 4 | | RA200-038R19-13M | .750 | A | | 2.000 | 2.000 | 1.969 | 1.969 | 2.2 | 1.52 | 18800 | 4 | RCKT 13 04 00 |
| | 13 | 3/4 | .375 | .250 | 6° | .138 | 5 | | RA200-038R19-13H | .750 | A | | 2.000 | 2.000 | 1.969 | 1.969 | 2.2 | 1.46 | 18800 | 5 | RCKT 13 04 00 |
| | 13 | 3/4 | .375 | .250 | 6° | .138 | 5 | | RA200-038R19-13H-HD | .750 | A | | 2.000 | 2.000 | 1.969 | 1.969 | 2.2 | 1.50 | 18800 | 5 | RCKT 13 04 00 |
| 2.250 | 19 | 1 | .563 | .375 | 7° | .228 | | 4 | RA200-057R25-19L | 1.000 | A | | 3.000 | 3.000 | 1.969 | 1.969 | 5.5 | 2.03 | 10600 | 4 | RCKT 19 06 00 |
| | 19 | 1 | .563 | .375 | 7° | .228 | 5 | | RA200-057R25-19M | 1.000 | A | | 3.000 | 3.000 | 1.969 | 1.969 | 5.5 | 2.08 | 10600 | 5 | RCKT 19 06 00 |
| 2.500 | 13 | 1 | .375 | .250 | 3° | .138 | | 4 | RA200-063R25-13L | 1.000 | A | | 3.000 | 3.000 | 1.969 | 1.969 | 2.2 | 2.40 | 18000 | 4 | RCKT 13 04 00 |
| | 13 | 1 | .375 | .250 | 3° | .138 | | 5 | RA200-063R25-13M | 1.000 | A | | 3.000 | 3.000 | 1.969 | 1.969 | 2.2 | 2.22 | 18000 | 5 | RCKT 13 04 00 |
| | 13 | 1 | .375 | .250 | 3° | .138 | 6 | | RA200-063R25-13H | 1.000 | A | | 3.000 | 3.000 | 1.969 | 1.969 | 2.2 | 2.30 | 18000 | 6 | RCKT 13 04 00 |
| 2.677 | 12 | 1 | .354 | .236 | 3° | .146 | | 6 | RA200-068J25.4-12M | 1.000 | | | 3.150 | 3.150 | 1.969 | 1.969 | 2.2 | 2.20 | 14000 | 6 | RCKT 12 04 M0 |
| 3.250 | 19 | 1 1/2 | .563 | .375 | 4° | .228 | | 4 | RA200-083R38-19L | 1.500 | A | | 4.000 | 4.000 | 2.480 | 2.480 | 5.5 | 5.38 | 9200 | 4 | RCKT 19 06 00 |
| | 19 | 1 1/2 | .563 | .375 | 4° | .228 | 6 | | RA200-083R38-19M | 1.500 | A | | 4.000 | 4.000 | 2.480 | 2.480 | 5.5 | 4.80 | 9200 | 6 | RCKT 19 06 00 |
| 3.465 | 12 | 1 1/4 | .354 | .236 | 2° | .146 | | 6 | RA200-088J31.75-12M | 1.250 | | | 3.937 | 3.937 | 2.480 | 2.480 | 2.2 | 4.26 | 12300 | 6 | RCKT 12 04 M0 |
| 3.500 | 13 | 1 1/2 | .375 | .250 | 2° | .138 | | 5 | RA200-089R38-13L | 1.500 | A | | 4.000 | 4.000 | 1.969 | 1.969 | 2.2 | 4.07 | 16200 | 5 | RCKT 13 04 00 |
| | 13 | 1 1/2 | .375 | .250 | 2° | .138 | 8 | | RA200-089R38-13M | 1.500 | A | | 4.000 | 4.000 | 1.969 | 1.969 | 2.2 | 3.70 | 16200 | 8 | RCKT 13 04 00 |
| 4.250 | 19 | 1 1/2 | .563 | .375 | 3° | .228 | 6 | | RA200-108R38-19M | 1.500 | B | | 5.000 | 5.000 | 2.480 | 2.480 | 5.5 | 5.56 | 8000 | 6 | RCKT 19 06 00 |
| 4.291 | 16 | 1 1/2 | .472 | .315 | 2° | .193 | | 6 | RA200-109J38.1-16M | 1.500 | | | 4.921 | 4.921 | 2.480 | 2.480 | 3.6 | 6.09 | 10000 | 6 | RCKT 16 06 M0 |
| 4.500 | 13 | 1 1/2 | .375 | .250 | 1° | .138 | 10 | | RA200-114R38-13M | 1.500 | B | | 5.000 | 5.000 | 2.480 | 2.480 | 2.2 | 6.49 | 14000 | 10 | RCKT 13 04 00 |
| 5.250 | 19 | 1 1/2 | .563 | .375 | 2° | .228 | | 6 | RA200-133R38-19L | 1.500 | B | | 6.000 | 6.000 | 2.480 | 2.480 | 5.5 | 8.42 | 6900 | 6 | RCKT 19 06 00 |
| | 19 | 1 1/2 | .563 | .375 | 2° | .228 | 8 | | RA200-133R38-19M | 1.500 | B | | 6.000 | 6.000 | 2.480 | 2.480 | 5.5 | 7.05 | 6900 | 8 | RCKT 19 06 00 |
| 5.500 | 13 | 1 1/2 | .375 | .250 | 1° | .138 | | 8 | RA200-140R38-13L | 1.500 | B | | 6.000 | 6.000 | 2.480 | 2.480 | 2.2 | 8.51 | 12300 | 8 | RCKT 13 04 00 |
| | 13 | 1 1/2 | .375 | .250 | 1° | .138 | 12 | | RA200-140R38-13M | 1.500 | B | | 6.000 | 6.000 | 2.480 | 2.480 | 2.2 | 6.93 | 12300 | 12 | RCKT 13 04 00 |
| 5.512 | 20 | 2 | .591 | .394 | 2° | .240 | 8 | | RA200-140J50.8-20M | 2.000 | | | 6.299 | 6.299 | 2.480 | 2.480 | 5.5 | 8.80 | 6900 | 8 | RCKT 20 06 M0 |
| 7.250 | 19 | 2 1/2 | .563 | .375 | 2° | .228 | | 8 | RA200-184R63-19L | 2.500 | C | 4.000 | 8.000 | 8.000 | 2.480 | 2.480 | 5.5 | 21.26 | 4700 | 8 | RCKT 19 06 00 |
| 9.250 | 19 | 2 1/2 | .563 | .375 | 1° | .228 | | 10 | RA200-235R63-19L | 2.500 | C | 4.000 | 10.000 | 10.000 | 2.480 | 2.480 | 5.5 | 28.70 | 2500 | 10 | RCKT 19 06 00 |

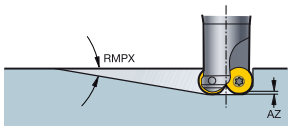
| | Spare parts | | |
|---|---|---|---|
| Ordering code | Insert screw | Shim | Shim screw |
| RA200-038R19-13H | 5513 020-09 | | |
| RA200-038R19-13H-HD | 5513 020-09 | | |
| RA200-038R19-13L | 5513 020-01 | 5322 110-06 | 5512 090-09 |
| RA200-038R19-13M | 5513 020-01 | 5322 110-06 | 5512 090-09 |
| RA200-063R25-13H | 5513 020-09 | | |
| RA200-063R25-13L | 5513 020-01 | 5322 110-06 | 5512 090-09 |
| RA200-063R25-13M | 5513 020-01 | 5322 110-06 | 5512 090-09 |
| RA200-089R38-13L | 5513 020-01 | 5322 110-06 | 5512 090-09 |
| RA200-089R38-13M | 5513 020-01 | 5322 110-06 | 5512 090-09 |
| RA200-114R38-13M | 5513 020-01 | 5322 110-06 | 5512 090-09 |
| RA200-140R38-13L | 5513 020-01 | 5322 110-06 | 5512 090-09 |
| RA200-140R38-13M | 5513 020-01 | 5322 110-06 | 5512 090-09 |
| RA200-057R25-19L | 5513 020-08 | | |
| RA200-057R25-19M | 5513 020-08 | | |
| RA200-083R38-19L | 5513 020-14 | 5322 110-07 | 5512 090-08 |
| RA200-083R38-19M | 5513 020-08 | | |
| RA200-108R38-19M | 5513 020-08 | | |
| RA200-133R38-19L | 5513 020-14 | 5322 110-07 | 5512 090-08 |
| RA200-133R38-19M | 5513 020-08 | | |
| RA200-184R63-19L | 5513 020-14 | 5322 110-07 | 5512 090-08 |
| RA200-235R63-19L | 5513 020-14 | 5322 110-07 | 5512 090-08 |

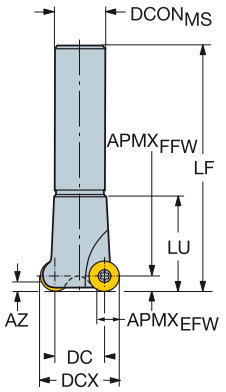
For the complete list of spare parts, visit www.sandvik.coromant.com

I139 L2 M1 N22 N9

# CoroMill® 200 face milling cutter

**Cylindrical shank**




## Metric version

| 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 |

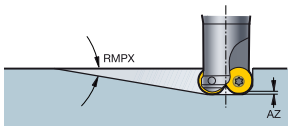
| | Spare parts |
|---|---|
| | Insert screw |
| 10 | 5513 020-09 |
| 12 | 5513 020-09 |
| 16 | 5513 020-07 |
| 20 | 5513 020-08 |

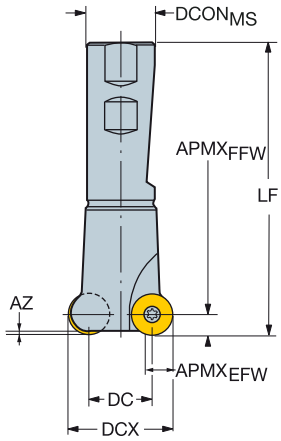
For the complete list of spare parts, visit www.sandvik.coromant.com

I139 L2 N22 N9

# CoroMill® 200 face milling cutter

**Whistle notch / Weldon**




## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | | Ordering code | Dimensions, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | DCONMS | DCX | BD | LB | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
| .625 | 09 | 1 | .281 | .187 | 13° | .106 | 2 | **RA200-016MN25-09M** | 1.000 | 1.000 | 1.000 | 3.000 | 5.197 | 3.000 | 1.4 | 1.21 | 37500 | 2 | RCKT 09 T3 00 |
| .750 | 13 | 1 1/4 | .375 | .250 | 13° | .138 | 2 | **RA200-019MN32-13M** | 1.250 | 1.250 | 1.250 | 3.750 | 6.024 | 3.750 | 2.2 | 1.90 | 31000 | 2 | RCKT 13 04 00 |
| 1.000 | 13 | 1 1/4 | .375 | .250 | 11° | .138 | 3 | **RA200-025MN32-13M** | 1.250 | 1.500 | 1.500 | 4.000 | 6.299 | | 2.2 | 2.50 | 26300 | 3 | RCKT 13 04 00 |
| 1.250 | 19 | 1 1/4 | .563 | .375 | 13° | .228 | 3 | **RA200-032MN32-19M** | 1.250 | 2.000 | 2.000 | 1.625 | 4.016 | | 5.5 | 1.98 | 20900 | 3 | RCKT 19 06 00 |
| 1.500 | 13 | 1 1/4 | .375 | .250 | 6° | .138 | 4 | **RA200-038MN32-13M** | 1.250 | 2.000 | 2.000 | 1.125 | 4.016 | | 2.2 | 1.68 | 22500 | 4 | RCKT 13 04 00 |

| | Spare parts |
|---|---|
| | Insert screw |
| 09 | 5513 020-30 |
| 13 | 5513 020-09 |
| 19 | 5513 020-08 |

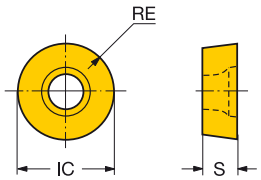
For the complete list of spare parts, visit www.sandvik.coromant.com

I139 L2 N22 N9



SANDVIK Coromant

# CoroMill® 200 insert for milling

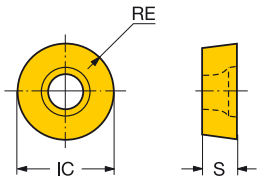



## Metric version

| | | | | RE | Ordering code | P | | | | | M | | | | | K | | | | N | | | | S | | | | | H | | | | Dimensions, mm, inch | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3220 | 3330 | 1130 | 530 | H10F | H13A | 1130 | H10F | H13A | S30T | S40T | 1010 | 1130 | 530 | IC | S |
| Light | KL | 10 | .394 | 5.00 | RCHT 10 T3 M0-KL | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | | | 10.0 | 3.97 |
| | | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .394 | .156 |
| | | 12 | .472 | 6.00 | RCHT 12 04 M0-KL | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | | | 12.0 | 4.76 |
| | | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .472 | .188 |
| | | 16 | .630 | 8.00 | RCHT 16 06 M0-KL | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | | | 16.0 | 6.35 |
| | | | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .630 | .250 |
| | | 20 | .787 | 10.00 | RCHT 20 06 M0-KL | | | | | | | | | | | | | | | ★ | | | | ☆ | | | | | | | | 20.0 | 6.35 |
| | | | | .394 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .787 | .250 |
| | ML | 10 | .394 | 5.00 | RCHT 10 T3 M0-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | 10.0 | 3.97 |
| | | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .394 | .156 |
| | | 12 | .472 | 6.00 | RCHT1204M0-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | 12.0 | 4.76 |
| | | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .472 | .188 |
| | | 16 | .630 | 8.00 | RCHT 16 06 M0-ML | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | 16.0 | 6.35 |
| | | | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .630 | .250 |
| | | 20 | .787 | 10.00 | RCHT 20 06 M0-ML | | | | | | | | | ☆ | | | | | | | | | | | | | | | | | | | 20.0 | 6.35 |
| | | | | .394 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .787 | .250 |
| | PL | 10 | .394 | 5.00 | RCHT 10 T3 M0-PL | ★ | | | | | | ☆ | | | | | | | | | ☆ | | | | ☆ | | | | | ★ | ☆ | | 10.0 | 3.97 |
| | | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .394 | .156 |
| | | 12 | .472 | 6.00 | RCHT 12 04 M0-PL | ★ | | | | ☆ | | ☆ | | | ☆ | | | | | | ☆ | ☆ | | | ☆ | | | | | ★ | ☆ | ☆ | 12.0 | 4.76 |
| | | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .472 | .188 |
| | | 16 | .630 | 8.00 | RCHT 16 06 M0-PL | ★ | | | | | | ☆ | | | | | | | | | ☆ | | | | ☆ | | | | | | ☆ | | 16.0 | 6.35 |
| | | | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .630 | .250 |
| | | 20 | .787 | 10.00 | RCHT 20 06 M0-PL | ★ | | | | | | ☆ | | | | | | | | | ☆ | | | | ☆ | | | | | | ☆ | | 20.0 | 6.35 |
| | | | | .394 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .787 | .250 |
| Medium | KM | 10 | .394 | 5.00 | RCKT 10 T3 M0-KM | | | | | | | | | | | | ☆ | ☆ | | ★ | | | | | | | | | | | | | 10.0 | 3.97 |
| | | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .394 | .156 |
| | | 12 | .472 | 6.00 | RCKT 12 04 M0-KM | | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | | | | | | | | | | | | 12.0 | 4.76 |
| | | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .472 | .188 |
| | | 16 | .630 | 8.00 | RCKT 16 06 M0-KM | | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | | | | | | | | | | | | 16.0 | 6.35 |
| | | | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .630 | .250 |
| | | 20 | .787 | 10.00 | RCKT 20 06 M0-KM | | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | | | | | | | | | | | | 20.0 | 6.35 |
| | | | | .394 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .787 | .250 |
| | MM | 10 | .394 | 5.00 | RCKT 10 T3 M0-MM | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | 10.0 | 3.97 |
| | | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .394 | .156 |
| | | 12 | .472 | 6.00 | RCKT 12 04 M0-MM | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | 12.0 | 4.76 |
| | | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .472 | .188 |
| | | 16 | .630 | 8.00 | RCKT 16 06 M0-MM | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | 16.0 | 6.35 |
| | | | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .630 | .250 |
| | | 20 | .787 | 10.00 | RCKT 20 06 M0-MM | | | | | | ★ | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | 20.0 | 6.35 |
| | | | | .394 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .787 | .250 |
| | PM | 10 | .394 | 5.00 | RCKT 10 T3 M0-PM | ☆ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | | | | | | ☆ | | | | ☆ | | | ★ | | | ☆ | | 10.0 | 3.97 |
| | | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .394 | .156 |
| | | 12 | .472 | 6.00 | RCKT 12 04 M0-PM | ☆ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | | | | | | ☆ | | | | ☆ | | | ★ | ☆ | | ☆ | | 12.0 | 4.76 |
| | | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .472 | .188 |
| | | 16 | .630 | 8.00 | RCKT 16 06 M0-PM | ☆ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | | | | | | ☆ | | | | ☆ | | | ★ | ☆ | | ☆ | | 16.0 | 6.35 |
| | | | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .630 | .250 |
| | | 20 | .787 | 10.00 | RCKT 20 06 M0-PM | ☆ | ☆ | ★ | ☆ | | | ☆ | | | ☆ | | | | | | ☆ | | | | ☆ | | | ★ | ☆ | | ☆ | | 20.0 | 6.35 |
| | | | | .394 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .787 | .250 |
| | WM | 10 | .394 | 5.00 | RCKT 10 T3 M0-WM | | | | | ☆ | | | | | ☆ | | | | | | | ☆ | ☆ | | | ☆ | | | | | | ☆ | 10.0 | 3.97 |
| | | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .394 | .156 |
| | | 12 | .472 | 6.00 | RCKT 12 04 M0-WM | | | | | ☆ | | | | | ☆ | | | | | | | ☆ | ☆ | | | ☆ | | | | | | ☆ | 12.0 | 4.76 |
| | | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .472 | .188 |
| | | 16 | .630 | 8.00 | RCKT 16 06 M0-WM | | | | | | | | | | | | | | | | | | ☆ | | | ☆ | | | | | | | 16.0 | 6.35 |
| | | | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .630 | .250 |
| | | 20 | .787 | 10.00 | RCKT 20 06 M0-WM | | | | | | | | | | | | | | | | | | | | | | | | | | | | 20.0 | 6.35 |
| | | | | .394 | | | | | | | | | | | | | | | | | | | | | | | | | | | | .787 | .250 |

I135 I222 I254 N22 N10

# CoroMill® 200 insert for milling

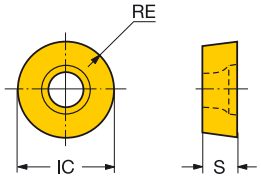



## Metric version

| | | | | RE | Ordering code | P | | | | | M | | | | | | K | | | | N | | | | S | | | | | | H | | | Dimensions, mm, inch | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | 1130 | 4220 | 4330 | 4340 | 530 | 1040 | 1130 | 2030 | 2040 | 530 | S30T | 1020 | 3040 | 3220 | 3330 | 1130 | 530 | H10F | H13A | 1130 | H10F | H13A | S30T | S40T | 1010 | 1130 | 530 | IC | S |
| Heavy | KH | 10 | .394 | 5.00 | RCKT 10 T3 M0-KH | | | | | | | | | | | | | ☆ | | ★ | | | | | | | | | | | | | 10.0 | 3.97 |
| | | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .394 | .156 |
| | | 12 | .472 | 6.00 | RCKT 12 04 M0-KH | | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | | | | | | | | | | | | 12.0 | 4.76 |
| | | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .472 | .188 |
| | | 16 | .630 | 8.00 | RCKT 16 06 M0-KH | | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | | | | | | | | | | | | 16.0 | 6.35 |
| | | | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .630 | .250 |
| | | 20 | .787 | 10.00 | RCKT 20 06 M0-KH | | | | | | | | | | | | ☆ | ☆ | ☆ | ★ | | | | | | | | | | | | | 20.0 | 6.35 |
| | | | | .394 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .787 | .250 |
| | PH | 10 | .394 | 5.00 | RCKT 10 T3 M0-PH | ☆ | | ★ | ☆ | | | ☆ | | | | | | | | | ☆ | | | | ☆ | | | | | | ☆ | | | 10.0 | 3.97 |
| | | | | .197 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .394 | .156 |
| | | 12 | .472 | 6.00 | RCKT 12 04 M0-PH | ☆ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | | ☆ | | | | ☆ | | | | | | ☆ | | | 12.0 | 4.76 |
| | | | | .236 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .472 | .188 |
| | | 16 | .630 | 8.00 | RCKT 16 06 M0-PH | ☆ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | | ☆ | | | | ☆ | | | | | | ☆ | | | 16.0 | 6.35 |
| | | | | .315 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .630 | .250 |
| | | 20 | .787 | 10.00 | RCKT 20 06 M0-PH | ☆ | ☆ | ★ | ☆ | | | ☆ | | | | | | | | | ☆ | | | | ☆ | | | | | | ☆ | | | 20.0 | 6.35 |
| | | | | .394 | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .787 | .250 |

I135 I222 I254 N22 N10

# CoroMill® 200 insert for milling



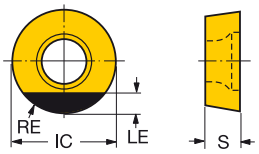

## Inch version

| | | | | | Ordering code | P | | | | M | | | | | K | | | N | | | S | | | | | | H | | Dimensions, mm, inch | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | RE | | 1130 | 4220 | 4330 | 4340 | 1040 | 1130 | 2030 | 2040 | S30T | S40T | 1020 | 3040 | 3330 | 1130 | H10F | H13A | 1130 | 2030 | H10F | H13A | S30T | S40T | 1010 | 1130 | IC | S |
| Light | 09 | 3/8 | 4.76 | | RCHT 09 T3 00-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | ★ | ☆ | 9.5 | 3.97 |
| | | | .188 | | | | | | | | | | | | | | | | | | | | | | | | | | | .375 | .156 |
| | | 3/8 | 4.76 | | RCHT 09 T3 00-ML | | | | | ★ | | | | | | | | | | | | | | | | | | | | 9.5 | 3.97 |
| | | | .188 | | | | | | | | | | | | | | | | | | | | | | | | | | | .375 | .156 |
| | 13 | 1/2 | 6.35 | | RCHT 13 04 00-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | ★ | ☆ | 12.7 | 4.76 |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | .500 | .188 |
| | | 1/2 | 6.35 | | RCHT 13 04 00-ML | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | | | | | | | 12.7 | 4.76 |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | .500 | .188 |
| | | 1/2 | 6.35 | | RCHT 13 04 00-KL | | | | | | | | | | | | | | | ★ | | | ☆ | | | | | | | 12.7 | 4.76 |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | .500 | .188 |
| | 19 | 3/4 | 9.53 | | RCHT 19 06 00-PL | ★ | | | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | ★ | | 19.1 | 6.35 |
| | | | .375 | | | | | | | | | | | | | | | | | | | | | | | | | | | .750 | .250 |
| | | 3/4 | 9.53 | | RCHT 19 06 00-ML | | | | | | | | ☆ | | | | | | | | | | | | | | | | | | 19.1 | 6.35 |
| | | | .375 | | | | | | | | | | | | | | | | | | | | | | | | | | | .750 | .250 |
| Medium | 09 | 3/8 | 4.76 | | RCKT 09 T3 00-PM | ☆ | | ★ | | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | 9.5 | 3.97 |
| | | | .188 | | | | | | | | | | | | | | | | | | | | | | | | | | | .375 | .156 |
| | | 3/8 | 4.76 | | RCKT 09 T3 00-MM | | | | | | | ☆ | ☆ | | | | | | | | | | ★ | | | | | | | 9.5 | 3.97 |
| | | | .188 | | | | | | | | | | | | | | | | | | | | | | | | | | | .375 | .156 |
| | 13 | 1/2 | 6.35 | | RCKT 13 04 00-PM | ☆ | ☆ | ★ | ☆ | | ☆ | | | ☆ | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | 12.7 | 4.76 |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | .500 | .188 |
| | | 1/2 | 6.35 | | RCKT 13 04 00-MM | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | | | | | | | 12.7 | 4.76 |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | .500 | .188 |
| | | 1/2 | 6.35 | | RCKT 13 04 00-WM | | | | | | | | | | | | | | | ☆ | | | | ★ | | | | | | 12.7 | 4.76 |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | .500 | .188 |
| | | 1/2 | 6.35 | | RCKT 13 04 00-KM | | | | | | | | | | | | ☆ | ★ | | | | | | | | | | | | 12.7 | 4.76 |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | .500 | .188 |
| | 19 | 3/4 | 9.53 | | RCKT 19 06 00-PM | ☆ | | ★ | ☆ | | ☆ | | | ☆ | ☆ | | | | ☆ | | | ☆ | | | | ★ | ☆ | | ☆ | 19.1 | 6.35 |
| | | | .375 | | | | | | | | | | | | | | | | | | | | | | | | | | | .750 | .250 |
| | | 3/4 | 9.53 | | RCKT 19 06 00-MM | | | | | ★ | | ☆ | ☆ | | | | | | | | | | ★ | | | | | | | 19.1 | 6.35 |
| | | | .375 | | | | | | | | | | | | | | | | | | | | | | | | | | | .750 | .250 |
| | | 3/4 | 9.53 | | RCKT 19 06 00-WM | | | | | | | | | | | | | | | ☆ | | | | ★ | | | | | | 19.1 | 6.35 |
| | | | .375 | | | | | | | | | | | | | | | | | | | | | | | | | | | .750 | .250 |
| Heavy | 09 | 3/8 | 4.76 | | RCKT 09 T3 00-PH | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | 9.5 | 3.97 |
| | | | .188 | | | | | | | | | | | | | | | | | | | | | | | | | | | .375 | .156 |
| | | 3/8 | 4.76 | | RCKT 09 T3 00-KH | | | | | | | | | | | | ☆ | | | | | | | | | | | | | 9.5 | 3.97 |
| | | | .188 | | | | | | | | | | | | | | | | | | | | | | | | | | | .375 | .156 |
| | 13 | 1/2 | 6.35 | | RCKT 13 04 00-PH | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | 12.7 | 4.76 |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | .500 | .188 |
| | | 1/2 | 6.35 | | RCKT 13 04 00-KH | | | | | | | | | | | | ☆ | | | | | | | | | | | | | 12.7 | 4.76 |
| | | | .250 | | | | | | | | | | | | | | | | | | | | | | | | | | | .500 | .188 |
| | 19 | 3/4 | 9.53 | | RCKT 19 06 00-PH | ☆ | ☆ | ★ | ☆ | | ☆ | | | | | | | | ☆ | | | ☆ | | | | | | | ☆ | 19.1 | 6.35 |
| | | | .375 | | | | | | | | | | | | | | | | | | | | | | | | | | | .750 | .250 |
| | | 3/4 | 9.53 | | RCKT 19 06 00-KH | | | | | | | | | | | ☆ | ☆ | ★ | | | | | | | | | | | | | 19.1 | 6.35 |
| | | | .375 | | | | | | | | | | | | | | | | | | | | | | | | | | | .750 | .250 |

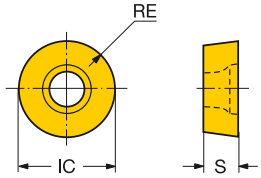
I135 I222 I254 N22 N10

# CoroMill® 200 insert for milling

RCHT




RCKT




## Advanced cutting materials

| | | RE | Ordering code | K 6190 | K CB50 | H 6190 | H CB50 | Dimensions, mm, inch IC | LE | S |
|---|---|---|---|---|---|---|---|---|---|---|
| Light | PO | 12 .472 6.00 | RCHT 12 04 M0 | | ☆ | | ☆ | 12.0 | 3.0 | 4.76 |
| | | .236 | | | | | | .472 | .118 | .188 |
| Medium | SK15 | 12 .472 6.00 | RCKT 12 04 MO | ☆ | | ☆ | | 12.0 | | 4.76 |
| | | .236 | | | | | | .472 | | .188 |
| | | 16 .630 8.00 | RCKT 16 06 MO | ☆ | | ☆ | | 16.0 | | 6.35 |
| | | .315 | | | | | | .630 | | .250 |

I135 I222 I254 N22 N10

# CoroMill® 216

## A metal remover for rough and semi-finish profiling

### Application

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

### ISO application area:

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

### Insert location

Same inserts for both central and peripheral locations.

inserts for higher security

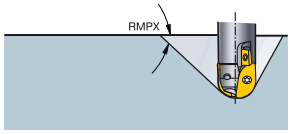
inserts with sharper edges and higher precision

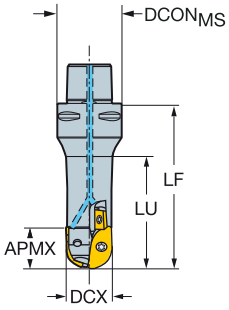
I144 I151

# CoroMill® 216 ball nose milling cutter

**Coromant Capto® - Internal coolant supply**

STDNO ISO26623-1
KAPR 90°




## Metric version

| DC | APMXFFW | APMXEFW | | | CZCMS | RMPX | AZ | CNSC | | Ordering code | Dimensions, mm DCON | DCX | BD1 | LF | LU | KG | RPMX | CICTBALL | MIIDBALL | CICTSP | MIIDSP |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 | 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 | | 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 | | 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 | | 1.75 | 7000 | 2 | R216-50 07 | 2 | APMT 160408-M |

## Inch version

| DC | APMXFFW | APMXEFW | | | CZCMS | RMPX | AZ | CNSC | | Ordering code | Dimensions, inch DCON | DCX | BD1 | LF | LU | LBS | RPMX | CICTBALL | MIIDBALL | CICTSP | MIIDSP |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.250 | 1.114 | .625 | 31 | | C3 | 85° | .625 | 3 | 2 | RA216-32C3-070 | 1.260 | 1.250 | 1.122 | 2.756 | 2.126 | 1.37 | 18500 | 2 | RA216-32 06 | | |
| 1.500 | 1.299 | .750 | 38 | | C4 | 85° | .750 | 3 | 2 | RA216-38C4-080 | 1.575 | 1.500 | 1.370 | 3.150 | 2.311 | 1.83 | 8000 | 2 | RA216-38 07 | | |
| 2.000 | 1.791 | 1.000 | 50 | 16 | C5 | 85° | 1.000 | 3 | 2 | RA216-51C5-125 | 1.969 | 2.000 | 1.835 | 4.921 | | 3.86 | 7000 | 2 | RA216-51 07 | 2 | APMT 160408-M |

## Metric version

| | 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 |

## Inch version

| | Spare parts | | |
|---|---|---|---|
| | Insert screw | Shim | Shim screw |
| 31 | 5513 020-07 | | |
| 38 | 5513 020-31 | | |
| 50 | 5513 021-03 | 5322 475-01 | 5513 020-09 |

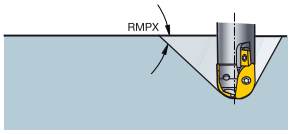
For the complete list of spare parts, visit www.sandvik.coromant.com

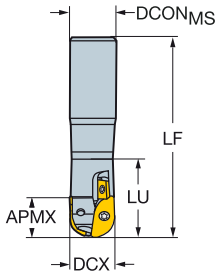
I151 L2 N22 N9 N15

# CoroMill® 216 ball nose milling cutter

**Cylindrical shank - Internal coolant supply**

KAPR 90°




## Metric version

| DC | APMX$_{FFW}$ | APMX$_{EFW}$ | | | CZC$_{MS}$ | RMPX | AZ | CNSC | | Ordering code | Dimensions, mm DCON | DCX | BD$_1$ | LF | LU | 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 | 0.31 | 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 | 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 | 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 | 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 | 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 | 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 | 1.56 | 18500 | 2 | R216-32 06 | | |

## Inch version

| DC | APMX$_{FFW}$ | APMX$_{EFW}$ | | | CZC$_{MS}$ | RMPX | AZ | | Ordering code | Dimensions, inch DCON | DCX | BD$_1$ | LF | LU | LBS | RPMX | CICT$_{BALL}$ | MIID$_{BALL}$ | CICT$_{SP}$ | MIID$_{SP}$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .375 | .310 | .187 | 9 | | 5/8 | 85° | .187 | 2 | RA216-10O16-038 | .625 | .375 | .343 | 6.000 | .717 | 0.64 | 13400 | 2 | RA216-10 02 | | |
| .500 | .444 | .250 | 12 | | 5/8 | 85° | .250 | 2 | RA216-13O16L-051 | .625 | .500 | .445 | 7.874 | 1.240 | 0.81 | 21000 | 2 | RA216-13 02 | | |
| .625 | .551 | .311 | 15 | | 5/8 | 85° | .311 | 2 | RA216-16O16L-043 | .625 | .625 | .575 | 9.000 | 1.689 | 0.84 | 20000 | 2 | RA216-16 03 | | |
| .750 | .669 | .374 | 19 | | 3/4 | 85° | .374 | 2 | RA216-19O19L-051 | .750 | 0.750 | .709 | 10.000 | 2.000 | 1.40 | 24000 | 2 | RA216-19 T3 | | |
| 1.000 | .906 | .500 | 25 | | 1 | 85° | .500 | 2 | RA216-25O25L-067 | 1.000 | 1.000 | .929 | 12.000 | 2.618 | 2.78 | 24000 | 2 | RA216-25 04 | | |
| 1.250 | 1.102 | .626 | 31 | 16 | 1 1/4 | 85° | .626 | 2 | RA216-32O32L-083 | 1.250 | 1.250 | 1.122 | 14.000 | 3.250 | 4.94 | 18500 | 2 | RA216-32 06 | 1 | APMT 160408-M |

## Metric version

| | | 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 | |

## Inch version

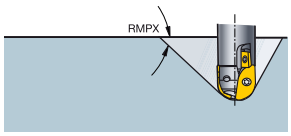
| | | Spare parts | |
|---|---|---|---|
| | | Insert screw | Protection insert screw |
| 9 | | 5513 020-40 | |
| 12 | | 5513 020-36 | |
| 15 | | 5513 020-36 | |
| 19 | | 5513 020-16 | |
| 25 | | 5513 020-02 | |
| 31 | 16 | 5513 020-07 | 5513 020-09 |

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

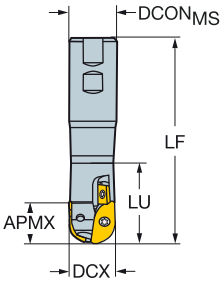
I151 L2 N22 N9 N15

# CoroMill® 216 ball nose milling cutter

**Weldon – Internal coolant supply**




STDNO ISO3338-2
KAPR 90°




## Metric version

| DC | APMXFFW | APMXEFW | | | CZCMS | RMPX | AZ | CNSC | | Ordering code | Dimensions, mm DCON | DCX | BD1 | LF | LU | KG | RPMX | CICTBALL | MIIDBALL | CICTSP | MIIDSP |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 12.0 | 10.8 | 6.0 | 12 | | 20 | 85° | 6.0 | 0 | 2 | R216-12B20-040 | 20.0 | 12.0 | 10.8 | 91.0 | 21.2 | 0.27 | 21000 | 2 | R216-12 02 | | |
| | 10.8 | 6.0 | 12 | | 20 | 85° | 6.0 | 0 | 2 | R216-12B20-060 | 20.0 | 12.0 | 10.8 | 111.0 | 24.0 | 0.30 | 21000 | 2 | R216-12 02 | | |
| 16.0 | 14.4 | 8.0 | 16 | | 20 | 85° | 8.0 | 1 | 2 | R216-16B20-040 | 20.0 | 16.0 | 14.7 | 91.0 | 28.2 | 0.28 | 20000 | 2 | R216-16 03 | | |
| | 14.4 | 8.0 | 16 | | 20 | 85° | 8.0 | 1 | 2 | R216-16B20-060 | 20.0 | 16.0 | 14.7 | 111.0 | 33.8 | 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 | 20.0 | 18.4 | 107.0 | 35.2 | 0.42 | 24000 | 2 | R216-20 T3 | | |
| | 17.9 | 10.0 | 20 | | 25 | 85° | 10.0 | 1 | 2 | R216-20B25-070 | 25.0 | 20.0 | 18.4 | 127.0 | 40.6 | 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 | 25.0 | 23.2 | 117.0 | 60.0 | 0.49 | 24000 | 2 | R216-25 04 | | |
| | 22.3 | 12.5 | 25 | | 25 | 85° | 12.5 | 1 | 2 | R216-25B25-080 | 25.0 | 25.0 | 23.2 | 137.0 | 80.0 | 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 | 30.0 | 26.8 | 131.0 | 60.4 | 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 | 30.0 | 26.8 | 161.0 | 90.4 | 0.86 | 19500 | 2 | R216-30 06 | 1 | APMT 160408-M |
| 32.0 | 28.6 | 16.0 | 32 | | 32 | 85° | 16.0 | 1 | 2 | R216-32B32-070 | 32.0 | 32.0 | 29.0 | 131.0 | 70.0 | 0.77 | 18500 | 2 | R216-32 06 | | |
| | 28.6 | 16.0 | 32 | | 32 | 85° | 16.0 | 1 | 2 | R216-32B32-100 | 32.0 | 32.0 | 29.0 | 161.0 | 100.0 | 0.87 | 18500 | 2 | R216-32 06 | | |
| 40.0 | 36.5 | 20.0 | 40 | 16 | 40 | 85° | 20.0 | 1 | 2 | R216-40B40-100 | 40.0 | 40.0 | 37.0 | 171.0 | 100.0 | 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 | 40.0 | 37.0 | 221.0 | 150.0 | 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 | 50.0 | 47.0 | 171.0 | | 1.88 | 7000 | 2 | R216-50 07 | | |
| | 44.6 | 25.0 | 50 | 16 | 50 | 85° | 25.0 | 1 | 2 | R216-50B50-125 | 50.0 | 50.0 | 46.4 | 206.0 | 125.0 | 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 | 50.0 | 46.4 | 256.0 | 175.0 | 3.45 | 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 | | | |
| 30 | 16 | 5513 020-07 | | | 5513 020-09 |
| 32 | | 5513 020-07 | | | |
| 40 | 16 | 5513 020-31 | | | 5513 020-09 |
| 50 | 16 | 5513 021-03 | 5322 475-01 | 5513 020-09 | |

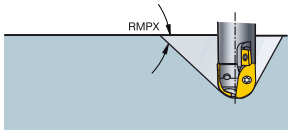
For the complete list of spare parts, visit www.sandvik.coromant.com

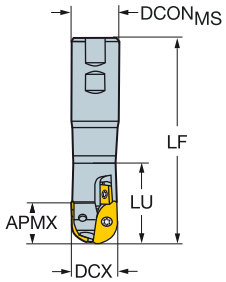
I151 L2 N22 N9 N15

# CoroMill® 216 ball nose milling cutter

**Weldon – Internal coolant supply**

STDNO ISO3338-2
KAPR 90°




## Inch and metric version

| DC | APMXFFW | APMXEFW | | CZCMS | RMPX | AZ | CNSC | | Ordering code | Dimensions, mm, inch DCONMS | DCX | BD1 | LB1 | LF | LU | NM | KG | RPMX | CICTBALL | MIIDBALL |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20.0 | 17.9 | 10.0 | 20 | 1 | 85° | 10.0 | 1 | 2 | **R216-20M25-076** | 25.4 | 20.0 | 18.4 | 31.8 | 134.1 | 40.7 | 2.0 | 0.03 | 24000 | 2 | R216-20 T3 |
| .787 | .705 | .394 | | | | .394 | | | | 1.000 | .787 | .724 | 1.250 | 5.281 | 1.602 | | | | | |
| 25.0 | 22.3 | 12.5 | 25 | 1 | 85° | 12.5 | 1 | 2 | **R216-25M25-089** | 25.4 | 25.0 | 24.4 | 76.2 | 146.8 | 88.9 | 3.0 | 0.58 | 24000 | 2 | R216-25 04 |
| .984 | .878 | .492 | | | | .492 | | | | 1.000 | .984 | .961 | 3.000 | 5.781 | 3.500 | | | | | |

| | Spare parts |
|---|---|
| | Insert screw |
| 20 | 5513 020-16 |
| 25 | 5513 020-52 |

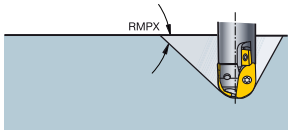
For the complete list of spare parts, visit www.sandvik.coromant.com

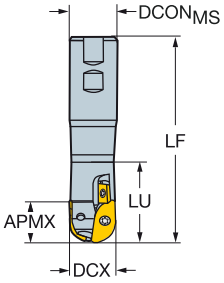
I151 L2 N22 N9 N15

# CoroMill® 216 ball nose milling cutter

**Weldon – Internal coolant supply**

STDNO ISO3338-2
KAPR 90°




## Inch version

| DC | APMX$_{FFW}$ | APMX$_{EFW}$ | | | CZC$_{MS}$ | RMPX | AZ | CNSC | | Ordering code | Dimensions, inch DCON | DCX | BD$_1$ | LF | LU | LBS | RPMX | CICT$_{BALL}$ | MIID$_{BALL}$ | CICT$_{SP}$ | MIID$_{SP}$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 0.500 | .444 | .250 | 12 | | 3/4 | 85° | .250 | 0 | 2 | **RA216-13M19-038** | 0.750 | 0.500 | .445 | 3.532 | .823 | 0.57 | 21000 | 2 | RA216-13 02 | | |
| | .444 | .250 | 12 | | 3/4 | 85° | .250 | 0 | 2 | **RA216-13M19-057** | 0.750 | 0.500 | .445 | 4.282 | .972 | 0.63 | 21000 | 2 | RA216-13 02 | | |
| 0.625 | .559 | .313 | 15 | | 3/4 | 85° | .313 | 1 | 2 | **RA216-16M19-038** | 0.750 | 0.625 | .575 | 3.532 | 1.063 | 0.57 | 20000 | 2 | RA216-16 03 | | |
| | .559 | .313 | 15 | | 3/4 | 85° | .313 | 1 | 2 | **RA216-16M19-057** | 0.750 | 0.625 | .575 | 4.282 | 1.315 | 0.65 | 20000 | 2 | RA216-16 03 | | |
| 0.750 | .669 | .375 | 19 | | 1 | 85° | .375 | 1 | 2 | **RA216-19M25-051** | 1.000 | 0.750 | .709 | 4.281 | 1.299 | 0.94 | 24000 | 2 | RA216-19 T3 | | |
| | .669 | .375 | 19 | | 1 | 85° | .375 | 1 | 2 | **RA216-19M25-076** | 1.000 | 0.750 | .709 | 5.281 | 1.461 | 0.92 | 24000 | 2 | RA216-19 T3 | | |
| 1.000 | .893 | .500 | 25 | | 1 | 85° | .500 | 1 | 2 | **RA216-25M25-057** | 1.000 | 1.000 | .929 | 4.531 | 2.250 | 1.08 | 24000 | 2 | RA216-25 04 | | |
| | .893 | .500 | 25 | | 1 | 85° | .500 | 1 | 2 | **RA216-25M25-089** | 1.000 | 1.000 | .929 | 5.781 | 3.500 | 1.29 | 24000 | 2 | RA216-25 04 | | |
| 1.250 | 1.114 | .625 | 31 | 16 | 1 1/4 | 85° | .625 | 1 | 2 | **RA216-32M32-070** | 1.250 | 1.250 | 1.122 | 5.031 | 2.748 | 1.72 | 18500 | 2 | RA216-32 06 | 1 | APMT 160408-M |
| | 1.114 | .625 | 31 | 16 | 1 1/4 | 85° | .625 | 1 | 2 | **RA216-32M32-101** | 1.250 | 1.250 | 1.122 | 6.281 | 4.000 | 2.07 | 18500 | 2 | RA216-32 06 | 1 | APMT 160408-M |
| 1.500 | 1.299 | .750 | 38 | 16 | 1 1/2 | 85° | .750 | 1 | 2 | **RA216-38M38-101** | 1.500 | 1.500 | 1.370 | 6.687 | 4.000 | 3.41 | 8000 | 2 | RA216-38 07 | 1 | APMT 160408-M |
| | 1.299 | .750 | 38 | 16 | 1 1/2 | 85° | .750 | 1 | 2 | **RA216-38M38-152** | 1.500 | 1.500 | 1.370 | 8.687 | 6.000 | 4.14 | 8000 | 2 | RA216-38 07 | 1 | APMT 160408-M |
| 2.000 | 1.791 | 1.000 | 50 | | 1 1/2 | 85° | 1.000 | 1 | 2 | **RA216-51M38-101** | 1.500 | 2.000 | 1.878 | 6.687 | | 4.30 | 7000 | 2 | RA216-51 07 | | |
| | 1.791 | 1.000 | 50 | 16 | 2 | 85° | 1.000 | 1 | 2 | **RA216-51M51-127** | 2.000 | 2.000 | 1.835 | 8.250 | 5.000 | 6.42 | 7000 | 2 | RA216-51 07 | 2 | APMT 160408-M |
| | 1.791 | 1.000 | 50 | 16 | 2 | 85° | 1.000 | 1 | 2 | **RA216-51M51-178** | 2.000 | 2.000 | 1.835 | 10.250 | 7.000 | 7.80 | 7000 | 2 | RA216-51 07 | 2 | APMT 160408-M |

| | | Spare parts | | | |
|---|---|---|---|---|---|
| | | Insert screw | Shim | Shim screw | Protection insert screw |
| 12 | | 5513 020-36 | | | |
| 15 | | 5513 020-36 | | | |
| 19 | | 5513 020-16 | | | |
| 25 | | 5513 020-52 | | | |
| 31 | 16 | 5513 020-07 | | | 5513 020-09 |
| 38 | 16 | 5513 020-31 | | | 5513 020-09 |
| 50 | 16 | 5513 021-03 | 5322 475-01 | 5513 020-09 | |

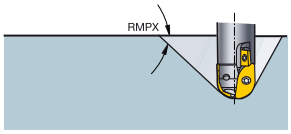
For the complete list of spare parts, visit www.sandvik.coromant.com

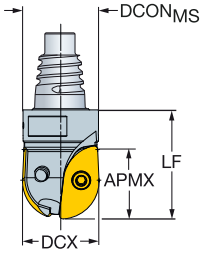
I151 L2 N22 N9 N15

# CoroMill® 216 ball nose milling cutter

**Coromant EH – Internal coolant supply**

KAPR 90°




## Metric version

| DC | | CZC$_{MS}$ | APMX$_{FFW}$ | RMPX | CNSC | | Ordering code | Dimensions, mm DCON | LF | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 10.0 | 10 | E10 | 8.60 | 85° | 0 | 2 | **R216-10EH10** | 9.7 | 20.0 | 0.09 | 12700 | 2 | R216-10 02 |
| 12.0 | 12 | E12 | 10.80 | 85° | 0 | 2 | **R216-12EH12** | 11.7 | 20.0 | 0.09 | 12700 | 2 | R216-12 02 |
| 16.0 | 16 | E16 | 14.40 | 85° | 1 | 2 | **R216-16EH16** | 15.5 | 25.0 | 0.11 | 12700 | 2 | R216-16 03 |
| 20.0 | 20 | E20 | 17.90 | 85° | 1 | 2 | **R216-20EH20** | 19.3 | 30.0 | 0.13 | 12700 | 2 | R216-20 T3 |
| 25.0 | 25 | E25 | 22.30 | 85° | 1 | 2 | **R216-25EH25** | 24.2 | 35.0 | 0.17 | 12700 | 2 | R216-25 04 |
| 30.0 | 30 | E25 | 26.90 | 85° | 1 | 2 | **R216-30EH25** | 24.2 | 50.0 | 0.23 | 12700 | 2 | R216-30 06 |
| 32.0 | 32 | E25 | 28.60 | 85° | 1 | 2 | **R216-32EH25** | 24.2 | 50.0 | 0.24 | 12700 | 2 | R216-32 06 |

## Inch version

| DC | | CZC$_{MS}$ | APMX$_{FFW}$ | RMPX | CNSC | | Ordering code | Dimensions, inch DCON | LF | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .375 | 9 | E10 | .310 | 85° | 0 | 2 | **RA216-10EH10** | .364 | .787 | 0.02 | 12700 | 2 | RA216-10 02 |
| .500 | 12 | E12 | .444 | 85° | 0 | 2 | **RA216-13EH12** | .484 | .787 | 0.22 | 12700 | 2 | RA216-13 02 |
| .625 | 15 | E16 | .559 | 85° | 1 | 2 | **RA216-16EH16** | .610 | .984 | 0.06 | 12700 | 2 | RA216-16 03 |
| .750 | 19 | E20 | .669 | 85° | 1 | 2 | **RA216-19EH20** | .728 | 1.181 | 0.28 | 12700 | 2 | RA216-19 T3 |
| 1.000 | 25 | E25 | .893 | 85° | 1 | 2 | **RA216-25EH25** | .965 | 1.378 | 0.37 | 12700 | 2 | RA216-25 04 |
| 1.250 | 31 | E25 | 1.114 | 85° | 1 | 2 | **RA216-32EH25** | .965 | 1.969 | 0.53 | 12700 | 2 | RA216-32 06 |

## Metric version

| | 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 |

## Inch version

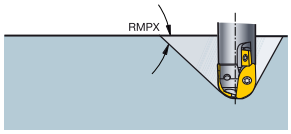
| | Spare parts |
|---|---|
| | Insert screw |
| 9 | 5513 020-40 |
| 12 | 5513 020-36 |
| 15 | 5513 020-36 |
| 19 | 5513 020-16 |
| 25 | 5513 020-52 |
| 31 | 5513 020-07 |

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

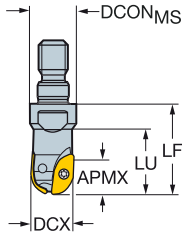
I151 L2 N22 N9 N15 N3

# CoroMill® 216 ball nose milling cutter

**Threaded coupling – Internal coolant supply**




KAPR 90°




## Metric version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | Ordering code | Dimensions, mm DCONMS | BD1 | 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 |

## Inch version

| DC | | CZCMS | APMXEFW | APMXFFW | RMPX | AZ | CNSC | | Ordering code | Dimensions, inch DCONMS | BD1 | LF | LU | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .500 | 12 | M8 | .250 | .444 | 85° | .250 | 0 | 2 | **RA216-13T08** | .504 | .445 | .906 | .646 | .8 | 0.19 | 12700 | 2 | RA216-13 02 |
| .750 | 19 | M10 | .375 | .669 | 85° | .375 | 1 | 2 | **RA216-19T10** | .701 | .709 | 1.181 | | 1.4 | 0.27 | 12700 | 2 | RA216-19 T3 |

## Metric version

| | 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 |

## Inch version

| | Spare parts |
|---|---|
| | Insert screw |
| 12 | 5513 020-36 |
| 19 | 5513 020-16 |

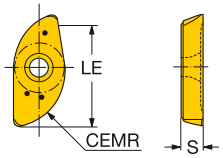
For the complete list of spare parts, visit www.sandvik.coromant.com

I151 L2 N22 N9 N15



SANDVIK Coromant

# CoroMill® 216 ball nose insert

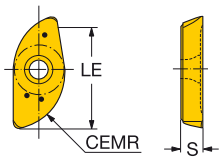



## Metric version

| | | | | | P | | | M | | | K | | N | | S | | | | H | | Dimensions, mm, inch | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | CEMR | Ordering code | | 1130 | 4220 | 4340 | 1130 | 2040 | S30T | 1130 | 4340 | 1130 | H13A | 1130 | 2040 | H13A | S30T | 1010 | 1130 | LE | S |
| Medium | 10 | 4.9 | R216-10 02 E-M | | ★ | | | ☆ | ★ | | ★ | | ☆ | | ☆ | ☆ | | | ★ | ☆ | 8.6 | 1.70 |
| | | .193 | | | | | | | | | | | | | | | | | | | .339 | .067 |
| | 12 | 5.9 | R216-12 02 E-M | | ★ | | | ☆ | ★ | ☆ | ★ | | ☆ | | ☆ | ☆ | | ★ | | ☆ | 10.8 | 2.38 |
| | | .231 | | | | | | | | | | | | | | | | | | | .425 | .094 |
| | | 6.0 | R216-12 02 M-M | | ★ | | ★ | ☆ | | | ★ | ☆ | ☆ | | ☆ | | | | ★ | ☆ | 10.8 | 2.38 |
| | | .236 | | | | | | | | | | | | | | | | | | | .425 | .094 |
| | 16 | 7.8 | R216-16 03 E-M | | ★ | | | ☆ | ★ | ☆ | ★ | | ☆ | | ☆ | ☆ | | ★ | | ☆ | 14.4 | 3.18 |
| | | .309 | | | | | | | | | | | | | | | | | | | .567 | .125 |
| | | 8.0 | R216-16 03 M-M | | ★ | ☆ | ★ | ☆ | ★ | | ★ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | ★ | ☆ | 14.4 | 3.18 |
| | | .315 | | | | | | | | | | | | | | | | | | | .567 | .125 |
| | 20 | 9.8 | R216-20 T3 E-M | | ★ | | | ☆ | ★ | ☆ | ★ | | ☆ | | ☆ | ☆ | | ★ | | ☆ | 17.9 | 3.97 |
| | | .386 | | | | | | | | | | | | | | | | | | | .705 | .156 |
| | | 10.0 | R216-20 T3 M-M | | ★ | ☆ | ★ | ☆ | ★ | | ★ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | ★ | ☆ | 17.9 | 3.97 |
| | | .394 | | | | | | | | | | | | | | | | | | | .705 | .156 |
| | 25 | 12.3 | R216-25 04 E-M | | ★ | | | ☆ | ★ | | ★ | | ☆ | | ☆ | ☆ | | | | ☆ | 22.3 | 4.76 |
| | | .483 | | | | | | | | | | | | | | | | | | | .878 | .188 |
| | | 12.5 | R216-25 04 M-M | | ★ | ☆ | ★ | ☆ | ★ | | ☆ | ★ | ☆ | | ☆ | ★ | | | ★ | ☆ | 22.3 | 4.76 |
| | | .492 | | | | | | | | | | | | | | | | | | | .878 | .188 |
| | 30 | 14.7 | R216-30 06 E-M | | ★ | | | ☆ | | ☆ | ★ | | ☆ | | ☆ | | | ★ | | ☆ | 26.9 | 6.35 |
| | | .580 | | | | | | | | | | | | | | | | | | | 1.059 | .250 |
| | | 15.0 | R216-30 06 M-M | | ★ | ☆ | ★ | ☆ | | | ☆ | ★ | ☆ | | ☆ | | | | ★ | ☆ | 26.9 | 6.35 |
| | | .591 | | | | | | | | | | | | | | | | | | | 1.059 | .250 |
| | 32 | 15.7 | R216-32 06 E-M | | ★ | | | ☆ | ★ | | ★ | | ☆ | | ☆ | ☆ | | | | ☆ | 28.6 | 6.35 |
| | | .619 | | | | | | | | | | | | | | | | | | | 1.126 | .250 |
| | | 16.0 | R216-32 06 M-M | | ★ | ☆ | ★ | ☆ | ★ | | ☆ | ★ | ☆ | | ☆ | ☆ | | | ★ | ☆ | 28.6 | 6.35 |
| | | .630 | | | | | | | | | | | | | | | | | | | 1.126 | .250 |
| | 40 | 19.7 | R216-40 07 E-M | | ★ | | | ☆ | | ☆ | ★ | | ☆ | | ☆ | | | ★ | | ☆ | 36.5 | 7.94 |
| | | .774 | | | | | | | | | | | | | | | | | | | 1.437 | .313 |
| | | 20.0 | R216-40 07 M-M | | ★ | | ★ | ☆ | | | ☆ | ★ | ☆ | | ☆ | | | | | ☆ | 36.5 | 7.94 |
| | | .787 | | | | | | | | | | | | | | | | | | | 1.437 | .313 |
| | 50 | 24.6 | R216-50 07 E-M | | ★ | | | ☆ | | | ★ | | ☆ | | ☆ | | | | | ☆ | 44.6 | 7.94 |
| | | .968 | | | | | | | | | | | | | | | | | | | 1.756 | .313 |
| | | 25.0 | R216-50 07 M-M | | ★ | | ★ | ☆ | | | ☆ | ★ | ☆ | | ☆ | | | | | ☆ | 44.6 | 7.94 |
| | | .984 | | | | | | | | | | | | | | | | | | | 1.756 | .313 |

I144 I222 I254 N22 N10

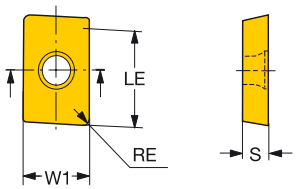
# CoroMill® 216 ball nose insert




## Inch version

| | | | | | Ordering code | P | | M | | K | | N | | S | | H | | Dimensions, mm, inch | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | 1130 | 4340 | 1130 | 2040 | 1130 | 4340 | 1130 | H13A | 1130 | H13A | 1010 | 1130 | LE | S |
| Medium | 9 | 3/8 | 4.7 | | RA216-10 02 E-M | ★ | | ☆ | | ★ | | ☆ | | ☆ | | | ☆ | 7.8 | 1.70 |
| | | | *.183* | | | | | | | | | | | | | | | *.310* | *.067* |
| | 12 | 1/2 | 6.2 | | RA216-13 02 E-M | ★ | | ☆ | | ★ | | ☆ | | ☆ | | | ☆ | 11.2 | 2.38 |
| | | | *.244* | | | | | | | | | | | | | | | *.444* | *.094* |
| | | 1/2 | 6.4 | | RA216-13 02 M-M | ★ | ★ | ☆ | | ★ | ☆ | ☆ | ★ | ☆ | ☆ | ★ | ☆ | 11.2 | 2.38 |
| | | | *.250* | | | | | | | | | | | | | | | *.444* | *.094* |
| | 15 | 5/8 | 7.8 | | RA216-16 03 E-M | ★ | | ☆ | | ★ | | ☆ | | ☆ | | | ☆ | 14.1 | 3.18 |
| | | | *.306* | | | | | | | | | | | | | | | *.559* | *.125* |
| | | 5/8 | 7.9 | | RA216-16 03 M-M | ★ | ★ | ☆ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | 14.1 | 3.18 |
| | | | *.313* | | | | | | | | | | | | | | | *.559* | *.125* |
| | 19 | 3/4 | 9.3 | | RA216-19 T3 E-M | ★ | | ☆ | | ★ | | ☆ | | ☆ | | | ☆ | 16.9 | 3.97 |
| | | | *.368* | | | | | | | | | | | | | | | *.669* | *.156* |
| | | 3/4 | 9.5 | | RA216-19 T3 M-M | ★ | ★ | ☆ | ★ | ☆ | ★ | ☆ | | ☆ | | | ☆ | 16.9 | 3.97 |
| | | | *.375* | | | | | | | | | | | | | | | *.669* | *.156* |
| | 25 | 1 | 12.5 | | RA216-25 04 E-M | ★ | | ☆ | | ★ | | ☆ | | ☆ | | | ☆ | 22.6 | 4.76 |
| | | | *.491* | | | | | | | | | | | | | | | *.893* | *.188* |
| | | 1 | 12.7 | | RA216-25 04 M-M | ★ | ★ | ☆ | | ☆ | ★ | ☆ | | ☆ | | ★ | ☆ | 22.6 | 4.76 |
| | | | *.500* | | | | | | | | | | | | | | | *.893* | *.188* |
| | 31 | 1 1/4 | 15.6 | | RA216-32 06 E-M | ★ | | ☆ | | ★ | | ☆ | | ☆ | | | ☆ | 28.2 | 6.35 |
| | | | *.614* | | | | | | | | | | | | | | | *1.114* | *.250* |
| | | 1 1/4 | 15.9 | | RA216-32 06 M-M | ★ | | ☆ | | ★ | | ☆ | | ☆ | | ★ | ☆ | 28.2 | 6.35 |
| | | | *.625* | | | | | | | | | | | | | | | *1.114* | *.250* |
| | 38 | 1 1/2 | 19.1 | | RA216-38 07 M-M | ★ | | ☆ | | ★ | | ☆ | | ☆ | | | ☆ | 32.9 | 7.94 |
| | | | *.750* | | | | | | | | | | | | | | | *1.299* | *.313* |
| | 50 | 2 | 25.4 | | RA216-51 07 M-M | ★ | | ☆ | | ★ | | ☆ | | ☆ | | | ☆ | 45.4 | 7.94 |
| | | | *1.000* | | | | | | | | | | | | | | | *1.791* | *.313* |

## Shank protection insert



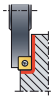
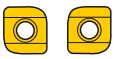
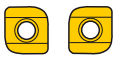
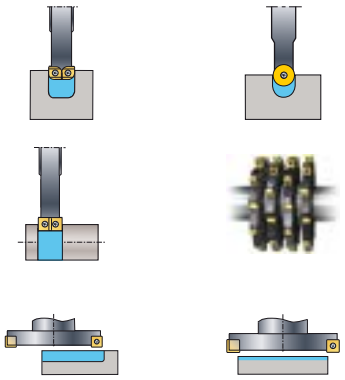
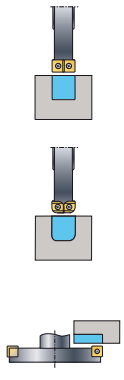
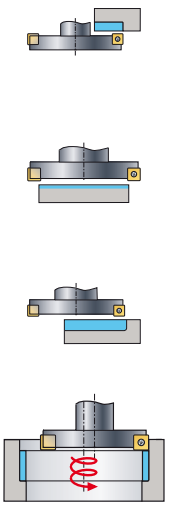

| | | | | Ordering code | P | M | K | Dimensions, mm, inch | | |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | RE | | 4340 | 4340 | 4340 | W1 | LE | S |
| Medium | WHX | 16 | 0.80 | APMT 16 04 08-M | ☆ | ☆ | ☆ | 9.2 | 16.0 | 4.76 |
| | | | *.031* | | | | | *.364* | *.630* | *.188* |

I144 I222 I254 N22 N10



SANDVIK Coromant

# 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 | I167 | I173 | I179 |
| Material | P M K N S H | | |
| Main operations | | |  |
| KAPR | 90° | 90° | 90° |
| $D_c$ mm<br>$D_c$ inch | 80 - 315<br>3.150 - 12.000 | 40 - 125<br>1.500 - 3.000 | 80 - 315<br>3.150 - 6.000 |
| APMX mm<br>APMX inch | 6.0 - 26.5<br>.236 - 1.043 | 6.0 - 10<br>.250 - .500 | 7.6 - 10.6<br>.299 - .417 |
| CDX mm<br>CDX inch | 114.5<br>4.508 | 34<br>1.339 | 114.5<br>4.508 |
| Insert | N331.1A<br>  R/L331.1A<br> RCHT, RCKT | N331.1A | N331.1A<br>  R/L331.1A |
| Insert sizes | 04,05,08,11 & 14<br>* 04,05,08,11 & 14<br>09,10,12,13 & 16 | 04,05 & 08 | 11<br>* 04,05,08,11 & 14 |
| Couplings | Arbor<br>Cylindrical<br>Bore with keyway<br>Weldon | Arbor<br>Cylindrical<br>Bore with keyway | Arbor<br>Cylindrical<br>Bore with keyway<br>Weldon |
| Other operations |  |  |  |

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

# CoroMill® 331

## Multi-purpose side and face milling cutter

### Application

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

### ISO application area:

P M K N S H

### Benefits and features

- Wide range of mounting options
- Wedge type cassette locking
- Accuracy, security and stability thanks 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

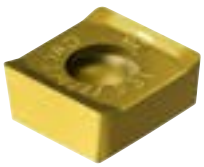
www.sandvik.coromant.com/coromill331

### 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.

I167 I183 N6



SANDVIK Coromant

Tailor Made

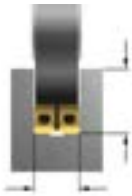
Tailor Made

### Half side

CDX ≤ 114.5 mm
CDX ≤ 4.311 inch

$a_p$ ≤ 10.6 mm
$a_p$ ≤ .417 inch

### Double half side



CDX ≤ 114.5 mm
CDX ≤ 4.311 inch

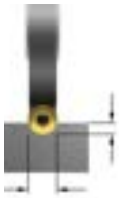
$a_p$ ≤ 27.2 - 33.8 mm
$a_p$ ≤ 1.071 - 1.331 inch

### Full slot with radius

CDX ≤ 114.5 mm
CDX ≤ 4.311 inch

$a_p$ ≤ 6 - 26.5 mm
$a_p$ ≤ .236 - 1.043 inch

### Full radius



CDX ≤ 114.5 mm
CDX ≤ 4.311 inch

$a_p$ ≤ 10 - 16 mm
$a_p$ ≤ .375 - .629 inch

### Full slot fixed pocket

CDX ≤ 34.0 mm
CDX ≤ .850 inch

$a_p$ ≤ 6 - 10 mm
$a_p$ ≤ .250 - .500 inch

### Full slot cassette

CDX ≤ 114.5 mm
CDX ≤ 4.311 inch

$a_p$ ≤ 6 - 26.5 mm
$a_p$ ≤ .236 - 1.043 inch

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

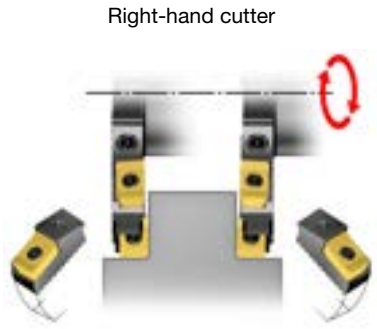
| Cutter bodies | | | | Neutral inserts | | Right- and left-hand inserts | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Groove width range mm | Groove width range inch | Cutter versions (end of code) | Insert size | Radius (RE) 0.5 mm .020 inch | Radius (RE) 0.8 mm .031 inch | Radius (RE) 1.52 mm .060 inch | Radius (RE) 2.29 mm .090 inch | Radius (RE) 3.05 mm .120 inch | Radius (RE) 4.83 mm .190 inch | Radius (RE) 6.35 mm .250 inch |
| 6-8 | .236-.315 | CM | 04 | | | | | | | |
| 8-10 | .315-.394 | DM | 05 | | | | | | | |
| 10-12 | .394-.472 | EM | 08 | | | | | | | |
| 12-15 | .472-.591 | FM | 08 | | | | | | | |
| 15-17.5 | .591-.689 | KM | 11 | | | | | | | |
| 17.5-20.5 | .689-.807 | LM | 11 | | | | | | | |
| 20.5-23.5 | .807-.925 | QM | 14 | | | | | | | |
| 23.5-26.5 | .925-1.043 | RM | 14 | | | | | | | |

Tailor Made

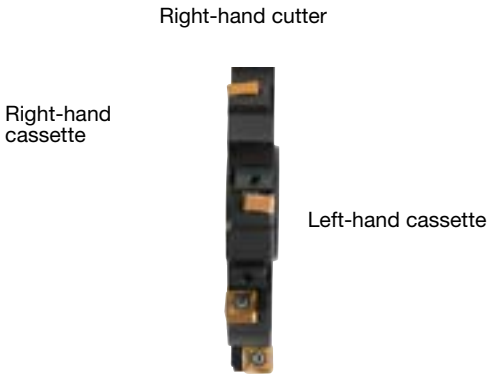
Other insert radii available as Tailor Made.

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

### Half side and face mill




### Full side and face mill

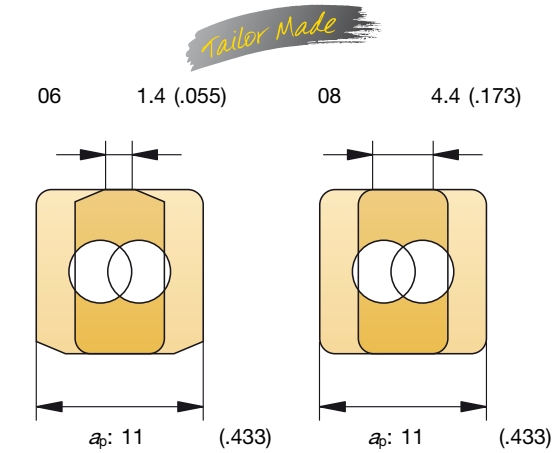



## Reduced cutting edge length for Tailor Made inserts

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

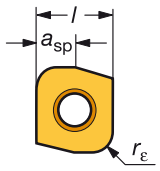
Reduced cutting edge length reduces overlapping, which in turn reduces wear in the overlapping zone, producing better chip control and reducing power consumption by up to 10%.

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




Tailor Made insert with reduced cutting edge length.

Standard insert size 08

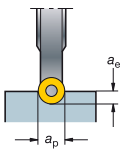



$$a_{sp} \approx \frac{a_p}{2} + 0{,}2$$

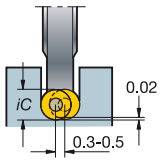
# Facilitated chip evacuation

### 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

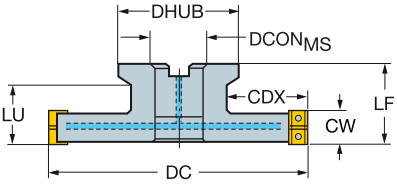
Note: The contact length of the cutting edge is 180°

For slots deeper than IC/2, a 0.3 - 0.5 mm (.012 - .020 inch) adjustment of each cassette is recommended. This will widen the slot 0.3 - 0.5 mm (.012 - .020 inch) 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°




**Metric version**

| 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 | 26 | 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 | | 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 the complete list of spare parts, visit www.sandvik.coromant.com

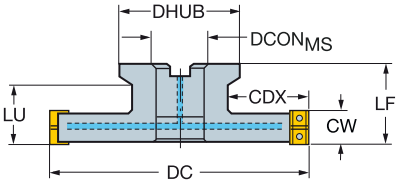
| | Accessories |
|---|---|
| CZCMS | Coolant screw |
| 27 | 5512 098-05 |
| 32 | 5512 098-04 |
| 40 | 5512 098-03 |

I183 L2 M1 N22 N6

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

**Arbor - Internal coolant supply**

STDNO ISO 6462:2011
KAPR 90°




## Inch version

| CW | CWX | DC | CDX | | CZCMS | CNSC | | Ordering code | Dimensions, inch DCONMS | ISO | LF | LU | DHUB | PSI | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .236 | .315 | 3.150 | .787 | 04 | 1 | 1 | 3 | R331.32C-080R25CM | 1.000 | A | 2.000 | 1.024 | 2.008 | 1160 | 0.5 | 1.16 | 19300 | 6 | N331.1A-04 |
| | | 4.000 | .866 | 04 | 1 | 1 | 4 | R331.32C-101R25CM | 1.000 | A | 2.000 | | 2.008 | 1160 | 0.5 | 1.85 | 17100 | 8 | N331.1A-04 |
| | | 5.000 | 1.201 | 04 | 1 1/4 | 1 | 5 | R331.32C-127R32CM | 1.250 | B | 2.000 | | 2.402 | 1160 | 0.5 | 1.98 | 15100 | 10 | N331.1A-04 |
| | | 6.000 | 1.465 | 04 | 1 1/2 | 1 | 6 | R331.32C-152R38CM | 1.500 | B | 2.000 | | 2.874 | 1160 | 0.5 | 3.10 | 13200 | 12 | N331.1A-04 |
| .315 | .394 | 3.150 | .787 | 05 | 1 | 1 | 3 | R331.32C-080R25DM | 1.000 | A | 2.000 | 1.024 | 2.008 | 1160 | 0.8 | 1.21 | 15000 | 6 | N331.1A-05 |
| | | 4.000 | .866 | 05 | 1 | 1 | 4 | R331.32C-101R25DM | 1.000 | A | 2.000 | | 2.008 | 1160 | 0.8 | 1.91 | 13200 | 8 | N331.1A-05 |
| | | 5.000 | 1.201 | 05 | 1 1/4 | 1 | 5 | R331.32C-127R32DM | 1.250 | B | 2.000 | | 2.402 | 1160 | 0.8 | 2.43 | 11700 | 10 | N331.1A-05 |
| | | 6.000 | 1.465 | 05 | 1 1/2 | 1 | 6 | R331.32C-152R38DM | 1.500 | B | 2.000 | | 2.874 | 1160 | 0.8 | 3.10 | 10200 | 12 | N331.1A-05 |
| .394 | .472 | 3.150 | .787 | 08 | 1 | 1 | 3 | R331.32C-080R25EM | 1.000 | A | 2.000 | 1.024 | 2.008 | 1160 | 0.8 | 1.21 | 18100 | 6 | N331.1A-08 |
| | | 4.000 | .866 | 08 | 1 | 1 | 4 | R331.32C-101R25EM | 1.000 | A | 2.000 | | 2.008 | 1160 | 0.8 | 1.91 | 15900 | 8 | N331.1A-08 |
| | | 5.000 | 1.201 | 08 | 1 1/4 | 1 | 5 | R331.32C-127R32EM | 1.250 | B | 2.000 | | 2.402 | 1160 | 0.8 | 2.87 | 14100 | 10 | N331.1A-08 |
| | | 6.000 | 1.465 | 08 | 1 1/2 | 1 | 6 | R331.32C-152R38EM | 1.500 | B | 2.000 | | 2.874 | 1160 | 0.8 | 3.92 | 12400 | 12 | N331.1A-08 |
| .472 | .591 | 3.150 | .787 | 08 | 1 | 1 | 3 | R331.32C-080R25FM | 1.000 | A | 2.000 | 1.024 | 2.008 | 1160 | 0.8 | 1.32 | 18100 | 6 | N331.1A-08 |
| | | 4.000 | .866 | 08 | 1 | 1 | 4 | R331.32C-101R25FM | 1.000 | A | 2.000 | | 2.008 | 1160 | 0.8 | 2.11 | 15900 | 8 | N331.1A-08 |
| | | 5.000 | 1.201 | 08 | 1 1/4 | 1 | 5 | R331.32C-127R32FM | 1.250 | B | 2.000 | | 2.402 | 1160 | 0.8 | 2.70 | 14100 | 10 | N331.1A-08 |
| | | 6.000 | 1.465 | 08 | 1 1/2 | 1 | 6 | R331.32C-152R38FM | 1.500 | B | 2.000 | | 2.874 | 1160 | 0.8 | 3.98 | 12400 | 12 | N331.1A-08 |
| .591 | .689 | 4.000 | 1.024 | 11 | 1 | 1 | 3 | R331.32C-101R25KM | 1.000 | A | 2.000 | 1.279 | 2.008 | 1160 | 2.2 | 2.23 | 14000 | 6 | N331.1A-11 |
| | | 5.000 | 1.201 | 11 | 1 1/4 | 1 | 4 | R331.32C-127R32KM | 1.250 | B | 2.000 | | 2.402 | 1160 | 2.2 | 2.90 | 12400 | 8 | N331.1A-11 |
| | | 6.000 | 1.465 | 11 | 1 1/2 | 1 | 5 | R331.32C-152R38KM | 1.500 | B | 2.000 | | 2.874 | 1160 | 2.2 | 4.27 | 10800 | 10 | N331.1A-11 |
| .689 | .807 | 5.000 | 1.201 | 11 | 1 1/4 | 1 | 4 | R331.32C-127R32LM | 1.250 | B | 2.000 | | 2.520 | 1160 | 2.2 | 3.09 | 12400 | 8 | N331.1A-11 |
| | | 6.000 | 1.465 | 11 | 1 1/2 | 1 | 5 | R331.32C-152R38LM | 1.500 | B | 2.000 | | 2.874 | 1160 | 2.2 | 4.85 | 10800 | 10 | N331.1A-11 |
| .807 | .925 | 6.000 | 1.465 | 14 | 1 1/2 | 1 | 5 | R331.32C-152R38QM | 1.500 | B | 2.000 | | 2.874 | 1160 | 2.2 | 5.51 | 9000 | 10 | N331.1A-14 |
| .925 | 1.043 | 6.000 | 1.465 | 14 | 1 1/2 | 1 | 5 | R331.32C-152R38RM | 1.500 | B | 2.000 | | 2.874 | 1160 | 2.2 | 6.61 | 9000 | 10 | N331.1A-14 |

| | | Spare parts | | | | |
|---|---|---|---|---|---|---|
| CW | DC | Cassette right | Cassette left | Insert screw | Wedge | Screw |
| .236 | 3.150 - 6.000 | 5321 240-15 | 5321 240-16 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| .315 | 3.150 - 6.000 | 5321 240-13 | 5321 240-14 | 5513 020-34 | 5431 105-06 | 5516 014-05 |
| .394 | 3.150 - 6.000 | 5321 240-01 | 5321 240-02 | 5513 020-24 | 5431 105-01 | 269-832 |
| .472 | 3.150 - 6.000 | 5321 240-03 | 5321 240-04 | 5513 020-24 | 5431 105-02 | 269-832 |
| .591 | 4.000 - 6.000 | 5321 240-07 | 5321 240-08 | 5513 020-29 | 5431 105-04 | 5516 010-02 |
| .689 | 5.000 - 6.000 | 5321 240-07 | 5321 240-08 | 5513 020-29 | 5431 105-04 | 5516 010-02 |
| .807 | 6.000 | 5321 240-09 | 5321 240-10 | 5513 020-29 | 5431 105-05 | 5516 010-02 |
| .925 | 6.000 | 5321 240-09 | 5321 240-10 | 5513 020-29 | 5431 105-05 | 5516 010-02 |

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

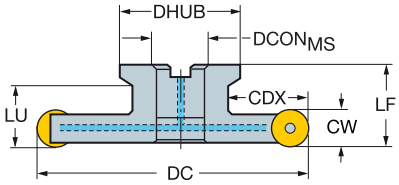
| | Accessories |
|---|---|
| $CZC_{MS}$ | Coolant screw |
| 1 | 5512 099-06 |
| 1.25 | 5512 099-05 |
| 1.5 | 5512 099-03 |

I183 L2 M1 N22 N6

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

**Arbor - Internal coolant supply**

STDNO ISO 6462:2011




## Metric version

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

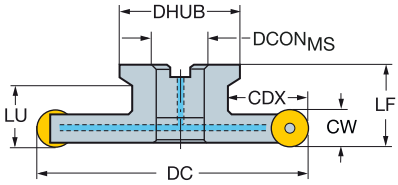
For the complete list of spare parts, visit www.sandvik.coromant.com

| | Accessories |
|---|---|
| $CZC_{MS}$ | Coolant screw |
| 27 | 5512 098-05 |
| 32 | 5512 098-04 |
| 40 | 5512 098-03 |

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

**Arbor - Internal coolant supply**

STDNO ISO 6462:2011




## Inch version

| CW | DC | CDX | | CZCMS | CNSC | | Ordering code | Dimensions, inch DCONMS | ISO | LF | LU | DHUB | PSI | FT/LBS | LBS | RPMX | RE | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .375 | 3.228 | .827 | 09 | 1 | 1 | 6 | R331.32C-082R25EMQ | 1.000 | A | 2.000 | 1.024 | 2.008 | 1160 | 2.2 | 1.32 | 18100 | .188 | 6 | RCKT 09 T3 00 |
| | 4.079 | .925 | 09 | 1 | 1 | 8 | R331.32C-103R25EMQ | 1.000 | A | 2.000 | | 2.008 | 1160 | 2.2 | 2.20 | 15900 | .188 | 8 | RCKT 09 T3 00 |
| | 5.079 | 1.200 | 09 | 1 1/4 | 1 | 10 | R331.32C-129R32EMQ | 1.250 | B | 2.000 | | 2.402 | 1160 | 2.2 | 2.65 | 14100 | .188 | 10 | RCKT 09 T3 00 |
| | 6.079 | 1.504 | 09 | 1 1/2 | 1 | 12 | R331.32C-154R38EMQ | 1.500 | B | 2.000 | | 2.874 | 1160 | 2.2 | 2.20 | 12400 | .188 | 12 | RCKT 09 T3 00 |
| .500 | 3.228 | .827 | 13 | 1 | 1 | 6 | R331.32C-082R25FMQ | 1.000 | A | 2.000 | 1.024 | 2.008 | 1160 | 2.2 | 1.54 | 18100 | .250 | 6 | RCKT 13 04 00 |
| | 4.079 | .925 | 13 | 1 | 1 | 8 | R331.32C-103R25FMQ | 1.000 | A | 2.000 | | 2.008 | 1160 | 2.2 | 2.20 | 15900 | .250 | 8 | RCKT 13 04 00 |
| | 5.079 | 1.200 | 13 | 1 1/4 | 1 | 10 | R331.32C-129R32FMQ | 1.250 | B | 2.000 | | 2.402 | 1160 | 2.2 | 2.87 | 14100 | .250 | 10 | RCKT 13 04 00 |
| | 6.079 | 1.504 | 13 | 1 1/2 | 1 | 12 | R331.32C-154R38FMQ | 1.500 | B | 2.000 | | 2.874 | 1160 | 2.2 | 4.41 | 12400 | .250 | 12 | RCKT 13 04 00 |
| .630 | 5.079 | 1.200 | 16 | 1 1/4 | 1 | 8 | R331.32C-129R32KMQ | 1.250 | B | 2.000 | 1.024 | 2.402 | 1160 | 3.6 | 3.09 | 12400 | .315 | 8 | RCKT 16 06 M0 |
| | 6.079 | 1.504 | 16 | 1 1/2 | 1 | 10 | R331.32C-154R38KMQ | 1.500 | B | 2.000 | | 2.874 | 1160 | 3.6 | 4.63 | 10800 | .315 | 10 | RCKT 16 06 M0 |
| | 4.081 | 1.051 | 16 | 1 | 1 | 6 | R331.32C-103R25KMQ | 1.279 | A | 2.000 | | 2.008 | 1160 | 3.6 | 5.95 | 14000 | .315 | 6 | RCKT 16 06 M0 |

| | | Spare parts | | | |
|---|---|---|---|---|---|
| CW | DC | Cassette neutral | Insert screw | Wedge | Screw |
| .375 | 3.228 | 5521 250-01 | 5513 020-30 | 5431 105-01 | 269-832 |
| .375 | 4.079 | 5521 250-01 | 5513 020-30 | 5431 105-01 | 5516 010-02 |
| .375 | 5.079 - 6.079 | 5521 250-01 | 5513 020-30 | 5431 105-01 | 339-831 |
| .500 | 3.228 | 5521 250-04 | 5513 020-09 | 5431 105-02 | 269-832 |
| .500 | 4.079 | 5521 250-04 | 5513 020-09 | 5431 105-02 | 5516 010-02 |
| .500 | 5.079 - 6.079 | 5521 250-04 | 5513 020-09 | 5431 105-02 | 339-831 |
| .630 | 4.079 - 6.079 | 5521 250-05 | 5513 020-07 | 5431 105-04 | 339-831 |

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

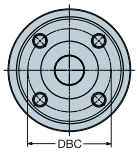
| | Accessories |
|---|---|
| $CZC_{MS}$ | Coolant screw |
| 1 | 5512 099-06 |
| 1.25 | 5512 099-05 |
| 1.5 | 5512 099-03 |

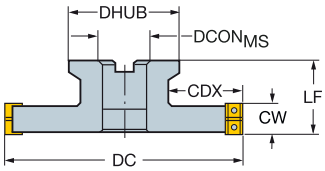
I183 L2 M1 N22 N6

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

**Arbor**

STDNO ISO6462
KAPR 90°



N331.1A

## Metric version

| 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 | 63.00 | 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 |

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

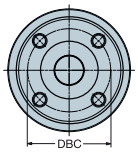
For the complete list of spare parts, visit www.sandvik.coromant.com

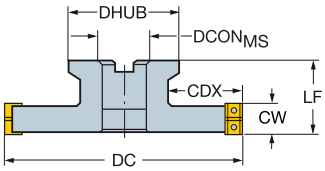
I183 L2 M1 N22 N6

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

**Arbor**

STDNO ISO6462
KAPR 90°



N331.1A

**Inch version**

| CW | CWX | DC | CDX | | CZCMS | | Ordering code | Dimensions, inch DCONMS | ISO | DBC | LF | DHUB | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .236 | .315 | 8.000 | 2.071 | 04 | 1 1/2 | 8 | R331.32-203R38CM0.236 | 1.500 | B | | 2.480 | 3.780 | 0.5 | 16.89 | 11700 | 16 | N331.1A-04 |
| .315 | .394 | 8.000 | 2.071 | 05 | 1 1/2 | 8 | R331.32-203R38DM0.315 | 1.500 | B | | 2.482 | 3.780 | 0.8 | 8.60 | 9100 | 16 | N331.1A-05 |
| .394 | .472 | 8.000 | 2.071 | 08 | 1 1/2 | 8 | R331.32-203R38EM0.394 | 1.500 | B | | 2.480 | 3.780 | 0.8 | 8.60 | 11000 | 16 | N331.1A-08 |
| .472 | .591 | 8.000 | 2.071 | 08 | 1 1/2 | 8 | R331.32-203R38FM0.472 | 1.500 | B | | 2.480 | 3.780 | 0.8 | 19.03 | 11000 | 16 | N331.1A-08 |
| .591 | .689 | 8.000 | 2.071 | 11 | 1 1/2 | 6 | R331.32-203R38KM0.591 | 1.500 | B | | 2.480 | 3.780 | 2.2 | 19.75 | 9600 | 12 | N331.1A-11 |
| .689 | .807 | 8.000 | 2.071 | 11 | 1 1/2 | 6 | R331.32-203R38LM0.689 | 1.500 | B | | 2.480 | 3.780 | 2.2 | 23.04 | 9600 | 12 | N331.1A-11 |
| .807 | .925 | 8.000 | 2.071 | 14 | 1 1/2 | 6 | R331.32-203R38QM0.807 | 1.500 | B | | 2.480 | 3.780 | 2.2 | 19.84 | 8000 | 12 | N331.1A-14 |
| .925 | 1.043 | 8.000 | 2.071 | 14 | 1 1/2 | 6 | R331.32-203R38RM0.925 | 1.500 | B | | 2.480 | 3.780 | 2.2 | 22.40 | 8000 | 12 | N331.1A-14 |
| | | 12.000 | 3.283 | 14 | 2 1/2 | 10 | R331.32-305R63RM0.925 | 2.500 | C | 4.000 | 2.480 | 5.354 | 2.2 | 22.93 | 6300 | 20 | N331.1A-14 |

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

I183

L2

M1

N22

N6

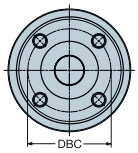


SANDVIK Coromant

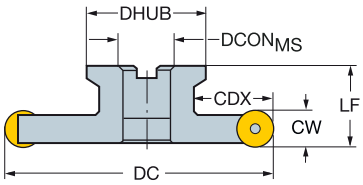
# CoroMill® 331 adjustable full side and face disc milling cutter

**Arbor**

STDNO




ISO6462



RCKT
RCHT

**Metric version**

| CW | DC | CDX | | CZC$_{MS}$ | | Ordering code | Dimensions, mm DCON$_{MS}$ | 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 the complete list of spare parts, visit www.sandvik.coromant.com

I183

L2

M1

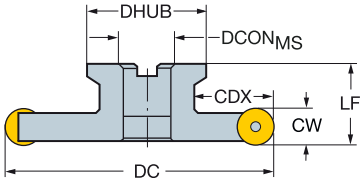
N22

N6

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

**Arbor**

STDNO ISO6462



RCKT
RCHT

**Inch version**

| CW | DC | CDX | | CZCMS | | Ordering code | Dimensions, inch DCONMS | ISO | LF | DHUB | FT/LBS | LBS | RPMX | RE | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .394 | 8.079 | 2.106 | 09 | 1 1/2 | 16 | **R331.32-205R38EMQ** | 1.500 | C | 2.462 | 3.780 | 2.2 | 9.48 | 11000 | .188 | 16 | RCKT 09 T3 00 |
| .500 | 8.079 | 2.106 | 13 | 1 1/2 | 16 | **R331.32-205R38FMQ** | 1.500 | C | 2.508 | 3.780 | 2.2 | 18.96 | 11000 | .250 | 16 | RCKT 13 04 00 |

| | | Spare parts | | |
|---|---|---|---|---|
| CW | DC" | Insert screw | Wedge | Screw |
| .394 | 8.078 | 5513 020-30 | 5431 105-01 | 339-831 |
| .500 | 8.078 | 5513 020-09 | 5431 105-02 | 339-831 |

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

I183

L2

M1

N22

N6



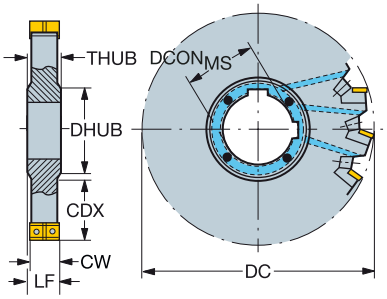
SANDVIK Coromant

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

**Bore with keyway – Internal coolant supply**

KAPR 90°

N331.1A




## Metric version

| 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 the complete list of spare parts, visit www.sandvik.coromant.com

| $CZC_{MS}$ | 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 |

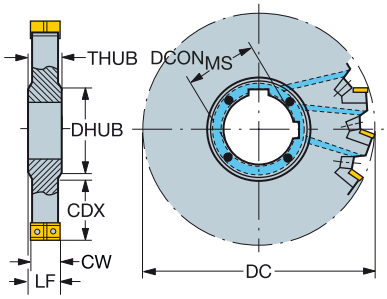
I183 L2 N22 N15 N6

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

**Bore with keyway – Internal coolant supply**

KAPR 90°

N331.1A




## Inch version

| CW | CWX | DC | CDX | | $CZC_{MS}$ | CNSC | | Ordering code | Dimensions, inch $DCON_{MS}$ | LF | DRVCT | DHUB | THUB | PSI | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .236 | .315 | 3.150 | .768 | 04 | 1 | 1 | 3 | N331.32C-080T25CM | 1.000 | .394 | 1 | 1.535 | .551 | 1160 | 0.5 | 1.04 | 19300 | 6 | N331.1A-04 |
| | | 4.000 | 1.043 | 04 | 1 1/4 | 1 | 4 | N331.32C-101T32CM | 1.250 | .394 | 1 | 1.811 | .551 | 1160 | 0.5 | 1.43 | 17100 | 8 | N331.1A-04 |
| | | 5.000 | 1.437 | 04 | 1 1/2 | 1 | 5 | N331.32C-127T38CM | 1.500 | .394 | 2 | 2.047 | .551 | 1160 | 0.5 | 1.57 | 15100 | 10 | N331.1A-04 |
| | | 6.000 | 1.929 | 04 | 1 1/2 | 1 | 6 | N331.32C-152T38CM | 1.500 | .394 | 2 | 2.047 | .551 | 1160 | 0.5 | 2.09 | 13200 | 12 | N331.1A-04 |
| .315 | .394 | 3.150 | .768 | 05 | 1 | 1 | 3 | N331.32C-080T25DM | 1.000 | .472 | 1 | 1.535 | .630 | 1160 | 0.8 | 1.11 | 15000 | 6 | N331.1A-05 |
| | | 4.000 | 1.043 | 05 | 1 1/4 | 1 | 4 | N331.32C-101T32DM | 1.250 | .472 | 1 | 1.811 | .630 | 1160 | 0.8 | 1.53 | 13200 | 8 | N331.1A-05 |
| | | 5.000 | 1.437 | 05 | 1 1/2 | 1 | 5 | N331.32C-127T38DM | 1.500 | .472 | 2 | 2.047 | .630 | 1160 | 0.8 | 1.85 | 11700 | 10 | N331.1A-05 |
| | | 6.000 | 1.929 | 05 | 1 1/2 | 1 | 6 | N331.32C-152T38DM | 1.500 | .472 | 2 | 2.047 | .630 | 1160 | 0.8 | 2.43 | 10200 | 12 | N331.1A-05 |
| .394 | .472 | 3.150 | .768 | 08 | 1 | 1 | 3 | N331.32C-080T25EM | 1.000 | .512 | 1 | 1.535 | .630 | 1160 | 0.8 | 0.88 | 18100 | 6 | N331.1A-08 |
| | | 4.000 | 1.043 | 08 | 1 1/4 | 1 | 4 | N331.32C-101T32EM | 1.250 | .512 | 1 | 1.811 | .630 | 1160 | 0.8 | 1.75 | 15900 | 8 | N331.1A-08 |
| | | 5.000 | 1.437 | 08 | 1 1/2 | 1 | 5 | N331.32C-127T38EM | 1.500 | .512 | 2 | 2.047 | .630 | 1160 | 0.8 | 1.93 | 14100 | 10 | N331.1A-08 |
| | | 6.000 | 1.929 | 08 | 1 1/2 | 1 | 6 | N331.32C-152T38EM | 1.500 | .512 | 2 | 2.047 | .630 | 1160 | 0.8 | 2.90 | 12400 | 12 | N331.1A-08 |
| .472 | .591 | 3.150 | .768 | 08 | 1 | 1 | 3 | N331.32C-080T25FM | 1.000 | .551 | 1 | 1.535 | .630 | 1160 | 0.8 | 1.10 | 18100 | 6 | N331.1A-08 |
| | | 4.000 | 1.043 | 08 | 1 1/4 | 1 | 4 | N331.32C-101T32FM | 1.250 | .551 | 1 | 1.811 | .630 | 1160 | 0.8 | 1.57 | 15900 | 8 | N331.1A-08 |
| | | 5.000 | 1.437 | 08 | 1 1/2 | 1 | 5 | N331.32C-127T38FM | 1.500 | .551 | 2 | 2.047 | .630 | 1160 | 0.8 | 2.50 | 14100 | 10 | N331.1A-08 |
| | | 6.000 | 1.929 | 08 | 1 1/2 | 1 | 6 | N331.32C-152T38FM | 1.500 | .551 | 2 | 2.047 | .630 | 1160 | 0.8 | 4.19 | 12400 | 12 | N331.1A-08 |
| .591 | .689 | 4.000 | 1.043 | 11 | 1 1/4 | 1 | 3 | N331.32C-101T32KM | 1.250 | .660 | 1 | 1.811 | .728 | 1160 | 2.2 | 1.76 | 14000 | 6 | N331.1A-11 |
| | | 5.000 | 1.437 | 11 | 1 1/2 | 1 | 4 | N331.32C-127T38KM | 1.500 | .660 | 1 | 2.047 | .728 | 1160 | 2.2 | 2.83 | 12400 | 8 | N331.1A-11 |
| | | 6.000 | 1.929 | 11 | 1 1/2 | 1 | 5 | N331.32C-152T38KM | 1.500 | .660 | 2 | 2.047 | .728 | 1160 | 2.2 | 3.90 | 10800 | 10 | N331.1A-11 |
| .689 | .807 | 5.000 | 1.437 | 11 | 1 1/2 | 1 | 4 | N331.32C-127T38LM | 1.500 | .768 | 1 | 2.047 | .847 | 1160 | 2.2 | 3.04 | 12400 | 8 | N331.1A-11 |
| | | 6.000 | 1.929 | 11 | 1 1/2 | 1 | 5 | N331.32C-152T38LM | 1.500 | .768 | 2 | 2.047 | .847 | 1160 | 2.2 | 4.34 | 10800 | 10 | N331.1A-11 |
| .807 | .925 | 6.000 | 1.929 | 14 | 1 1/2 | 1 | 5 | N331.32C-152T38QM | 1.500 | .886 | 2 | 2.047 | .965 | 1160 | 2.2 | 4.25 | 9200 | 10 | N331.1A-14 |
| .925 | 1.043 | 6.000 | 1.929 | 14 | 1 1/2 | 1 | 5 | N331.32C-152T38RM | 1.500 | 1.004 | 2 | 2.047 | 1.083 | 1160 | 2.2 | 5.52 | 9200 | 10 | N331.1A-14 |

| | | Spare parts | | |
|---|---|---|---|---|
| CW | DC" | Insert screw | Wedge | Screw |
| .236 | 3.150-6.000 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| .315 | 3.150-6.000 | 5513 020-34 | 5431 105-06 | 5516 014-05 |
| .394 | 3.150-6.000 | 5513 020-24 | 5431 105-01 | 269-832 |
| .472 | 3.150-6.000 | 5513 020-24 | 5431 105-02 | 269-832 |
| .591 | 4.000-6.000 | 5513 020-29 | 5431 105-04 | 5516 010-02 |
| .689 | 5.000-6.000 | 5513 020-29 | 5431 105-04 | 5516 010-02 |
| .807 | 6.000 | 5513 020-29 | 5431 105-05 | 5516 010-02 |
| .925 | 6.000 | 5513 020-29 | 5431 105-05 | 5516 010-02 |

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

| $CZC_{MS}$ | Coolant screw set | Spacing ring set |
|---|---|---|
| 25 | 5512 077-101 | 5549 091-512 |
| 32 | 5512 077-103 | 5549 091-522 |
| 38 | 5512 077-102 | 5549 091-532 |

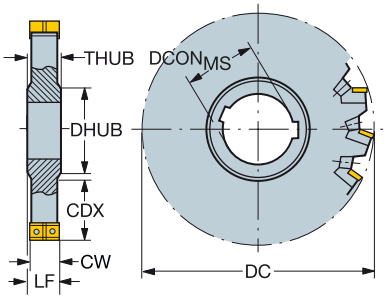
I183 L2 N22 N15 N6

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

**Bore with keyway**

KAPR 90°

N331.1A




## Metric version

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

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

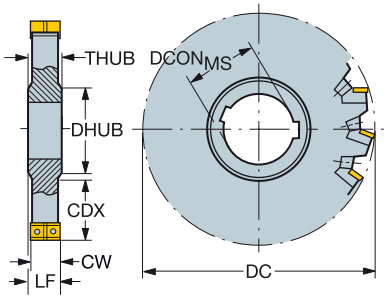
I183 L2 N22 N6

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

**Bore with keyway**

KAPR 90°

N331.1A




**Inch version**

| CW | CWX | DC | CDX | | CZC$_{MS}$ | | Ordering code | Dimensions, inch DCON$_{MS}$ | LF | DRVCT | DHUB | THUB | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .236 | .315 | 8.000 | 2.618 | 04 | 2 | 8 | N331.32-203T51CM0.236 | 2.000 | .394 | 2 | 2.677 | .551 | 0.5 | 5.73 | 11700 | 16 | N331.1A-04 |
| .315 | .394 | 8.000 | 2.618 | 05 | 2 | 8 | N331.32-203T51DM0.315 | 2.000 | .473 | 2 | 2.677 | .630 | 0.8 | 3.70 | 9100 | 16 | N331.1A-05 |
| .472 | .591 | 8.000 | 2.618 | 08 | 2 | 8 | N331.32-203T51FM0.472 | 2.000 | .551 | 2 | 2.677 | .630 | 0.8 | 5.36 | 11000 | 16 | N331.1A-08 |
| .591 | .689 | 8.000 | 2.618 | 11 | 2 | 6 | N331.32-203T51KM0.591 | 2.000 | .660 | 2 | 2.677 | .728 | 2.2 | 6.57 | 9600 | 12 | N331.1A-11 |
| | | 10.000 | 3.622 | 11 | 2 | 8 | N331.32-254T51KM0.591 | 2.000 | .660 | 2 | 2.677 | .728 | 2.2 | 17.64 | 8500 | 16 | N331.1A-11 |
| | | 12.000 | 4.311 | 11 | 2 1/2 | 10 | N331.32-305T63KM0.591 | 2.500 | .660 | 2 | 3.307 | .728 | 2.2 | 15.87 | 7600 | 20 | N331.1A-11 |
| .689 | .807 | 8.000 | 2.618 | 11 | 2 | 6 | N331.32-203T51LM0.689 | 2.000 | .768 | 2 | 2.677 | .847 | 2.2 | 7.46 | 9600 | 12 | N331.1A-11 |
| | | 10.000 | 3.622 | 11 | 2 | 8 | N331.32-254T51LM0.689 | 2.000 | .768 | 2 | 2.677 | .847 | 2.2 | 22.49 | 8500 | 16 | N331.1A-11 |
| .807 | .925 | 8.000 | 2.618 | 14 | 2 | 6 | N331.32-203T51QM0.807 | 2.000 | .886 | 2 | 2.677 | .965 | 2.2 | 7.94 | 8000 | 12 | N331.1A-14 |
| | | 10.000 | 3.622 | 14 | 2 | 8 | N331.32-254T51QM0.807 | 2.000 | .886 | 2 | 2.677 | .965 | 2.2 | 16.09 | 7100 | 16 | N331.1A-14 |
| .925 | 1.043 | 8.000 | 2.618 | 14 | 2 | 6 | N331.32-203T51RM0.925 | 2.000 | 1.004 | 2 | 2.677 | 1.083 | 2.2 | 7.87 | 8000 | 12 | N331.1A-14 |

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

I183 L2 N22 N6

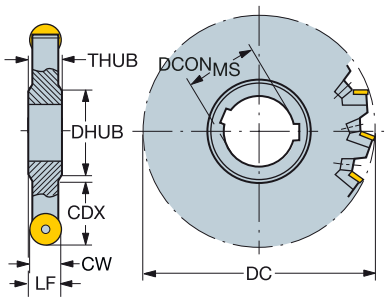


SANDVIK Coromant

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

**Bore with keyway**

RCKT
RCHT




**Metric version**

| | | | | | | | 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 |

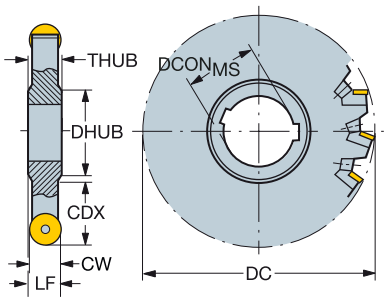
For the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 N22 N6

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

**Bore with keyway**

RCKT
RCHT




**Inch version**

| | | | | | | | Dimensions, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| CW | DC | CDX | | $CZC_{MS}$ | | Ordering code | $DCON_{MS}$ | LF | DRVCT | DHUB | THUB | FT/LBS | LBS | RPMX | RE | CICT | MIID |
| .375 | 3.228 | .807 | 09 | 1 | 6 | N331.32-082T25EMQ | 1.000 | .503 | 1 | 1.535 | .630 | 2.2 | 1.19 | 18100 | .188 | 6 | RCKT 09 T3 00 |
| | 4.079 | 1.083 | 09 | 1 1/4 | 8 | N331.32-103T32EMQ | 1.250 | .503 | 1 | 1.811 | .630 | 2.2 | 1.85 | 18100 | .188 | 8 | RCKT 09 T3 00 |
| | 8.079 | 2.657 | 09 | 2 | 16 | N331.32-205T51EMQ | 2.000 | .503 | 2 | 2.677 | .630 | 2.2 | 4.41 | 11000 | .188 | 16 | RCKT 09 T3 00 |
| .500 | 3.228 | .807 | 13 | 1 | 6 | N331.32-082T25FMQ | 1.000 | .565 | 1 | 1.535 | .630 | 2.2 | 1.37 | 18100 | .250 | 6 | RCKT 13 04 00 |
| | 4.079 | 1.083 | 13 | 1 1/4 | 8 | N331.32-103T32FMQ | 1.250 | .565 | 1 | 1.811 | .630 | 2.2 | 1.85 | 15900 | .250 | 8 | RCKT 13 04 00 |
| | 6.079 | 1.970 | 13 | 1 1/2 | 12 | N331.32-154T38FMQ | 1.500 | .565 | 2 | 2.047 | .630 | 2.2 | 3.35 | 12400 | .250 | 12 | RCKT 13 04 00 |
| | 8.079 | 2.657 | 13 | 2 | 16 | N331.32-205T51FMQ | 2.000 | .565 | 2 | 2.677 | .630 | 2.2 | 5.03 | 11000 | .250 | 16 | RCKT 13 04 00 |

| | | Spare parts | | |
|---|---|---|---|---|
| CW | DC" | Insert screw | Wedge | Screw |
| .375 | 3.228 | 5513 020-30 | 5431 105-01 | |
| .375 | 4.078-8.078 | 5513 020-30 | 5431 105-01 | 339-831 |
| .500 | 3.228 | 5513 020-09 | 5431 105-02 | |
| .500 | 4.078-8.078 | 5513 020-09 | 5431 105-02 | 339-831 |

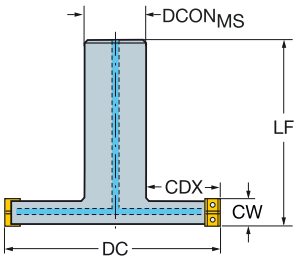
For the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 N22 N6

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

**Cylindrical shank - Internal coolant supply**

KAPR 90°




## Metric version

| CW | CWX | DC | CDX | | $CZC_{MS}$ | CNSC | | Ordering code | Dimensions, mm $DCON_{MS}$ | 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 |

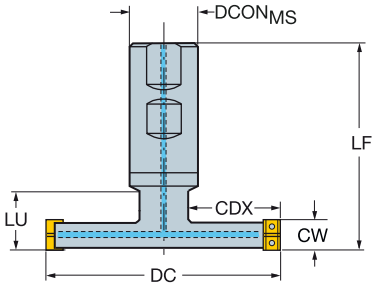
For the complete list of spare parts, visit www.sandvik.coromant.com

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

**Weldon – Internal coolant supply**

STDNO ISO3338-2
KAPR 90°

N331.1A




## Inch version

| CW | CWX | DC | CDX | | CZCMS | CNSC | | Ordering code | Dimensions, inch DCONMS | LF | LU | PSI | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .236 | .315 | 3.150 | .787 | 04 | 1 1/2 | 1 | 3 | R331.32C-080M38CM | 1.500 | 4.921 | 1.732 | 1160 | 0.8 | 2.87 | 19300 | 6 | N331.1A-04 |
| | | 4.000 | .945 | 04 | 2 | 1 | 4 | R331.32C-101M51CM | 2.000 | 5.512 | | 1160 | 0.5 | 3.12 | 17100 | 8 | N331.1A-04 |
| .315 | .394 | 3.150 | .787 | 05 | 1 1/2 | 1 | 3 | R331.32C-080M38DM | 1.500 | 4.921 | 1.732 | 1160 | 0.8 | 2.99 | 15000 | 6 | N331.1A-05 |
| | | 4.000 | .945 | 05 | 2 | 1 | 4 | R331.32C-101M51DM | 2.000 | 5.512 | | 1160 | 0.8 | 4.13 | 13200 | 8 | N331.1A-05 |
| .394 | .472 | 3.150 | .787 | 08 | 1 1/2 | 1 | 3 | R331.32C-080M38EM | 1.500 | 4.921 | 1.732 | 1160 | 0.8 | 3.04 | 18100 | 6 | N331.1A-08 |
| | | 4.000 | .945 | 08 | 2 | 1 | 4 | R331.32C-101M51EM | 2.000 | 5.512 | | 1160 | 0.8 | 5.76 | 15900 | 8 | N331.1A-08 |

| | | Spare parts | | |
|---|---|---|---|---|
| CW | DC" | Insert screw | Wedge | Screw |
| .236 | 3.150-4.000 | 5513 020-19 | 5431 105-07 | 5516 014-06 |
| .315 | 3.150-4.000 | 5513 020-34 | 5431 105-06 | 5516 014-05 |
| .394 | 3.150-4.000 | 5513 020-24 | 5431 105-01 | 269-832 |

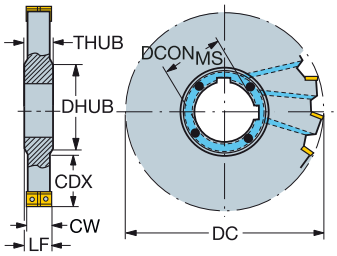
For the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 N22 N15 N6

# CoroMill® 331 full side and face disc milling cutter

**Bore with keyway – Internal coolant supply**

KAPR 90°



N331.1A

## Metric version

| 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 |

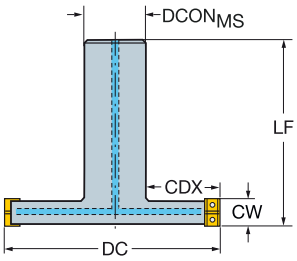
For the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 N22 N15 N6

# CoroMill® 331 full side and face disc milling cutter

**Cylindrical shank - Internal coolant supply**

KAPR 90°




**Metric version**

| 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 the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 N22 N6



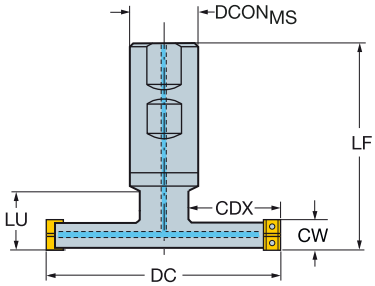
SANDVIK Coromant

# CoroMill® 331 full side and face disc milling cutter

**Weldon – Internal coolant supply**

STDNO ISO3338-2
KAPR 90°

N331.1A




## Inch version

| CW | DC | CDX | | CZCMS | CNSC | | Ordering code | Dimensions, inch DCONMS | LF | LU | PSI | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .250 | 1.500 | .409 | 04 | 1 | 1 | 2 | R331.35C-038M25CMA04 | 1.000 | 4.140 | 1.500 | 1160 | 0.5 | 0.69 | 30000 | 4 | N331.1A-04 |
| | 2.000 | .583 | 04 | 1 | 1 | 3 | R331.35C-051M25CMA04 | 1.000 | 4.140 | 1.500 | 1160 | 0.5 | 0.82 | 25000 | 6 | N331.1A-04 |
| | 2.500 | .732 | 04 | 1 1/4 | 1 | 3 | R331.35C-063M32CMA04 | 1.250 | 4.140 | 1.500 | 1160 | 0.5 | 1.32 | 22000 | 6 | N331.1A-04 |
| | 3.000 | .850 | 04 | 1 1/4 | 1 | 4 | R331.35C-076M32CMA04 | 1.250 | 4.140 | 1.500 | 1160 | 0.5 | 1.59 | 22000 | 8 | N331.1A-04 |
| .312 | 1.500 | .409 | 04 | 1 | 1 | 2 | R331.35C-038M25DMA05 | 1.000 | 4.140 | 1.500 | 1160 | 0.8 | 0.70 | 30000 | 4 | N331.1A-04 |
| | 2.000 | .583 | 04 | 1 | 1 | 3 | R331.35C-051M25DMA05 | 1.000 | 4.140 | 1.500 | 1160 | 0.8 | 0.84 | 25000 | 6 | N331.1A-04 |
| | 2.500 | .732 | 04 | 1 1/4 | 1 | 3 | R331.35C-063M32DMA05 | 1.250 | 4.140 | 1.500 | 1160 | 0.8 | 1.37 | 22000 | 6 | N331.1A-04 |
| | 3.000 | .850 | 04 | 1 1/4 | 1 | 4 | R331.35C-076M32DMA05 | 1.250 | 4.140 | 1.500 | 1160 | 0.8 | 1.66 | 19500 | 8 | N331.1A-04 |
| .375 | 1.500 | .409 | 05 | 1 | 1 | 2 | R331.35C-038M25EMA06 | 1.000 | 4.140 | 1.500 | 1160 | 0.8 | 0.71 | 23500 | 4 | N331.1A-05 |
| | 2.000 | .583 | 05 | 1 | 1 | 3 | R331.35C-051M25EMA06 | 1.000 | 4.140 | 1.500 | 1160 | 0.8 | 0.85 | 19500 | 6 | N331.1A-05 |
| | 2.500 | .732 | 05 | 1 1/4 | 1 | 3 | R331.35C-063M32EMA06 | 1.250 | 4.140 | 1.500 | 1160 | 0.8 | 1.40 | 17000 | 6 | N331.1A-05 |
| | 3.000 | .850 | 05 | 1 1/4 | 1 | 4 | R331.35C-076M32EMA06 | 1.250 | 4.140 | 1.500 | 1160 | 0.8 | 1.72 | 15000 | 8 | N331.1A-05 |
| .500 | 1.500 | .409 | 08 | 1 | 1 | 2 | R331.35C-038M25EMA08 | 1.000 | 4.140 | 1.500 | 1160 | 0.8 | 0.73 | 28000 | 4 | N331.1A-08 |
| | 2.000 | .583 | 08 | 1 | 1 | 3 | R331.35C-051M25EMA08 | 1.000 | 4.140 | 1.500 | 1160 | 0.8 | 0.90 | 23500 | 6 | N331.1A-08 |
| | 2.500 | .732 | 08 | 1 1/4 | 1 | 3 | R331.35C-063M32EMA08 | 1.250 | 4.140 | 1.500 | 1160 | 0.8 | 1.50 | 20500 | 6 | N331.1A-08 |
| | 3.000 | .850 | 08 | 1 1/4 | 1 | 4 | R331.35C-076M32EMA08 | 1.250 | 4.140 | 1.500 | 1160 | 0.8 | 1.85 | 18500 | 8 | N331.1A-08 |

| | | Spare parts |
|---|---|---|
| CW | DC" | Insert screw |
| .250 | 1.500-2.500 | 5513 020-19 |
| .312 | 1.500-3.000 | 5513 020-19 |
| .375 | 1.500-3.000 | 5513 020-34 |
| .500 | 1.500-3.000 | 5513 020-24 |

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

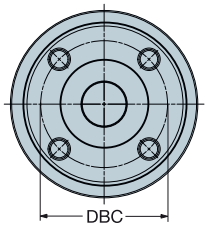
I183 L2 N22 N15 N6

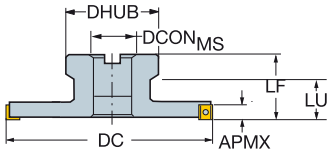
# CoroMill® 331 adjustable half side and face disc milling cutter

**Arbor**

STDNO
KAPR

ISO6462
90°



N331.1A

**Metric version**

| 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 | R331.52-080Q27EMR | 27.0 | A | | 63.00 | 40 | 54.0 | 1.2 | 0.80 | 18100 | 6 | N331.1A-08 |
| 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 |
| 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 the complete list of spare parts, visit www.sandvik.coromant.com

I183

L2

M1

N22

N6

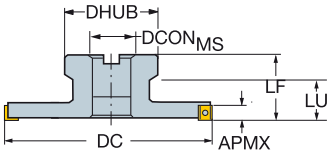


SANDVIK Coromant

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

**Arbor**

STDNO ISO6462
KAPR 90°



N331.1A

**Inch version**

| DC | | CZCMS | APMX | | Ordering code | Dimensions, inch DCONMS | ISO | LF | LU | DHUB | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 3.150 | 08 | 1 | .299 | 6 | **R331.52-080R25EMR** | 1.000 | A | 2.480 | 1.574 | 2.126 | 0.8 | 1.76 | 18100 | 6 | N331.1A-08 |

| | Spare parts | | |
|---|---|---|---|
| Ordering code | Insert screw | Wedge | Screw |
| R331.52-080R25EMR | 5513 020-24 | 5431 105-01 | 339-831 |

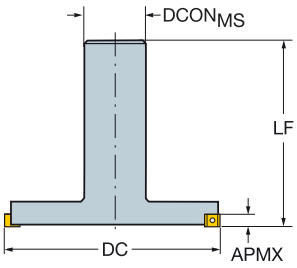
For the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 M1 N22 N6

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

**Cylindrical shank**

KAPR 90°



N331.1A

**Metric version**

| DC | | CZCMS | APMX | | Ordering code | Dimensions, mm DCONMS | 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 |

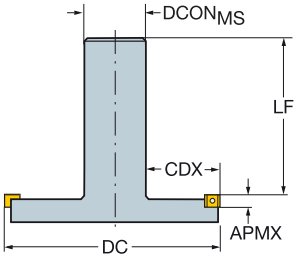
| Spare parts | | |
|---|---|---|
| Insert screw | Wedge | Screw |
| 5513 020-24 | 5431 105-01 | 339-831 |

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

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

**Cylindrical shank**

KAPR 90°



N331.1A

**Metric version**

| DC | CDX | | CZCMS | APMX | | Ordering code | Dimensions, mm DCONMS | 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 the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 N22 N6



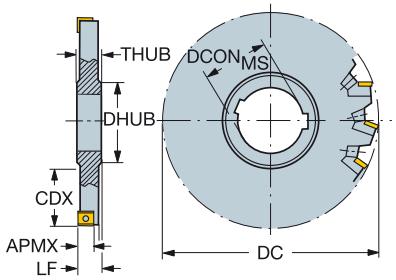
SANDVIK Coromant

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

**Bore with keyway**

KAPR 90°

N331.1A




## Metric version

| 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 | 5516 010-02 |
| R/L331.52-100S32FM | 5513 020-24 | 5431 105-02 | 5516 010-02 |
| 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 the complete list of spare parts, visit www.sandvik.coromant.com

I183

L2

N22

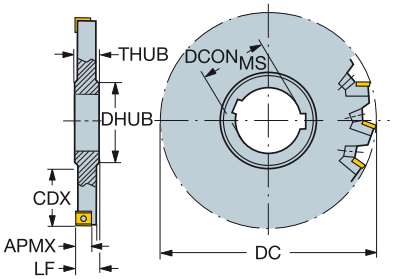
N6

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

**Bore with keyway**

KAPR 90°

N331.1A




## Inch version

| DC | | CZC$_{MS}$ | CDX | APMX | | Ordering code | Dimensions, inch DCON$_{MS}$ | LF | DRVCT | DHUB | THUB | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 3.150 | 08 | 1 | .768 | .299 | 6 | **R331.52-080T25EM** | 1.000 | .512 | 1 | 1.535 | .630 | 0.8 | 1.23 | 18100 | 6 | N331.1A-08 |
| 3.150 | 08 | 1 | .768 | .299 | 6 | **R/L331.52-080T25FM** | 1.000 | .551 | 1 | 1.535 | .630 | 0.8 | 1.28 | 18100 | 6 | N331.1A-08 |
| 5.000 | 11 | 1 1/2 | 1.437 | .417 | 8 | **R331.52-127T38KM** | 1.500 | .659 | 1 | 2.047 | .728 | 2.2 | 2.98 | 12000 | 8 | N331.1A-11 |
| 6.000 | 11 | 1 1/2 | 1.929 | .417 | 10 | **R/L331.52-152T38KM** | 1.500 | .659 | 2 | 2.047 | .728 | 2.2 | 3.97 | 10000 | 10 | N331.1A-11 |
| 8.000 | 11 | 2 | 2.618 | .417 | 12 | **R/L331.52-203T51MM** | 2.000 | 1.149 | 2 | 2.677 | 1.228 | 2.2 | 18.34 | 9600 | 12 | N331.1A-11 |

| | Spare parts | | |
|---|---|---|---|
| Ordering code | Insert screw | Wedge | Screw |
| R/L331.52-080T25EM | 5513 020-24 | 5431 105-01 | 269-832 |
| R/L331.52-080T25FM | 5513 020-24 | 5431 105-02 | 269-832 |
| R/L331.52-101T32EM | 5513 020-24 | 5431 105-01 | 5516 010-02 |
| R/L331.52-101T32FM | 5513 020-24 | 5431 105-02 | 5516 010-02 |
| R/L331.52-127T38EM | 5513 020-24 | 5431 105-01 | 339-831 |
| R/L331.52-127T38FM | 5513 020-24 | 5431 105-02 | 339-831 |
| R/L331.52-152T38EM | 5513 020-24 | 5431 105-01 | 339-831 |
| R/L331.52-152T38FM | 5513 020-24 | 5431 105-02 | 339-831 |
| R/L331.52-101T32KM | 5513 020-29 | 5431 105-04 | 339-831 |
| R/L331.52-152T38KM | 5513 020-29 | 5431 105-04 | 339-831 |
| R/L331.52-127T38KM | 5513 020-29 | 5431 105-04 | 339-831 |
| R/L331.52-203T51MM | 5513 020-29 | 5431 105-03 | 339-831 |
| R/L331.52-254T51MM | 5513 020-29 | 5431 105-03 | 339-831 |
| R/L331.52-305T63NM | 5513 020-29 | 5431 105-04 | 339-831 |

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

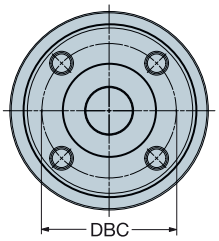
I183 L2 N22 N6

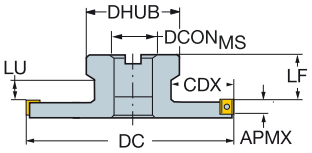
# CoroMill® 331 adjustable half side and back face disc milling cutter

**Arbor**

STDNO
KAPR

ISO 6462:2011
90°



N331.1A

## Metric version

| DC | CDX | | CZCMS | APMX | | Ordering code | Dimensions, mm DCONMS | 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 | R331.52-125Q32EML | 32.0 | B | | 53.00 | | 64.0 | 1.2 | 1.81 | 14100 | 10 | 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 |
| 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 |

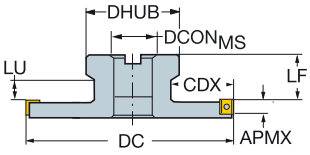
For the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 M1 N22 N6

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

**Arbor**

STDNO ISO6462
KAPR 90°



N331.1A

**Inch version**

| DC | CDX | | CZCMS | APMX | | Ordering code | Dimensions, inch DCONMS | ISO | LF | LU | DHUB | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 3.150 | .787 | 08 | 1 | .299 | 6 | **R331.52-080R25FML** | 1.000 | A | 2.008 | 28 | 2.126 | 0.8 | 2.16 | 18100 | 6 | N331.1A-08 |
| 4.000 | .866 | 08 | 1 | .299 | 8 | **R331.52-101R25FML** | 1.000 | A | 2.008 | | 2.126 | 0.8 | 3.81 | 15900 | 8 | N331.1A-08 |
| 5.000 | 1.201 | 08 | 1 1/4 | .299 | 10 | **R331.52-127R32FML** | 1.250 | B | 2.008 | | 2.520 | 0.8 | 4.32 | 14100 | 10 | N331.1A-08 |
| 4.000 | 1.024 | 11 | 1 | .417 | 6 | **R331.52-101R25KML** | 1.000 | A | 1.890 | 25 | 2.126 | 2.2 | 4.14 | 14000 | 6 | N331.1A-11 |

| | Spare parts | | |
|---|---|---|---|
| Ordering code | Insert screw | Wedge | Screw |
| R331.52-080R25EML | 5513 020-24 | 5431 105-01 | 269-832 |
| R331.52-080R25FML | 5513 020-24 | 5431 105-02 | 269-832 |
| R331.52-101R25EML | 5513 020-24 | 5431 105-01 | 339-831 |
| R331.52-101R25FML | 5513 020-24 | 5431 105-02 | 339-831 |
| R331.52-127R32EML | 5513 020-24 | 5431 105-01 | 339-831 |
| R331.52-127R32FML | 5513 020-24 | 5431 105-02 | 339-831 |
| R331.52-152R38EML | 5513 020-24 | 5431 105-01 | 339-831 |
| R331.52-152R38FML | 5513 020-24 | 5431 105-02 | 339-831 |
| R331.52-101R25KML | 5513 020-29 | 5431 105-04 | 339-831 |
| R331.52-127R32KML | 5513 020-29 | 5431 105-04 | 339-831 |
| R331.52-152R38KML | 5513 020-29 | 5431 105-04 | 339-831 |
| R331.52-203R38MML | 5513 020-29 | 5431 105-03 | 339-831 |
| R331.52-254R63MML | 5513 020-29 | 5431 105-03 | 339-831 |
| R331.52-305R63NML | 5513 020-29 | 5431 105-04 | 339-831 |

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

I183

L2

M1

N22

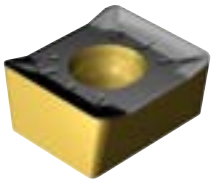
N6

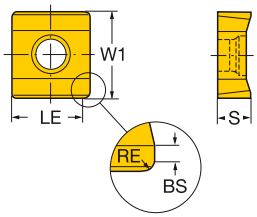


SANDVIK Coromant

# CoroMill® 331 insert for side and face milling

KRINS 90°



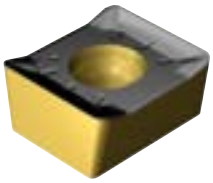


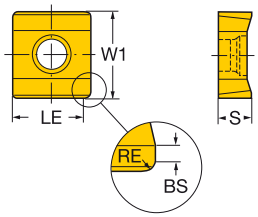

| | | | RE | Ordering code | P | | | | M | | | | K | | | | N | | | | S | | | | H | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1130 | 4330 | 4340 | 530 | 1040 | 2040 | 530 | S30T | 1020 | 3040 | 3220 | 3330 | 1130 | 530 | H10 | H13A | 1130 | 2040 | H13A | S30T | 1130 | 530 | W1 | LE | S | BS |
| Light | KL | 04 | 0.50 | N331.1A-04 35 05E-KL | | | | | | | | | ★ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 |
| | | | .020 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | 05 | 0.80 | N331.1A-05 45 08E-KL | | | | | | | | | ★ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | 08 | 0.80 | N331.1A-08 45 08E-KL | | | | | | | | | ★ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | 11 | 0.80 | N331.1A-11 50 08E-KL | | | | | | | | | ★ | ☆ | ☆ | ☆ | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | 14 | 0.80 | N331.1A-14 50 08E-KL | | | | | | | | | ★ | ☆ | ☆ | ☆ | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | NL | 04 | 0.50 | N331.1A-04 35 05H-NL | ☆ | | | | | | | | | | | | ☆ | | ★ | | ☆ | | | | ☆ | | 9.5 | 4.6 | 3.50 | 0.2 |
| | | | .020 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .181 | .138 | .008 |
| | | 05 | 0.80 | N331.1A-05 45 08H-NL | ☆ | | | | | | | | | | | | ☆ | | ★ | | ☆ | | | | ☆ | | 9.5 | 5.7 | 4.45 | 0.8 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .175 | .031 |
| | | 08 | 0.80 | N331.1A-08 45 08H-NL | ☆ | | | | | | | | | | | | ☆ | | ★ | | ☆ | | | | ☆ | | 9.5 | 7.7 | 4.45 | 0.9 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .175 | .035 |
| | | 11 | 0.80 | N331.1A-11 50 08H-NL | ☆ | | | | | | | | | | | | ☆ | | ★ | | ☆ | | | | ☆ | | 11.5 | 10.7 | 4.95 | 1.3 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .195 | .051 |
| | | 14 | 0.80 | N331.1A-14 50 08H-NL | ☆ | | | | | | | | | | | | ☆ | | ★ | | ☆ | | | | ☆ | | 11.5 | 13.7 | 4.95 | 1.1 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .195 | .043 |
| | PL | 04 | 0.50 | N331.1A-04 35 05H-PL | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 |
| | | | .020 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | 05 | 0.80 | N331.1A-05 45 08H-PL | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | 08 | 0.80 | N331.1A-08 45 08H-PL | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | 11 | 0.80 | N331.1A-11 50 08H-PL | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | 14 | 0.80 | N331.1A-14 50 08H-PL | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | WL | 04 | 0.50 | N331.1A-04 35 05H-WL | ☆ | | | | | | | | | | | | ☆ | | ☆ | | ☆ | | ☆ | | ☆ | | 9.5 | 4.6 | 3.50 | 0.4 |
| | | | .020 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | 05 | 0.80 | N331.1A-05 45 08H-WL | ☆ | | | | | | | | | | | | ☆ | | ☆ | | ☆ | | ☆ | | ☆ | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | 08 | 0.80 | N331.1A-08 45 08H-WL | ☆ | | | ☆ | | ☆ | | | | | | | ☆ | ☆ | ☆ | | ☆ | | ☆ | | ☆ | ☆ | 9.5 | 7.7 | 4.45 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | 11 | 0.80 | N331.1A-11 50 08H-WL | ☆ | | | | | | | | | | | | ☆ | | ☆ | | ☆ | | ☆ | | ☆ | | 11.5 | 10.7 | 4.95 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | 14 | 0.80 | N331.1A-14 50 08H-WL | ☆ | | | | | | | | | | | | ☆ | | ☆ | | ☆ | | ☆ | | ☆ | | 11.5 | 13.7 | 4.95 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | L30 | 04 | 0.50 | N331.1A-043505E-L30 | | | | | ☆ | ☆ | | ☆ | | | | | | | | | | ☆ | | ☆ | | | 9.5 | 4.6 | 3.49 | 0.4 |
| | | | .020 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .181 | .137 | .016 |
| | | 05 | 0.80 | N331.1A-054508E-L30 | | | | | ☆ | ☆ | | ☆ | | | | | | | | | | ☆ | | ☆ | | | 9.5 | 5.7 | 4.49 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .177 | .047 |
| | | 08 | 0.80 | N331.1A-084508E-L30 | | | | | ☆ | ☆ | | ☆ | | | | | | | | | | ☆ | | ☆ | | | 9.5 | 7.7 | 4.49 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .177 | .047 |
| | | 11 | 0.80 | N331.1A-115008E-L30 | | | | | ☆ | ☆ | | ☆ | | | | | | | | | | ☆ | | ☆ | | | 11.5 | 10.7 | 4.99 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .196 | .047 |
| | | 14 | 0.80 | N331.1A-145008E-L30 | | | | | ☆ | ☆ | | ☆ | | | | | | | | | | ☆ | | ☆ | | | 11.5 | 13.7 | 4.98 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .196 | .047 |

I167 I222 I254 N22 N6 N10

# CoroMill® 331 insert for side and face milling

KRINS 90°



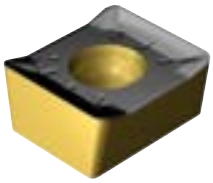


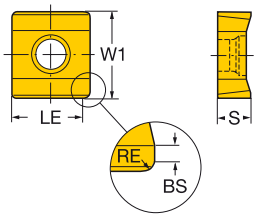

| | | RE | Ordering code | P 1130 | P 4330 | P 4340 | P 530 | M 1040 | M 2040 | M 530 | M S30T | K 1020 | K 3040 | K 3220 | K 3330 | N 1130 | N 530 | N H10 | N H13A | S 1130 | S 2040 | S H13A | S S30T | H 1130 | H 530 | Dimensions, mm, inch W1 | LE | S | BS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Light | L50 | 04 | N331.1A-043505E-L50 | ★ | | | | ★ | ☆ | | ☆ | | | | | | | | | ☆ | ☆ | | ★ | | | 9.5 | 4.6 | 3.49 | 0.4 |
| | | .020 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .181 | .137 | .016 |
| | | 05 | 0.80 | N331.1A-054508E-L50 | ★ | | | | ★ | ☆ | | ☆ | | | | | | | | | ☆ | ☆ | | ★ | | | 9.5 | 5.7 | 4.49 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .177 | .047 |
| | | 08 | 0.80 | N331.1A-084508E-L50 | ★ | | | | ★ | ☆ | | ☆ | | | | | | | | | ☆ | ☆ | | ★ | | | 9.5 | 7.7 | 4.49 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .177 | .047 |
| | | 11 | 0.80 | N331.1A-115008E-L50 | ★ | | | | ★ | ☆ | | ☆ | | | | | | | | | ☆ | ☆ | | ★ | | | 11.5 | 10.7 | 4.99 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .196 | .047 |
| | | 14 | 0.80 | N331.1A-145008E-L50 | ★ | | | | ★ | ☆ | | ☆ | | | | | | | | | ☆ | ☆ | | ★ | | | 11.5 | 13.7 | 4.98 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .196 | .047 |
| Medium | KM | 04 | 0.50 | N331.1A-04 35 05M-KM | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 |
| | | .020 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | 05 | 0.80 | N331.1A-05 45 08E-KM | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | 0.80 | N331.1A-05 45 08M-KM | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | 08 | 0.80 | N331.1A-08 45 08E-KM | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | 0.80 | N331.1A-08 45 08M-KM | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | 11 | 0.80 | N331.1A-11 50 08E-KM | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | 0.80 | N331.1A-11 50 08M-KM | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | 14 | 0.80 | N331.1A-14 50 08E-KM | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | | 0.80 | N331.1A-14 50 08M-KM | | | | | | | | | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | PM | 04 | 0.50 | N331.1A-04 35 05M-PM | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | 9.5 | 4.6 | 3.50 | 0.4 |
| | | .020 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | 05 | 0.80 | N331.1A-05 45 08H-PM | | ☆ | | | | | | | | | | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | 0.80 | N331.1A-05 45 08M-PM | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | 9.5 | 5.7 | 4.45 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | 08 | 0.80 | N331.1A-08 45 08H-PM | | ☆ | | | | | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | 0.80 | N331.1A-08 45 08M-PM | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | 11 | 0.80 | N331.1A-11 50 08H-PM | | ☆ | | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | 0.80 | N331.1A-11 50 08M-PM | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | 11.5 | 10.7 | 4.95 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | 14 | 0.80 | N331.1A-14 50 08H-PM | | ☆ | | | | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | | 0.80 | N331.1A-14 50 08M-PM | | ☆ | ☆ | | | | | | | | | | | | | | | | | | | | 11.5 | 13.7 | 4.95 | 1.2 |
| | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |

I167 I222 I254 N22 N6 N10

# CoroMill® 331 insert for side and face milling

KRINS 90°






| | | | RE | Ordering code | P | | | | M | | | | K | | | | N | | | | S | | | | H | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1130 | 4330 | 4340 | 530 | 1040 | 2040 | 530 | S30T | 1020 | 3040 | 3220 | 3330 | 1130 | 530 | H10 | H13A | 1130 | 2040 | H13A | S30T | 1130 | 530 | W1 | LE | S | BS |
| Medium | M30 | 04 | 0.50 | N331.1A-043505E-M30 | ★ | ★ | | | | | | | ★ | ★ | | | | | | | | | | | ☆ | | 9.5 | 4.6 | 3.50 | 0.4 |
| | | | .020 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | 05 | 0.80 | N331.1A-054508E-M30 | ★ | ★ | | | | | | | ★ | ★ | | | | | | | | | | | | | 9.5 | 5.7 | 4.50 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .224 | .177 | .047 |
| | | 08 | 0.80 | N331.1A-084508E-M30 | ★ | ★ | | | | | | | ★ | ★ | | | | | | | | | | | ☆ | | 9.5 | 7.7 | 4.50 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .177 | .047 |
| | | 11 | 0.80 | N331.1A-115008E-M30 | ★ | ★ | | | | | | | ★ | ★ | | | | | | | | | | | ☆ | | 11.5 | 10.7 | 5.00 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .197 | .047 |
| | | 14 | 0.80 | N331.1A-145008E-M30 | ★ | ★ | | | | | | | ★ | ★ | | | | | | | | | | | ☆ | | 11.5 | 13.7 | 5.00 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .197 | .047 |
| | WM | 08 | 0.80 | N331.1A-08 45 08H-WM | | | | ☆ | | | ☆ | | | | | | | ☆ | ☆ | | | ☆ | | | ☆ | | 9.5 | 7.7 | 4.45 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | 11 | 0.80 | N331.1A-11 50 08H-WM | | | | ☆ | | | ☆ | | | | | | | ☆ | ☆ | | | ☆ | | | ☆ | | 11.5 | 10.7 | 4.95 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | 14 | 0.80 | N331.1A-14 50 08H-WM | | | | | | | | | | | | | | | ☆ | | | ☆ | | | | | 11.5 | 13.7 | 4.95 | 1.2 |
| | | | .031 | | | | | | | | | | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |

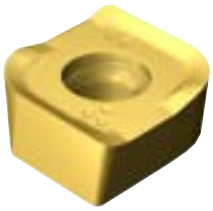
| | | | RE | Ordering code | P | | K | | N | S | H | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1130 | 4330 | 1020 | 3040 | 1130 | 1130 | 1130 | W1 | LE | S | BS |
| Light | KL | 08 | 2.00 | N331.1A-08 45 20E-KL | | | ★ | | | | | 9.5 | 6.5 | 4.50 | 1.2 |
| | | | .079 | | | | | | | | | .374 | .256 | .177 | .047 |
| | | 11 | 2.00 | N331.1A-11 50 20E-KL | | | ★ | | | | | 11.5 | 9.5 | 5.00 | 1.2 |
| | | | .079 | | | | | | | | | .453 | .374 | .197 | .047 |
| | PL | 08 | 2.00 | N331.1A-08 45 20H-PL | ★ | | | | ☆ | ☆ | ☆ | 9.5 | 6.5 | 4.50 | 1.2 |
| | | | .079 | | | | | | | | | .374 | .256 | .177 | .047 |
| | | 11 | 2.00 | N331.1A-11 50 20H-PL | ★ | | | | ☆ | ☆ | ☆ | 11.5 | 9.5 | 5.00 | 1.2 |
| | | | .079 | | | | | | | | | .453 | .374 | .197 | .047 |
| Medium | KM | 08 | 2.00 | N331.1A-08 45 20E-KM | | | ★ | ★ | | | | 9.5 | 6.5 | 4.45 | 1.2 |
| | | | .079 | | | | | | | | | .374 | .256 | .175 | .047 |
| | | 11 | 2.00 | N331.1A-11 50 20E-KM | | | ★ | ★ | | | | 11.5 | 9.5 | 4.95 | 1.2 |
| | | | .079 | | | | | | | | | .453 | .374 | .195 | .047 |
| | PM | 08 | 2.00 | N331.1A-08 45 20H-PM | ★ | ★ | | | ☆ | ☆ | ☆ | 9.5 | 6.5 | 4.45 | 1.2 |
| | | | .079 | | | | | | | | | .374 | .256 | .175 | .047 |
| | | 11 | 2.00 | N331.1A-11 50 20H-PM | ★ | ★ | | | ☆ | ☆ | ☆ | 11.5 | 9.5 | 4.95 | 1.2 |
| | | | .079 | | | | | | | | | .453 | .374 | .195 | .047 |

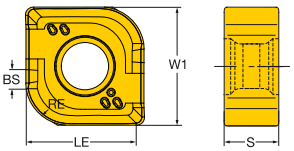
I167 I222 I254 N22 N6 N10

# CoroMill® 331 insert for side and face milling

**Cutter bodies for radii inserts available as Tailor Made.**

KRINS 90°





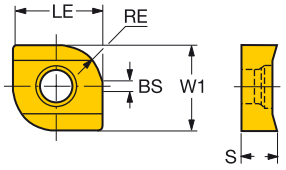

| | | SSC | RE | Ordering code | P | | | | | M | | | | K | | | N | S | | | H | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1040 | 1130 | 2040 | 3040 | 4330 | 1040 | 1130 | 2040 | S30T | 1020 | 3040 | 4330 | 1130 | 1130 | 2040 | S30T | 1130 | W1 | LE | S | BS |
| Light | L50 | 11 | 3.05 | R/L331.1A-115030E-L50 | ☆ | | ☆ | | | ★ | | ☆ | ☆ | | | | | | ☆ | ★ | | 11.5 | 10.7 | 5.00 | 1.3 |
| | | | *.120* | | | | | | | | | | | | | | | | | | | *.453* | *.421* | *.197* | *.051* |
| | | | 4.00 | R/L331.1A-115040E-L50 | ☆ | | ☆ | | | ★ | | ☆ | ☆ | | | | | | ☆ | ★ | | 11.5 | 10.7 | 5.00 | 1.4 |
| | | | *.157* | | | | | | | | | | | | | | | | | | | *.453* | *.421* | *.197* | *.055* |
| | | | 4.83 | R/L331.1A-115048E-L50 | ☆ | | ☆ | | | ★ | | ☆ | ☆ | | | | | | ☆ | ★ | | 11.5 | 10.7 | 5.00 | 1.5 |
| | | | *.190* | | | | | | | | | | | | | | | | | | | *.453* | *.421* | *.197* | *.059* |
| | | | 6.35 | R/L331.1A-115063E-L50 | ☆ | | ☆ | | | ★ | | ☆ | ☆ | | | | | | ☆ | ★ | | 11.5 | 10.7 | 5.00 | 1.6 |
| | | | *.250* | | | | | | | | | | | | | | | | | | | *.453* | *.421* | *.197* | *.063* |
| Medium | WM | 08 | 4.00 | R/L331.1A-08 45 40H-WM | | ★ | | ☆ | ☆ | | | | | ★ | ☆ | ☆ | | | | | | 9.5 | 7.7 | 4.45 | 1.4 |
| | | | *.157* | | | | | | | | | | | | | | | | | | | *.374* | *.303* | *.175* | *.055* |
| | M30 | 11 | 1.52 | R/L331.1A-115015E-M30 | | ★ | | ☆ | ☆ | | ☆ | | | ★ | ☆ | ☆ | ☆ | ☆ | | | ☆ | 11.5 | 10.7 | 5.00 | 1.2 |
| | | | *.060* | | | | | | | | | | | | | | | | | | | *.453* | *.421* | *.197* | *.047* |
| | | | 2.29 | R/L331.1A-115023E-M30 | | ★ | | ☆ | ☆ | | ☆ | | | ★ | ☆ | ☆ | ☆ | ☆ | | | ☆ | 11.5 | 10.7 | 5.00 | 1.2 |
| | | | *.090* | | | | | | | | | | | | | | | | | | | *.453* | *.421* | *.197* | *.047* |
| | | | 3.05 | R/L331.1A-115030E-M30 | | ★ | | ☆ | ☆ | | ☆ | | | ★ | ☆ | ☆ | ☆ | ☆ | | | ☆ | 11.5 | 10.7 | 5.00 | 1.3 |
| | | | *.120* | | | | | | | | | | | | | | | | | | | *.453* | *.421* | *.197* | *.051* |
| | WM | 11 | 4.00 | R/L331.1A-11 50 40H-WM | | ★ | | ☆ | ☆ | | ☆ | | | ★ | ☆ | ☆ | ☆ | ☆ | | | ☆ | 11.5 | 10.7 | 4.95 | 1.4 |
| | | | *.157* | | | | | | | | | | | | | | | | | | | *.453* | *.421* | *.195* | *.055* |
| | | 14 | 4.00 | R/L331.1A-14 50 40H-WM | | ★ | | ☆ | ☆ | | ☆ | | | ★ | ☆ | ☆ | ☆ | ☆ | | | ☆ | 11.5 | 13.7 | 4.95 | 1.4 |
| | | | *.157* | | | | | | | | | | | | | | | | | | | *.453* | *.539* | *.195* | *.055* |

I167 I222 I254 N22 N6 N10

# CoroMill® 331 insert for side and face milling

**Cutter bodies for radii inserts available as Tailor Made.**

KRINS 90°



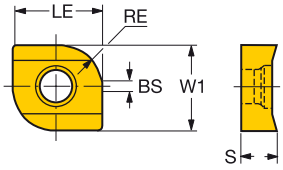

| | | | | | P | | M | | K | | N | | S | | | | H | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | RE | Ordering code | 1130 | 4340 | 1040 | 1130 | 1025 | 4340 | 1130 | H10F | 1040 | 1130 | S30T | H10F | 1130 | W1 | LE | S | BS |
| Light | WL | 04 | 1.52 | L331.1A-04 35 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 9.5 | 4.6 | 3.50 | 0.4 |
| | | | .060 | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | | 2.29 | L331.1A-04 35 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 9.5 | 4.6 | 3.50 | 0.4 |
| | | | .090 | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | | 1.52 | R331.1A-04 35 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 9.5 | 4.6 | 3.50 | 0.4 |
| | | | .060 | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | | 2.29 | R331.1A-04 35 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 9.5 | 4.6 | 3.50 | 0.4 |
| | | | .090 | | | | | | | | | | | | | | | .374 | .181 | .138 | .016 |
| | | 05 | 1.52 | L331.1A-05 45 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 9.5 | 5.7 | 4.45 | 1.2 |
| | | | .060 | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | | 2.29 | L331.1A-05 45 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | ★ | ★ | ☆ | | ☆ | ★ | 9.5 | 5.7 | 4.45 | 1.2 |
| | | | .090 | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | | 3.05 | L331.1A-05 45 30H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 9.5 | 5.7 | 4.45 | 1.3 |
| | | | .120 | | | | | | | | | | | | | | | .374 | .224 | .175 | .051 |
| | | | 1.52 | R331.1A-05 45 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 9.5 | 5.7 | 4.45 | 1.2 |
| | | | .060 | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | | 2.29 | R331.1A-05 45 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | ★ | ★ | ☆ | | ☆ | ★ | 9.5 | 5.7 | 4.45 | 1.2 |
| | | | .090 | | | | | | | | | | | | | | | .374 | .224 | .175 | .047 |
| | | | 3.05 | R331.1A-05 45 30H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 9.5 | 5.7 | 4.45 | 1.3 |
| | | | .120 | | | | | | | | | | | | | | | .374 | .224 | .175 | .051 |
| | | 08 | 1.52 | L331.1A-08 45 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ☆ | ☆ | ★ | | ★ | 9.5 | 7.7 | 4.45 | 1.2 |
| | | | .060 | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | | 2.29 | L331.1A-08 45 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | ★ | ☆ | ☆ | ★ | ☆ | ★ | 9.5 | 7.7 | 4.45 | 1.2 |
| | | | .090 | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | | 3.05 | L331.1A-08 45 30H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | ★ | ★ | ☆ | | ☆ | ★ | 9.5 | 7.7 | 4.45 | 1.3 |
| | | | .120 | | | | | | | | | | | | | | | .374 | .303 | .175 | .051 |
| | | | 1.52 | R331.1A-08 45 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ☆ | ☆ | ★ | | ★ | 9.5 | 7.7 | 4.45 | 1.2 |
| | | | .060 | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | | 2.29 | R331.1A-08 45 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | ★ | ☆ | ☆ | ★ | ☆ | ★ | 9.5 | 7.7 | 4.45 | 1.2 |
| | | | .090 | | | | | | | | | | | | | | | .374 | .303 | .175 | .047 |
| | | | 3.05 | R331.1A-08 45 30H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 9.5 | 7.7 | 4.45 | 1.3 |
| | | | .120 | | | | | | | | | | | | | | | .374 | .303 | .175 | .051 |
| | | 11 | 1.52 | L331.1A-11 50 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ☆ | ☆ | ★ | | ★ | 11.5 | 10.7 | 4.95 | 1.2 |
| | | | .060 | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | | 2.29 | L331.1A-11 50 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | ★ | ☆ | ☆ | ★ | ☆ | ★ | 11.5 | 10.7 | 4.95 | 1.2 |
| | | | .090 | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | | 3.05 | L331.1A-11 50 30H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 10.7 | 4.95 | 1.3 |
| | | | .120 | | | | | | | | | | | | | | | .453 | .421 | .195 | .051 |
| | | | 4.83 | L331.1A-11 50 48H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 10.7 | 4.95 | 1.5 |
| | | | .190 | | | | | | | | | | | | | | | .453 | .421 | .195 | .059 |
| | | | 6.35 | L331.1A-11 50 63H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 10.7 | 4.95 | 1.6 |
| | | | .250 | | | | | | | | | | | | | | | .453 | .421 | .195 | .063 |
| | | | 1.52 | R331.1A-11 50 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ☆ | ☆ | ★ | | ★ | 11.5 | 10.7 | 4.95 | 1.2 |
| | | | .060 | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | | 2.29 | R331.1A-11 50 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | ★ | ☆ | ☆ | ★ | ☆ | ★ | 11.5 | 10.7 | 4.95 | 1.2 |
| | | | .090 | | | | | | | | | | | | | | | .453 | .421 | .195 | .047 |
| | | | 3.05 | R331.1A-11 50 30H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 10.7 | 4.95 | 1.3 |
| | | | .120 | | | | | | | | | | | | | | | .453 | .421 | .195 | .051 |
| | | | 4.83 | R331.1A-11 50 48H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 10.7 | 4.95 | 1.5 |
| | | | .190 | | | | | | | | | | | | | | | .453 | .421 | .195 | .059 |
| | | | 6.35 | R331.1A-11 50 63H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 10.7 | 4.95 | 1.6 |
| | | | .250 | | | | | | | | | | | | | | | .453 | .421 | .195 | .063 |

I167 I222 I254 N22 N6 N10

# CoroMill® 331 insert for side and face milling

**Cutter bodies for radii inserts available as Tailor Made.**

KRINS 90°

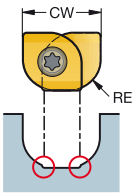



| | | | RE | Ordering code | P | | M | | K | | N | | S | | | | H | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1130 | 4340 | 1040 | 1130 | 1025 | 4340 | 1130 | H10F | 1040 | 1130 | S30T | H10F | 1130 | W1 | LE | S | BS |
| Light | WL | 14 | 1.52 | L331.1A-14 50 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 13.7 | 4.95 | 1.2 |
| | | | .060 | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | | | 2.29 | L331.1A-14 50 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 13.7 | 4.95 | 1.2 |
| | | | .090 | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | | | 3.05 | L331.1A-14 50 30H-WL | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ★ | ☆ | | ☆ | ★ | 11.5 | 13.7 | 4.95 | 1.3 |
| | | | .120 | | | | | | | | | | | | | | | .453 | .539 | .195 | .051 |
| | | | 4.83 | L331.1A-14 50 48H-WL | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ★ | ☆ | | ☆ | ★ | 11.5 | 13.7 | 4.95 | 1.5 |
| | | | .190 | | | | | | | | | | | | | | | .453 | .539 | .195 | .059 |
| | | | 6.35 | L331.1A-14 50 63H-WL | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | | ★ | ☆ | | | ★ | 11.5 | 13.7 | 4.95 | 1.6 |
| | | | .250 | | | | | | | | | | | | | | | .453 | .539 | .195 | .063 |
| | | | 1.52 | R331.1A-14 50 15H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 13.7 | 4.95 | 1.2 |
| | | | .060 | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | | | 2.29 | R331.1A-14 50 23H-WL | ★ | | ★ | ☆ | ☆ | | ☆ | | ★ | ☆ | | | ★ | 11.5 | 13.7 | 4.95 | 1.2 |
| | | | .090 | | | | | | | | | | | | | | | .453 | .539 | .195 | .047 |
| | | | 3.05 | R331.1A-14 50 30H-WL | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ★ | ☆ | | ☆ | ★ | 11.5 | 13.7 | 4.95 | 1.3 |
| | | | .120 | | | | | | | | | | | | | | | .453 | .539 | .195 | .051 |
| | | | 4.83 | R331.1A-14 50 48H-WL | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | | ★ | ☆ | | | ★ | 11.5 | 13.7 | 4.95 | 1.5 |
| | | | .190 | | | | | | | | | | | | | | | .453 | .539 | .195 | .059 |
| | | | 6.35 | R331.1A-14 50 63H-WL | ★ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | | ★ | ☆ | | | ★ | 11.5 | 13.7 | 4.95 | 1.6 |
| | | | .250 | | | | | | | | | | | | | | | .453 | .539 | .195 | .063 |

## Limitations when using inserts with large corner radius

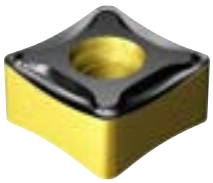
**Full slot milling**

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

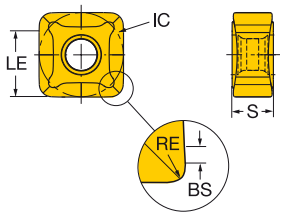



I167 I222 I254 N22 N6 N10

# CoroMill® 331 insert for side and face milling

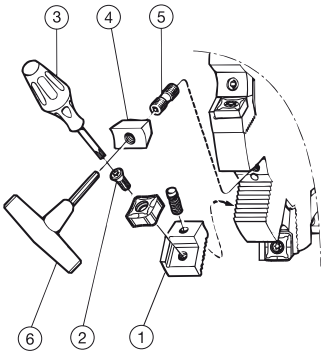


KRINS 88°




| | | RE | Ordering code | P 1130 | P 4220 | P 4330 | P 4340 | M 1130 | K 1020 | K 3040 | K 3330 | N 1130 | S 1130 | H 1130 | H 4220 | Dimensions, mm, inch IC | LE | S | BS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Medium | PM | 13 0.80 | N331.1D-136508E-PM | ☆ | | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | 13.4 | 11.4 | 6.55 | 1.2 |
| | | .031 | | | | | | | | | | | | | | .528 | .449 | .258 | .047 |
| | | 0.80 | N331.1D-136508M-PM | | ☆ | ★ | | | ☆ | ☆ | ★ | | | | ☆ | 13.4 | 11.4 | 6.55 | 1.2 |
| | | .031 | | | | | | | | | | | | | | .528 | .449 | .258 | .047 |
| | | 1.20 | N331.1D-136512M-PM | | ☆ | | | | ☆ | ☆ | ★ | | | | ☆ | 13.4 | 11.0 | 6.55 | 1.2 |
| | | .047 | | | | | | | | | | | | | | .528 | .433 | .258 | .047 |
| | | 2.00 | N331.1D-136520E-PM | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | 13.4 | 10.2 | 6.55 | 1.2 |
| | | .079 | | | | | | | | | | | | | | .528 | .402 | .258 | .047 |
| | | 2.00 | N331.1D-136520M-PM | | ☆ | | | | ☆ | ☆ | ★ | | | | ☆ | 13.4 | 10.2 | 6.55 | 1.2 |
| | | .079 | | | | | | | | | | | | | | .528 | .402 | .258 | .047 |

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



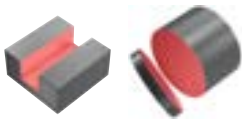
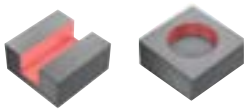
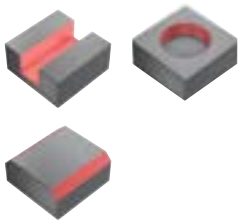
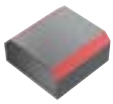

Note that the diameter of the cutter increases by 3.2 mm (.126 inch) when using the cassettes for double sided inserts.

| Cutter type | 1 Cassette, Right | 1 Cassette Left | 2 Screw | 3 Key (Torx Plus) | Torque wrench[1)] | 4 Wedge | 5 Screw | 6 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

I167 I222 I254 N22 N6 N10

# Groove-, thread-, and chamfer milling tools

| | CoroMill® QD | CoroMill® 328 | CoroMill® 327 | CoroMill® 495 |
|---|---|---|---|---|
| | | | | |
| Page | Groove milling I191 | Groove milling I203<br>Thread milling I213 | Groove milling I208<br>Thread milling I214<br>Chamfer milling I217 | Chamfer milling I218 |
| Material | P M K N S H | P M K N S | P M K N S | P M K N S |
| Main operations |  |  |  |  |
| $D_c$ mm<br>$D_c$ inch | 63 - 315<br>2.480 - 12.402 | 39 - 80<br>1.500 - 10.000 | 9.7 - 34.7<br>1.250 - 10.000 | 12 - 63<br>1.25 - 4 |
| APMX mm<br>APMX inch | | 6<br>.236 | 6 - 10<br>.240 - .394 | 3.8 - 7.7<br>.079 |
| CW mm<br>CW inch | 2.00 - 6.35<br>.079 - .250 | 1.3 - 5.15<br>.051 | 0.7 - 5.15<br>.028 - .203 | |
| CDX mm<br>CDX inch | 21.0 - 117.5<br>.827 - 4.425 | 3.0 - 5.0<br>.118 - .197 | 0.5 - 10.0<br>.020 - .394 | |
| Insert | | | | |
| Insert sizes | E, F, G, H, J, K | 13 | 06, 09, 12, 14 | 09 |
| Couplings | Arbor with driving screws<br>Cylindrical shank | Bore with keyway<br>Weldon<br>Arbor | Coromant Capto® Short<br>Weldon<br>Integrated ER collets | Coromant Capto®<br>Cylindrical shank<br>Weldon<br>Coromant EH |
| Internal coolant | ✓ | | ✓ | ✓ |
| Options | | | | Angles available: 15°, 30°, 45°, 60° |
| Other operations | | | | |

# 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

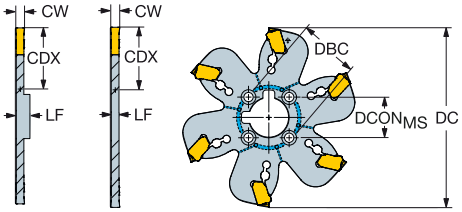
The internal coolant solution provides great chip evacuation. By getting rid of chip issues, surface quality is improved, and machining security ensured. Internal coolant also helps regulate the heat at the cutting zone, which is especially beneficial for ISO S materials.

I192 I198 N6

# CoroMill® QD indexable grooving and parting off cutter

**Arbor - Internal coolant supply**

KAPR 90°




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

**Metric version**

| 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 adapter.

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

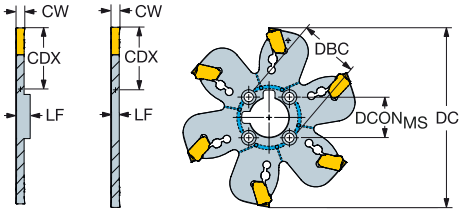
For the complete list of spare parts, visit www.sandvik.coromant.com

I198 L2 N22 N6 N15

# CoroMill® QD indexable grooving and parting off cutter

**Arbor - Internal coolant supply**

KAPR 90°




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

**Inch version**

| CW | DC | CDX | SSC | CZC$_{MS}$ | CNSC | | | Ordering code | Dimensions, inch DCON$_{MS}$ | DBC | LF | DRVCT | PSI | LBS | RPMX | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .079 | 3.000 | .870 | E | X10 | 4 | | 5 | AQD-EC076X10-M | .394 | .866 | .104 | 0 | 725 | 0.25 | 4400 | QD-NE-0200-020E-PM |
| | 4.000 | 1.016 | E | Y25 | 4 | | 8 | AQD-EC102Y25-M | 1.000 | 1.417 | .104 | 2 | 725 | 0.31 | 3800 | QD-NE-0200-020E-PM |
| | 5.000 | 1.260 | E | Y31 | 4 | | 10 | AQD-EC127Y31-M | 1.250 | 1.772 | .104 | 2 | 725 | 0.56 | 3400 | QD-NE-0200-020E-PM |
| | 6.000 | 1.425 | E | Y38 | 4 | | 12 | AQD-EC152Y38-M | 1.500 | 2.480 | .104 | 2 | 725 | 0.07 | 3100 | QD-NE-0200-020E-PM |
| .094 | 3.000 | .870 | F | X10 | 4 | 5 | | AQD-FC076X10-M | .394 | .866 | .086 | 0 | 725 | 0.27 | 5100 | QD-NF-0239-020E-PM |
| | 4.000 | 1.016 | F | Y25 | 4 | | 8 | AQD-FC102Y25-M | 1.000 | 1.417 | .086 | 2 | 725 | 0.34 | 4400 | QD-NF-0239-020E-PM |
| | 5.000 | 1.260 | F | Y31 | 4 | | 10 | AQD-FC127Y31-M | 1.250 | 1.772 | .086 | 2 | 725 | 0.62 | 3900 | QD-NF-0239-020E-PM |
| | 6.000 | 1.425 | F | Y38 | 4 | 12 | | AQD-FC152Y38-M | 1.500 | 2.480 | .086 | 2 | 725 | 0.74 | 3600 | QD-NF-0239-020E-PM |
| .125 | 3.000 | .870 | G | X10 | 4 | 5 | | AQD-GC076X10-M | .394 | .866 | .110 | 0 | 1015 | 0.24 | 6300 | QD-NG-0318-020E-PM |
| | 4.000 | 1.016 | G | Y25 | 4 | 8 | | AQD-GC102Y25-M | 1.000 | 1.417 | .110 | 2 | 1015 | 0.37 | 5400 | QD-NG-0318-020E-PM |
| | 5.000 | 1.260 | G | Y31 | 4 | 10 | | AQD-GC127Y31-M | 1.250 | 1.772 | .110 | 2 | 1015 | 0.66 | 4800 | QD-NG-0318-020E-PM |
| | 6.000 | 1.425 | G | Y38 | 4 | 10 | | AQD-GC152Y38-M | 1.500 | 2.480 | .110 | 2 | 1015 | 0.80 | 4400 | QD-NG-0318-020E-PM |
| .157 | 4.000 | 1.016 | H | Y25 | 4 | 6 | | AQD-HC102Y25-M | 1.000 | 1.417 | .144 | 2 | 1015 | 0.42 | 4400 | QD-NH-0400-025E-PM |
| | 5.000 | 1.260 | H | Y31 | 4 | | 8 | AQD-HC127Y31-M | 1.250 | 1.772 | .144 | 2 | 1015 | 0.77 | 3900 | QD-NH-0400-025E-PM |
| | 6.000 | 1.425 | H | Y38 | 4 | | 10 | AQD-HC152Y38-M | 1.500 | 2.480 | .144 | 2 | 1015 | 0.96 | 3600 | QD-NH-0400-025E-PM |
| .187 | 4.000 | 1.016 | J | Y25 | 4 | 6 | | AQD-JC102Y25-M | 1.000 | 1.417 | .178 | 2 | 1015 | 0.47 | 3700 | QD-NJ-0476-030E-PM |
| | 5.000 | 1.260 | J | Y31 | 4 | 8 | | AQD-JC127Y31-M | 1.250 | 1.772 | .178 | 2 | 1015 | 0.87 | 3300 | QD-NJ-0476-030E-PM |
| | 6.000 | 1.425 | J | Y38 | 4 | 10 | | AQD-JC152Y38-M | 1.500 | 2.480 | .178 | 2 | 1015 | 1.12 | 3000 | QD-NJ-0476-030E-PM |
| .250 | 4.000 | 1.016 | K | Y25 | 4 | | 6 | AQD-KC102Y25-M | 1.000 | 1.417 | .229 | 2 | 1015 | 0.54 | 3800 | QD-NK-0635-035E-PM |
| | 5.000 | 1.260 | K | Y31 | 4 | | 8 | AQD-KC127Y31-M | 1.250 | 1.772 | .229 | 2 | 1015 | 0.98 | 3400 | QD-NK-0635-035E-PM |
| | 6.000 | 1.425 | K | Y38 | 4 | | 10 | AQD-KC152Y38-M | 1.500 | 2.480 | .229 | 2 | 1015 | 1.31 | 3100 | QD-NK-0635-035E-PM |

Note: coupling Y38 uses cap screws, which are included with the adapter.

| | Spare parts |
|---|---|
| DC" | Screw |
| 3.000 | 5513 015-11 |
| 4.000 | 5513 015-10 |
| 5.000 | 5513 015-09 |

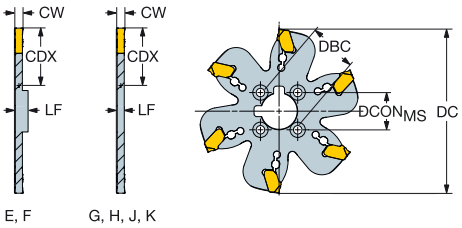
For the complete list of spare parts, visit www.sandvik.coromant.com

I198 L2 N22 N6 N15

# CoroMill® QD indexable grooving and parting off cutter

**Arbor**

KAPR 90°




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

**Metric version**

| CW | DC | CDX | SSC | CZCMS | | | Ordering code | Dimensions, mm DCONMS | 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 adapter.

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

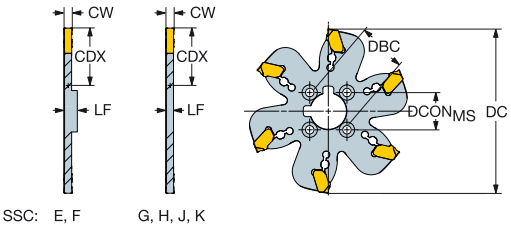
For spare parts, visit www.sandvik.coromant.com

I198 L2 N22 N6

# CoroMill® QD indexable grooving and parting off cutter

**Arbor**

KAPR 90°




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

**Inch version**

| CW | DC | CDX | SSC | CZC$_{MS}$ | | | Ordering code | Dimensions, inch DCON$_{MS}$ | DBC | LF | DRVCT | LBS | RPMX | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .079 | 3.000 | .870 | E | X10 | | 5 | AQD-E-076X10-M | .394 | .866 | .104 | 0 | 0.25 | 4400 | QD-NE-0200-020E-PM |
| | 4.000 | 1.016 | E | Y25 | | 8 | AQD-E-102Y25-M | 1.000 | 1.417 | .104 | 2 | 0.31 | 3800 | QD-NE-0200-020E-PM |
| | 5.000 | 1.260 | E | Y31 | | 10 | AQD-E-127Y31-M | 1.250 | 1.772 | .104 | 2 | 0.57 | 3400 | QD-NE-0200-020E-PM |
| | 6.000 | 1.425 | E | Y38 | | 12 | AQD-E-152Y38-M | 1.500 | 2.480 | .104 | 2 | 0.66 | 3100 | QD-NE-0200-020E-PM |
| | 8.000 | 2.425 | E | Y38 | 16 | | AQD-E-203Y38-M | 1.500 | 2.480 | .104 | 2 | 1.46 | 2700 | QD-NE-0200-020E-PM |
| .094 | 3.000 | .870 | F | X10 | | 5 | AQD-F-076X10-M | .394 | .866 | .086 | 0 | 0.27 | 5100 | QD-NF-0239-020E-PM |
| | 4.000 | 1.016 | F | Y25 | | 8 | AQD-F-102Y25-M | 1.000 | 1.417 | .086 | 2 | 0.35 | 4400 | QD-NF-0239-020E-PM |
| | 5.000 | 1.260 | F | Y31 | | 10 | AQD-F-127Y31-M | 1.250 | 1.772 | .086 | 2 | 0.62 | 3900 | QD-NF-0239-020E-PM |
| | 6.000 | 1.425 | F | Y38 | 12 | | AQD-F-152Y38-M | 1.500 | 2.480 | .086 | 2 | 0.75 | 3600 | QD-NF-0239-020E-PM |
| | 8.000 | 2.425 | F | Y38 | 16 | | AQD-F-203Y38-M | 1.500 | 2.480 | .086 | 2 | 1.63 | 3100 | QD-NF-0239-020E-PM |
| | 10.000 | 3.425 | F | Y38 | 20 | | AQD-F-254Y38-M | 1.500 | 2.480 | .086 | 2 | 2.16 | 2800 | QD-NF-0239-020E-PM |
| .125 | 3.000 | .870 | G | X10 | 5 | | AQD-G-076X10-M | .394 | .866 | .110 | 0 | 0.29 | 6300 | QD-NG-0318-020E-PM |
| | 4.000 | 1.016 | G | Y25 | 8 | | AQD-G-102Y25-M | 1.000 | 1.417 | .110 | 2 | 0.37 | 5400 | QD-NG-0318-020E-PM |
| | 5.000 | 1.260 | G | Y31 | 10 | | AQD-G-127Y31-M | 1.250 | 1.772 | .110 | 2 | 0.68 | 4800 | QD-NG-0318-020E-PM |
| | 6.000 | 1.425 | G | Y38 | 10 | | AQD-G-152Y38-M | 1.500 | 2.480 | .110 | 2 | 0.81 | 4400 | QD-NG-0318-020E-PM |
| | 8.000 | 2.425 | G | Y38 | | 16 | AQD-G-203Y38-M | 1.500 | 2.480 | .110 | 2 | 1.68 | 3800 | QD-NG-0318-020E-PM |
| | 10.000 | 3.425 | G | Y38 | | 20 | AQD-G-254Y38-M | 1.500 | 2.480 | .110 | 2 | 2.38 | 3400 | QD-NG-0318-020E-PM |
| | 12.000 | 4.425 | G | Y38 | | 24 | AQD-G-305Y38-M | 1.500 | 2.480 | .110 | 2 | 3.97 | 3100 | QD-NG-0318-020E-PM |
| .157 | 4.000 | 1.016 | H | Y25 | 6 | | AQD-H-102Y25-M | 1.000 | 1.417 | .144 | 2 | 0.90 | 4400 | QD-NH-0400-025E-PM |
| | 5.000 | 1.260 | H | Y31 | | 8 | AQD-H-127Y31-M | 1.250 | 1.772 | .144 | 2 | 0.77 | 3900 | QD-NH-0400-025E-PM |
| | 6.000 | 1.425 | H | Y38 | | 10 | AQD-H-152Y38-M | 1.500 | 2.480 | .144 | 2 | 0.97 | 3600 | QD-NH-0400-025E-PM |
| | 8.000 | 2.425 | H | Y38 | | 14 | AQD-H-203Y38-M | 1.500 | 2.480 | .144 | 2 | 2.14 | 3100 | QD-NH-0400-025E-PM |
| | 10.000 | 3.425 | H | Y38 | | 20 | AQD-H-254Y38-M | 1.500 | 2.480 | .144 | 2 | 3.11 | 2800 | QD-NH-0400-025E-PM |
| | 12.000 | 4.425 | H | Y38 | | 24 | AQD-H-305Y38-M | 1.500 | 2.480 | .144 | 2 | 4.94 | 2500 | QD-NH-0400-025E-PM |
| .187 | 4.000 | 1.016 | J | Y25 | 6 | | AQD-J-102Y25-M | 1.000 | 1.417 | .178 | 2 | 0.47 | 3700 | QD-NJ-0476-030E-PM |
| | 5.000 | 1.260 | J | Y31 | 8 | | AQD-J-127Y31-M | 1.250 | 1.772 | .178 | 2 | 0.87 | 3300 | QD-NJ-0476-030E-PM |
| | 6.000 | 1.425 | J | Y38 | 10 | | AQD-J-152Y38-M | 1.500 | 2.480 | .178 | 2 | 1.13 | 3000 | QD-NJ-0476-030E-PM |
| | 8.000 | 2.425 | J | Y38 | | 14 | AQD-J-203Y38-M | 1.500 | 2.480 | .178 | 2 | 2.51 | 2600 | QD-NJ-0476-030E-PM |
| | 10.000 | 3.425 | J | Y38 | | 18 | AQD-J-254Y38-M | 1.500 | 2.480 | .178 | 2 | 3.73 | 2400 | QD-NJ-0476-030E-PM |
| | 12.000 | 4.425 | J | Y38 | | 24 | AQD-J-305Y38-M | 1.500 | 2.480 | .178 | 2 | 5.90 | 2100 | QD-NJ-0476-030E-PM |
| .250 | 4.000 | 1.016 | K | Y25 | | 6 | AQD-K-102Y25-M | 1.000 | 1.417 | .229 | 2 | 0.54 | 3800 | QD-NK-0635-035E-PM |
| | 5.000 | 1.260 | K | Y31 | | 8 | AQD-K-127Y31-M | 1.250 | 1.772 | .229 | 2 | 0.99 | 3400 | QD-NK-0635-035E-PM |
| | 6.000 | 1.425 | K | Y38 | | 10 | AQD-K-152Y38-M | 1.500 | 2.480 | .229 | 2 | 1.32 | 3100 | QD-NK-0635-035E-PM |
| | 8.000 | 2.425 | K | Y38 | 14 | | AQD-K-203Y38-M | 1.500 | 2.480 | .229 | 2 | 2.91 | 2700 | QD-NK-0635-035E-PM |
| | 10.000 | 3.425 | K | Y38 | 18 | | AQD-K-254Y38-M | 1.500 | 2.480 | .229 | 2 | 4.32 | 2400 | QD-NK-0635-035E-PM |
| | 12.000 | 4.425 | K | Y38 | 24 | | AQD-K-305Y38-M | 1.500 | 2.480 | .229 | 2 | 7.01 | 2200 | QD-NK-0635-035E-PM |

Note: coupling Y38 uses cap screws, which are included with the adapter.

| | Spare parts |
|---|---|
| DC" | Screw |
| 3.000 | 5513 015-11 |
| 4.000 | 5513 015-10 |
| 5.000 | 5513 015-09 |

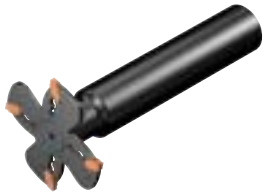
For spare parts, visit www.sandvik.coromant.com

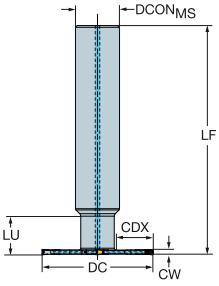
I198 L2 N22 N6

# CoroMill® QD indexable grooving and parting off cutter

**Cylindrical shank - Internal coolant supply**

KAPR 90°






## Metric version

| CW | DC | CDX | SSC | CZCMS | CNSC | | Ordering code | Dimensions, mm DCONMS | 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 |

## Inch version

| CW | DC | CDX | SSC | CZCMS | CNSC | | Ordering code | Dimensions, inch DCONMS | LF | LU | PSI | LBS | RPMX | BD | LB | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .079 | 2.480 | .827 | E | 1 | 4 | 4 | AQD-EC063O25-M | 1.000 | 5.118 | .921 | 1015 | 1.51 | 4900 | .748 | .858 | QD-NE-0200-020E-PM |
| .094 | 2.480 | .827 | F | 1 | 4 | 4 | AQD-FC063O25-M | 1.000 | 5.118 | .941 | 1015 | 1.52 | 5600 | .748 | .878 | QD-NF-0239-020E-PM |
| .125 | 2.480 | .827 | G | 1 | 4 | 4 | AQD-GC063O25-M | 1.000 | 5.118 | .957 | 1015 | 1.53 | 6900 | .748 | .894 | QD-NG-0318-020E-PM |
| .157 | 2.992 | .965 | H | 1 1/4 | 4 | 4 | AQD-HC076O31-M | 1.250 | 5.118 | 1.012 | 1015 | 2.25 | 5100 | .984 | .933 | QD-NH-0400-025E-PM |
| .187 | 2.992 | 1.024 | J | 1 1/4 | 4 | 4 | AQD-JC076O31-M | 1.250 | 5.118 | 1.051 | 1015 | 2.23 | 4300 | .866 | .972 | QD-NJ-0476-030E-PM |
| .250 | 2.992 | 1.024 | K | 1 1/4 | 4 | 4 | AQD-KC076O31-M | 1.250 | 5.118 | 1.091 | 1015 | 2.44 | 4400 | .866 | 1.012 | QD-NK-0635-035E-PM |

| Spare parts |
|---|
| Coolant plug |
| 5643 028-02 |

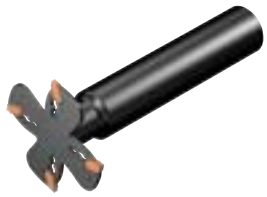
For the complete list of spare parts, visit www.sandvik.coromant.com

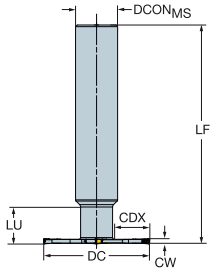
I198 L2 N22 N6 N15

# CoroMill® QD indexable grooving and parting off cutter

**Cylindrical shank**

KAPR 90°






## Metric version

| CW | DC | CDX | SSC | CZCMS | | Ordering code | Dimensions, mm DCONMS | 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 |

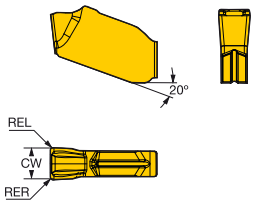
## Inch version

| CW | DC | CDX | SSC | CZCMS | | Ordering code | Dimensions, inch DCONMS | LF | LU | LBS | RPMX | BD | LB | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .079 | 2.480 | .827 | E | 1 | 4 | AQD-E-063O25-M | 1.000 | 5.118 | .921 | 1.54 | 4900 | .748 | .858 | QD-NE-0200-020E-PM |
| .094 | 2.480 | .827 | F | 1 | 4 | AQD-F-063O25-M | 1.000 | 5.118 | .941 | 1.55 | 5600 | .748 | .878 | QD-NF-0239-020E-PM |
| .125 | 2.480 | .827 | G | 1 | 4 | AQD-G-063O25-M | 1.000 | 5.118 | .957 | 1.56 | 6900 | .748 | .894 | QD-NG-0318-020E-PM |
| .157 | 2.992 | .965 | H | 1 1/4 | 4 | AQD-H-076O31-M | 1.250 | 5.118 | 1.012 | 2.29 | 5100 | .984 | .933 | QD-NH-0400-025E-PM |
| .187 | 2.992 | 1.024 | J | 1 1/4 | 4 | AQD-J-076O31-M | 1.250 | 5.118 | 1.051 | 2.26 | 4300 | .866 | .972 | QD-NJ-0476-030E-PM |
| .250 | 2.992 | 1.024 | K | 1 1/4 | 4 | AQD-K-076O31-M | 1.250 | 5.118 | 1.091 | 2.28 | 4400 | .866 | 1.012 | QD-NK-0635-035E-PM |

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

I198 L2 N22 N6 N15

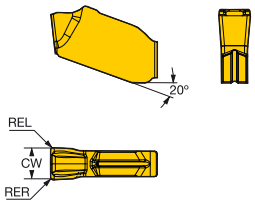
# CoroMill® QD insert for grooving




| | SSC | CW | REL | RER | Ordering code | P | | M | | | K | | N | | S | | | | H | Dimensions, mm, inch | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | 1130 | 4340 | 1040 | 2040 | S30T | 1020 | 3330 | 1130 | H13A | 1130 | H13A | S30T | S40T | 1130 | AN | CWTOLL | CWTOLU |
| Light | E | 2.00 | 0.10 | 0.10 | QD-NE-0200-010E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | .079 | .004 | .004 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | .079 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .079 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .079 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | .079 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | F | 2.39 | 0.10 | 0.10 | QD-NF-0239-010E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | .094 | .004 | .004 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | .094 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .094 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .094 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | .094 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.50 | 0.10 | 0.10 | QD-NF-0250-010E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | .098 | .004 | .004 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.50 | 0.20 | 0.20 | QD-NF-0250-020E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | .098 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.50 | 0.20 | 0.20 | QD-NF-0250-020E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .098 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.50 | 0.20 | 0.20 | QD-NF-0250-020E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .098 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.50 | 0.20 | 0.20 | QD-NF-0250-020E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | .098 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | G | 3.00 | 0.10 | 0.10 | QD-NG-0300-010E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | .118 | .004 | .004 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | .118 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .118 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .118 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | .118 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.18 | 0.10 | 0.10 | QD-NG-0318-010E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | .125 | .004 | .004 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | .125 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .125 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .125 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | .125 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | H | 4.00 | 0.15 | 0.15 | QD-NH-0400-015E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | .157 | .006 | .006 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | .157 | .010 | .010 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .157 | .010 | .010 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .157 | .010 | .010 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | .157 | .010 | .010 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |

I192 I222 I254 N22 N6 N10

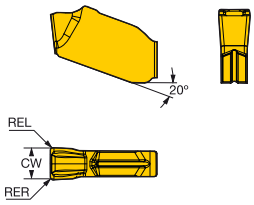
# CoroMill® QD insert for grooving




| | SSC | CW | REL | RER | Ordering code | P 1130 | P 4340 | M 1040 | M 2040 | M S30T | K 1020 | K 3330 | N 1130 | N H13A | S 1130 | S H13A | S S30T | S S40T | H 1130 | Dimensions, mm, inch AN | CWTOLL | CWTOLU |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Light | J | 4.76 | 0.20 | 0.20 | QD-NJ-0476-020E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | *.187* | *.008* | *.008* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | *.187* | *.012* | *.012* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | *.187* | *.012* | *.012* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | *.187* | *.012* | *.012* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | *.187* | *.012* | *.012* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 5.00 | 0.20 | 0.20 | QD-NJ-0500-020E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | *.197* | *.008* | *.008* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | *.197* | *.012* | *.012* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | *.197* | *.012* | *.012* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | *.197* | *.012* | *.012* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | *.197* | *.012* | *.012* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | K | 6.00 | 0.25 | 0.25 | QD-NK-0600-025E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | *.236* | *.010* | *.010* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | *.236* | *.014* | *.014* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | *.236* | *.014* | *.014* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | *.236* | *.014* | *.014* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | *.236* | *.014* | *.014* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 6.35 | 0.25 | 0.25 | QD-NK-0635-025E-NL | | | | | | | | | ★ | | ☆ | | | | 7° | 0.005 | 0.055 |
| | | *.250* | *.010* | *.010* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-KL | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.055 |
| | | *.250* | *.014* | *.014* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-ML | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | *.250* | *.014* | *.014* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-PL | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | *.250* | *.014* | *.014* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |
| | | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-SL | | | | | ☆ | | | ☆ | | ☆ | | ★ | | ☆ | 7° | 0.005 | 0.055 |
| | | *.250* | *.014* | *.014* | | | | | | | | | | | | | | | | *7°* | *.0002* | *.0022* |

I192 I222 I254 N22 N6 N10

# CoroMill® QD insert for grooving



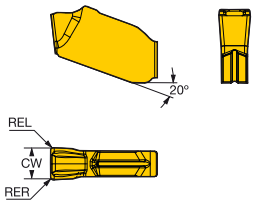

| | SSC | CW | REL | RER | Ordering code | P 1130 | P 4340 | M 1040 | M 2040 | M S30T | K 1020 | K 3330 | N 1130 | N H13A | S 1130 | S H13A | S S30T | S S40T | H 1130 | Dimensions, mm, inch AN | CWTOLL | CWTOLU |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Medium | E | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .079 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .079 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.00 | 0.20 | 0.20 | QD-NE-0200-020E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .079 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.00 | 0.20 | 0.20 | QD-NE-0200-020M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .079 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 2.00 | 0.35 | 0.35 | QD-NE-0200-035M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .079 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | F | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .094 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .094 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .094 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.39 | 0.20 | 0.20 | QD-NF-0239-020M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .094 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 2.39 | 0.35 | 0.35 | QD-NF-0239-035M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .094 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 2.50 | 0.20 | 0.20 | QD-NF-0250-020E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .098 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.50 | 0.20 | 0.20 | QD-NF-0250-020E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .098 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.50 | 0.20 | 0.20 | QD-NF-0250-020E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .098 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 2.50 | 0.20 | 0.20 | QD-NF-0250-020M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .098 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 2.50 | 0.35 | 0.35 | QD-NF-0250-035M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .098 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | G | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .118 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .118 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.00 | 0.20 | 0.20 | QD-NG-0300-020E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .118 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.00 | 0.20 | 0.20 | QD-NG-0300-020M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .118 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 3.00 | 0.35 | 0.35 | QD-NG-0300-035M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .118 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .125 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .125 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.18 | 0.20 | 0.20 | QD-NG-0318-020E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .125 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 3.18 | 0.20 | 0.20 | QD-NG-0318-020M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .125 | .008 | .008 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 3.18 | 0.35 | 0.35 | QD-NG-0318-035M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .125 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | H | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .157 | .010 | .010 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .157 | .010 | .010 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.00 | 0.25 | 0.25 | QD-NH-0400-025E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .157 | .010 | .010 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.00 | 0.25 | 0.25 | QD-NH-0400-025M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .157 | .010 | .010 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 4.00 | 0.40 | 0.40 | QD-NH-0400-040M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .157 | .016 | .016 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |

I192 I222 I254 N22 N6 N10



SANDVIK Coromant

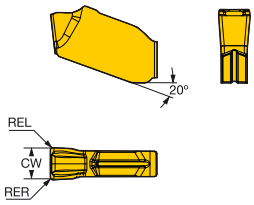
# CoroMill® QD insert for grooving




| | SSC | CW | REL | RER | Ordering code | P 1130 | P 4340 | M 1040 | M 2040 | M S30T | K 1020 | K 3330 | N 1130 | N H13A | S 1130 | S H13A | S S30T | S S40T | H 1130 | Dimensions, mm, inch AN | CWTOLL | CWTOLU |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Medium | J | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .187 | .012 | .012 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .187 | .012 | .012 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .187 | .012 | .012 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 4.76 | 0.30 | 0.30 | QD-NJ-0476-030M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .187 | .012 | .012 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 4.76 | 0.45 | 0.45 | QD-NJ-0476-045M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .187 | .018 | .018 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .197 | .012 | .012 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .197 | .012 | .012 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .197 | .012 | .012 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 5.00 | 0.30 | 0.30 | QD-NJ-0500-030M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .197 | .012 | .012 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 5.00 | 0.45 | 0.45 | QD-NJ-0500-045M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .197 | .018 | .018 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | K | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .236 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .236 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 6.00 | 0.35 | 0.35 | QD-NK-0600-035E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .236 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 6.00 | 0.35 | 0.35 | QD-NK-0600-035M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .236 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 6.00 | 0.50 | 0.50 | QD-NK-0600-050M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .236 | .020 | .020 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-MM | | | ★ | ☆ | | | | | | | | | | | 7° | 0.005 | 0.055 |
| | | .250 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-PM | ★ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.055 |
| | | .250 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 6.35 | 0.35 | 0.35 | QD-NK-0635-035E-SM | | | | | ☆ | | | ☆ | | ☆ | | ★ | ☆ | ☆ | 7° | 0.005 | 0.055 |
| | | .250 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0022 |
| | | 6.35 | 0.35 | 0.35 | QD-NK-0635-035M-PM | ☆ | ☆ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | .250 | .014 | .014 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |
| | | 6.35 | 0.50 | 0.50 | QD-NK-0635-050M-KM | | | | | | ★ | ☆ | | | | | | | | 7° | 0.005 | 0.105 |
| | | .250 | .020 | .020 | | | | | | | | | | | | | | | | 7° | .0002 | .0041 |

I192 I222 I254 N22 N6 N10

# CoroMill® QD insert for grooving




| | SSC | CW | REL | RER | Ordering code | P | | M | | | K | | N | | S | | | | H | Dimensions, mm, inch | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | 1130 | 4340 | 1040 | 2040 | S30T | 1020 | 3330 | 1130 | H13A | 1130 | H13A | S30T | S40T | 1130 | AN | CWTOLL | CWTOLU |
| Heavy | E | 2.00 | 0.35 | 0.35 | QD-NE-0200-035M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.079* | *.014* | *.014* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |
| | F | 2.39 | 0.35 | 0.35 | QD-NF-0239-035M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.094* | *.014* | *.014* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |
| | | 2.50 | 0.35 | 0.35 | QD-NF-0250-035M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.098* | *.014* | *.014* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |
| | G | 3.00 | 0.35 | 0.35 | QD-NG-0300-035M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.118* | *.014* | *.014* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |
| | | 3.18 | 0.35 | 0.35 | QD-NG-0318-035M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.125* | *.014* | *.014* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |
| | H | 4.00 | 0.40 | 0.40 | QD-NH-0400-040M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.157* | *.016* | *.016* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |
| | J | 4.76 | 0.45 | 0.45 | QD-NJ-0476-045M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.187* | *.018* | *.018* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |
| | | 5.00 | 0.45 | 0.45 | QD-NJ-0500-045M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.197* | *.018* | *.018* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |
| | K | 6.00 | 0.50 | 0.50 | QD-NK-0600-050M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.236* | *.020* | *.020* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |
| | | 6.35 | 0.50 | 0.50 | QD-NK-0635-050M-PH | ☆ | ★ | | | | | | ☆ | | ☆ | | | | ☆ | 7° | 0.005 | 0.105 |
| | | *.250* | *.020* | *.020* | | | | | | | | | | | | | | | | 7° | *.0002* | *.0041* |

I192 I222 I254 N22 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 program 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

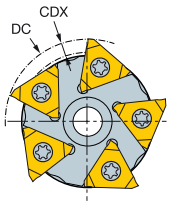
Thread milling

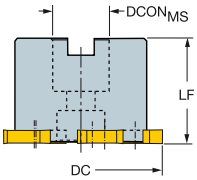
I204 I207

# CoroMill® 328 groove milling cutter

**Arbor**

STDNO ISO 6462:2011
KAPR 90°




## Metric version

| 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 |

## Inch version

| CW | DC | CDX | | CZC$_{MS}$ | | Ordering code | Dimensions, inch DCON$_{MS}$ | ISO | LF | DHUB | FT/LBS | LBS | RPMX | BD | LB | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .051 | 2.480 | .197 | 13 | 3/4 | 5 | **A328-063Q19-13M** | .750 | A | 1.575 | 2.008 | 4.7 | 1.77 | 11900 | 2.008 | 1.575 | 328R13-130 00-GM |

| Spare parts |
|---|
| Insert screw |
| 5513 039-05 |

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

I207 L2 M1 N22 N12

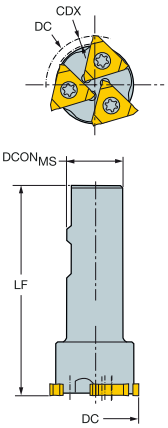


SANDVIK Coromant

# CoroMill® 328 groove milling cutter

**Weldon**

KAPR 90°




## Metric version

| 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 |

## Inch version

| CW | DC | CDX | | $CZC_{MS}$ | | Ordering code | Dimensions, inch $DCON_{MS}$ | ISO | LF | FT/LBS | LBS | RPMX | BD | LB | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .051 | 1.535 | .118 | 13 | 3/4 | 2 | **A328-039B19-13M** | .750 | WE | 4.921 | 4.7 | 0.94 | 19300 | 1.260 | 2.921 | 328R13-130 00-GM |
| | 1.732 | .157 | 13 | 3/4 | 3 | **A328-044B19-13M** | .750 | WE | 4.921 | 4.7 | 1.09 | 17100 | 1.339 | 2.921 | 328R13-130 00-GM |

| Spare parts |
|---|
| Insert screw |
| 5513 039-05 |

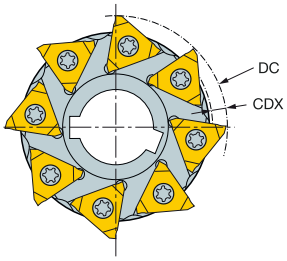
For the complete list of spare parts, visit www.sandvik.coromant.com

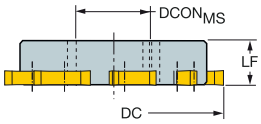
I207 L2 N22 N12

# CoroMill® 328 groove milling cutter

**Bore with keyway**

KAPR 90°




**Metric version**

| 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 the complete list of spare parts, visit www.sandvik.coromant.com

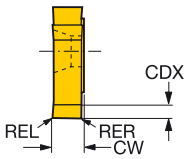
I207 L2 N22 N12



SANDVIK Coromant

# CoroMill® 328 insert for groove milling

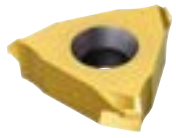
## For circlip grooves

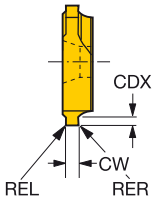



## For circlip grooves

| | | CW | REL | RER | CDX | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | H 1025 | AN | CWTOLL | CWTOLU | RETOLL | RETOLU |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Dimensions, mm, inch | | | | | | | | | | |
| Medium | 13 | 1.30 | 0.10 | 0.10 | 5.00 | 328R13-130 00-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.051* | *.004* | *.004* | *.197* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 1.60 | 0.10 | 0.10 | 5.00 | 328R13-160 00-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.063* | *.004* | *.004* | *.197* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 1.85 | 0.15 | 0.15 | 5.00 | 328R13-185 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.073* | *.006* | *.006* | *.197* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 2.15 | 0.15 | 0.15 | 5.00 | 328R13-215 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.085* | *.006* | *.006* | *.197* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 2.65 | 0.15 | 0.15 | 5.00 | 328R13-265 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.104* | *.006* | *.006* | *.197* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 3.15 | 0.15 | 0.15 | 5.00 | 328R13-315 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.124* | *.006* | *.006* | *.197* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 4.15 | 0.15 | 0.15 | 5.00 | 328R13-415 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.163* | *.006* | *.006* | *.197* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 5.15 | 0.15 | 0.15 | 5.00 | 328R13-515 02-GM | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.203* | *.006* | *.006* | *.197* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |

## For circlip grooves and chamfering






| | | CW | REL | RER | CDX | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | H 1025 | AN | CWTOLL | CWTOLU | RETOLL | RETOLU |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Dimensions, mm, inch | | | | | | | | | | |
| Medium | 13 | 1.85 | 0.15 | 0.15 | 1.25 | 328R13-185 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.073* | *.006* | *.006* | *.049* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 2.15 | 0.15 | 0.15 | 1.50 | 328R13-215 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.085* | *.006* | *.006* | *.059* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 2.65 | 0.15 | 0.15 | 1.50 | 328R13-265 4515-GC | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.104* | *.006* | *.006* | *.059* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 2.65 | 0.15 | 0.15 | 1.75 | 328R13-265 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.104* | *.006* | *.006* | *.069* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 3.15 | 0.15 | 0.15 | 1.75 | 328R13-315 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.124* | *.006* | *.006* | *.069* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 4.15 | 0.15 | 0.15 | 2.00 | 328R13-415 4520-GC | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.163* | *.006* | *.006* | *.079* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 4.15 | 0.15 | 0.15 | 2.50 | 328R13-415 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.163* | *.006* | *.006* | *.098* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |
| | | 5.15 | 0.15 | 0.15 | 3.00 | 328R13-515 45-GC | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 6° | 0.090 | 0.110 | -0.050 | 0.050 |
| | | *.203* | *.006* | *.006* | *.118* | | | | | | | | | *.0035* | *.0043* | *-.0020* | *.0020* |

I204 I222 I254 N22 N12

# 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 program with different shank lengths and diameters
- Large program of inserts covering, for instance, circlips, o-rings, slots and threads
- Secure locking of insert
- Through coolant
- Different thread pitches possible with one tool

www.sandvik.coromant.com/coromill327

### 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

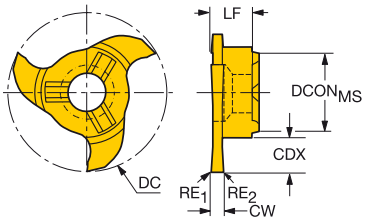
I209

L2



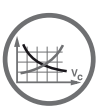
SANDVIK Coromant

# CoroMill® 327 solid-carbide head for grooving




| | | | | | | | P | M | K | N | S | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| CW | $RE_1$ | $RE_2$ | $CZC_{MS}$ | CDX | ZEFP | Ordering code | 1025 | 1025 | 1025 | 1025 | 1025 | $DCON_{MS}$ | DC | LF | CWTOLL | CWTOLU | RPMX |
| 1.00 | 0.00 | 0.00 | 6.0 | 1.5 | 3 | 327R06-10 10000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.000 | 0.020 | 50000 |
| .039 | .000 | .000 | | .059 | | | | | | | | .236 | .382 | .138 | .0000 | .0008 | |
| 1.50 | 0.20 | 0.20 | | 1.5 | 3 | 327R06-10 15002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.000 | 0.020 | 50000 |
| .059 | .008 | .008 | | .059 | | | | | | | | .236 | .382 | .138 | .0000 | .0008 | |
| 2.00 | 0.20 | 0.20 | | 1.5 | 3 | 327R06-10 20002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.000 | 0.020 | 50000 |
| .079 | .008 | .008 | | .059 | | | | | | | | .236 | .382 | .138 | .0000 | .0008 | |
| 2.50 | 0.20 | 0.20 | | 1.5 | 3 | 327R06-10 25002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.000 | 0.020 | 50000 |
| .098 | .008 | .008 | | .059 | | | | | | | | .236 | .382 | .138 | .0000 | .0008 | |
| 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 |
| .059 | .004 | .004 | | .138 | | | | | | | | .354 | .697 | .226 | .0000 | .0008 | |
| 1.50 | 0.20 | 0.20 | | 3.5 | 3 | 327R09-18 15002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| .059 | .008 | .008 | | .138 | | | | | | | | .354 | .697 | .226 | .0000 | .0008 | |
| 2.00 | 0.20 | 0.20 | | 3.5 | 3 | 327R09-18 20002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| .079 | .008 | .008 | | .138 | | | | | | | | .354 | .697 | .226 | .0000 | .0008 | |
| 2.00 | 0.20 | 0.20 | | 3.5 | 6 | 327R09-18 20002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| .079 | .008 | .008 | | .138 | | | | | | | | .354 | .697 | .226 | .0000 | .0008 | |
| 2.50 | 0.20 | 0.20 | | 3.5 | 3 | 327R09-18 25002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| .098 | .008 | .008 | | .138 | | | | | | | | .354 | .697 | .226 | .0000 | .0008 | |
| 2.50 | 0.20 | 0.20 | | 3.5 | 6 | 327R09-18 25002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| .098 | .008 | .008 | | .138 | | | | | | | | .354 | .697 | .226 | .0000 | .0008 | |
| 3.00 | 0.20 | 0.20 | | 3.5 | 3 | 327R09-18 30002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| .118 | .008 | .008 | | .138 | | | | | | | | .354 | .697 | .226 | .0000 | .0008 | |
| 3.00 | 0.20 | 0.20 | | 3.5 | 6 | 327R09-18 30002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.000 | 0.020 | 50000 |
| .118 | .008 | .008 | | .138 | | | | | | | | .354 | .697 | .226 | .0000 | .0008 | |
| 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 |
| .059 | .008 | .008 | | .177 | | | | | | | | .472 | .854 | .224 | .0000 | .0008 | |
| 2.00 | 0.20 | 0.20 | | 4.5 | 3 | 327R12-22 20002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.000 | 0.020 | 50000 |
| .079 | .008 | .008 | | .177 | | | | | | | | .472 | .854 | .224 | .0000 | .0008 | |
| 2.50 | 0.20 | 0.20 | | 4.5 | 3 | 327R12-22 25002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.000 | 0.020 | 50000 |
| .098 | .008 | .008 | | .177 | | | | | | | | .472 | .854 | .224 | .0000 | .0008 | |
| 3.00 | 0.20 | 0.20 | | 4.5 | 3 | 327R12-22 30002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.000 | 0.020 | 50000 |
| .118 | .008 | .008 | | .177 | | | | | | | | .472 | .854 | .224 | .0000 | .0008 | |
| 4.00 | 0.20 | 0.20 | | 4.5 | 3 | 327R12-22 40002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.000 | 0.020 | 50000 |
| .157 | .008 | .008 | | .177 | | | | | | | | .472 | .854 | .224 | .0000 | .0008 | |
| 1.50 | 0.10 | 0.10 | | 6.5 | 6 | 327R12-28 15001-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.45 | 0.000 | 0.020 | 50000 |
| .059 | .004 | .004 | | .256 | | | | | | | | .472 | 1.091 | .254 | .0000 | .0008 | |
| 2.00 | 0.20 | 0.20 | | 6.4 | 6 | 327R12-28 20002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.40 | 0.000 | 0.020 | 50000 |
| .079 | .008 | .008 | | .252 | | | | | | | | .472 | 1.091 | .252 | .0000 | .0008 | |
| 2.50 | 0.20 | 0.20 | | 6.5 | 6 | 327R12-28 25002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.25 | 0.000 | 0.020 | 50000 |
| .098 | .008 | .008 | | .256 | | | | | | | | .472 | 1.091 | .246 | .0000 | .0008 | |
| 3.00 | 0.20 | 0.20 | | 6.5 | 6 | 327R12-28 30002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.25 | 0.000 | 0.020 | 50000 |
| .118 | .008 | .008 | | .256 | | | | | | | | .472 | 1.091 | .246 | .0000 | .0008 | |
| 4.00 | 0.20 | 0.20 | | 6.5 | 6 | 327R12-28 40002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 27.70 | 6.25 | 0.000 | 0.020 | 50000 |
| .157 | .008 | .008 | | .256 | | | | | | | | .472 | 1.091 | .246 | .0000 | .0008 | |
| 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 |
| .059 | .000 | .000 | | .256 | | | | | | | | .563 | 1.091 | .256 | .0000 | .0008 | |
| 2.00 | 0.20 | 0.20 | | 6.5 | 3 | 327R14-28 20002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| .079 | .008 | .008 | | .256 | | | | | | | | .563 | 1.091 | .256 | .0000 | .0008 | |
| 2.50 | 0.20 | 0.20 | | 6.5 | 3 | 327R14-28 25002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| .098 | .008 | .008 | | .256 | | | | | | | | .563 | 1.091 | .256 | .0000 | .0008 | |
| 3.00 | 0.20 | 0.20 | | 6.5 | 3 | 327R14-28 30002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| .118 | .008 | .008 | | .256 | | | | | | | | .563 | 1.091 | .256 | .0000 | .0008 | |
| 3.50 | 0.20 | 0.20 | | 6.5 | 3 | 327R14-28 35002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| .138 | .008 | .008 | | .256 | | | | | | | | .563 | 1.091 | .256 | .0000 | .0008 | |
| 4.00 | 0.20 | 0.20 | | 6.5 | 3 | 327R14-28 40002-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 27.70 | 6.50 | 0.000 | 0.020 | 50000 |
| .157 | .008 | .008 | | .256 | | | | | | | | .563 | 1.091 | .256 | .0000 | .0008 | |

L2

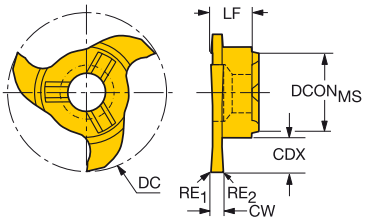

I222

I254

N22

N11

# CoroMill® 327 solid-carbide head for grooving



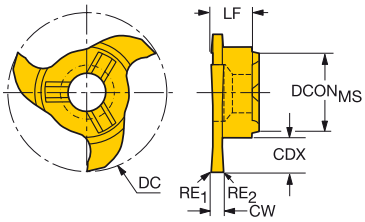

| CW | RE1 | RE2 | CZCMS | CDX | ZEFP | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | Dimensions, mm, inch DCONMS | DC | LF | CWTOLL | CWTOLU | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.50 | 0.10 | 0.10 | 14.0 | 10.0 | 6 | 327R14-35 15001-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 34.70 | 6.25 | 0.000 | 0.020 | 50000 |
| *.059* | *.004* | *.004* | | *.394* | | | | | | | | *.563* | *1.366* | *.246* | *.0000* | *.0008* | |
| 2.00 | 0.20 | 0.20 | | 10.0 | 6 | 327R14-35 20002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 34.70 | 6.25 | 0.000 | 0.020 | 50000 |
| *.079* | *.008* | *.008* | | *.394* | | | | | | | | *.563* | *1.366* | *.246* | *.0000* | *.0008* | |
| 2.50 | 0.20 | 0.20 | | 10.0 | 6 | 327R14-35 25002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 34.70 | 6.25 | 0.000 | 0.020 | 50000 |
| *.098* | *.008* | *.008* | | *.394* | | | | | | | | *.563* | *1.366* | *.246* | *.0000* | *.0008* | |
| 3.00 | 0.20 | 0.20 | | 10.0 | 6 | 327R14-35 30002-GMM | ☆ | ☆ | ☆ | ☆ | ☆ | 14.30 | 34.70 | 6.25 | 0.000 | 0.020 | 50000 |
| *.118* | *.008* | *.008* | | *.394* | | | | | | | | *.563* | *1.366* | *.246* | *.0000* | *.0008* | |

L2 I222 I254 N22 N11



SANDVIK Coromant

# CoroMill® 327 solid-carbide head for grooving

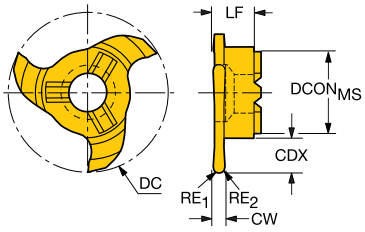



## For circlip grooves

| | | | | | | | P | M | K | N | S | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| CW | $RE_1$ | $RE_2$ | $CZC_{MS}$ | CDX | ZEFP | Ordering code | 1025 | 1025 | 1025 | 1025 | 1025 | $DCON_{MS}$ | DC | LF | CWTOLL | CWTOLU | RPMX |
| 0.70 | 0.00 | 0.00 | 6.0 | 1.5 | 3 | 327R06-10 07000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.050 | 0.070 | 50000 |
| *.028* | *.000* | *.000* | | *.059* | | | | | | | | *.236* | *.382* | *.138* | *.0020* | *.0028* | |
| 0.80 | 0.00 | 0.00 | | 1.5 | 3 | 327R06-10 08000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.050 | 0.070 | 50000 |
| *.031* | *.000* | *.000* | | *.059* | | | | | | | | *.236* | *.382* | *.138* | *.0020* | *.0028* | |
| 0.90 | 0.00 | 0.00 | | 1.5 | 3 | 327R06-10 09000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.050 | 0.070 | 50000 |
| *.035* | *.000* | *.000* | | *.059* | | | | | | | | *.236* | *.382* | *.138* | *.0020* | *.0028* | |
| 1.10 | 0.00 | 0.00 | | 1.5 | 3 | 327R06-10 11000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.090 | 0.110 | 50000 |
| *.043* | *.000* | *.000* | | *.059* | | | | | | | | *.236* | *.382* | *.138* | *.0035* | *.0043* | |
| 1.30 | 0.00 | 0.00 | | 1.5 | 3 | 327R06-10 13000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.090 | 0.110 | 50000 |
| *.051* | *.000* | *.000* | | *.059* | | | | | | | | *.236* | *.382* | *.138* | *.0035* | *.0043* | |
| 1.60 | 0.00 | 0.00 | | 1.5 | 3 | 327R06-10 16000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 9.70 | 3.50 | 0.090 | 0.110 | 50000 |
| *.063* | *.000* | *.000* | | *.059* | | | | | | | | *.236* | *.382* | *.138* | *.0035* | *.0043* | |
| 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 |
| *.043* | *.000* | *.000* | | *.138* | | | | | | | | *.354* | *.697* | *.226* | *.0035* | *.0043* | |
| 1.30 | 0.00 | 0.00 | | 3.5 | 3 | 327R09-18 13000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.090 | 0.110 | 50000 |
| *.051* | *.000* | *.000* | | *.138* | | | | | | | | *.354* | *.697* | *.226* | *.0035* | *.0043* | |
| 1.60 | 0.00 | 0.00 | | 3.5 | 3 | 327R09-18 16000-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 17.70 | 5.75 | 0.090 | 0.110 | 50000 |
| *.063* | *.000* | *.000* | | *.138* | | | | | | | | *.354* | *.697* | *.226* | *.0035* | *.0043* | |
| 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 |
| *.063* | *.000* | *.000* | | *.177* | | | | | | | | *.472* | *.854* | *.224* | *.0035* | *.0043* | |
| 1.85 | 0.15 | 0.15 | | 4.5 | 3 | 327R12-22 18502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| *.073* | *.006* | *.006* | | *.177* | | | | | | | | *.472* | *.854* | *.224* | *.0035* | *.0043* | |
| 2.15 | 0.20 | 0.20 | | 4.5 | 3 | 327R12-22 21502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| *.085* | *.008* | *.008* | | *.177* | | | | | | | | *.472* | *.854* | *.224* | *.0035* | *.0043* | |
| 2.65 | 0.15 | 0.15 | | 4.5 | 3 | 327R12-22 26502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| *.104* | *.006* | *.006* | | *.177* | | | | | | | | *.472* | *.854* | *.224* | *.0035* | *.0043* | |
| 3.15 | 0.15 | 0.15 | | 4.5 | 3 | 327R12-22 31502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| *.124* | *.006* | *.006* | | *.177* | | | | | | | | *.472* | *.854* | *.224* | *.0035* | *.0043* | |
| 4.15 | 0.15 | 0.15 | | 4.5 | 3 | 327R12-22 41502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| *.163* | *.006* | *.006* | | *.177* | | | | | | | | *.472* | *.854* | *.224* | *.0035* | *.0043* | |
| 5.15 | 0.15 | 0.15 | | 4.5 | 3 | 327R12-22 51502-GM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.70 | 0.090 | 0.110 | 50000 |
| *.203* | *.006* | *.006* | | *.177* | | | | | | | | *.472* | *.854* | *.224* | *.0035* | *.0043* | |

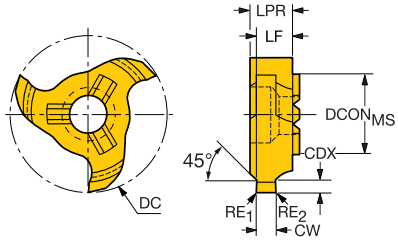
L2 I222 I254 N22 N11

# CoroMill® 327 solid-carbide head for grooving




## For full radius grooves

| CW | RE1 | RE2 | CZCMS | CDX | ZEFP | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | Dimensions, mm, inch DCONMS | DC | LF | CWTOLL | CWTOLU | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.20 | 1.10 | 1.10 | 6.0 | 2.5 | 3 | 327R06-12 22011-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 11.70 | 3.50 | 0.000 | 0.030 | 50000 |
| *.087* | *.043* | *.043* | | *.098* | | | | | | | | *.236* | *.461* | *.138* | *.0000* | *.0012* | |
| 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 |
| *.087* | *.043* | *.043* | | *.138* | | | | | | | | *.354* | *.697* | *.226* | *.0000* | *.0012* | |
| 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 |
| *.039* | *.020* | *.020* | | *.177* | | | | | | | | *.472* | *.854* | *.226* | *.0000* | *.0012* | |
| 2.00 | 1.00 | 1.00 | | 4.5 | 3 | 327R12-22 20010-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.75 | 0.000 | 0.030 | 50000 |
| *.079* | *.039* | *.039* | | *.177* | | | | | | | | *.472* | *.854* | *.226* | *.0000* | *.0012* | |
| 3.00 | 1.50 | 1.50 | | 4.5 | 3 | 327R12-22 30015-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.75 | 0.000 | 0.030 | 50000 |
| *.118* | *.059* | *.059* | | *.177* | | | | | | | | *.472* | *.854* | *.226* | *.0000* | *.0012* | |
| 4.00 | 2.00 | 2.00 | | 4.5 | 3 | 327R12-22 40020-RM | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.75 | 0.000 | 0.030 | 50000 |
| *.157* | *.079* | *.079* | | *.177* | | | | | | | | *.472* | *.854* | *.226* | *.0000* | *.0012* | |




## Circlip grooves with chamfer

| CW | RE1 | RE2 | CZCMS | CDX | ZEFP | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | Dimensions, mm, inch DCONMS | DC | LF | LPR | CWTOLL | CWTOLU | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.10 | 0.00 | 0.00 | 12.0 | 0.5 | 3 | 327R12-22 11045-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| *.043* | *.000* | *.000* | | *.020* | | | | | | | | *.472* | *.854* | *.197* | *.228* | *.0035* | *.0043* | |
| 1.30 | 0.00 | 0.00 | | 0.7 | 3 | 327R12-22 13045-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.20 | 5.80 | 0.090 | 0.110 | 50000 |
| *.051* | *.000* | *.000* | | *.026* | | | | | | | | *.472* | *.854* | *.205* | *.228* | *.0035* | *.0043* | |
| 1.60 | 0.00 | 0.00 | | 1.0 | 3 | 327R12-22 16045-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| *.063* | *.000* | *.000* | | *.039* | | | | | | | | *.472* | *.854* | *.197* | *.228* | *.0035* | *.0043* | |
| 1.85 | 0.15 | 0.15 | | 1.3 | 3 | 327R12-22 18545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.20 | 5.80 | 0.090 | 0.110 | 50000 |
| *.073* | *.006* | *.006* | | *.049* | | | | | | | | *.472* | *.854* | *.205* | *.228* | *.0035* | *.0043* | |
| 2.15 | 0.15 | 0.15 | | 1.5 | 3 | 327R12-22 21545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.30 | 5.85 | 0.090 | 0.110 | 50000 |
| *.085* | *.006* | *.006* | | *.059* | | | | | | | | *.472* | *.854* | *.209* | *.230* | *.0035* | *.0043* | |
| 2.65 | 0.15 | 0.15 | | 1.5 | 3 | 327R12-22 26545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| *.104* | *.006* | *.006* | | *.059* | | | | | | | | *.472* | *.854* | *.197* | *.228* | *.0035* | *.0043* | |
| 3.15 | 0.20 | 0.20 | | 1.8 | 3 | 327R12-22 31545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.30 | 5.80 | 0.090 | 0.110 | 50000 |
| *.124* | *.008* | *.008* | | *.069* | | | | | | | | *.472* | *.854* | *.209* | *.228* | *.0035* | *.0043* | |
| 4.15 | 0.20 | 0.20 | | 2.0 | 3 | 327R12-22 41545-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.30 | 5.85 | 0.090 | 0.110 | 50000 |
| *.163* | *.008* | *.008* | | *.079* | | | | | | | | *.472* | *.854* | *.209* | *.230* | *.0035* | *.0043* | |
| 1.30 | 0.00 | 0.00 | | 0.8 | 3 | 327R12-221304508-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.20 | 5.80 | 0.090 | 0.110 | 50000 |
| *.051* | *.000* | *.000* | | *.031* | | | | | | | | *.472* | *.854* | *.205* | *.228* | *.0035* | *.0043* | |
| 1.60 | 0.00 | 0.00 | | 0.8 | 3 | 327R12-221604508-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| *.063* | *.000* | *.000* | | *.031* | | | | | | | | *.472* | *.854* | *.197* | *.228* | *.0035* | *.0043* | |
| 2.65 | 0.15 | 0.15 | | 1.8 | 3 | 327R12-222654518-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.00 | 5.80 | 0.090 | 0.110 | 50000 |
| *.104* | *.006* | *.006* | | *.071* | | | | | | | | *.472* | *.854* | *.197* | *.228* | *.0035* | *.0043* | |
| 4.15 | 0.20 | 0.20 | | 2.5 | 3 | 327R12-224154525-GC | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 21.70 | 5.30 | 5.85 | 0.090 | 0.110 | 50000 |
| *.163* | *.008* | *.008* | | *.098* | | | | | | | | *.472* | *.854* | *.209* | *.230* | *.0035* | *.0043* | |

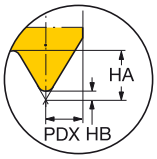
L2 I222 I254 N22 N11

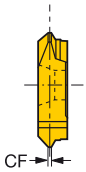


SANDVIK Coromant

# CoroMill® 328 insert for thread milling

**For internal threads**




## Metric 60° Topping

| SSC | TP | NT | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | H 1025 | Dimensions, mm, inch CF | HA | HB | PDX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 13 | 1.50 | 1 | 328R13-150 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.2 | 0.97 | 0.16 | 0.85 |
| | .059 | | | | | | | | | .007 | .0382 | .0063 | .033 |
| | 2.00 | 1 | 328R13-200 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.3 | 1.30 | 0.22 | 1.05 |
| | .079 | | | | | | | | | .010 | .0512 | .0087 | .041 |
| | 3.00 | 1 | 328R13-300 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.4 | 1.95 | 0.32 | 1.35 |
| | .118 | | | | | | | | | .015 | .0768 | .0126 | .053 |
| | 3.50 | 1 | 328R13-350 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.4 | 2.27 | 0.38 | 1.55 |
| | .138 | | | | | | | | | .017 | .0894 | .0150 | .061 |
| | 4.00 | 1 | 328R13-400 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.5 | 2.60 | 0.43 | 1.75 |
| | .157 | | | | | | | | | .020 | .1024 | .0169 | .069 |
| | 4.50 | 1 | 328R13-450 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.6 | 2.92 | 0.49 | 1.95 |
| | .177 | | | | | | | | | .022 | .1150 | .0193 | .077 |
| | 5.00 | 1 | 328R13-500 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.6 | 3.25 | 0.54 | 2.05 |
| | .197 | | | | | | | | | .025 | .1280 | .0213 | .081 |
| | 5.50 | 1 | 328R13-550 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.7 | 3.57 | 0.60 | 2.30 |
| | .217 | | | | | | | | | .027 | .1406 | .0236 | .091 |
| | 6.00 | 1 | 328R13-600 MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.8 | 3.90 | 0.65 | 2.45 |
| | .236 | | | | | | | | | .030 | .1535 | .0256 | .096 |

## UN 60° Full form

| SSC | TPI | NT | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | H 1025 | Dimensions, mm, inch CF | HA | HB | PDX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 13 | 16.0 | 1 | 328R13-16 UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.2 | 1.02 | 0.16 | 0.80 |
| | | | | | | | | | | .008 | .0402 | .0063 | .031 |
| | 12.0 | 1 | 328R13-12 UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.3 | 1.38 | 0.23 | 1.00 |
| | | | | | | | | | | .010 | .0543 | .0091 | .039 |
| | 8.0 | 1 | 328R13-08 UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.4 | 2.06 | 0.34 | 1.40 |
| | | | | | | | | | | .016 | .0811 | .0134 | .055 |
| | 4.0 | 1 | 328R13-04 UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.8 | 4.12 | 0.68 | 2.55 |
| | | | | | | | | | | .031 | .1622 | .0268 | .100 |

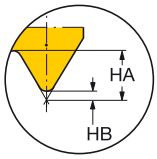
## 60° V-profile

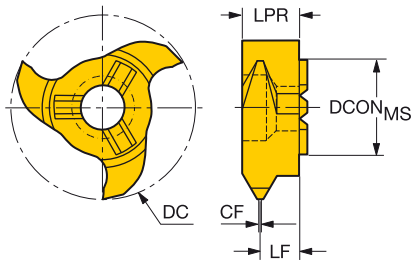
| SSC | TPN | TPX | TPIN | TPIX | NT | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | H 1025 | Dimensions, mm, inch CF | HA | HB | PDX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 13 | 1.5 | 3.5 | 7.0 | 16.0 | 1 | 328R13-150 VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.2 | 2.31 | 0.13 | 1.95 |
| | | | | | | | | | | | | | .007 | .0909 | .0051 | .077 |
| | 4.0 | 6.0 | 4.0 | 6.0 | 1 | 328R13-400 VM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 0.5 | 4.06 | 0.41 | 2.60 |
| | | | | | | | | | | | | | .020 | .1598 | .0161 | .102 |

I204 I222 I254 N22 N12

# CoroMill® 327 solid-carbide head for thread milling

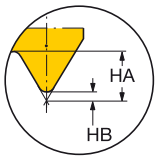
**For internal threads**

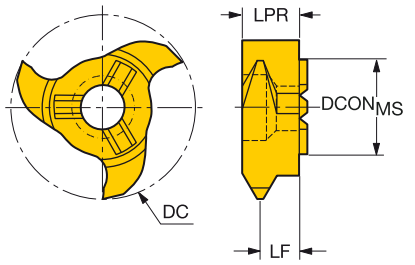



## V-profile 60° Non-topping

| TPN | TPX | TPIN | TPIX | $D_c$ | $CZC_{MS}$ | ZEFP | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | $DCON_{MS}$ | 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 |
| | | | | *.461* | | | | | | | | | *.236* | *.005* | *.054* | *.004* | *.110* | *.142* |
| 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 |
| | | | | *.697* | | | | | | | | | *.354* | *.005* | *.051* | *.004* | *.185* | *.230* |
| 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 |
| | | | | *.697* | | | | | | | | | *.354* | *.005* | *.051* | *.004* | *.197* | *.230* |
| 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 | 4.60 | 5.80 |
| | | | | *.854* | | | | | | | | | *.472* | *.005* | *.051* | *.004* | *.181* | *.228* |
| 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 | 5.10 | 6.35 |
| | | | | *.854* | | | | | | | | | *.472* | *.005* | *.051* | *.004* | *.201* | *.250* |
| 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 |
| | | | | *.461* | | | | | | | | | *.236* | *.012* | *.079* | *.009* | *.087* | *.142* |
| 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 |
| | | | | *.697* | | | | | | | | | *.354* | *.012* | *.113* | *.009* | *.165* | *.230* |
| 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 |
| | | | | *.697* | | | | | | | | | *.354* | *.012* | *.113* | *.009* | *.169* | *.230* |
| 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 | 3.70 | 5.60 |
| | | | | *.854* | | | | | | | | | *.472* | *.012* | *.115* | *.009* | *.146* | *.220* |
| 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 | 4.20 | 6.05 |
| | | | | *.854* | | | | | | | | | *.472* | *.012* | *.115* | *.009* | *.165* | *.238* |




## Whitworth 55° Full form

| TPI | DC | $CZC_{MS}$ | ZEFP | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | $DCON_{MS}$ | HA | HB | LF | LPR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 19 | 11.70 | 6.0 | 3 | 327R06-12 19WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 1.07 | 0.21 | 2.5 | 3.60 |
| | *.461* | | | | | | | | | | *.042* | *.008* | *.098* | *.142* |
| 19 | 17.70 | 9.0 | 3 | 327R09-18 19WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.07 | 0.21 | 4.9 | 5.85 |
| | *.697* | | | | | | | | | | *.042* | *.008* | *.193* | *.230* |
| 14 | 11.70 | 6.0 | 3 | 327R06-12 14WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 1.45 | 0.29 | 2.3 | 3.60 |
| | *.461* | | | | | | | | | | *.057* | *.011* | *.091* | *.142* |
| 14 | 17.70 | 9.0 | 3 | 327R09-18 14WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.45 | 0.29 | 4.6 | 5.85 |
| | *.697* | | | | | | | | | | *.057* | *.011* | *.181* | *.230* |
| 11 | 11.70 | 6.0 | 3 | 327R06-12 11WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 6.00 | 1.85 | 0.37 | 2.0 | 3.60 |
| | *.461* | | | | | | | | | | *.073* | *.015* | *.079* | *.142* |
| 11 | 17.70 | 9.0 | 3 | 327R09-18 11WH-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.85 | 0.37 | 4.4 | 5.85 |
| | *.697* | | | | | | | | | | *.073* | *.015* | *.173* | *.230* |

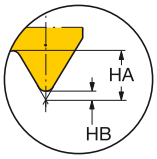
L2 I222 I254 N22 N11

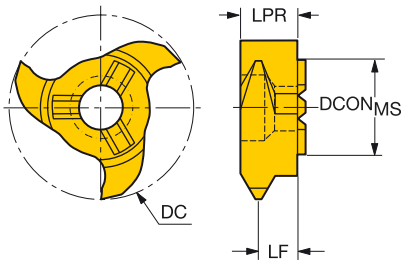


SANDVIK Coromant

# CoroMill® 327 solid-carbide head for thread milling

**For internal threads**



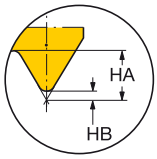

## UN 60° Topping

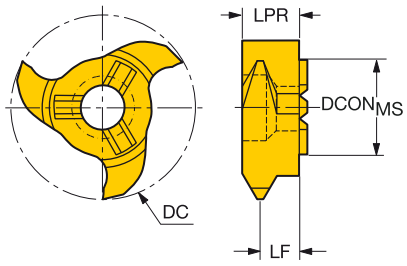
| TPI | $D_c$ | $CZC_{MS}$ | APMX | ZEFP | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | Dimensions, mm, inch $DCON_{MS}$ | HA | HB | LF | LPR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20 | 17.70 | 9.0 | 0.69 | 3 | 327R09-18 20UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.82 | 0.14 | 5.2 | 5.85 |
| | .697 | | | | | | | | | | .354 | .032 | .006 | .205 | .230 |
| 18 | 17.70 | 9.0 | 0.76 | 3 | 327R09-18 18UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.92 | 0.15 | 5.0 | 5.85 |
| | .697 | | | | | | | | | | .354 | .036 | .006 | .197 | .230 |
| 16 | 17.70 | 9.0 | 0.86 | 3 | 327R09-18 16UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.03 | 0.17 | 5.0 | 5.85 |
| | .697 | | | | | | | | | | .354 | .041 | .007 | .197 | .230 |
| 16 | 17.70 | 9.0 | 0.86 | 6 | 327R09-18 16UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.03 | 0.17 | 5.0 | 5.85 |
| | .697 | | | | | | | | | | .354 | .041 | .007 | .197 | .230 |
| 14 | 17.70 | 9.0 | 0.99 | 3 | 327R09-18 14UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.18 | 0.20 | 5.0 | 5.85 |
| | .697 | | | | | | | | | | .354 | .046 | .008 | .197 | .230 |
| 14 | 17.70 | 9.0 | 0.99 | 6 | 327R09-18 14UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.18 | 0.20 | 5.0 | 5.85 |
| | .697 | | | | | | | | | | .354 | .046 | .008 | .197 | .230 |
| 12 | 17.70 | 9.0 | 1.14 | 3 | 327R09-18 12UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.37 | 0.23 | 4.9 | 5.85 |
| | .697 | | | | | | | | | | .354 | .054 | .009 | .193 | .230 |
| 12 | 17.70 | 9.0 | 1.14 | 6 | 327R09-18 12UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.37 | 0.23 | 4.9 | 5.85 |
| | .697 | | | | | | | | | | .354 | .054 | .009 | .193 | .230 |
| 11 | 17.70 | 9.0 | 1.24 | 3 | 327R09-18 11UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.50 | 0.25 | 4.8 | 5.85 |
| | .697 | | | | | | | | | | .354 | .059 | .010 | .189 | .230 |
| 11 | 17.70 | 9.0 | 1.24 | 6 | 327R09-18 11UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.50 | 0.25 | 4.8 | 5.85 |
| | .697 | | | | | | | | | | .354 | .059 | .010 | .189 | .230 |
| 10 | 17.70 | 9.0 | 1.37 | 3 | 327R09-18 10UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.65 | 0.27 | 4.7 | 5.85 |
| | .697 | | | | | | | | | | .354 | .065 | .011 | .185 | .230 |
| 8 | 17.70 | 9.0 | 1.73 | 3 | 327R09-18 08UN-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 2.06 | 0.34 | 4.4 | 5.85 |
| | .697 | | | | | | | | | | .354 | .081 | .013 | .173 | .230 |
| 8 | 17.70 | 9.0 | 1.73 | 6 | 327R09-18 08UN-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 2.06 | 0.34 | 4.4 | 5.85 |
| | .697 | | | | | | | | | | .354 | .081 | .013 | .173 | .230 |

L2 I222 I254 N22 N11

# CoroMill® 327 solid-carbide head for thread milling

**For internal threads**




## Metric 60° Topping

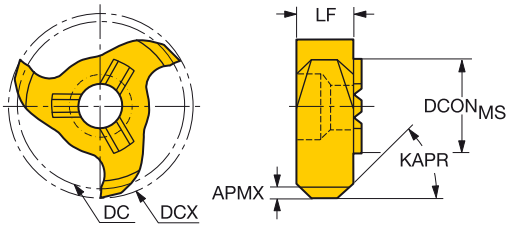
| TP | DC | $CZC_{MS}$ | ZEFP | Ordering code | P 1025 | M 1025 | K 1025 | N 1025 | S 1025 | Dimensions, mm $DCON_{MS}$ | HA | HB | LF | LPR |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.50 | 17.70 | 9.0 | 3 | 327R09-18 150MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.97 | 0.16 | 4.8 | 5.85 |
| .059 | .697 | | | | | | | | | .354 | .038 | .006 | .189 | .230 |
| 1.50 | 17.70 | 9.0 | 6 | 327R09-18 150MM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 0.97 | 0.16 | 5.0 | 5.85 |
| .059 | .697 | | | | | | | | | .354 | .038 | .006 | .197 | .230 |
| 2.00 | 17.70 | 9.0 | 3 | 327R09-18 200MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.30 | 0.22 | 4.6 | 5.85 |
| .079 | .697 | | | | | | | | | .354 | .051 | .009 | .181 | .230 |
| 2.00 | 17.70 | 9.0 | 6 | 327R09-18 200MM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.30 | 0.22 | 4.8 | 5.85 |
| .079 | .697 | | | | | | | | | .354 | .051 | .009 | .189 | .230 |
| 3.00 | 17.70 | 9.0 | 3 | 327R09-18 300MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.95 | 0.32 | 4.3 | 5.85 |
| .118 | .697 | | | | | | | | | .354 | .077 | .013 | .169 | .230 |
| 3.00 | 17.70 | 9.0 | 6 | 327R09-18 300MM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 1.95 | 0.32 | 4.6 | 5.85 |
| .118 | .697 | | | | | | | | | .354 | .077 | .013 | .181 | .230 |
| 3.50 | 17.70 | 9.0 | 3 | 327R09-18 350MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 2.27 | 0.38 | 4.0 | 5.85 |
| .138 | .697 | | | | | | | | | .354 | .089 | .015 | .157 | .230 |
| 3.50 | 17.70 | 9.0 | 6 | 327R09-18 350MM-THM | ☆ | ☆ | ☆ | ☆ | ☆ | 9.00 | 2.27 | 0.38 | 4.0 | 5.85 |
| .138 | .697 | | | | | | | | | .354 | .089 | .015 | .157 | .230 |
| 1.50 | 21.70 | 12.0 | 3 | 327R12-22 150MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 0.97 | 0.16 | 4.8 | 5.80 |
| .059 | .854 | | | | | | | | | .472 | .038 | .006 | .189 | .228 |
| 1.75 | 21.70 | 12.0 | 3 | 327R12-22 175MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 1.14 | 0.19 | 4.7 | 5.80 |
| .069 | .854 | | | | | | | | | .472 | .045 | .007 | .185 | .228 |
| 2.00 | 21.70 | 12.0 | 3 | 327R12-22 200MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 1.30 | 0.22 | 4.6 | 5.80 |
| .079 | .854 | | | | | | | | | .472 | .051 | .009 | .181 | .228 |
| 3.00 | 21.70 | 12.0 | 3 | 327R12-22 300MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 1.95 | 0.32 | 4.3 | 5.80 |
| .118 | .854 | | | | | | | | | .472 | .077 | .013 | .169 | .228 |
| 3.50 | 21.70 | 12.0 | 3 | 327R12-22 350MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 2.27 | 0.38 | 4.0 | 5.80 |
| .138 | .854 | | | | | | | | | .472 | .089 | .015 | .157 | .228 |
| 4.00 | 21.70 | 12.0 | 3 | 327R12-22 400MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 2.60 | 0.43 | 3.9 | 5.80 |
| .157 | .854 | | | | | | | | | .472 | .102 | .017 | .154 | .228 |
| 4.50 | 21.70 | 12.0 | 3 | 327R12-22 450MM-TH | ☆ | ☆ | ☆ | ☆ | ☆ | 12.00 | 2.92 | 0.49 | 3.7 | 5.70 |
| .177 | .854 | | | | | | | | | .472 | .115 | .019 | .146 | .224 |

L2 I222 I254 N22 N11



SANDVIK Coromant

# CoroMill® 327 solid-carbide head for chamfering




| KAPR | $CZC_{MS}$ | APMX | ZEFP | Ordering code | P | M | K | N | S | $DCON_{MS}$ | DC | DCX | LF | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1025 | 1025 | 1025 | 1025 | 1025 | Dimensions, mm, inch | | | | |
| 45° | 6.0 | 0.80 | 3 | 327R06-12 12045-CH | ★ | ★ | ★ | ★ | ★ | 6.00 | 10.10 | 11.7 | 3.60 | 80000 |
| | | .031 | | | | | | | | .236 | .398 | .461 | .142 | |
| 45° | 12.0 | 1.70 | 3 | 327R12-22 20045-CH | ★ | ★ | ★ | ★ | ★ | 12.00 | 18.30 | 21.7 | 5.85 | 80000 |
| | | .067 | | | | | | | | .472 | .720 | .854 | .230 | |

L2 I222 I254 N22 N11

# CoroMill® 495

## Versatile chamfer cutter

### Application

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

### ISO application area:

P M N S H

### Benefits and features

- Versatile tool for many different chamfer operations
- Flexible inserts capable to perform on 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

I219 I221

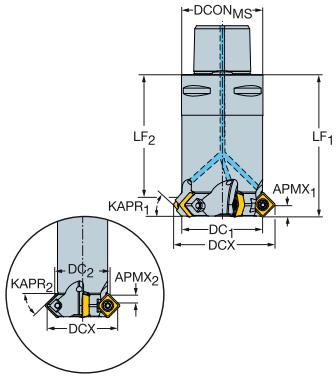


SANDVIK Coromant

# CoroMill® 495 chamfer milling cutter

**Coromant Capto® - Internal coolant supply**

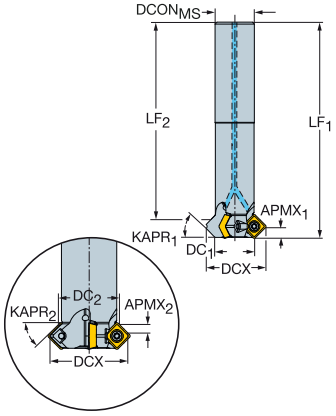
STDNO ISO26623-1




## Metric version

| 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




## Metric version

| 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 |

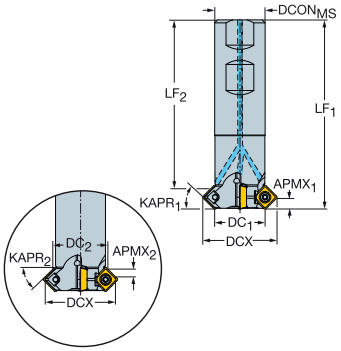
For the complete list of spare parts, visit www.sandvik.coromant.com

I221 L2 N22 N9 N15

# CoroMill® 495 chamfer milling cutter

**Weldon – Internal coolant supply**

STDNO ISO3338-2




## Inch version

| KAPR1 | KAPR2 | | CZCMS | APMX1 | APMX2 | CNSC | | Ordering code | Dimensions, inch DCONMS | DC1 | DC2 | DCX | BD | LF1 | LF2 | LU | PSI | FT/LBS | LBS | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30° | 60° | 09 | 5/8 | .150 | .260 | 1 | 1 | A495-013M16-3009L | .625 | .520 | .771 | 1.071 | .723 | 2.882 | 2.437 | | 290 | 1.0 | 0.43 | 13600 | 1 | 495-09T3M-XL |
| 45° | 45° | 09 | 5/8 | .215 | .215 | 1 | 1 | A495-013M16-4509L | .625 | .520 | .745 | 0.969 | .489 | 2.882 | 2.520 | | 290 | 1.0 | 0.41 | 13600 | 1 | 495-09T3M-XL |
| 60° | 30° | 09 | 5/8 | .268 | .155 | 1 | 1 | A495-013M16-6009L | .625 | .520 | .560 | 0.838 | .577 | 2.882 | 2.500 | .768 | 290 | 1.0 | 0.19 | 13600 | 1 | 495-09T3M-XL |
| 75° | | 09 | 5/8 | .304 | | 1 | 1 | A495-013M16-7509L | .625 | .520 | | 0.686 | .562 | | | | 290 | 1.0 | 0.18 | 13600 | 1 | 495-09T3M-XL |
| 45° | 45° | 09 | 3/4 | .215 | .215 | 1 | 3 | A495-020M19-4509M | .750 | .770 | .788 | 1.219 | .739 | 3.350 | 2.879 | | 290 | 1.0 | 0.50 | 9500 | 3 | 495-09T3M-XL |
| 75° | | 09 | 1 | .304 | | 1 | 3 | A495-026M25-7509H | 1.000 | 1.020 | | 1.185 | 1.009 | | | | 290 | 1.0 | 0.87 | 8000 | 3 | 495-09T3M-XL |
| 30° | 60° | 09 | 1 | .150 | .260 | 1 | 4 | A495-026M25-3009H | 1.000 | 1.020 | .560 | 1.571 | 1.223 | 3.750 | 3.306 | | 290 | 1.0 | 0.95 | 8000 | 4 | 495-09T3M-XL |
| 45° | 45° | 09 | 1 | .215 | .215 | 1 | 4 | A495-026M25-4509H | 1.000 | 1.020 | 1.038 | 1.469 | .989 | 3.750 | 3.285 | | 290 | 1.0 | 0.93 | 8000 | 4 | 495-09T3M-XL |
| 60° | 30° | 09 | 1 | .268 | .155 | 1 | 4 | A495-026M25-6009H | 1.000 | 1.020 | .804 | 1.338 | .754 | 3.751 | 3.283 | 1.319 | 290 | 1.0 | 0.84 | 8000 | 4 | 495-09T3M-XL |

| Spare parts |
|---|
| Insert screw |
| 5513 020-04 |

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

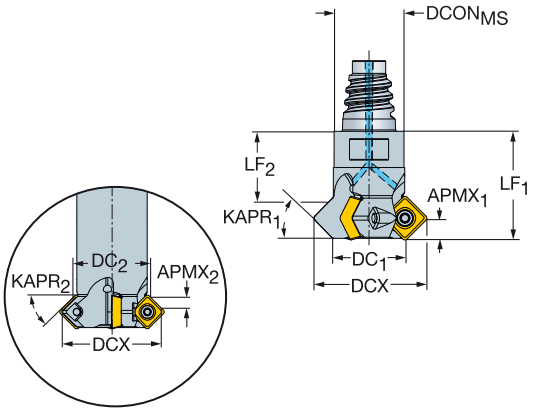
I221 L2 N22 N9 N15



SANDVIK Coromant

# CoroMill® 495 chamfer milling cutter

**Coromant EH – Internal coolant supply**




## Metric version

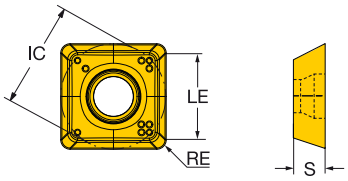
| KAPR1 | KAPR2 | ↔ | CZCMS | APMX1 | APMX2 | CNSC | | Ordering code | Dimensions, mm DCONMS | DC1 | DC2 | DCX | BD | LF1 | LF2 | BAR | NM | KG | RPMX | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 45° | 45° | 09 | E16 | 5.4 | 5.4 | 1 | 1 | 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 the complete list of spare parts, visit 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, inch IC | LE | S |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Medium | PL | 09 | 0.80 | 495-09T3M-PM | | ★ | | ☆ | ☆ | ☆ | ☆ | 9.0 | 7.4 | 3.51 |
| | | | .031 | | | | | | | | | .354 | .291 | .138 |
| | ML | 09 | 0.80 | 495-09T3M-MM | ☆ | | ★ | | | | | 9.0 | 7.4 | 3.51 |
| | | | .031 | | | | | | | | | .354 | .291 | .138 |

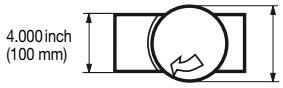
L2 I222 N22 N9 N15 N3

# Milling with large engagement, metric values

| 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 $v_{c1}$ 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 $v_{c1}$ 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 $v_{c1}$ 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 |
| | | **Gray 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. 5.000 inch (125 mm), centered over the workpiece. Working engagement 4.000 inch (100 mm).

| 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 | | | | |

| 1040 | S30T | S40T | GC2030 | GC2040 | GC4230 | GC4240 | 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 | GC4230 | GC4240 | 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, metric values

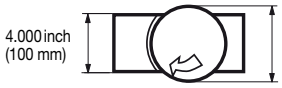
| ISO N | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CD10 | H10 | CT530 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ mm | | |
| | | | | | | 0.1 – 0.15 – 0.2 | 0.1 – 0.15 – 0.2 | 0.1 – 0.15 – 0.2 |
| MC No. | CMC No. | Material | N/mm² | HB | mc | Cutting speed $v_c$, m/min | | |
| | | **Aluminum 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 |
| | | **Aluminum 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 |
| | | **Aluminum alloys** | | | | | | |
| N1.1.Z.UT | 30.3 | Al >99% | 350 | 30 | | 1900 –1750 –1600 | 950 –880 –810 | 1050-960-890 |
| | | **Aluminum 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 | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | 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 |
| MC No. | CMC No. | Material | N/mm² | HB | mc | 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 base** | | | | | | |
| 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 alloys1)** | | Rm2) | | | | |
| 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 | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | 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 |
| MC No. | CMC No. | Material | N/mm² | HB | mc | 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) 30-45° lead angle. Positive cutting geometry and coolant should be used.

2) Rm = ultimate tensile strength measured in MPa.




**Conditions:**

Cutter, dia. 5.000 inch (125 mm), centered over the workpiece. Working engagement 4.000 inch (100 mm).

| 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 | 940–870–810 | 750–700–650 | 990–910–850 | | | | | |
| 890–820–760 | 850–780–730 | 680–630–580 | 890–820–760 | | | | | |
| 990–910–850 | 940–870–810 | 750–700–650 | 990–910–850 | | | | | |
| 990–920–850 | 850–790–730 | 680–630–580 | 990–920–850 | | | | | |
| 990–920–850 | 950–880–810 | 760–700–650 | 990–920–850 | | | | | |
| 395–370–340 | 380–350–325 | 300–280–260 | 395–370–340 | | | | | |
| 300–275–255 | 285–265–245 | 225–210–195 | 300–275–255 | | | | | |
| 495–460–425 | 470–435–405 | 375–350–325 | 495–460–425 | | | | | |
| 495–460–425 | 470–435–405 | 375–350–325 | 495–460–425 | | | | | |
| 345–320–295 | 330–305–285 | 265–245–225 | 345–320–295 | | | | | |

| 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 | – | – | 55 –50 –45 | 60 –55 –45 | – | | | |
| 40 –37 –35 | – | – | 40 –38 –34 | 45 –39 –32 | – | | | |
| 50 –50 –45 | – | – | 55 –50 –45 | 55 –50 –40 | – | | | |
| 32 –30 –27 | – | – | 34 –31 –28 | 35 –31 –26 | – | | | |
| 40 –37 –34 | – | – | 40 –37 –34 | 40 –38 –31 | – | | | |
| 22 –19 –17 | – | – | 23 –21 –18 | 23 –21 –17 | – | | | |
| 15 –14 –12 | – | – | 17 –15 –13 | 17 –15 –12 | – | | | |
| 14 –13 –12 | – | – | 15 –14 –12 | 15 –14 –11 | – | | | |
| 115 –105 –100 | 150 –135 –125 | 125 –115 –110 | 120 –105 –95 | 120 –110 –100 | 150-135-125 | | | |
| 45 –40 –38 | 65 –60 –55 | 45 –40 –39 | 50 –45 –39 | 45 –39 –36 | 65-60-55 | | | |
| 34 –31 –29 | 50 –50 –45 | 38 –36 –33 | 40 –37 –34 | 37 –33 –30 | 55-50-45 | | | |

| 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 | | | | | |

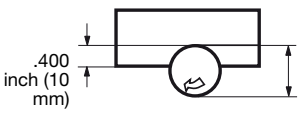
# Milling with small engagement, metric values

| 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 $v_{c1}$ 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 $v_{c1}$ 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 $v_{c1}$ 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 |
| | | **Gray 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) 30-45° lead angle. Positive cutting geometry and coolant should be used.




**Conditions:**

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

| GC1025 | GC1130 | GC4220 | GC4330 | GC4340 | GC2030 | GC2040 | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Max chip thickness, $h_{ex}$ mm | | | | | | | | | | |
| 0.05-0.1-0.2 | 0.05-0.1-0.2 | 0.1-0.15-0.3 | 0.1-0.2-0.3 | 0.1-0.2-0.3 | 0.05 – 0.15 – 0.25 | 0.1 – 0.2 – 0.3 | | | | |
| Cutting speed $v_c$, m/min | | | | | | | | | | |
| 365-360-345 | 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 | - |

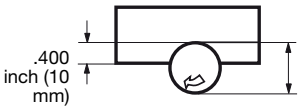
# Milling with small engagement, metric values

| ISO N | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | 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 |
| MC No. | CMC No. | Material | N/mm² | HB | mc | Cutting speed $v_{c1}$ m/min | | |
| | | **Aluminum 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 |
| | | **Aluminum 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 |
| | | **Aluminum alloys** | | | | | | |
| N1.1.Z.UT | 30.3 | Al >99% | 350 | 30 | | 2150 –2100 –2050 | 1150 –1150 –1150 | 1050-1050-1050 |
| | | **Aluminum 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 | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | 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 |
| MC No. | CMC No. | Material | N/mm² | HB | mc | Cutting speed $v_{c1}$ 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 base** | | | | | | |
| 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 alloys1)** | | 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 | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | 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 |
| MC No. | CMC No. | Material | N/mm² | HB | mc | Cutting speed $v_{c1}$ 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) 30-45° lead angle. Positive cutting geometry and coolant should be used.
2) Rm = ultimate tensile strength measured in MPa.




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

| 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<br><br>1000 –980 –970 | 1100 –1100 –1050<br><br>1000 –980 –970 | 1050 –1050 –1000<br><br>950 –940 –920 | 850 –830 –820<br><br>760 –750 –740 | | | | | | | |
| 1100 –1100 –1050<br>110 –1100 –1100 | 1100 –1100 –1050<br>1100 –1100 –1100 | 1050 –1050 –1000<br>950 –940 –920 | 850 –830 –820<br>760 –750 –740 | | | | | | | |
| 1100 –1100 –1100 | 1100 –1100 –1100 | 1050 –1050 –1050 | 850 –840 –825 | | | | | | | |
| 445 –440 –430<br>335 –330 –325 | 445 –440 –430<br>335 –330 –325 | 425 –420 –410<br>320 –315 –310 | 340 –335 –330<br>255 –250 –245 | | | | | | | |
| 560 –550 –540<br>560 –550 –540<br>390 –380 –375 | 560 –550 –540<br>560 –550 –540<br>390 –380 –375 | 530 –520 –510<br>530 –520 –510<br>370 –365 –360 | 425 –415 –410<br>425 –415 –410<br>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<br>50-50-50 | 60 –60 –60<br>45 –45 –40 | –<br>– | –<br>– | 65 –65 –65<br>50 –50 –45 | 70 –65 –65<br>50 –50 –45 | | | | | |
| 65-65-60<br>40-39-38<br>50-50-50 | 60 –55 –55<br>36 –35 –33<br>45 –45 –40 | –<br>–<br>– | –<br>–<br>– | 65 –60 –60<br>40 –38 –38<br>50 –45 –45 | 65 –65 –60<br>40 –39 –38<br>50 –50 –45 | | | | | |
| 28-27-26<br>20-19-19<br>19-19-18 | 26 –24 –23<br>18 –17 –16<br>17 –16 –16 | –<br>–<br>– | –<br>–<br>– | 28 –27 –26<br>20 –19 –19<br>19 –18 –17 | 28 –27 –26<br>20 –19 –19<br>19 –18 –17 | | | | | |
| 140-140-135<br>55-55-55<br>45-40-40 | 130 –125 –120<br>50 –50 –45<br>38 –37 –36 | 170 –165 –160<br>75 -75 -70<br>65 –60 –66 | 145 –145 –140<br>55-50-50<br>45-45-45 | 140 –135 –130<br>55-55-55<br>50 –45 –45 | 145 –140 –135<br>50 –50 –50<br>45 –40 –40 | | | | | |

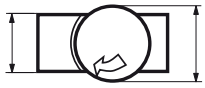
| GC4220 | GC3040 | GC1010 | GC1130 | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ mm** | | | | | | | | | | |
| 0.1-0.12-0.25 | 0.1-0.2-0.25 | 0.07-0.12-0.2 | 0.07-0.12-0.2 | | | | | | | |
| **Cutting speed $v_c$, m/min** | | | | | | | | | | |
| 65–65–60 | 55-50-50 | 130-125-120 | 45-45-45 | | | | | | | |
| 125–125–115 | 100-95-95 | 250-240-230 | 90-85-85 | | | | | | | |

# Milling with large engagement, inch values

| ISO P | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CT530 | GC1010 | GC2040 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .004 – .006 – .008 | .002 – .004 – .008 | .004-.008-.016 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_{c}$, ft/min | | |
| | | **Steel** | | | | | | |
| | | **Unalloyed** | | | | | | |
| P1.1.Z.AN | 01.1 | C = 0.10 – 0.25% | 216,500 | 125 | 0.25 | 1400-1250-1150 | - | 960-780-520 |
| P1.2.Z.AN | 01.2 | C = 0.25 – 0.55% | 233,000 | 150 | 0.25 | 1250-1150-1050 | - | 860-700-470 |
| P1.3.Z.AN | 01.3 | C = 0.55 – 0.80% | 247,000 | 170 | 0.25 | 1200-1050-970 | - | 810-660-440 |
| P1.3.Z.AN | 01.4 | | 260,500 | 210 | 0.25 | 1050-940-850 | - | 710-580-390 |
| P1.3.Z.HT | 01.5 | | 291,500 | 300 | 0.25 | 770-690-630 | - | 520-430-285 |
| | | **Low alloyed (alloying elements ≤ 5%)** | | | | | | |
| P2.1.Z.AN | 02.1 | Non-hardened | 246,500 | 175 | 0.25 | 980-890-800 | - | 670-550-370 |
| P2.5.Z.HT | 02.2 | Hardened and tempered | 278,500 | 300 | 0.25 | 640-580-520 | - | 440-360-240 |
| | | **High alloyed (alloying elements > 5%)** | | | | | | |
| P3.0.Z.AN | 03.11 | Annealed | 282,000 | 200 | 0.25 | 740-670-610 | 590-540-440 | 510-415-275 |
| P3.1.Z.AN | 03.13 | Hardened tool steel | 311,000 | 200 | 0.25 | 620-560-500 | 490-445-360 | 415-340-225 |
| P3.0.Z.HT | 03.21 | | 420,000 | 300 | 0.25 | 540-485-440 | 430-390-315 | 365-300-200 |
| P3.0.Z.HT | 03.22 | | 448,500 | 380 | 0.25 | 340-305-275 | 270-245-200 | 225-185-125 |
| | | **Castings** | | | | | | |
| P1.5.C.UT | 06.1 | Unalloyed | 204,000 | 150 | 0.25 | 1000-910-820 | 800-720-590 | 680-560-370 |
| P2.6.C.UT | 06.2 | Low alloyed (alloying elements ≤ 5%) | 230,500 | 200 | 0.25 | 800-720-650 | 630-570-470 | 550-445-300 |
| P3.0.C.UT | 06.3 | High alloyed (alloying elements > 5%) | 283,500 | 200 | 0.25 | 580-530-475 | 465-420-345 | 400-325-220 |

| ISO M | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CT530 | GC1025 | M30B |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .004 – .006 – .008 | .002 – .004 – .008 | .004 – .006 – .008 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_{c}$, ft/min | | |
| | | **Stainless steel** | | | | | | |
| | | **Ferritic/martensitic** | | | | | | |
| P5.0.Z.AN | 05.11 | Non-hardened | 262,000 | 200 | 0.21 | 940-830-740 | 830-740-590 | 860-680-430 |
| P5.0.Z.PH | 05.12 | PH-hardened | 411,500 | 330 | 0.21 | 670-600-530 | 590-520-415 | 560-450-285 |
| P5.0.Z.HT | 05.13 | Hardened | 340,000 | 330 | 0.21 | 700-620-550 | 610-540-430 | 640-510-325 |
| | | **Austenitic** | | | | | | |
| M1.0.Z.AQ | 05.21 | Non-hardened | 285,000 | 200 | 0.21 | 870-780-690 | 820-730-580 | – |
| M1.0.Z.PH | 05.22 | PH-hardened | 414,000 | 330 | 0.21 | 640-580-510 | 560-500-400 | – |
| M2.0.Z.AQ | 05.23 | Super austenitic | 328,000 | 200 | | – | – | – |
| | | **Austenitic-ferritic (Duplex)** | | | | | | |
| M3.1.Z.AQ | 05.51 | Non-weldable ≥ 0.05%C | 286,500 | 230 | 0.21 | 850-760-680 | 670-600-475 | – |
| M3.2.Z.AQ | 05.52 | Weldable < 0.05%C | 356,500 | 260 | 0.21 | 750-670-600 | 570-510-405 | – |
| | | **Stainless steel – Cast** | | | | | | |
| | | **Ferritic/martensitic** | | | | | | |
| P5.0.C.UT | 15.11 | Non-hardened | 246,500 | 200 | 0.25 | 830-740-660 | 740-660-520 | 760-600-380 |
| P5.0C.PH | 15.12 | PH-hardened | 354,500 | 330 | 0.25 | 590-520-465 | 520-460-365 | 495-395-250 |
| P5.0.C.HT | 15.13 | Hardened | 311,000 | 330 | 0.25 | 640-570-510 | 560-500-395 | 590-465-295 |
| M1.0.C.UT | 15.21 | Non hardened | 261,000 | 200 | 0.25 | 830-740-660 | 780-690-550 | – |
| M1.0C.PH | 15.22 | PH-hardened | 356,000 | 330 | 0.25 | 590-530-470 | 520-460-365 | – |
| M2.0.C.AQ | 15.23 | Super austenitic | 310,500 | 200 | | – | – | – |
| | | **Austenitic-ferritic (Duplex)** | | | | | | |
| M3.1.C.AQ | 15.51 | Non-weldable ≥ 0.05%C | 258,000 | 230 | 0.25 | 810-720-640 | 640-570-450 | – |
| M3.2.C.AQ | 15.52 | Weldable < 0.05%C | 326,500 | 260 | 0.25 | 700-630-560 | 530-475-375 | – |

| ISO K | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CB50 | CC6190 | GC1010 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .004 – .006 – .008 | .004 – .008 – .012 | .004 – .008 – .012 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_{c}$, ft/min | | |
| | | **Malleable cast iron** | | | | | | |
| | 07.1 | Ferritic (short chipping) | 115,000 | 130 | 0.28 | - | 4250-3500-2850 | 740-605-490 |
| K1.1.C.NS | 07.2 | Pearlitic (long chipping) | 131,000 | 230 | 0.28 | - | 3550-2900-2350 | 605-510-410 |
| | | **Gray cast iron** | | | | | | |
| K2.1.C.UT | 08.1 | Low tensile strength | 130,000 | 180 | 0.28 | 2950-2550-2150 | 5150-4200-3450 | 800-655-540 |
| K2.2.C.UT | 08.2 | High tensile strength | 159,500 | 245 | 0.28 | 2750-2350-2000 | 3900-3200-2600 | 640-525-425 |
| | | **Nodular cast iron** | | | | | | |
| K3.1.C.UT | 09.1 | Ferritic | 130,000 | 160 | 0.28 | - | 3300-2700-2200 | 510-410-345 |
| K3.3.C.UT | 09.2 | Pearlitic | 194,500 | 250 | 0.28 | 1600-1350-1150 | 2750-2250-1850 | 475-390-310 |




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

| GC1025 | GC1130 | GC4220 | GC4330 | GC4340 | GC3040 | GC2030 | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ inch** | | | | | | | | | | |
| .002-.004-.008 | .002-.004-.008 | .004-.008-.012 | .004-.008-.012 | .004-.008-.012 | .004-.008-.012 | .004-.008-.016 | | | | |
| **Cutting speed $v_c$, ft/min** | | | | | | | | | | |
| 1100-1000-820 | 1250-1100-910 | 1600-1300-1050 | 1300-1050-870 | 1100-910-740 | 1250-1050-850 | 960-780-520 | | | | |
| 1000-910-740 | 1100-1000-820 | 1450-1200-960 | 1150-960-780 | 1000-820-670 | 1150-930-760 | 860-700-470 | | | | |
| 950-860-700 | 1050-940-770 | 1350-1100-910 | 1100-900-740 | 940-770-630 | 1100-880-720 | 810-660-440 | | | | |
| 820-750-610 | 910-820-670 | 1200-970-790 | 970-790-650 | 820-670-550 | 940-770-630 | 710-580-390 | | | | |
| 610-550-450 | 670-610-500 | 880-720-590 | 710-580-475 | 610-500-405 | 700-570-465 | 520-430-285 | | | | |
| 920-830-680 | 860-780-640 | 1100-920-750 | 920-750-610 | 780-640-520 | 890-730-600 | 670-550-370 | | | | |
| 510-460-375 | 560-510-415 | 730-600-490 | 600-490-400 | 510-415-340 | 580-475-390 | 440-360-240 | | | | |
| 590-540-440 | 590-540-440 | 970-800-650 | 630-510-420 | 540-440-360 | 680-550-450 | 510-415-275 | | | | |
| 490-445-360 | 490-445-360 | 710-580-475 | 520-430-350 | 445-360-295 | 560-460-375 | 415-340-225 | | | | |
| 430-390-315 | 430-390-315 | 610-500-410 | 455-370-305 | 390-315-260 | 490-400-325 | 365-300-200 | | | | |
| 270-245-200 | 270-245-200 | 385-315-255 | 285-235-190 | 245-200-160 | 305-250-205 | 225-185-125 | | | | |
| 800-720-590 | 800-720-590 | 1150-940-770 | 850-690-570 | 720-590-480 | 910-740-610 | 680-560-370 | | | | |
| 630-570-470 | 630-570-470 | 910-740-610 | 680-550-450 | 570-470-385 | 720-590-485 | 550-445-300 | | | | |
| 465-420-345 | 465-420-345 | 670-550-445 | 495-405-330 | 420-345-280 | 530-435-355 | 400-325-220 | | | | |

| GC1130 | 1040 | S30T | S40T | GC2030 | GC2040 | GC4330 | GC4340 | GC1010 | | |
|---|---|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ inch** | | | | | | | | | | |
| .002-.004-.008 | .002-.006-.010 | .002-.006-.010 | .004-.008-.012 | .002-.006-.010 | .004-.008-.012 | .004-.008-.012 | .004-.008-.016 | .004 -.006-.008 | | |
| **Cutting speed $v_c$, ft/min** | | | | | | | | | | |
| 830-740-590 | 610-450-330 | 830-610-450 | 810-650-510 | 790-630-500 | 780-620-495 | 900-710-570 | 690-550-345 | 940-830-740 | | |
| 590-520-415 | 430-315-235 | 580-430-320 | 560-445-355 | 560-445-350 | 540-425-340 | 620-490-390 | 455-365-230 | 670-600-530 | | |
| 610-540-430 | 445-330-245 | 610-445-330 | 590-470-375 | 580-460-365 | 570-450-360 | 640-510-410 | 520-410-260 | 700-620-550 | | |
| 820-730-580 | 590-435-325 | 810-600-445 | 680-540-430 | 770-610-485 | 660-520-415 | | 610-485-305 | 870-780-690 | | |
| 560-500-400 | 415-305-225 | 560-415-305 | 540-425-340 | 540-425-340 | 520-410-325 | | 440-350-220 | 640-580-510 | | |
| – | 405-300-220 | 560-415-305 | 475-375-300 | – | – | – | – | 560-415-305 | | |
| 670-600-475 | 495-365-270 | 670-495-365 | 570-450-360 | 640-510-405 | 550-435-345 | | 550-435-275 | 850-760-680 | | |
| 570-510-405 | 410-305-225 | 570-420-310 | 460-365-290 | 540-425-340 | 440-350-280 | | 440-350-220 | 750-670-600 | | |
| 740-660-520 | 540-400-295 | 730-540-400 | 720-570-455 | 700-560-445 | 690-550-440 | 800-630-500 | 610-485-305 | 830-740-660 | | |
| 520-460-365 | 375-275-200 | 510-380-280 | 490-390-310 | 485-385-305 | 470-375-295 | 540-430-340 | 400-320-200 | 590-520-465 | | |
| 560-500-395 | 405-300-220 | 560-410-305 | 540-430-345 | 530-420-335 | 520-415-330 | 590-470-375 | 475-375-240 | 640-570-510 | | |
| 780-690-550 | 560-415-310 | 770-570-425 | 650-520-415 | 730-580-465 | 630-500-395 | | 580-460-290 | 830-740-660 | | |
| 520-460-365 | 365-270-200 | 520-380-280 | 490-390-310 | 485-385-305 | 470-375-300 | | 400-320-200 | 590-530-470 | | |
| – | 365-270-200 | 500-370-275 | 425-340-270 | – | – | – | – | – | | |
| 640-570-450 | 470-350-255 | 640-470-345 | 540-430-340 | 610-485-385 | 520-410-325 | | 520-415-260 | 810-720-640 | | |
| 530-475-375 | 385-285-210 | 530-390-290 | 430-345-275 | 495-395-315 | 415-330-265 | | 410-325-205 | 700-630-560 | | |

| GC3220 | GC3330 | GC3040 | K20W | GC4330 | GC4340 | GC1020 | H13A | K20D | K20M | K15W |
|---|---|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ inch** | | | | | | | | | | |
| .004-.008-.012 | .004-.008-.016 | .004-.008-.016 | .004-.008-.012 | .004-.008-.012 | .004-.008-.012 | .004-.008-.016 | .004-.008-.016 | .004-.008-.012 | .004-.008-.012 | .004-.008-.012 |
| **Cutting speed $v_c$, ft/min** | | | | | | | | | | |
| 870-710-580 | 850-700-465 | 790-640-430 | 730-600-490 | 700-570-465 | 630-520-425 | 670-550-445 | 395-335-245 | 870-710-580 | 835-690-560 | - |
| 720-590-480 | 700-570-380 | 650-530-355 | 600-495-405 | 570-470-385 | 520-430-350 | 550-450-370 | 325-280-205 | 720-590-480 | 690-560-460 | - |
| 950-780-630 | 930-760-510 | 850-700-465 | 800-650-530 | 760-620-510 | 690-570-465 | 730-600-485 | 430-365-270 | 950-780-630 | 900-740-605 | 800-650-530 |
| 760-620-510 | 740-610-405 | 680-560-375 | 640-520-425 | 610-495-405 | 550-455-370 | 580-475-390 | 340-290-215 | 760-620-510 | 720-590-490 | 640-520-425 |
| 590-485-395 | 920-750-500 | 530-435-290 | 500-410-335 | 475-390-320 | 435-355-290 | 455-370-305 | 270-230-170 | 590-485-395 | 575-460-380 | - |
| 550-450-370 | 740-610-405 | 495-405-270 | 465-380-310 | 440-360-295 | 405-330-270 | 425-350-285 | 250-215-155 | 550-450-370 | 525-424-360 | - |

# Milling with large engagement, inch values

| ISO N | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CD10 | H10 | H13A |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .004-.006-.008 | .004-.006-.008 | .004-.006-.008 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_{c_1}$ ft/min | | |
| | | **Aluminum alloys** | | | | | | |
| N1.2.Z.UT | 30.11 | Wrought or wrought and coldworked, non-aging | 58,000 | 60 | | 6150-5700-5250 | 3050-2850-2650 | 2450-2250-2100 |
| N1.2.Z.AG | 30.12 | Wrought or wrought and aged | 94,500 | 100 | | 5550-5100-4750 | 2750-2550-2350 | 2200-2050-1900 |
| | | **Aluminum alloys** | | | | | | |
| N1.3.C.UT | 30.21 | Cast, non-aging | 87,000 | 75 | 0.25 | 6150-5700-5250 | 3050-2850-2650 | 2450-2250-2100 |
| N1.3.C.AG | 30.22 | Cast or cast and aged | 101,500 | 90 | 0.25 | 5550-5150-4750 | 2750-2550-2350 | 2200-2050-1900 |
| | | **Aluminum alloys** | | | | | | |
| N1.1.Z.UT | 30.3 | Al >99% | 50,500 | 30 | | 6200-5700-5300 | 3100-2850-2650 | 2450-2300-2100 |
| | | **Aluminum alloys** | | | | | | |
| | 30.41 | Cast, 13–15% Si | 101,500 | 130 | | 2450-2300-2100 | 1250-1150-1050 | 990-910-850 |
| N1.4.C.NS | 30.42 | Cast, 16–22% Si | 101,500 | 130 | | 1850-1700-1600 | 930-860-790 | 740-690-630 |
| | | **Copper and copper alloys** | | | | | | |
| N3.3.U.UT | 33.1 | Free cutting alloys, ≥1% Pb | 79,500 | 110 | 0.25 | 3100-2850-2650 | 1550-1450-1300 | 1250-1150-1050 |
| N3.2.C.UT | 33.2 | Brass, leaded bronzes, ≤1% Pb | 80,000 | 90 | | 3100-2850-2650 | 1550-1400-1300 | 1250-1150-1050 |
| N3.1.U.UT | 33.3 | Bronze and non-leaded copper incl. electrolytic copper | 196,000 | 100 | 0.25 | 2150-2000-1850 | 1100-1000-920 | 860-800-740 |

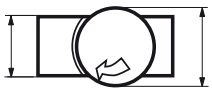
| ISO S | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | GC1025 | GC1130 | GC1010 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .004-.006-.008 | .004-.006-.008 | .004 – .006 – .008 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_{c_1}$ ft/min | | |
| | | **Heat resistant super alloys** | | | | | | |
| | | **Iron base** | | | | | | |
| S1.0.U.AN | 20.11 | Annealed or solution treated | 348,000 | 200 | 0.25 | 200-180-160 | 200-180-160 | - |
| S1.0.U.AG | 20.12 | Aged or solution treated and aged | 359,000 | 280 | 0.25 | 150-135-120 | 150-135-120 | |
| | | **Nickel base** | | | | | | |
| S2.0.Z.AN | 20.21 | Annealed or solution treated | 383,000 | 250 | 0.25 | 190-170-155 | 190-170-155 | - |
| S2.0.Z.AG | 20.22 | Aged or solution treated and aged | 420,500 | 350 | 0.25 | 120-105-95 | 120-105-95 | - |
| S2.0.C.NS | 20.24 | Cast or cast and aged | 436,500 | 320 | 0.25 | 145-130-120 | 150-140-120 | - |
| | | **Cobalt base** | | | | | | |
| S3.0.Z.AN | 20.31 | Annealed or solution treated | 391,500 | 200 | 0.25 | 80-70-65 | 80-70-65 | - |
| S3.0.Z.AG | 20.32 | Solution treated and aged | 432,000 | 300 | 0.25 | 55-50-45 | 55-50-45 | - |
| S3.0.C.NS | 20.33 | Cast or cast and aged | 450,500 | 320 | 0.25 | 50-45-40 | 50-45-40 | - |
| | | **Titanium alloys1)** | | **Rm2)** | | | | |
| S4.1.Z.UT | 23.1 | Commercial pure (99.5% Ti) | 188,500 | 400 | 0.23 | 415-375-340 | 415-375-340 | 445-380-330 |
| S4.2.Z.AN | 23.21 | α, near α and α + β alloys, annealed | 203,000 | 950 | 0.23 | 185-165-150 | 185-165-150 | 200-170-145 |
| S4.3.Z.AG | 23.22 | α + β alloys in aged cond., β alloys, annealed or aged | 203,000 | 1050 | 0.23 | 145-130-120 | 145-130-120 | 155-135-115 |

| ISO H | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CB50 | CT530 | GC1130 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .003-.005-.008 | .003-.004-.008 | .003-.005-.008 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_{c_1}$ ft/min | | |
| | | **Extra hard steel** | | | | | | |
| H1.3.Z.HA | 04.1 | Hardened and tempered | 606,500 | 59 HRC | 0.25 | 520-455-370 | 260-245-185 | 130-115-95 |
| | | **Chilled cast iron** | | | | | | |
| H2.0.C.UT | 10.1 | Cast or cast and aged | 326,500 | 400 | 0.28 | 990-870-700 | 495-465-350 | 250-215-175 |

1) 30-45° lead angle. Positive cutting geometry and coolant should be used.

2) Rm = ultimate tensile strength measured in MPa.

4.000 inch (100 mm)



5.000 inch (125 mm)

**Conditions:**

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



SANDVIK Coromant

| CT530 | GC1025 | GC1130 | H10F | | | | | |
|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ inch** | | | | | | | | |
| .004-.006-.008 | .004-.006-.008 | .004-.006-.008 | .004-.006-.008 | | | | | |
| **Cutting speed $v_c$, ft/min** | | | | | | | | |
| 3400-3100-2900 | 3200-3000-2750 | 3200-3000-2750 | 3050-2850-2650 | | | | | |
| 3050-2800-2600 | 2900-2700-2500 | 2900-2700-2500 | 2750-2550-2350 | | | | | |
| 3400-3150-2900 | 3250-3000-2750 | 3250-3000-2750 | 3050-2850-2650 | | | | | |
| 3050-2800-2600 | 3250-3000-2750 | 3250-3000-2750 | 2750-2550-2350 | | | | | |
| 3400-3150-2900 | 3250-3000-2800 | 3250-3000-2800 | 3100-2850-2650 | | | | | |
| 1350-1250-1150 | 1300-1200-1100 | 1300-1200-1100 | 1250-1150-1050 | | | | | |
| 1000-940-870 | 970-900-830 | 970-900-830 | 930-860-790 | | | | | |
| 1700-1550-1450 | 1600-1500-1400 | 1600-1500-1400 | 1550-1450-1300 | | | | | |
| 1700-1550-1450 | 1600-1500-1400 | 1600-1500-1400 | 1550-1400-1300 | | | | | |
| 1200-1100-1000 | 1150-1050-970 | 1150-1050-970 | 1100-1000-920 | | | | | |

| H13A | H10F | S30T | S40T | GC2030 | GC2040 | | | |
|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ inch** | | | | | | | | |
| .004-.006-.008 | .004-.006-.008 | .004-.006-.008 | .004-.006-.008 | .004-.006-.008 | .004-.006-.010 | | | |
| **Cutting speed $v_c$, ft/min** | | | | | | | | |
| 195-180-170 | 180-165-155 | - | - | 185-165-150 | 190-170-140 | | | |
| 145-130-120 | 130-120-115 | - | - | 135-125-110 | 140-125-105 | | | |
| 185-175-160 | 170-160-145 | - | - | 175-160-145 | 180-165-135 | | | |
| 115-105-100 | 105-95-90 | - | - | 110-100-90 | 115-100-85 | | | |
| 145-135-125 | 130-120-110 | - | - | 135-120-110 | 135-125-100 | | | |
| 75-65-60 | 70-65-55 | - | - | 75-65-60 | 75-65-55 | | | |
| 55-50-45 | 50-45-39 | - | - | 55-50-45 | 55-50-39 | | | |
| 50-45-40 | 45-40-37 | - | - | 50-45-39 | 50-45-35 | | | |
| 410-380-350 | 375-345-320 | 445-380-330 | 415-375-340 | 385-350-315 | 400-360-325 | | | |
| 165-150-140 | 145-135-125 | 200-170-145 | 150-135-125 | 155-140-125 | 140-130-115 | | | |
| 125-115-105 | 110-105-95 | 155-135-115 | 125-115-100 | 135-120-110 | 120-110-100 | | | |

| GC4220 | GC3040 | GC1010 | GC1025 | | | | | |
|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ inch** | | | | | | | | |
| .004-.006-.010 | .004-.008-.010 | .003-.005-.008 | .003-.005-.008 | | | | | |
| **Cutting speed $v_c$, ft/min** | | | | | | | | |
| 175-150-115 | 140-110-95 | 360-310-255 | 130-115-95 | | | | | |
| 330-285-220 | 270-205-180 | 690-600-490 | 250-215-175 | | | | | |

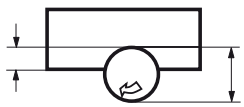
# Milling with small engagement, inch values

| ISO P | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CT530 | GC1010 | GC2040 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .004-.006-.008 | .002-.004-.008 | .004-.008-.012 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_{c_1}$ ft/min | | |
| | | **Steel** | | | | | | |
| | | **Unalloyed** | | | | | | |
| P1.1.Z.AN | 01.1 | C = 0.10 –0.25% | 216,500 | 125 | 0.25 | 1650-1600-1550 | - | 1100-1050-1000 |
| P1.2.Z.AN | 01.2 | C = 0.25–0.55% | 233,000 | 150 | 0.25 | 1450-1450-1400 | - | 1000-960-920 |
| P1.3.Z.AN | 01.3 | C = 0.55–0.80% | 247,000 | 170 | 0.25 | 1400-1350-1350 | - | 950-900-860 |
| P1.3.Z.AN | 01.4 | | 260,500 | 210 | 0.25 | 1200-1200-1150 | - | 830-800-760 |
| P1.3.Z.HT | 01.5 | | 291,500 | 300 | 0.25 | 890-880-860 | - | 610-590-560 |
| | | **Low-alloy (alloying elements ≤5%)** | | | | | | |
| P2.1.Z.AN | 02.1 | Non-hardened | 246,500 | 175 | 0.25 | 1150-1100-1100 | - | 790-750-720 |
| P2.5.Z.HT | 02.2 | Hardened and tempered | 278,500 | 300 | 0.25 | 750-730-720 | - | 510-490-470 |
| | | **High-alloy (alloying elements >5%)** | | | | | | |
| P3.0.Z.AN | 03.11 | Annealed | 282,000 | 200 | 0.25 | 870-850-830 | 640-630-600 | 590-570-540 |
| P3.1.Z.AN | 03.13 | Hardened tool steel | 311,000 | 200 | 0.25 | 720-700-690 | 530-520-495 | 485-465-440 |
| P3.0.Z.HT | 03.21 | | 420,000 | 300 | 0.25 | 630-620-600 | 465-455-435 | 425-405-390 |
| P3.0.Z.HT | 03.22 | | 448,500 | 380 | 0.25 | 395-385-380 | 290-285-270 | 265-255-240 |
| | | **Castings** | | | | | | |
| P1.5.C.UT | 06.1 | Unalloyed | 204,000 | 150 | 0.25 | 1150-1150-1100 | 860-840-810 | 790-760-730 |
| P2.6.C.UT | 06.2 | Low-alloy (alloying elements ≤5%) | 230,500 | 200 | 0.25 | 930-910-890 | 690-670-640 | 640-610-580 |
| P3.0.C.UT | 06.3 | High-alloy (alloying elements >5%) | 283,500 | 200 | 0.25 | 680-670-650 | 500-490-470 | 465-445-425 |

| ISO M | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CT530 | GC1025 | M30B |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .004-.006-.008 | .004-.006-.008 | .004-.008-.012 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_{c_1}$ ft/min | | |
| | | **Stainless steel** | | | | | | |
| | | **Ferritic/martensitic** | | | | | | |
| P5.0.Z.AN | 05.11 | Non-hardened | 262,000 | 200 | 0.21 | 1100-1100-1050 | 910-890-840 | 910-890-840 |
| P5.0.Z.PH | 05.12 | PH-hardened | 411,500 | 330 | 0.21 | 800-780-760 | 640-630-590 | 640-630-590 |
| P5.0.Z.HT | 05.13 | Hardened | 340,000 | 330 | 0.21 | 830-810-790 | 660-650-610 | 660-650-610 |
| | | **Austenitic** | | | | | | |
| M1.0.Z.AQ | 05.21 | Non-hardened | 285,000 | 200 | 0.21 | 1050-1000-990 | 890-870-830 | - |
| M1.0.Z.PH | 05.22 | PH-hardened | 414,000 | 330 | 0.21 | 770-750-730 | 620-600-570 | - |
| M2.0.Z.AQ | 05.23 | Super austenitic | 328,000 | 200 | | - | - | - |
| | | **Austenitic-ferritic (Duplex)** | | | | | | |
| M3.1.Z.AQ | 05.51 | Non-weldable ≥ 0.05%C | 286,500 | 230 | 0.21 | 1000-990-970 | 740-720-680 | - |
| M3.2.Z.AQ | 05.52 | Weldable < 0.05%C | 356,500 | 260 | 0.21 | 900-880-860 | 620-610-580 | - |
| | | **Stainless steel – Cast** | | | | | | |
| | | **Ferritic/martensitic** | | | | | | |
| P5.0.C.UT | 15.11 | Non-hardened | 246,500 | 200 | 0.25 | 990-970-940 | 810-790-750 | 810-790-750 |
| P5.0c.PH | 15.12 | PH-hardened | 354,500 | 330 | 0.25 | 700-680-670 | 560-550-520 | 560-550-520 |
| P5.0.C.HT | 15.13 | Hardened | 311,000 | 330 | 0.25 | 760-740-720 | 610-590-570 | 610-590-570 |
| | | **Austenitic** | | | | | | |
| M1.0.C.UT | 15.21 | Austenitic | 261,000 | 200 | 0.25 | 990-960-940 | 850-830-790 | - |
| M1.0c.PH | 15.22 | PH-hardened | 356,000 | 330 | 0.25 | 700-690-670 | 570-550-520 | - |
| M2.0.C.AQ | 15.23 | Super austenitic | 310,500 | 200 | | - | - | - |
| | | **Austenitic-ferritic (Duplex)** | | | | | | |
| M3.1.C.AQ | 15.51 | Non-weldable ≥ 0.05%C | 258,000 | 230 | 0.25 | 960-940-910 | 700-680-650 | - |
| M3.2.C.AQ | 15.52 | Weldable < 0.05%C | 326,500 | 260 | 0.25 | 840-820-800 | 580-560-540 | - |

| ISO K | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CB50 | CC6190 | GC1010 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .004-.006-.008 | .004-.006-.012 | .004-.008-.012 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_{c_1}$ ft/min | | |
| | | **Malleable cast iron** | | | | | | |
| | 07.1 | Ferritic (short chipping) | 115,000 | 130 | 0.28 | - | 5000-4800-4550 | 810-800-760 |
| K1.1.C.NS | 07.2 | Pearlitic (long chipping) | 131,000 | 230 | 0.28 | - | 4100-3950-3750 | 670-660-630 |
| | | **Gray cast iron** | | | | | | |
| K2.1.C.UT | 08.1 | Low tensile strength | 130,000 | 180 | 0.28 | 3800-3650-3550 | 6050-5750-5500 | 890-870-830 |
| K2.2.C.UT | 08.2 | High tensile strength | 159,500 | 245 | 0.28 | 3550-3400-3300 | 4600-4400-4200 | 710-690-660 |
| | | **Nodular cast iron** | | | | | | |
| K3.1.C.UT | 09.1 | Ferritic | 130,000 | 160 | 0.28 | - | 3850-3700-3550 | 560-540-520 |
| K3.3.C.UT | 09.2 | Pearlitic | 194,500 | 250 | 0.28 | 2050-2000-1900 | 3200-3050-2900 | 520-500-480 |

.400 inch (10 mm)



1.000 inch (25 mm)

**Conditions:**

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



SANDVIK Coromant

| GC1025 | GC1130 | GC4220 | GC4330 | GC4340 | GC3040 | GC2030 | GC2040 | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Max chip thickness, $h_{ex}$ inch | | | | | | | | | | |
| .002-.004-.008 | .002-.004-.008 | .004-.006-.012 | .004-.006-.012 | .004-.008-.012 | .004-.006-.012 | .004- .006-.010 | .004-.008-.012 | | | |
| Cutting speed $v_c$, ft/min | | | | | | | | | | |
| 1200-1200-1150 | 1350-1300-1250 | 1850-1850-1700 | 1500-1450-1400 | 1300-1250-1200 | 1500-1450-1350 | 1100-1100-1050 | 1100-1050-1000 | | | |
| 1100-1050-1000 | 1200-1150-1100 | 1700-1650-1550 | 1350-1300-1250 | 1150-1100-1050 | 1350-1300-1200 | 1000-990-940 | 1000-960-920 | | | |
| 1000-1000-960 | 1150-1100-1050 | 1600-1550-1450 | 1300-1250-1200 | 1100-1050-1000 | 1250-1250-1150 | 950-930-880 | 950-900-860 | | | |
| 890-870-830 | 980-960-920 | 1400-1350-1250 | 1150-1100-1050 | 960-920-880 | 1100-1050-1000 | 830-820-780 | 830-800-760 | | | |
| 660-650-620 | 730-710-680 | 1000-1000-940 | 840-800-760 | 710-680-650 | 810-800-740 | 610-600-570 | 610-590-560 | | | |
| 990-970-930 | 930-910-870 | 1300-1300-1200 | 1050-1000-980 | 910-870-830 | 1050-1000-950 | 790-770-740 | 790-750-720 | | | |
| 550-540-520 | 610-590-570 | 860-840-780 | 700-670-640 | 590-570-540 | 680-660-620 | 510-500-480 | 510-490-470 | | | |
| 640-630-600 | 640-630-600 | 1150-1100-1050 | 740-700-670 | 630-600-570 | 790-770-720 | 590-580-550 | 590-570-540 | | | |
| 530-520-495 | 530-520-495 | 830-810-760 | 610-580-560 | 520-495-475 | 660-640-600 | 485-475-450 | 485-465-440 | | | |
| 465-455-435 | 465-455-435 | 720-700-660 | 530-510-485 | 455-435-415 | 570-560-520 | 425-415-400 | 425-405-390 | | | |
| 290-285-270 | 290-285-270 | 450-440-410 | 335-320-305 | 285-270-260 | 360-350-330 | 265-260-250 | 265-255-240 | | | |
| 860-840-810 | 860-840-810 | 1350-1300-1200 | 990-950-910 | 840-810-770 | 1050-1050-970 | 790-780-740 | 790-760-730 | | | |
| 690-670-640 | 690-670-640 | 1050-1050-970 | 790-760-720 | 670-640-610 | 850-830-770 | 640-630-600 | 640-610-580 | | | |
| 500-490-470 | 500-490-470 | 780-760-710 | 580-550-530 | 490-470-450 | 620-610-570 | 465-455-435 | 465-445-425 | | | |

| GC1130 | 1040 | S30T | S40T | GC2030 | GC2040 | GC4230 | GC4240 | GC1010 | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Max chip thickness, $h_{ex}$ inch | | | | | | | | | | |
| .002-.004-.008 | .002-.006-.010 | .002-.006.010 | .004-.008-.010 | .002-.006-.010 | .004-.008-.010 | .004-.008-.010 | .004-.008-.012 | .002-.004-.008 | | |
| Cutting speed $v_c$, ft/min | | | | | | | | | | |
| 910-890-840 | 680-640-600 | 930-870-810 | 970-920-900 | 860-820-780 | 930-890-860 | 1050-1000-990 | 820-780-740 | 1100-1100-1050 | | |
| 640-630-590 | 485-450-420 | 660-610-570 | 670-630-620 | 610-580-550 | 640-610-590 | 740-700-680 | 540-520-490 | 800-780-760 | | |
| 660-650-610 | 500-470-440 | 680-540-590 | 710-670-650 | 630-600-570 | 680-640-630 | 770-730-710 | 620-590-560 | 830-810-790 | | |
| 890-870-830 | 660-640-580 | 910-850-800 | 810-770-750 | 840-800-760 | 780-740-730 | - | 730-690-660 | 1050-1000-990 | | |
| 620-600-570 | 465-435-405 | 630-590-550 | 640-610-590 | 580-560-530 | 620-590-570 | - | 520-500-475 | 770-750-730 | | |
| - | 455-425-395 | 630-590-550 | 570-540-520 | - | - | - | - | 630-590-550 | | |
| 740-720-680 | 560-520-490 | 750-710-660 | 680-650-630 | 700-670-630 | 650-620-610 | - | 650-620-590 | 1000-990-970 | | |
| 620-610-580 | 465-435-405 | 640-600-560 | 550-520-510 | 590-560-530 | 530-500-490 | - | 530-500-475 | 900-880-860 | | |
| 810-790-750 | 610-570-530 | 830-770-720 | 860-820-800 | 770-730-690 | 830-790-770 | 950-900-880 | 730-690-660 | 990-970-940 | | |
| 560-550-520 | 420-390-365 | 580-540-500 | 580-550-540 | 530-500-475 | 560-530-520 | 650-610-600 | 475-455-430 | 700-680-670 | | |
| 610-590-570 | 455-425-400 | 620-580-550 | 650-620-600 | 580-550-520 | 620-590-580 | 710-670-650 | 570-540-510 | 760-740-720 | | |
| 850-830-790 | 640-590-550 | 870-810-760 | 780-740-720 | 800-760-720 | 750-710-690 | | 690-660-630 | 990-960-940 | | |
| 570-550-520 | 420-395-365 | 580-540-510 | 590-560-540 | 530-500-480 | 560-540-520 | | 480-455-430 | 700-690-670 | | |
| - | 415-385-360 | 570-530-495 | 510-480-470 | - | - | - | - | - | | |
| 700-680-650 | 530-495-460 | 710-670-620 | 640-610-600 | 670-630-600 | 620-590-570 | | 620-590-560 | 960-940-910 | | |
| 580-560-540 | 430-405-375 | 590-560-520 | 520-490-480 | 540-520-490 | 495-470-460 | | 490-465-440 | 840-820-800 | | |

| GC3220 | GC3330 | GC3040 | K20W | K20M | GC4230 | GC4240 | GC1020 | H13A | K20D | K15W |
|---|---|---|---|---|---|---|---|---|---|---|
| Max chip thickness, $h_{ex}$ inch | | | | | | | | | | |
| .004-.006-.010 | .004-.008-.012 | .004-.008-.012 | .004-.008-.012 | .004-.008-.012 | .004-.006-.010 | .004-.006-.010 | .004-.008-.012 | .004-.008-.012 | .004-.008-.012 | .004-.008-.012 |
| Cutting speed $v_c$, ft/min | | | | | | | | | | |
| 1000-1000-950 | 990-950-910 | 920-880-840 | 860-820-780 | 970-950-900 | 810-800-760 | 740-730-690 | 780-750-710 | 445-430-415 | 1000-970-930 | - |
| 840-820-790 | 820-780-750 | 760-720-690 | 710-670-650 | 800-790-740 | 670-660-630 | 610-600-570 | 640-620-590 | 365-355-340 | 840-800-770 | - |
| 1100-1100-1050 | 1100-1050-990 | 1000-950-910 | 930-890-850 | 1050-1030-985 | 890-870-830 | 810-790-760 | 850-810-780 | 485-465-450 | 1100-1050-1000 | 930-890-850 |
| 890-870-830 | 870-830-790 | 800-770-730 | 740-710-680 | 855-820-790 | 710-690-660 | 650-630-610 | 680-650-620 | 385-370-360 | 890-850-810 | 740-710-680 |
| 690-680-650 | 1100-1050-980 | 630-600-570 | 580-560-530 | 655-640-625 | 560-540-520 | 510-495-475 | 530-510-485 | 305-295-285 | 690-660-630 | - |
| 650-630-600 | 870-830-790 | 580-560-530 | 540-520-495 | 605-605-575 | 520-500-480 | 470-460-440 | 495-475-455 | 280-270-260 | 650-620-590 | - |

# Milling with small engagement, inch values

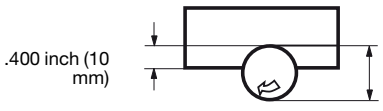
| ISO N | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CD10 | CT530 | H10 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .004-.006-.008 | .004-.006-.008 | .004-.006-.008 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_c$, ft/min | | |
| | | **Aluminum alloys** | | | | | | |
| N1.2.Z.UT | 30.11 | Wrought or wrought and coldworked, non-aging | 58,000 | 60 | | 6950-6800-6700 | 3800-3750-3700 | 3450-3400-3350 |
| N1.2.Z.AG | 30.12 | Wrought or wrought and aged | 94,500 | 100 | | 6250-6150-6050 | 3450-3400-3300 | 3100-3050-3000 |
| | | **Aluminum alloys** | | | | | | |
| N1.3.C.UT | 30.21 | Cast, non-aging | 87,000 | 75 | 0.25 | 6950-6800-6700 | 3800-3750-3700 | 3450-3400-3350 |
| N1.3.C.AG | 30.22 | Cast or cast and aged | 101,500 | 90 | 0.25 | 6250-6150-6050 | 3450-3400-3300 | 3150-3050-3000 |
| | | **Aluminum alloys** | | | | | | |
| N1.1.Z.UT | 30.3 | Al >99% | 50,500 | 30 | | 7000-6850-6750 | 3850-3750-3700 | 3500-3450-3350 |
| | | **Aluminum alloys** | | | | | | |
| | 30.41 | Cast, 13–15% Si | 101,500 | 130 | | 2800-2750-2700 | 1550-1500-1500 | 1400-1350-1350 |
| N1.4.C.NS | 30.42 | Cast, 16–22% Si | 101,500 | 130 | | 2100-2050-2000 | 1150-1150-1100 | 1050-1050-1000 |
| | | **Copper and copper alloys** | | | | | | |
| N3.3.U.UT | 33.1 | Free cutting alloys, ≥1% Pb | 79,500 | 110 | 0.25 | 3500-3400-3350 | 1900-1900-1850 | 1750-1700-1700 |
| N3.2.C.UT | 33.2 | Brass, leaded bronzes, ≤1% Pb | 80,000 | 90 | | 3450-3400-3350 | 1900-1900-1850 | 1750-1700-1700 |
| N3.1.U.UT | 33.3 | Bronze and non-leaded copper incl. electrolytic copper | 196,000 | 100 | 0.25 | 2450-2400-2350 | 1350-1300-1300 | 1200-1200-1150 |

| ISO S | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | GC1025 | GC1130 | GC1010 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .002-.006-.008 | .002-.006-.008 | .004-.006-.008 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_c$, ft/min | | |
| | | **Heat resistant super alloys** | | | | | | |
| | | **Iron base** | | | | | | |
| S1.0.U.AN | 20.11 | Annealed or solution treated | 348,000 | 200 | 0.25 | 235-225-220 | 235-225-220 | - |
| S1.0.U.AG | 20.12 | Aged or solution treated and aged | 359,000 | 280 | 0.25 | 175-170-165 | 175-170-165 | - |
| | | **Nickel base** | | | | | | |
| S2.0.Z.AN | 20.21 | Annealed or solution treated | 383,000 | 250 | 0.25 | 225-215-210 | 225-215-210 | - |
| S2.0.Z.AG | 20.22 | Aged or solution treated and aged | 420,500 | 350 | 0.25 | 140-135-130 | 140-135-130 | - |
| S2.0.C.NS | 20.24 | Cast or cast and aged | 436,500 | 320 | 0.25 | 175-165-160 | 175-165-160 | - |
| | | **Cobalt base** | | | | | | |
| S3.0.Z.AN | 20.31 | Annealed or solution treated | 391,500 | 200 | 0.25 | 100-95-90 | 100-95-90 | - |
| S3.0.Z.AG | 20.32 | Solution treated and aged | 432,000 | 300 | 0.25 | 70-65-65 | 70-65-65 | - |
| S3.0.C.NS | 20.33 | Cast or cast and aged | 450,500 | 320 | 0.25 | 65-60-60 | 65-60-60 | - |
| | | **Titanium alloys1)** | | Rm2) | | | | |
| S4.1.Z.UT | 23.1 | Commercial pure (99.5% Ti) | 188,500 | 400 | 0.23 | 495-470-460 | 495-470-460 | 560-540-520 |
| S4.2.Z.AN | 23.21 | α, near α and α + β alloys, annealed | 203,000 | 950 | 0.23 | 220-210-205 | 220-210-205 | 250-245-235 |
| S4.3.Z.AG | 23.22 | α + β alloys in aged cond., β alloys, annealed or aged | 203,000 | 1050 | 0.23 | 170-165-160 | 170-165-160 | 195-190-185 |

| ISO H | | | Specific cutting force $k_{c1}$ | Hardness Brinell | | CB50 | CT530 | GC1130 |
|---|---|---|---|---|---|---|---|---|
| | | | | | | Max chip thickness, $h_{ex}$ inch | | |
| | | | | | | .003-.005-.008 | .003-.004-.008 | .003-.005-.008 |
| MC No. | CMC No. | Material | lbs/in² | HB | mc | Cutting speed $v_c$, ft/min | | |
| | | **Extra hard steel** | | | | | | |
| H1.3.Z.HA | 04.1 | Hardened and tempered | 606,500 | 59 HRC | 0.25 | 610-600-570 | 305-300-285 | 155-150-140 |
| | | **Chilled cast iron** | | | | | | |
| H2.0.C.UT | 10.1 | Cast or cast and aged | 326,500 | 400 | 0.28 | 1150-1150-1100 | 580-570-540 | 295-285-270 |

1) 30-45° lead angle. Positive cutting geometry and coolant should be used.

2) Rm = ultimate tensile strength measured in MPa.




**Conditions:**

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



SANDVIK Coromant

| GC1025 | GC1130 | H10F | H13A | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ inch** | | | | | | | | | | |
| .004-.006-.008 | .004-.006-.008 | .004-.006-.008 | .004-.006-.008 | | | | | | | |
| **Cutting speed $v_c$, ft/min** | | | | | | | | | | |
| 3650-3600-3500 | 3650-3600-3500 | 3450-3400-3350 | 2750-2700-2700 | | | | | | | |
| 3300-3200-3150 | 3300-3200-3150 | 3100-3050-3000 | 2500-2450-2400 | | | | | | | |
| 3650-3600-3500 | 3650-3600-3500 | 3450-3400-3350 | 2750-2700-2700 | | | | | | | |
| 3650-3600-3500 | 3650-3600-3500 | 3150-3050-3000 | 2500-2450-2400 | | | | | | | |
| 3650-3600-3550 | 3650-3600-3550 | 3500-3450-3350 | 2800-2750-2700 | | | | | | | |
| 1450-1450-1400 | 1450-1450-1400 | 1400-1350-1350 | 1100-1100-1100 | | | | | | | |
| 1100-1100-1050 | 1100-1100-1050 | 1050-1050-1000 | 840-820-810 | | | | | | | |
| 1850-1800-1750 | 1850-1800-1750 | 1750-1700-1700 | 1400-1350-1350 | | | | | | | |
| 1850-1800-1750 | 1850-1800-1750 | 1750-1700-1700 | 1400-1350-1350 | | | | | | | |
| 1250-1250-1250 | 1250-1250-1250 | 1200-1200-1150 | 970-950-940 | | | | | | | |

| H13A | H10F | S30T | S40T | GC2030 | GC2040 | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ inch** | | | | | | | | | | |
| .004-.006-.008 | .004-.008-.012 | .004-.006-.008 | .004-.006-.008 | .002-.006-.008 | .002-.006-.010 | | | | | |
| **Cutting speed $v_c$, ft/min** | | | | | | | | | | |
| 220-215-215 | 200-195-190 | - | - | 220-210-205 | 225-215-210 | | | | | |
| 160-160-155 | 150-145-140 | - | - | 165-155-155 | 165-160-150 | | | | | |
| 210-210-205 | 195-185-180 | - | - | 210-200-195 | 215-210-200 | | | | | |
| 130-130-125 | 115-115-110 | - | - | 130-125-125 | 135-130-125 | | | | | |
| 160-160-155 | 145-140-135 | - | - | 160-155-150 | 165-155-150 | | | | | |
| 90-90-85 | 85-80-75 | - | - | 90-90-85 | 90-90-85 | | | | | |
| 65-65-60 | 60-55-55 | - | - | 65-65-60 | 65-65-60 | | | | | |
| 60-60-60 | 55-55-50 | - | - | 60-60-55 | 60-60-55 | | | | | |
| 465-455-445 | 420-405-395 | 560-540-520 | 485-470-460 | 460-440-430 | 480-455-445 | | | | | |
| 185-180-175 | 165-160-155 | 250-245-235 | 175-170-170 | 185-180-175 | 170-160-160 | | | | | |
| 140-140-135 | 125-120-115 | 195-190-185 | 145-145-140 | 160-150-150 | 145-135-135 | | | | | |

| GC4220 | GC3040 | GC1010 | GC1025 | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| **Max chip thickness, $h_{ex}$ inch** | | | | | | | | | | |
| .004-.005-.010 | .004-.008-.010 | .003-.005-.008 | .003-.005-.008 | | | | | | | |
| **Cutting speed $v_c$, ft/min** | | | | | | | | | | |
| 215-215-195 | 175-165-160 | 420-405-390 | 155-150-140 | | | | | | | |
| 410-400-370 | 335-315-305 | 810-790-750 | 295-285-270 | | | | | | | |

# Face milling tools

## CoroMill® 345

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 345L-1305M-PM | 0.3 | (0.16-0.4) | 0.21 | (0.11-0.28) | .012 | (.006-.016) | .008 | (.004-.011) |
| 345R-1305E-KL | 0.11 | (0.07-0.2) | 0.08 | (0.05-0.14) | .004 | (.003-.008) | .003 | (.002-.006) |
| 345R-1305E-KM | 0.3 | (0.16-0.4) | 0.21 | (0.11-0.28) | .012 | (.006-.016) | .008 | (.004-.011) |
| 345R-1305E-PL | 0.11 | (0.07-0.2) | 0.08 | (0.05-0.14) | .004 | (.003-.008) | .003 | (.002-.006) |
| 345R-1305M-KH | 0.35 | (0.3-0.49) | 0.25 | (0.21-0.35) | .014 | (.012-.019) | .010 | (.008-.014) |
| 345R-1305M-KL | 0.16 | (0.07-0.23) | 0.11 | (0.05-0.16) | .006 | (.003-.009) | .004 | (.002-.006) |
| 345R-1305M-KM | 0.3 | (0.16-0.4) | 0.21 | (0.11-0.28) | .012 | (.006-.016) | .008 | (.004-.011) |
| 345R-1305M-PH | 0.45 | (0.35-0.55) | 0.32 | (0.25-0.39) | .018 | (.014-.022) | .013 | (.010-.015) |
| 345R-1305M-PL | 0.17 | (0.07-0.21) | 0.12 | (0.05-0.15) | .007 | (.003-.008) | .005 | (.002-.006) |
| 345R-1305M-PM | 0.3 | (0.16-0.4) | 0.21 | (0.11-0.28) | .012 | (.006-.016) | .008 | (.004-.011) |
| 345R-13T5E-ML | 0.11 | (0.07-0.2) | 0.08 | (0.05-0.14) | .004 | (.003-.008) | .003 | (.002-.006) |
| 345R-13T5E-MM | 0.11 | (0.07-0.2) | 0.08 | (0.05-0.14) | .004 | (.003-.008) | .003 | (.002-.006) |
| 345R-13T5M-MM | 0.25 | (0.16-0.34) | 0.18 | (0.11-0.24) | .010 | (.006-.013) | .007 | (.004-.009) |

## CoroMill® 245

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R245-12T3E | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) | .009 | (.004-.011) | .004 | (.002-.006) |
| R245-12T3E-AL | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| R245-12T3E-KL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| R245-12T3E-ML | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| R245-12T3E-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| R245-12T3K-MM | 0.23 | (0.1-0.28) | 0.16 | (0.07-0.2) | .009 | (.004-.011) | .006 | (.003-.008) |
| R245-12T3M-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| R245-12T3M-KL | 0.17 | (0.08-0.21) | 0.12 | (0.06-0.15) | .007 | (.003-.008) | .005 | (.002-.006) |
| R245-12T3M-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| R245-12T3M-PH1 | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| R245-12T3M-PL1 | 0.17 | (0.08-0.21) | 0.12 | (0.06-0.15) | .007 | (.003-.008) | .005 | (.002-.006) |
| R245-12T3M-PM1 | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| R245-18T6M-KM | 0.28 | (0.16-0.49) | 0.2 | (0.11-0.35) | .011 | (.006-.019) | .008 | (.004-.014) |
| R245-18T6M-MM | 0.28 | (0.16-0.49) | 0.2 | (0.11-0.35) | .011 | (.006-.019) | .008 | (.004-.014) |
| R245-18T6M-PM | 0.28 | (0.16-0.49) | 0.2 | (0.11-0.35) | .011 | (.006-.019) | .008 | (.004-.014) |

## CoroMill® 419

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 419N-140530E-SM | 0.61 | (0.4-1.2) | 0.2 | (0.13-0.39) | .024 | (.016-.047) | .008 | (.005-.015) |
| 419N-140530M-KH | 0.98 | (0.49-2) | 0.32 | (0.16-0.65) | .039 | (.019-.079) | .013 | (.006-.026) |
| 419R-1405E-MM | 0.71 | (0.34-1.2) | 0.23 | (0.11-0.39) | .028 | (.013-.047) | .009 | (.004-.015) |
| 419R-1405M-PH | 0.98 | (0.46-2) | 0.32 | (0.15-0.65) | .039 | (.018-.079) | .013 | (.006-.026) |
| 419R-1405M-PM | 0.8 | (0.4-1.78) | 0.26 | (0.13-0.58) | .031 | (.016-.070) | .010 | (.005-.023) |

## CoroMill® 210

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R210-090412M-KM | 0.98 | (0.4-1.5) | 0.17 | (0.07-0.26) | .039 | (.016-.059) | .007 | (.003-.010) |
| R210-090412M-MM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) | .059 | (.016-.08) | .010 | (.003-.014) |
| R210-090412M-PM | 0.98 | (0.4-1.5) | 0.17 | (0.07-0.26) | .039 | (.016-.059) | .007 | (.003-.010) |
| R210-090414E-KM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) | .059 | (.016-.080) | .010 | (.003-.014) |
| R210-090414E-MM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) | .059 | (.016-.080) | .010 | (.003-.014) |
| R210-090414E-PM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) | .059 | (.016-.080) | .010 | (.003-.014) |
| R210-140512M-KM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) | .059 | (.016-.080) | .010 | (.003-.014) |
| R210-140512M-MM | 2.02 | (0.4-2.99) | 0.35 | (0.07-0.52) | .080 | (.016-.118) | .014 | (.003-.020) |
| R210-140512M-PM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) | .059 | (.016-.080) | .010 | (.003-.014) |
| R210-140514E-KM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) | .059 | (.016-.080) | .010 | (.003-.014) |
| R210-140514E-MM | 2.02 | (0.4-2.99) | 0.35 | (0.07-0.52) | .080 | (.016-.118) | .014 | (.003-.020) |
| R210-140514E-PM | 1.5 | (0.4-2.02) | 0.26 | (0.07-0.35) | .059 | (.016-.080) | .010 | (.003-.014) |

## CoroMill® 425

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 425N-1707E-KLW12 | 0.19 | (0.02-0.28) | 0.08 | (0.01-0.12) | .007 | (.001-.011) | .003 | (0-.005) |

# Face milling tools

## CoroMill® 415

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 415N-050206M-M30 | 0.39 | (0.3-0.5) | 0.10 | (0.078-0.129) | .015 | (.012-.020) | .004 | (.003-.005) |
| 415N-070310M-M30 | 0.46 | (0.35-0.55) | 0.12 | (0.091-0.142) | .018 | (.014-.022) | .005 | (.004-.006) |
| 415N-070320E-M30 | 0.46 | (0.35-0.55) | 0.12 | (0.091-0.142) | .018 | (.014-.022) | .005 | (.004-.006) |
| 415N-070320M-M30 | 0.46 | (0.35-0.55) | 0.12 | (0.091-0.142) | .018 | (.014-.022) | .005 | (.004-.006) |
| 415N-050212E-M30 | 0.39 | (0.3-0.5) | 0.10 | (0.078-0.129) | .015 | (.012-.020) | .004 | (.003-.005) |
| 415N-050212M-M30 | 0.39 | (0.3-0.5) | 0.10 | (0.078-0.129) | .015 | (.012-.020) | .004 | (.003-.005) |

## CoroMill® 745

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 745L-2109E-M50 | 0.25 | (0.18-0.42) | 0.17 | (0.12-0.28) | .010 | (.007-.017) | .007 | (.005-.011) |
| * | 0.61 | (0.44-1.02) | 0.17 | (0.12-0.28) | .024 | (.017-.040) | .007 | (.005-.011) |
| 745R-2109E-H50 | 0.3 | (0.21-0.45) | 0.2 | (0.14-0.30) | .012 | (.008-.018) | .008 | (.006-.012) |
| * | 0.73 | (0.51-1.09) | 0.2 | (0.14-0.30) | .029 | (.020-.043) | .008 | (.006-.012) |
| 745R-2109E-M30 | 0.21 | (0.15-0.3) | 0.14 | (0.10-0.20) | .008 | (.006-.012) | .006 | (.004-.008) |
| * | 0.51 | (0.36-0.73) | 0.14 | (0.10-0.20) | .020 | (.014-.029) | .006 | (.004-.008) |
| 745R-2109E-M31 | 0.21 | (0.15-0.3) | 0.14 | (0.1-0.2) | .008 | (.006-.012) | .006 | (.004-.008) |
| 745R-2109E-M50 | 0.25 | (0.18-0.42) | 0.17 | (0.12-0.28) | .010 | (.007-.017) | .007 | (.005-.011) |
| * | 0.61 | (0.44-0.90) | 0.17 | (0.12-0.28) | .024 | (.017-.035) | .007 | (.005-.011) |

* High-feed cutter

# Shoulder milling tools

## CoroMill® 490

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 490L-140408M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) | .007 | (.005-.010) | .007 | (.005-.010) |
| 490R-08T304E-ML | 0.13 | (0.08-0.18) | 0.13 | (0.08-0.18) | .005 | (.003-.007) | .005 | (.003-.007) |
| 490R-08T304M-KL | 0.12 | (0.05-0.15) | 0.12 | (0.05-0.15) | .005 | (.002-.006) | .005 | (.002-.006) |
| 490R-08T304M-PL | 0.08 | (0.05-0.12) | 0.08 | (0.05-0.12) | .003 | (.002-.005) | .003 | (.002-.005) |
| 490R-08T308E-ML | 0.14 | (0.08-0.18) | 0.14 | (0.08-0.18) | .006 | (.003-.007) | .006 | (.003-.007) |
| 490R-08T308E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) | .007 | (.005-.009) | .007 | (.005-.009) |
| 490R-08T308M-KH | 0.24 | (0.15-0.3) | 0.24 | (0.15-0.3) | .009 | (.006-.012) | .009 | (.006-.012) |
| 490R-08T308M-KL | 0.12 | (0.05-0.15) | 0.12 | (0.05-0.15) | .005 | (.002-.006) | .005 | (.002-.006) |
| 490R-08T308M-KM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) | .007 | (.004-.008) | .007 | (.004-.008) |
| 490R-08T308M-MM | 0.16 | (0.1-0.2) | 0.16 | (0.1-0.2) | .006 | (.004-.008) | .006 | (.004-.008) |
| 490R-08T308M-PH | 0.2 | (0.15-0.25) | 0.2 | (0.15-0.25) | .008 | (.006-.010) | .008 | (.006-.010) |
| 490R-08T308M-PL | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) | .004 | (.002-.006) | .004 | (.002-.006) |
| 490R-08T308M-PM | 0.15 | (0.1-0.2) | 0.15 | (0.1-0.2) | .006 | (.004-.008) | .006 | (.004-.008) |
| 490R-08T312E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) | .007 | (.005-.009) | .007 | (.005-.009) |
| 490R-08T312M-KM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) | .007 | (.004-.008) | .007 | (.004-.008) |
| 490R-08T312M-PM | 0.14 | (0.08-0.18) | 0.14 | (0.08-0.18) | .006 | (.003-.007) | .006 | (.003-.007) |
| 490R-08T316E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) | .007 | (.005-.009) | .007 | (.005-.009) |
| 490R-08T316M-KH | 0.24 | (0.15-0.3) | 0.24 | (0.15-0.3) | .009 | (.006-.012) | .009 | (.006-.012) |
| 490R-08T316M-KM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) | .007 | (.004-.008) | .007 | (.004-.008) |
| 490R-08T316M-PH | 0.21 | (0.15-0.25) | 0.21 | (0.15-0.25) | .008 | (.006-.010) | .008 | (.006-.010) |
| 490R-08T316M-PM | 0.14 | (0.08-0.18) | 0.14 | (0.08-0.18) | .006 | (.003-.007) | .006 | (.003-.007) |
| 490R-140408E | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) | .004 | (.003-.006) | .004 | (.003-.006) |
| 490R-140408E-ML | 0.14 | (0.08-0.18) | 0.14 | (0.08-0.18) | .006 | (.003-.007) | .006 | (.003-.007) |
| 490R-140408E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) | .007 | (.005-.009) | .007 | (.005-.009) |
| 490R-140408M-MM | 0.16 | (0.12-0.2) | 0.16 | (0.12-0.2) | .006 | (.005-.008) | .006 | (.005-.008) |
| 490R-140408M-PH | 0.28 | (0.2-0.35) | 0.28 | (0.2-0.35) | .011 | (.008-.014) | .011 | (.008-.014) |
| 490R-140408M-PL | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) | .004 | (.002-.006) | .004 | (.002-.006) |
| 490R-140408M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) | .007 | (.005-.010) | .007 | (.005-.010) |
| 490R-140412E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) | .007 | (.005-.009) | .007 | (.005-.009) |
| 490R-140412M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) | .007 | (.005-.010) | .007 | (.005-.010) |
| 490R-140416E-MM | 0.17 | (0.12-0.22) | 0.17 | (0.12-0.22) | .007 | (.005-.009) | .007 | (.005-.009) |
| 490R-140416M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) | .007 | (.005-.010) | .007 | (.005-.010) |
| 490R-140420E | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) | .004 | (.003-.006) | .004 | (.003-.006) |
| 490R-140420E-MM | 0.16 | (0.12-0.2) | 0.17 | (0.12-0.22) | .006 | (.005-.008) | .007 | (.005-.009) |
| 490R-140420M-MM | 0.16 | (0.12-0.2) | 0.16 | (0.12-0.2) | .006 | (.005-.008) | .006 | (.005-.008) |
| 490R-140420M-PH | 0.28 | (0.2-0.35) | 0.28 | (0.2-0.35) | .011 | (.008-.014) | .011 | (.008-.014) |
| 490R-140420M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) | .007 | (.005-.010) | .007 | (.005-.010) |

# Shoulder milling tools

## CoroMill® 390

| | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| **Ordering code** | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 390R-070202E-ML | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) | .002 | (.001-.003) | .002 | (.001-.003) |
| 390R-070202E-NL | 0.1 | (0.02-0.2) | 0.1 | (0.02-0.2) | .004 | (.001-.008) | .004 | (.001-.008) |
| 390R-070202E-PL | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) | .002 | (.001-.003) | .002 | (.001-.003) |
| 390R-070202M-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070202M-PM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070204E-KL | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) | .003 | (.001-.004) | .002 | (.001-.003) |
| 390R-070204E-ML | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) | .002 | (.001-.003) | .002 | (.001-.003) |
| 390R-070204E-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070204E-NL | 0.05 | (0.02-0.07) | 0.1 | (0.02-0.2) | .002 | (.001-.003) | .004 | (.001-.008) |
| 390R-070204E-PL | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) | .002 | (.001-.003) | .002 | (.001-.003) |
| 390R-070204M-KM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070204M-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070204M-PM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070208E-KL | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) | .003 | (.001-.004) | .002 | (.001-.003) |
| 390R-070208E-ML | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) | .002 | (.001-.003) | .002 | (.001-.003) |
| 390R-070208E-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070208E-NL | 0.05 | (0.02-0.07) | 0.1 | (0.02-0.2) | .002 | (.001-.003) | .004 | (.001-.008) |
| 390R-070208E-PL | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) | .002 | (.001-.003) | .002 | (.001-.003) |
| 390R-070208M-KM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070208M-MM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070208M-PM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070212E-ML | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) | .003 | (.001-.004) | .002 | (.001-.003) |
| 390R-070212E-PL | 0.05 | (0.02-0.07) | 0.05 | (0.02-0.07) | .002 | (.001-.003) | .002 | (.001-.003) |
| 390R-070212M-MM | 0.1 | (0.02-0.2) | 0.07 | (0.03-0.1) | .004 | (.001-.008) | .003 | (.001-.004) |
| 390R-070212M-PM | 0.07 | (0.03-0.1) | 0.07 | (0.03-0.1) | .003 | (.001-.004) | .003 | (.001-.004) |
| 390R-070216E-ML | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) | .003 | (.001-.004) | .002 | (.001-.003) |
| 390R-070216E-PL | 0.07 | (0.03-0.1) | 0.05 | (0.02-0.07) | .003 | (.001-.004) | .002 | (.001-.003) |
| 390R-070216M-KM | 0.05 | (0.02-0.07) | 0.07 | (0.03-0.1) | .002 | (.001-.003) | .003 | (.001-.004) |
| 390R-070216M-MM | 0.1 | (0.02-0.2) | 0.07 | (0.03-0.1) | .004 | (.001-.008) | .003 | (.001-.004) |
| 390R-070216M-PM | 0.12 | (0.08-0.2) | 0.07 | (0.03-0.1) | .005 | (.003-.008) | .003 | (.001-.004) |
| R390-11T302E-KM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.18) | .004 | (.003-.006) | .004 | (.003-.007) |
| R390-11T302E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T302E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T304E-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-11T304M-KM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) | .004 | (.003-.006) | .004 | (.003-.006) |
| R390-11T304M-PM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) | .004 | (.003-.006) | .004 | (.003-.006) |
| R390-11T308E-KL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-11T308E-ML | 0.08 | (0.04-0.15) | 0.08 | (0.04-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-11T308E-NL | 0.18 | (0.06-0.35) | 0.15 | (0.05-0.25) | .007 | (.002-.014) | .006 | (.002-.010) |
| R390-11T308E-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-11T308E-PLW | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T308M-KL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-11T308M-KM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T308M-MM | 0.13 | (0.08-0.2) | 0.13 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T308M-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-11T308M-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T310M-KH | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T310M-MH | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T310M-PH | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T312E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-11T312E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T312E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T316E-KM | 0.15 | (0.1-0.25) | 0.1 | (0.08-0.18) | .006 | (.004-.010) | .004 | (.003-.007) |
| R390-11T316E-ML | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T316E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T316E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T316M-KM | 0.12 | (0.08-0.2) | 0.15 | (0.1-0.25) | .005 | (.003-.008) | .006 | (.004-.010) |
| R390-11T316M-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T320E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-11T320E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T320E-NL | 0.18 | (0.06-0.4) | 0.18 | (0.06-0.35) | .007 | (.002-.016) | .007 | (.002-.014) |
| R390-11T320E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T324E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-11T324E-ML | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T324E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T324E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T331E-KM | 0.15 | (0.1-0.25) | 0.1 | (0.08-0.18) | .006 | (.004-.010) | .004 | (.003-.007) |
| R390-11T331E-ML | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T331E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T331E-NL | 0.18 | (0.06-0.4) | 0.18 | (0.06-0.4) | .007 | (.002-.016) | .007 | (.002-.016) |
| R390-11T331E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T331M-KM | 0.12 | (0.08-0.2) | 0.15 | (0.1-0.25) | .005 | (.003-.008) | .006 | (.004-.010) |
| R390-11T331M-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-11T304E-P4-NL | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) | .007 | (.004-.008) | .007 | (.004-.008) |
| R390-170404E-KM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.18) | .004 | (.003-.006) | .004 | (.003-.007) |
| R390-170404E-MM | 0.15 | (0.08-0.2) | 0.12 | (0.08-0.2) | .006 | (.003-.008) | .005 | (.003-.008) |

# Shoulder milling tools

## CoroMill® 390

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R390-170404E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170404M-KM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) | .004 | (.003-.006) | .004 | (.003-.006) |
| R390-170404M-PM | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) | .004 | (.003-.006) | .004 | (.003-.006) |
| R390-170408E-KL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-170408E-ML | 0.08 | (0.04-0.15) | 0.08 | (0.04-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-170408E-NL | 0.17 | (0.1-0.2) | 0.15 | (0.08-0.25) | .007 | (.004-.008) | .006 | (.003-.010) |
| R390-170408E-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-170408M-KH | 0.2 | (0.15-0.35) | 0.2 | (0.15-0.35) | .008 | (.006-.014) | .008 | (.006-.014) |
| R390-170408M-KL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-170408M-KM | 0.15 | (0.1-0.25) | 0.15 | (0.1-0.25) | .006 | (.004-.010) | .006 | (.004-.010) |
| R390-170408M-MM | 0.15 | (0.08-0.2) | 0.15 | (0.08-0.2) | .006 | (.003-.008) | .006 | (.003-.008) |
| R390-170408M-PH | 0.2 | (0.15-0.35) | 0.2 | (0.15-0.35) | .008 | (.006-.014) | .008 | (.006-.014) |
| R390-170408M-PL | 0.08 | (0.05-0.15) | 0.08 | (0.05-0.15) | .003 | (.002-.006) | .003 | (.002-.006) |
| R390-170408M-PM | 0.15 | (0.1-0.25) | 0.15 | (0.1-0.25) | .006 | (.004-.010) | .006 | (.004-.010) |
| R390-170412E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-170412E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170412E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170416E-KM | 0.15 | (0.1-0.25) | 0.1 | (0.08-0.18) | .006 | (.004-.010) | .004 | (.003-.007) |
| R390-170416E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170416E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170416M-KM | 0.12 | (0.08-0.2) | 0.15 | (0.1-0.25) | .005 | (.003-.008) | .006 | (.004-.010) |
| R390-170416M-PH | 0.2 | (0.15-0.35) | 0.2 | (0.15-0.35) | .008 | (.006-.014) | .008 | (.006-.014) |
| R390-170416M-PM | 0.15 | (0.1-0.25) | 0.15 | (0.1-0.25) | .006 | (.004-.010) | .006 | (.004-.010) |
| R390-170420E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-170420E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170420E-NL | 0.2 | (0.12-0.32) | 0.2 | (0.1-0.3) | .008 | (.005-.013) | .008 | (.004-.012) |
| R390-170420E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170424E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-170424E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170424E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170431E-KM | 0.15 | (0.1-0.25) | 0.1 | (0.08-0.18) | .006 | (.004-.010) | .004 | (.003-.007) |
| R390-170431E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170431E-NL | 0.2 | (0.12-0.32) | 0.2 | (0.12-0.32) | .008 | (.005-.013) | .008 | (.005-.013) |
| R390-170431E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170431M-KM | 0.12 | (0.08-0.2) | 0.15 | (0.1-0.25) | .005 | (.003-.008) | .006 | (.004-.010) |
| R390-170431M-PM | 0.15 | (0.1-0.25) | 0.15 | (0.1-0.25) | .006 | (.004-.010) | .006 | (.004-.010) |
| R390-170440E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-170440E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170440E-NL | 0.2 | (0.12-0.4) | 0.2 | (0.12-0.32) | .008 | (.005-.016) | .008 | (.005-.013) |
| R390-170440E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170448E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-170448E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170448E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170450E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-170450E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170450E-NL | 0.2 | (0.12-0.4) | 0.2 | (0.12-0.4) | .008 | (.005-.016) | .008 | (.005-.016) |
| R390-170450E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170460E-KM | 0.1 | (0.08-0.18) | 0.1 | (0.08-0.18) | .004 | (.003-.007) | .004 | (.003-.007) |
| R390-170460E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170460E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170464E-KM | 0.08 | (0.04-0.15) | 0.1 | (0.08-0.18) | .003 | (.002-.006) | .004 | (.003-.007) |
| R390-170464E-MM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170464E-PM | 0.12 | (0.08-0.2) | 0.12 | (0.08-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R390-170408E-P6-NL | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) | .007 | (.004-.008) | .007 | (.004-.008) |
| R390-180608H-KL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) | .004 | (.002-.009) | .004 | (.002-.009) |
| R390-180608H-ML | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) | .004 | (.002-.009) | .004 | (.002-.009) |
| R390-180608H-PL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) | .004 | (.002-.009) | .004 | (.002-.009) |
| R390-180608M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180608M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) | .007 | (.004-.012) | .007 | (.004-.012) |
| R390-180608M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180612H-KL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) | .004 | (.002-.009) | .004 | (.002-.009) |
| R390-180612H-ML | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) | .004 | (.002-.009) | .004 | (.002-.009) |
| R390-180612H-PL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) | .004 | (.002-.009) | .004 | (.002-.009) |
| R390-180612M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180612M-KMR | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180612M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) | .007 | (.004-.012) | .007 | (.004-.012) |
| R390-180612M-MMR | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) | .007 | (.004-.012) | .007 | (.004-.012) |
| R390-180612M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180612M-PMR | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180616H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180616H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180616M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180616M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) | .007 | (.004-.012) | .007 | (.004-.012) |
| R390-180616M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180620H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180620H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |

# Shoulder milling tools

## CoroMill® 390

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R390-180620M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180620M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) | .007 | (.004-.012) | .007 | (.004-.012) |
| R390-180620M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180624H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180624H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180631H-KL | 0.11 | (0.05-0.22) | 0.11 | (0.05-0.22) | .004 | (.002-.009) | .004 | (.002-.009) |
| R390-180631H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180631H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180631M-KM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180631M-MM | 0.18 | (0.1-0.3) | 0.18 | (0.1-0.3) | .007 | (.004-.012) | .007 | (.004-.012) |
| R390-180631M-PM | 0.2 | (0.08-0.3) | 0.2 | (0.08-0.3) | .008 | (.003-.012) | .008 | (.003-.012) |
| R390-180640H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180640H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180650H-ML | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180650H-PL | 0.12 | (0.05-0.22) | 0.12 | (0.05-0.22) | .005 | (.002-.009) | .005 | (.002-.009) |
| R390-180660H-ML | 0.14 | (0.05-0.22) | 0.14 | (0.05-0.22) | .006 | (.002-.009) | .006 | (.002-.009) |
| R390-180660H-PL | 0.14 | (0.05-0.22) | 0.14 | (0.05-0.22) | .006 | (.002-.009) | .006 | (.002-.009) |
| R390-180664H-ML | 0.14 | (0.05-0.22) | 0.14 | (0.05-0.22) | .006 | (.002-.009) | .006 | (.002-.009) |
| R390-180664H-PL | 0.14 | (0.05-0.22) | 0.14 | (0.05-0.22) | .006 | (.002-.009) | .006 | (.002-.009) |

## CoroMill® 690

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 690-100508M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-100510M-P-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-100512M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-100516M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-100520M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-100531M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140608M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140610M-P-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140612M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140616M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140620M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140624M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140631M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140650M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140660M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |
| 690-140664M-E-SL | 0.1 | (0.05-0.2) | 0.1 | (0.05-0.2) | .004 | (.002-.008) | .004 | (.002-.008) |

## CoroMill® Century

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R590-110504H-NL | 0.15 | (0.05-0.3) | 0.2 | (0.1-0.4) | .006 | (.002-.012) | .008 | (.004-.016) |
| R590-110508H-KL | 0.12 | (0.07-0.2) | 0.08 | (0.05-0.15) | .005 | (.003-.008) | .003 | (.002-.006) |
| R590-110508H-PL | 0.12 | (0.01-0.15) | 0.08 | (0.05-0.15) | .005 | (0-.006) | .003 | (.002-.006) |
| R590-110508H-PR2-KM | 0.2 | (0.1-0.4) | 0.2 | (0.1-0.3) | .008 | (.004-.016) | .008 | (.004-.012) |
| R590-1105H-PC2-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) | .006 | (.002-.012) | .006 | (.002-.012) |
| R590-1105H-PC5-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) | .006 | (.002-.012) | .006 | (.002-.012) |
| R590-1105H-PR2-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) | .006 | (.002-.012) | .006 | (.002-.012) |
| R590-1105H-PR5-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) | .006 | (.002-.012) | .006 | (.002-.012) |
| R590-1105H-PS2-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) | .006 | (.002-.012) | .006 | (.002-.012) |
| R590-1105H-PS5-NL | 0.15 | (0.05-0.3) | 0.15 | (0.05-0.3) | .006 | (.002-.012) | .006 | (.002-.012) |
| L590-1105H-ZC2-KL | 0.08 | (0.05-0.15) | 0.2 | (0.1-0.3) | .003 | (.002-.006) | .008 | (.004-.012) |
| R590-1105H-ZC2-KL | 0.2 | (0.1-0.3) | 0.2 | (0.1-0.3) | .008 | (.004-.012) | .008 | (.004-.012) |

# Disc milling tools

## CoroMill® 331

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| L331.1A-115030E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) | .004 | (.0007-.0047) | .0031 | (.0007-.0039) |
| L331.1A-115040E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) | .004 | (.0007-.0047) | .0031 | (.0007-.0039) |
| L331.1A-115048E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) | .004 | .0007-.0047 | .0031 | (.0007-.0039) |
| L331.1A-115063E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) | .004 | (.0007-.0047) | .0031 | (.0007-.0039) |
| L331.1A-115015E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .0047 | (.0015-.0066) |
| L331.1A-115023E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .0047 | (.0015-.0066) |
| L331.1A-115030E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .0047 | (.0015-.0066) |
| L331.1A-043515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-043523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-054515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-054523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-054530H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-084515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-084523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-084530H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-115015H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-115023H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-115030H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-115048H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-115063H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-145015H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-145023H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-145030H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-145048H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| L331.1A-145063H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-115030E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) | .004 | (.0007-.0047) | .0031 | (.0007-.0039) |
| R331.1A-115040E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) | .004 | (.0007-.0047) | .0031 | (.0007-.0039) |
| R331.1A-115048E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) | .004 | (.0007-.0047) | .0031 | (.0007-.0039) |
| R331.1A-115063E-L50 | 0.10 | (0.02-0.12) | 0.08 | (0.02-0.10) | .004 | (.0007-.0047) | .0031 | (.0007-.0039) |
| R331.1A-115015E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .0047 | (.0015-.0066) |
| R331.1A-115023E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .0047 | (.0015-.0066) |
| R331.1A-115030E-M30 | 0.14 | (0.05-0.20) | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .0047 | (.0015-.0066) |
| R331.1A-043515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-043523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-054515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-054523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-054530H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-084515H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-084523H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-084530H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-115015H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-115023H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-115030H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-115048H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-115063H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-145015H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-145023H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-145030H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-145048H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| R331.1A-145063H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-043505E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) | .002 | (.0004-.003) | .002 | (.0004- .0027) |
| N331.1A-043505E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) | .004 | (.0007-.007) | .003 | (.0007-.0059) |
| N331.1A-043505E-M30 | 0.14 | (0.05-0.20 | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .005 | (.0019- .0078) |
| N331.1A-054508E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) | .002 | (.0004-.003) | .002 | (.0004-.0027) |
| N331.1A-054508E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) | .004 | (.0007-.007) | .003 | (.0007-.0059) |
| N331.1A-054508E-M30 | 0.14 | (0.05-0.20 | 0.12 | (0.01-0.07) | .006 | (.0019-.0078) | .005 | (.0019- .0078) |
| N331.1A-084508E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) | .002 | (.0004-.003) | .002 | (.0004-.0027) |
| N331.1A-084508E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) | .004 | (.0007-.007) | .003 | (.0007-.0059) |
| N331.1A-084508E-M30 | 0.14 | (0.05-0.20 | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .005 | (.0019- .0078) |
| N331.1A-115008E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) | .002 | (.0004-.003) | .002 | (.0004-.0027) |
| N331.1A-115008E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) | .004 | (.0007-.007) | .003 | (.0007-.0059) |
| N331.1A-115008E-M30 | 0.14 | (0.05-0.20 | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .005 | (.0019- .0078) |
| N331.1A-145008E-L30 | 0.06 | (0.01-0.08) | 0.05 | (0.01-0.07) | .002 | (.0004-.003) | .002 | (.0004-.0027) |
| N331.1A-145008E-L50 | 0.10 | (0.02-0.18) | 0.08 | (0.02-0.15) | .004 | (.0007-.007) | .003 | (.0007-.0059) |
| N331.1A-145008E-M30 | 0.14 | (0.05-0.20 | 0.12 | (0.04-0.17) | .006 | (.0019-.0078) | .005 | (.0019- .0078) |
| N331.1A-043505H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-054508H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-084508H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-115008H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-145008H-WL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-084508H-WM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-115008H-WM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-145008H-WM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |

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

# Disc milling tools

## CoroMill® 331

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| N331.1A-043505H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-054508H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-084508H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-115008H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-145008H-ML | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-043505H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-054508H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-084508H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-115008H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-145008H-MM | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-043505H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) | .0047 | (.0004-.0071) | .0039 | (.0004-.0059) |
| N331.1A-054508H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) | .0047 | (.0004-.0071) | .0039 | (.0004-.0059) |
| N331.1A-084508H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) | .0047 | (.0004-.0071) | .0039 | (.0004-.0059) |
| N331.1A-115008H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) | .0047 | (.0004-.0071) | .0039 | (.0004-.0059) |
| N331.1A-145008H-NL | 0.12 | (0.01-0.18) | 0.1 | (0.01-0.15) | .0047 | (.0004-.0071) | .0039 | (.0004-.0059) |
| N331.1A-043505H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-054508H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-084508H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-115008H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-145008H-PL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-054508H-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-084508H-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-115008H-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-145008H-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-043505M-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-054508M-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-084508M-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-115008M-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-145008M-PM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-043505E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-054508E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-084508E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-115008E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-145008E-KL | 0.12 | (0.08-0.18) | 0.1 | (0.03-0.15) | .0047 | (.0031-.0071) | .0039 | (.0012-.0059) |
| N331.1A-054508E-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-084508E-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-115008E-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-145008E-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-043505M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-054508M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-084508M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-115008M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1A-145008M-KM | 0.15 | (0.06-0.3) | 0.13 | (0.05-0.25) | .0059 | (.0024-.0118) | .0051 | (.002-.0098) |
| N331.1D-136508E-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) | .0079 | (.0031-.0094) | .0067 | (.0028-.0079) |
| N331.1D-136508M-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) | .0079 | (.0031-.0094) | .0067 | (.0028-.0079) |
| N331.1D-136512M-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) | .0079 | (.0031-.0094) | .0067 | (.0028-.0079) |
| N331.1D-136520E-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) | .0079 | (.0031-.0094) | .0067 | (.0028-.0079) |
| N331.1D-136520M-PM | 0.20 | (0.08-0.24) | 0.17 | (0.07-0.2) | .0079 | (.0031-.0094) | .0067 | (.0028-.0079) |

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

# Disc milling tools

## Profile milling tools

### CoroMill® 300

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| R300-0517E-PM | 0.08 | (0.05-0.12) | 0.08 | (0.05-0.12) | .003 | (.002-.005) | .003 | (.002-.005) |
| R300-0720E-MM | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) | .004 | (.002-.006) | .004 | (.002-.006) |
| R300-0720E-PM | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) | .004 | (.002-.006) | .004 | (.002-.006) |
| R300-0724E-MM | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) | .004 | (.002-.006) | .004 | (.002-.006) |
| R300-0724E-PM | 0.1 | (0.05-0.15) | 0.1 | (0.05-0.15) | .004 | (.002-.006) | .004 | (.002-.006) |
| R300-0828E-KL | 0.13 | (0.05-0.2) | 0.11 | (0.05-0.15) | .005 | (.002-.008) | .004 | (.002-.006) |
| R300-0828E-KM | 0.15 | (0.07-0.25) | 0.13 | (0.05-0.2) | .006 | (.003-.010) | .005 | (.002-.008) |
| R300-0828E-MM | 0.13 | (0.07-0.2) | 0.13 | (0.05-0.2) | .005 | (.003-.008) | .005 | (.002-.008) |
| R300-0828E-PL | 0.11 | (0.05-0.15) | 0.11 | (0.05-0.15) | .004 | (.002-.006) | .004 | (.002-.006) |
| R300-0828E-PM | 0.13 | (0.05-0.2) | 0.13 | (0.05-0.2) | .005 | (.002-.008) | .005 | (.002-.008) |
| R300-0828M-KH | 0.15 | (0.07-0.25) | 0.15 | (0.07-0.25) | .006 | (.003-.010) | .006 | (.003-.010) |
| R300-0828M-MH | 0.13 | (0.05-0.2) | 0.15 | (0.07-0.25) | .005 | (.002-.008) | .006 | (.003-.010) |
| R300-0828M-MM | 0.13 | (0.07-0.2) | 0.13 | (0.07-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R300-0828M-PH | 0.15 | (0.07-0.25) | 0.15 | (0.07-0.25) | .006 | (.003-.010) | .006 | (.003-.010) |
| R300-0828M-PM | 0.13 | (0.07-0.2) | 0.13 | (0.07-0.2) | .005 | (.003-.008) | .005 | (.003-.008) |
| R300-0932E-MM | 0.15 | (0.07-0.23) | 0.13 | (0.04-0.2) | .006 | (.003-.009) | .005 | (.002-.008) |
| R300-0932E-PM | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) | .006 | (.002-.009) | .005 | (.002-.008) |
| R300-0932M-PH | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) | .007 | (.003-.011) | .006 | (.002-.010) |
| R300-0932M-PM | 0.15 | (0.07-0.23) | 0.13 | (0.06-0.2) | .006 | (.003-.009) | .005 | (.002-.008) |
| R300-1032E-KL | 0.21 | (0.05-0.29) | 0.13 | (0.04-0.15) | .008 | (.002-.011) | .005 | (.002-.006) |
| R300-1032E-MM | 0.17 | (0.07-0.29) | 0.18 | (0.04-0.25) | .007 | (.003-.011) | .007 | (.002-.010) |
| R300-1032E-PL | 0.15 | (0.05-0.17) | 0.13 | (0.04-0.15) | .006 | (.002-.007) | .005 | (.002-.006) |
| R300-1032E-PM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) | .008 | (.002-.011) | .007 | (.002-.010) |
| R300-1032M-KH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) | .009 | (.003-.014) | .008 | (.002-.012) |
| R300-1032M-MH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) | .009 | (.003-.014) | .008 | (.002-.012) |
| R300-1032M-MM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) | .007 | (.003-.011) | .006 | (.002-.010) |
| R300-1032M-PH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) | .009 | (.003-.014) | .008 | (.002-.012) |
| R300-1032M-PM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) | .007 | (.003-.011) | .006 | (.002-.010) |
| R300-1240E-KM | 0.23 | (0.07-0.35) | 0.18 | (0.04-0.25) | .009 | (.003-.014) | .007 | (.002-.010) |
| R300-1240E-ML | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) | .006 | (.002-.009) | .005 | (.002-.008) |
| R300-1240E-MM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) | .008 | (.002-.011) | .007 | (.002-.010) |
| R300-1240E-PL | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) | .006 | (.002-.009) | .005 | (.002-.008) |
| R300-1240E-PM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) | .008 | (.002-.011) | .007 | (.002-.010) |
| R300-1240M-KH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) | .009 | (.003-.014) | .008 | (.002-.012) |
| R300-1240M-MH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) | .009 | (.003-.014) | .008 | (.002-.012) |
| R300-1240M-MM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) | .007 | (.003-.011) | .006 | (.002-.010) |
| R300-1240M-PH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) | .009 | (.003-.014) | .008 | (.002-.012) |
| R300-1240M-PM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) | .007 | (.003-.011) | .006 | (.002-.010) |
| R300-1340E-ML | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) | .006 | (.002-.009) | .005 | (.002-.008) |
| R300-1340E-MM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) | .008 | (.002-.011) | .007 | (.002-.010) |
| R300-1340E-PL | 0.15 | (0.05-0.23) | 0.13 | (0.04-0.2) | .006 | (.002-.009) | .005 | (.002-.008) |
| R300-1340E-PM | 0.21 | (0.05-0.29) | 0.18 | (0.04-0.25) | .008 | (.002-.011) | .007 | (.002-.010) |
| R300-1340M-KH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) | .009 | (.003-.014) | .008 | (.002-.012) |
| R300-1340M-MH | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) | .009 | (.003-.014) | .008 | (.002-.012) |
| R300-1340M-MM | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) | .007 | (.003-.011) | .006 | (.002-.010) |

# Profile milling tools

## CoroMill® 300

| | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| **Ordering code** | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| **R300-1340M-PH** | 0.23 | (0.07-0.35) | 0.2 | (0.06-0.3) | .009 | (.003-.014) | .008 | (.002-.012) |
| **R300-1340M-PM** | 0.17 | (0.07-0.29) | 0.15 | (0.06-0.25) | .007 | (.003-.011) | .006 | (.002-.010) |
| **R300-1648E-KM** | 0.29 | (0.07-0.46) | 0.2 | (0.04-0.3) | .011 | (.003-.018) | .008 | (.002-.012) |
| **R300-1648E-ML** | 0.17 | (0.05-0.23) | 0.15 | (0.04-0.2) | .007 | (.002-.009) | .006 | (.002-.008) |
| **R300-1648E-MM** | 0.21 | (0.07-0.29) | 0.2 | (0.04-0.3) | .008 | (.003-.011) | .008 | (.002-.012) |
| **R300-1648E-PL** | 0.17 | (0.05-0.23) | 0.15 | (0.04-0.2) | .007 | (.002-.009) | .006 | (.002-.008) |
| **R300-1648E-PM** | 0.23 | (0.05-0.35) | 0.2 | (0.04-0.3) | .009 | (.002-.014) | .008 | (.002-.012) |
| **R300-1648M-KH** | 0.29 | (0.07-0.46) | 0.25 | (0.06-0.4) | .011 | (.003-.018) | .010 | (.002-.016) |
| **R300-1648M-MH** | 0.29 | (0.07-0.46) | 0.25 | (0.06-0.4) | .011 | (.003-.018) | .010 | (.002-.016) |
| **R300-1648M-MM** | 0.21 | (0.07-0.29) | 0.18 | (0.06-0.25) | .008 | (.003-.011) | .007 | (.002-.010) |
| **R300-1648M-PH** | 0.29 | (0.07-0.46) | 0.25 | (0.06-0.4) | .011 | (.003-.018) | .010 | (.002-.016) |
| **R300-1648M-PM** | 0.21 | (0.07-0.29) | 0.18 | (0.06-0.25) | .008 | (.003-.011) | .007 | (.002-.010) |
| **R300-2060E-ML** | 0.28 | (0.06-0.35) | 0.2 | (0.04-0.25) | .011 | (.002-.014) | .008 | (.002-.010) |
| **R300-2060E-MM** | 0.35 | (0.06-0.57) | 0.25 | (0.04-0.4) | .014 | (.002-.022) | .010 | (.002-.016) |
| **R300-2060E-PL** | 0.28 | (0.06-0.35) | 0.2 | (0.04-0.25) | .011 | (.002-.014) | .008 | (.002-.010) |
| **R300-2060E-PM** | 0.35 | (0.06-0.57) | 0.25 | (0.04-0.4) | .014 | (.002-.022) | .010 | (.002-.016) |
| **R300-2060M-KH** | 0.49 | (0.07-0.78) | 0.35 | (0.05-0.55) | .019 | (.003-.031) | .014 | (.002-.022) |
| **R300-2060M-MH** | 0.49 | (0.07-0.78) | 0.35 | (0.05-0.55) | .019 | (.003-.031) | .014 | (.002-.022) |
| **R300-2060M-MM** | 0.28 | (0.07-0.42) | 0.2 | (0.05-0.3) | .011 | (.003-.017) | .008 | (.002-.012) |
| **R300-2060M-PH** | 0.49 | (0.07-0.78) | 0.35 | (0.05-0.55) | .019 | (.003-.031) | .014 | (.002-.022) |
| **R300-2060M-PM** | 0.28 | (0.07-0.42) | 0.2 | (0.05-0.3) | .011 | (.003-.017) | .008 | (.002-.012) |
| **R300-2570E-ML** | 0.31 | (0.06-0.4) | 0.22 | (0.04-0.28) | .012 | (.002-.016) | .009 | (.002-.011) |
| **R300-2570E-PL** | 0.31 | (0.06-0.4) | 0.22 | (0.04-0.28) | .012 | (.002-.016) | .009 | (.002-.011) |
| **R300-2570M-KH** | 0.57 | (0.07-0.85) | 0.4 | (0.05-0.6) | .022 | (.003-.033) | .016 | (.002-.024) |
| **R300-2570M-MM** | 0.31 | (0.07-0.47) | 0.22 | (0.05-0.33) | .012 | (.003-.019) | .009 | (.002-.013) |
| **R300-2570M-PH** | 0.57 | (0.07-0.85) | 0.4 | (0.05-0.6) | .022 | (.003-.033) | .016 | (.002-.024) |
| **R300-2570M-PM** | 0.31 | (0.07-0.47) | 0.22 | (0.05-0.33) | .012 | (.003-.019) | .009 | (.002-.013) |

## CoroMill® 600

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

## CoroMill® 216

| | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| **Ordering code** | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| **APMT160408-M** | 0.35 | (0.14-0.7) | 0.25 | (0.1-0.5) | .014 | (.006-.028) | .010 | (.004-.020) |
| **R216-1002E-M** | 0.14 | (0.06-0.21) | 0.1 | (0.04-0.15) | .006 | (.002-.008) | .004 | (.002-.006) |
| **R216-1202E-M** | 0.14 | (0.06-0.21) | 0.1 | (0.04-0.15) | .006 | (.002-.008) | .004 | (.002-.006) |
| **R216-1202M-M** | 0.14 | (0.08-0.21) | 0.1 | (0.04-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| **R216-1603E-M** | 0.14 | (0.06-0.21) | 0.1 | (0.04-0.15) | .006 | (.002-.008) | .004 | (.002-.006) |
| **R216-1603M-M** | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| **R216-20T3E-M** | 0.21 | (0.06-0.25) | 0.15 | (0.04-0.18) | .008 | (.002-.010) | .006 | (.002-.007) |
| **R216-20T3M-M** | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| **R216-2504E-M** | 0.21 | (0.06-0.25) | 0.15 | (0.04-0.18) | .008 | (.002-.010) | .006 | (.002-.007) |
| **R216-2504M-M** | 0.17 | (0.08-0.21) | 0.12 | (0.06-0.15) | .007 | (.003-.008) | .005 | (.002-.006) |
| **R216-3006E-M** | 0.24 | (0.06-0.28) | 0.17 | (0.04-0.2) | .009 | (.002-.011) | .007 | (.002-.008) |
| **R216-3006M-M** | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) | .008 | (.003-.011) | .006 | (.002-.008) |
| **R216-3206E-M** | 0.24 | (0.06-0.28) | 0.17 | (0.04-0.2) | .009 | (.002-.011) | .007 | (.002-.008) |
| **R216-3206M-M** | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) | .008 | (.003-.011) | .006 | (.002-.008) |
| **R216-4007E-M** | 0.28 | (0.06-0.35) | 0.2 | (0.04-0.25) | .011 | (.002-.014) | .008 | (.002-.010) |
| **R216-4007M-M** | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) | .011 | (.004-.017) | .008 | (.003-.012) |
| **R216-5007E-M** | 0.28 | (0.06-0.35) | 0.2 | (0.04-0.25) | .011 | (.002-.014) | .008 | (.002-.010) |
| **R216-5007M-M** | 0.35 | (0.1-0.7) | 0.25 | (0.07-0.5) | .014 | (.004-.028) | .010 | (.003-.020) |

# Profile milling tools

## CoroMill® 216

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| **RA216-1002E-M** | 0.14 | (0.06-0.21) | 0.1 | (0.04-0.15) | .006 | (.002-.008) | .004 | (.002-.006) |
| **RA216-1302E-M** | 0.14 | (0.06-0.21) | 0.1 | (0.04-0.15) | .006 | (.002-.008) | .004 | (.002-.006) |
| **RA216-1302M-M** | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| **RA216-1603M-M** | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| **RA216-19T3E-M** | 0.21 | (0.06-0.25) | 0.15 | (0.04-0.18) | .008 | (.002-.010) | .006 | (.002-.007) |
| **RA216-19T3M-M** | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| **RA216-2504E-M** | 0.21 | (0.06-0.25) | 0.15 | (0.04-0.18) | .008 | (.002-.010) | .006 | (.002-.007) |
| **RA216-2504M-M** | 0.17 | (0.08-0.21) | 0.12 | (0.06-0.15) | .007 | (.003-.008) | .005 | (.002-.006) |
| **RA216-3206M-M** | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) | .008 | (.003-.011) | .006 | (.002-.008) |
| **RA216-3807M-M** | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) | .011 | (.004-.017) | .008 | (.003-.012) |
| **RA216-5107M-M** | 0.35 | (0.1-0.7) | 0.25 | (0.07-0.5) | .014 | (.004-.028) | .010 | (.003-.020) |

# Profile milling tools

## CoroMill® 200

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| RCHT09T300-ML | 0.15 | (0.08-0.2) | 0.15 | (0.08-0.2) | .006 | (.003-.008) | .006 | (.003-.008) |
| RCHT09T300-PL | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) | .004 | (.003-.006) | .004 | (.003-.006) |
| RCHT10T3M0-KL | 0.17 | (0.1-0.2) | 0.1 | (0.08-0.15) | .007 | (.004-.008) | .004 | (.003-.006) |
| RCHT10T3M0-ML | 0.15 | (0.08-0.2) | 0.15 | (0.08-0.2) | .006 | (.003-.008) | .006 | (.003-.008) |
| RCHT10T3M0-PL | 0.1 | (0.08-0.15) | 0.1 | (0.08-0.15) | .004 | (.003-.006) | .004 | (.003-.006) |
| RCHT1204M0 | 0.21 | (0.1-0.42) | 0.1 | (0.08-0.15) | .008 | (.004-.017) | .004 | (.003-.006) |
| RCHT1204M0-KL | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) | .009 | (.004-.011) | .004 | (.002-.006) |
| RCHT1204M0-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| RCHT130400-KL | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) | .009 | (.004-.011) | .004 | (.002-.006) |
| RCHT130400-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) | .008 | (.003-.011) | .006 | (.002-.008) |
| RCHT130400-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| RCHT1606M0-KL | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) | .009 | (.004-.011) | .004 | (.002-.006) |
| RCHT1606M0-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) | .008 | (.003-.011) | .006 | (.002-.008) |
| RCHT1606M0-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| RCHT190600-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) | .008 | (.003-.011) | .006 | (.002-.008) |
| RCHT190600-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| RCHT2006M0-KL | 0.24 | (0.1-0.28) | 0.1 | (0.06-0.15) | .009 | (.004-.011) | .004 | (.002-.006) |
| RCHT2006M0-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) | .008 | (.003-.011) | .006 | (.002-.008) |
| RCHT2006M0-PL | 0.14 | (0.08-0.21) | 0.1 | (0.06-0.15) | .006 | (.003-.008) | .004 | (.002-.006) |
| RCHT1204M0-ML | 0.21 | (0.08-0.28) | 0.15 | (0.06-0.2) | .008 | (.003-.011) | .006 | (.002-.008) |
| RCKT09T300-KH | 0.25 | (0.1-0.3) | 0.25 | (0.1-0.3) | .010 | (.004-.012) | .010 | (.004-.012) |
| RCKT09T300-MM | 0.2 | (0.1-0.3) | 0.2 | (0.1-0.3) | .008 | (.004-.012) | .008 | (.004-.012) |
| RCKT09T300-PH | 0.25 | (0.1-0.3) | 0.25 | (0.1-0.3) | .010 | (.004-.012) | .010 | (.004-.012) |
| RCKT09T300-PM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) | .007 | (.004-.008) | .007 | (.004-.008) |
| RCKT10T3M0-KH | 0.25 | (0.1-0.3) | 0.25 | (0.1-0.3) | .010 | (.004-.012) | .010 | (.004-.012) |
| RCKT10T3M0-KM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) | .007 | (.004-.008) | .007 | (.004-.008) |
| RCKT10T3M0-MM | 0.2 | (0.1-0.3) | 0.2 | (0.1-0.3) | .008 | (.004-.012) | .008 | (.004-.012) |
| RCKT10T3M0-PH | 0.25 | (0.1-0.3) | 0.25 | (0.1-0.3) | .010 | (.004-.012) | .010 | (.004-.012) |
| RCKT10T3M0-PM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) | .007 | (.004-.008) | .007 | (.004-.008) |
| RCKT10T3M0-WM | 0.17 | (0.1-0.2) | 0.17 | (0.1-0.2) | .007 | (.004-.008) | .007 | (.004-.008) |
| RCKT1204M0-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT1204M0-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT1204M0-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) | .011 | (.004-.017) | .008 | (.003-.012) |
| RCKT1204M0-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT1204M0-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT1204M0-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT1204MO | 0.35 | (0.1-0.42) | 0.15 | (0.07-0.3) | .014 | (.004-.017) | .006 | (.003-.012) |
| RCKT130400-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT130400-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT130400-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) | .011 | (.004-.017) | .008 | (.003-.012) |
| RCKT130400-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT130400-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT130400-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT1606M0-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT1606M0-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT1606M0-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) | .011 | (.004-.017) | .008 | (.003-.012) |
| RCKT1606M0-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT1606M0-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT1606M0-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT1606MO | 0.35 | (0.1-0.42) | 0.15 | (0.07-0.3) | .014 | (.004-.017) | .006 | (.003-.012) |
| RCKT190600-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT190600-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT190600-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) | .011 | (.004-.017) | .008 | (.003-.012) |
| RCKT190600-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT190600-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT190600-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT2006M0-KH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT2006M0-KM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT2006M0-MM | 0.28 | (0.1-0.42) | 0.2 | (0.07-0.3) | .011 | (.004-.017) | .008 | (.003-.012) |
| RCKT2006M0-PH | 0.35 | (0.1-0.42) | 0.25 | (0.07-0.3) | .014 | (.004-.017) | .010 | (.003-.012) |
| RCKT2006M0-PM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |
| RCKT2006M0-WM | 0.24 | (0.1-0.28) | 0.17 | (0.07-0.2) | .009 | (.004-.011) | .007 | (.003-.008) |

# Groove milling tools

## CoroMill® 327

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 327R12-22 11045-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 13045-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 16045-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 18545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 21545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 26545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 31545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 41545-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-221304508-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-221604508-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-222654518-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-224154525-GC | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R06-10 10000-GM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R06-10 15002-GM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R06-10 20002-GM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R06-10 25002-GM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R09-18 15002-GM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 20002-GM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 25002-GM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 30002-GM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R12-22 15002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 20002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 25002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 30002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 40002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R14-28 15000-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R14-28 20002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R14-28 25002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R14-28 30002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R14-28 35002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R14-28 40002-GM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R09-18 15001-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 20002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 25002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 30002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R12-28 15001-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-28 20002-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-28 25002-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-28 30002-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-28 40002-GMM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R14-35 15001-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R14-35 20002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R14-35 25002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R14-35 30002-GMM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R06-12 22011-RM | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R09-18 22011-RM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R12-22 10005-RM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 20010-RM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 30015-RM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 40020-RM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |

## CoroMill® 328

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 328R13-13000-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-16000-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-18502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-18545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-21502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-21545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-26502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-26545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-2654515-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-31502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-31545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-41502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-41545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-4154520-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-51502-GM | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-51545-GC | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |

# Groove milling tools

## CoroMill® QD

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| QD-NE-0200-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NF-0239-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NF-0250-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NG-0300-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NG-0318-010E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NH-0400-015E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NJ-0476-020E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NJ-0500-020E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NK-0600-025E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NK-0635-025E-NL | 0.16 | (0.01-0.3) | 0.13 | (0.01-0.25) | .006 | (.0004-.012) | .0051 | (.0004-.0098) |
| QD-NE-0200-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NF-0239-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NF-0250-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NG-0300-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NG-0318-020E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NH-0400-025E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NJ-0476-030E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NJ-0500-030E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NK-0600-035E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NK-0635-035E-SL | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NE-0200-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NF-0239-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NF-0250-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NG-0300-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NG-0318-020E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NH-0400-025E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NJ-0476-030E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NJ-0500-030E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NK-0600-035E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NK-0635-035E-SM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NE-0200-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NF-0239-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NF-0250-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NG-0300-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NG-0318-020E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NH-0400-025E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NJ-0476-030E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NJ-0500-030E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NK-0600-035E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NK-0635-035E-ML | 0.05 | (0.01-0.08) | 0.04 | (0.01-0.07) | .002 | (.0004-.003) | .0016 | (.0004-.0028) |
| QD-NE-0200-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NF-0239-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NF-0250-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NG-0300-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NG-0318-020E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NH-0400-025E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NJ-0476-030E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NJ-0500-030E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NK-0600-035E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NK-0635-035E-MM | 0.09 | (0.05-0.14) | 0.08 | (0.04-0.12) | .0035 | (.002-.0055) | .0031 | (.0016-.0047) |
| QD-NE-0200-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |
| QD-NF-0239-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |
| QD-NF-0250-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |
| QD-NG-0300-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |
| QD-NH-0400-025E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |
| QD-NG-0318-020E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |
| QD-NJ-0476-030E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |
| QD-NJ-0500-030E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |
| QD-NK-0600-035E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |
| QD-NK-0635-035E-KL | 0.13 | (0.02-0.18) | 0.11 | (0.02-0.15) | .0051 | (.0008-.006) | .0043 | (.0008-.0059) |

Recommendation for diameter 63 mm (2.5 inch) 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

# Groove milling tools

## CoroMill® QD

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| QD-NE-0200-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NF-0239-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NF-0250-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NG-0300-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NG-0318-035M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NH-0400-040M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NJ-0476-045M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NJ-0500-045M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NK-0600-050M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NK-0635-050M-KM | 0.13 | (0.05-0.18) | 0.11 | (0.04-0.15) | .0051 | (.002-.006) | .0043 | (.0016-.0059) |
| QD-NE-0200-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NF-0239-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NF-0250-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NG-0300-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NG-0318-020E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NH-0400-025E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NJ-0476-030E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NJ-0500-030E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NK-0600-035E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NK-0635-035E-PL | 0.06 | (0.02-0.08) | 0.05 | (0.02-0.08) | .0024 | (.0008-.0031) | .002 | (.0008-.0031) |
| QD-NE-0200-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NF-0239-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NF-0250-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NG-0300-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NG-0318-020E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NH-0400-025E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NJ-0476-030E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NJ-0500-030E-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NK-0600-035E-PM | 0.2 | (0.08-0.12) | 0.1 | (0.07-0.1) | .0079 | (.0031-.0047) | .0039 | (.0028-.0039) |
| QD-NK-0635-035E-PM | 0.2 | (0.08-0.12) | 0.1 | (0.07-0.1) | .0079 | (.0031-.0047) | .0039 | (.0028-.0039) |
| QD-NE-0200-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NF-0239-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NF-0250-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NG-0300-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NG-0318-020M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NH-0400-025M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NJ-0476-030M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NJ-0500-030M-PM | 0.13 | (0.08-0.18) | 0.11 | (0.07-0.15) | .0051 | (.0031-.006) | .0043 | (.0028-.0059) |
| QD-NK-0600-035M-PM | 0.12 | (0.08-0.12) | 0.1 | (0.07-0.1) | .0047 | (.0031-.0047) | .0039 | (.0028-.0039) |
| QD-NK-0635-035M-PM | 0.12 | (0.08-0.12) | 0.1 | (0.07-0.1) | .0047 | (.0031-.0047) | .0039 | (.0028-.0039) |
| QD-NE-0200-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) | .0051 | (.002-.006) | .0043 | (.0016-.0051) |
| QD-NF-0239-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) | .0051 | (.002-.006) | .0043 | (.0016-.0051) |
| QD-NF-0250-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) | .0051 | (.002-.006) | .0043 | (.0016-.0051) |
| QD-NG-0300-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) | .0051 | (.002-.006) | .0043 | (.0016-.0051) |
| QD-NG-0318-035M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) | .0051 | (.002-.006) | .0043 | (.0016-.0051) |
| QD-NH-0400-040M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) | .0051 | (.002-.006) | .0043 | (.0016-.0051) |
| QD-NJ-0476-045M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) | .0051 | (.002-.006) | .0043 | (.0016-.0051) |
| QD-NJ-0500-045M-PH | 0.13 | (0.05-0.15) | 0.11 | (0.04-0.13) | .0051 | (.002-.006) | .0043 | (.0016-.0051) |
| QD-NK-0600-050M-PH | 0.12 | (0.05-0.12) | 0.1 | (0.04-0.1) | .0047 | (.002-.0047) | .0039 | (.0016-.0039) |
| QD-NK-0635-050M-PH | 0.12 | (0.05-0.12) | 0.1 | (0.04-0.1) | .0047 | (.002-.0047) | .0039 | (.0016-.0039) |

Recommendation for diameter 63 mm (2.5 inch) cutters
- PL is the 1st choice geometry in ISO P applications
- Use maximum 70% of the recommended $h_{ex}$ value when using the PM geometry
- PH geometry is not recommended

# Thread milling

## CoroMill® 328

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 328R13-04UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-06UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-08UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-10UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-12UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-14UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-150MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-150VM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-16UN-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-200MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-300MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-350MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-400MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-400VM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-450MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-500MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-550MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |
| 328R13-600MM-TH | 0.1 | (0.04-0.15) | 0.07 | (0.03-0.1) | .004 | (.002-.006) | .003 | (.001-.004) |

## CoroMill® 327

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 327R06-12 100VM-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R09-18 100VM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R12-22 100VM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R06-12 250VM-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R09-18 250VM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R12-22 250VM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R06-12 19WH-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R09-18 19WH-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R06-12 14WH-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R09-18 14WH-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R06-12 11WH-TH | 0.05 | (0.02-0.06) | 0.05 | (0.02-0.06) | .0020 | (.0008-.0024) | .0020 | (.0008-.0024) |
| 327R09-18 11WH-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 24UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 20UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 18UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 16UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 14UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 12UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 11UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 10UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 08UN-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 150MM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 200MM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 300MM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 350MM-TH | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R12-22 150MM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 175MM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 200MM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 300MM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 350MM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 400MM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 450MM-TH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R09-18 100VM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R12-22 100VM-THM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R09-18 250VM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R12-22 250VM-THM | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R09-18 24UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 20UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 18UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 16UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 14UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 12UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 11UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 10UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 08UN-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 150MM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 200MM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 300MM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |
| 327R09-18 350MM-THM | 0.06 | (0.03-0.08) | 0.06 | (0.03-0.08) | .0024 | (.0012-.0031) | .0024 | (.0012-.0031) |

# Chamfer milling tools

## CoroMill® 495

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 495-09T3M-MM | 0.17 | (0.12-0.25) | 0.16 | (0.12-0.2) | .007 | (.005-.010) | .006 | (.005-.008) |
| 495-09T3M-PM | 0.17 | (0.12-0.25) | 0.17 | (0.12-0.25) | .007 | (.005-.010) | .007 | (.005-.010) |

## CoroMill® 327

| Ordering code | Feed per tooth, $f_z$ mm/tooth | | Max chip thickness, $h_{ex}$ mm | | Feed per tooth, $f_z$ inch/tooth | | Max chip thickness, $h_{ex}$ inch | |
|---|---|---|---|---|---|---|---|---|
| | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) | Starting value | (min.- max.) |
| 327R06-12 12045-CH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |
| 327R12-22 20045-CH | 0.07 | (0.04-0.1) | 0.07 | (0.04-0.1) | .0028 | (.0016-.0039) | .0028 | (.0016-.0039) |

# Grades for milling

**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 GC4230 in abrasive materials.

**M30B (HC)** – P35 (P30-P40)
Tough, CVD-coated (thin coating) 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.

### 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 is not available, 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.

**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

## 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 for gray 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 gray 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 gray cast milling applications with good stability in dry conditions.

**GC3040 (HC)** – K30 (K20-K40)
Medium-hard, CVD-coated grade with thick coating for tough and demanding, medium to rough milling applications of gray 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 gray cast iron milling applications with good stability in dry conditions.

### Complementary grades

**CB50 (BN)** – K10 (K01-K20)
Hard, CBN-tipped grade for light roughing to finishing of gray cast iron in stable, dry conditions. Use when dimensional stability and long tool life are crucial.

**CC6190 (CN)** – K05 (K01-K15)
Hard, silicon nitride ceramic grade for very high cutting speeds in light roughing to semi-finishing of gray 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.

**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 ($Si_3N_4$). |

**Cubic boron nitride:**

| | |
|---|---|
| BN | Polycrystalline boron nitride[1]. |

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

# 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 is not available, 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)].

# 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 is not available, 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-coated grade with a thin coating for light roughing to finishing of hardened steel with 36 HRC or higher to be used in stable conditions for both wet and dry machining.

**GC4220(HC)** – H25 (H15-H30)
Hard, CVD-coated 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 is not available, 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 in 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 ($Si_3N_4$).

**Cubic 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 J29

CoroDrill® 880 J39

Trepanning tool J56

## Which drilling solution meets 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. Additionally, the work piece material, design of the component, batch sizes and machine type need to be considered.

Generally speaking, symmetrical drills such as solid carbide or exchangeable tip drills 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 they run with lower feeds, they impose lower axial force on the workpiece.

## Select your strategy

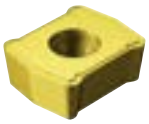
Drilling is often carried out late in the manufacturing process, after previous operations have already enhanced the initial component's value. The drilling application, although seemingly simple, is a complex operation that can have significant consequences if the tool malfunctions or is run beyond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

**Drilling deep holes**
- The process of drilling deeper holes requires longer tools that are more sensitive to deflection
- Chip evacuation occurs over longer distance
- When drilling 6-7xD holes with CoroDrill® DS20, a feed reduction at entry and exit is required. Entry feed should be 75% of the recommended feed rate, and exit feed should be 0.05 mm/rev. (.0019 inch/rev)

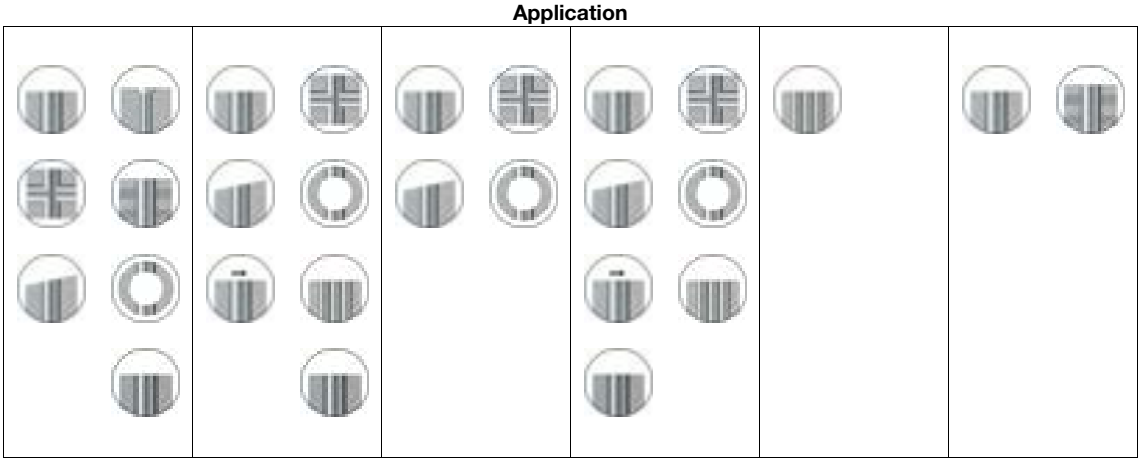
**Important factors to consider:**
- When drilling holes deeper than 6xD with CoroDrill® 870, use a piloting operation
- Ensure that coolant flow is sufficient to evacuate chips
- Adjust your cutting data to obtain satisfactory chips, a stable process and to ultimately meet the demands for your hole

**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 those previously mentioned, a factor that has a large impact is cutting data

**Adjust cutting data to optimize your process:**
- 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** |
| $D_c$ mm<br>$D_c$ inch | 10.00-33.00<br>.393-1.299 | 15.00-40.00<br>.591-1.575 | 12.00-63.50<br>.500-2.500 | 65.00-84.00<br>2.559-3.307 | 60.00-110.00<br>2.362-4.331 | |
| ISO application area | P<br>M<br>K<br>N<br>S | P<br>M<br>K<br>N<br>S<br>H | P<br>M<br>K<br>N<br>S<br>H | P<br>M<br>K<br>N<br>S<br>H | P<br>M<br>K<br>N<br>S<br>H | P<br>M<br>K<br>N<br>S<br>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** | **J27** | **J39** | **J39** | **J56** | **J59** |

**Application**



# CoroDrill® 870

## Secure and predictable holemaking process

**ISO application area:**

P M K N S

### Benefits and features

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

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

www.sandvik.coromant.com/corodrill870

### Drill bodies

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

### Drill tips

- Easy handling and secure tip changing
- Tip changing possible while tool is in the machine to reduce downtime

### Drill tip geometries

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

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

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.

### Hole tolerance (not applicable for GP geometry)

H9 – H10

| Diameter range, mm (inch) | | 10.00-18.00 (.394 - .708) | 18.01-30.00 (.708 - 1.181) | 30.01-33.00 (1.181 - 1.220) |
|---|---|---|---|---|
| Hole tolerance, mm (inch) | 3×DC-8×DC | 0/+0.043 (.0017) | 0/+0.052 (.0020) | 0/+0.062 (.0024) |
| | 10×DC | 0/+0.070 (.0028) | 0/+0.084 (.0033) | 0/+0.100 (.0039) |

J6

J12

N6



SANDVIK Coromant

# 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 -PM. The difference for -KM is its corner chamfer, which reduces exit breakouts in the workpiece 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 provides 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 that further increases wear resistance.
- First choice in ISO K

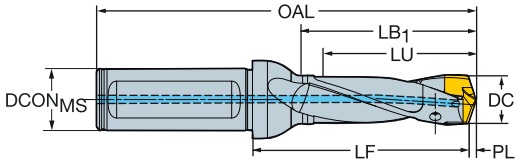
### GC2334

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

# CoroDrill® 870 exchangeable tip drill

**Drill bodies – internal coolant supply**

**Cylindrical shank with flat according to ISO 9766**




## Metric design

| 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 | 0.143 | 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 | |

J12 L2 N22 N6 N15

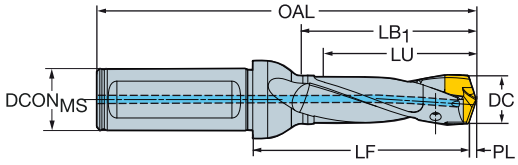


SANDVIK Coromant

# CoroDrill® 870 exchangeable tip drill

**Drill bodies – internal coolant supply**

**Cylindrical shank with flat according to ISO 9766**




## Metric design

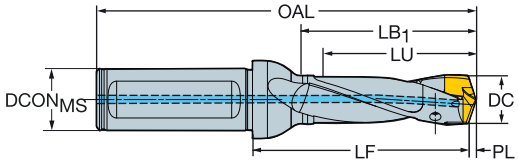
| | | | | | | | Dimensions, mm | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DCN | DCX | | LU | $CZC_{MS}$ | TCHA | Ordering code | $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | BAR | KG | RPMX | $MIID_P$ |
| 17.00 | 17.99 | 17 | 56.71 | 20 | H9 | 870-1700-17L20-3 | 20.00 | 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 | |
| 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 | |

J12 L2 N22 N6 N15

# CoroDrill® 870 exchangeable tip drill

**Drill bodies – internal coolant supply**

**Cylindrical shank with flat according to ISO 9766**




## Metric design

| DCN | DCX | | LU | CZC$_{MS}$ | TCHA | Ordering code | Dimensions, mm DCON$_{MS}$ | LF | OAL | LB$_1$ | PL | BAR | KG | RPMX | MIID$_P$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 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 |
|---|---|
| | Insert screw |
| 6 | 5513 031-15 |
| 7 | 5513 031-15 |
| 8 | 5513 031-15 |
| 9 | 5513 031-15 |
| 10 | 5513 031-12 |
| 11 | 5513 031-12 |
| 12 | 5513 031-12 |
| 13 | 5513 031-12 |
| 14 | 5513 031-12 |
| 15 | 5513 031-12 |
| 16 | 5513 031-13 |
| 17 | 5513 031-13 |
| 18 | 5513 031-13 |
| 19 | 5513 031-13 |
| 20 | 5513 031-14 |
| 21 | 5513 031-14 |
| 22 | 5513 031-14 |
| 23 | 5513 031-14 |
| 24 | 5513 031-16 |
| 25 | 5513 031-16 |
| 26 | 5513 031-16 |
| 27 | 5513 031-16 |
| 28 | 5513 031-17 |
| 29 | 5513 031-17 |
| 30 | 5513 031-17 |
| 31 | 5513 031-17 |

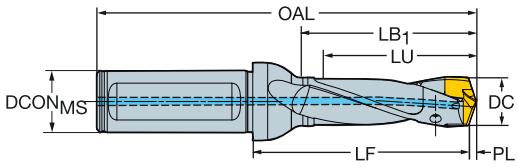
For the complete list of spare parts, visit www.sandvik.coromant.com

J12 L2 N22 N6 N15

# CoroDrill® 870 exchangeable tip drill

**Drill bodies – internal coolant supply**

**Cylindrical shank with flat according to ISO 9766**




## Inch design

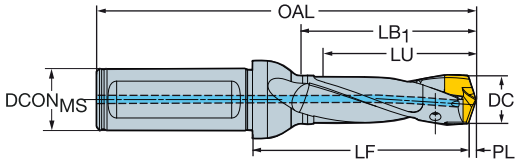
| DCN | DCX | | LU | CZC$_{MS}$ | TCHA | Ordering code | Dimensions, inch DCON$_{MS}$ | LF | OAL | LB$_1$ | PL | PSI | LBS | RPMX | MIID$_P$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .393 | .413 | 6 | 1.302 | 5/8 | H9 | 870-1000-6LX063-3 | .625 | 1.827 | 3.780 | 1.378 | .063 | 145 | 0.308 | 33000 | 870-1040-6-PM |
| .393 | .413 | 6 | 2.128 | 5/8 | H9 | 870-1000-6LX063-5 | .625 | 2.654 | 4.606 | 2.205 | .063 | 145 | 0.324 | 15000 | |
| .393 | .413 | 6 | 3.367 | 5/8 | H9 | 870-1000-6LX063-8 | .625 | 3.913 | 5.866 | 3.465 | .063 | 217 | 0.344 | 12000 | |
| .393 | .413 | 6 | 4.193 | 5/8 | H10 | 870-1000-6LX063-10 | .625 | 4.740 | 6.693 | 4.291 | .063 | 435 | 0.352 | 9000 | |
| .413 | .433 | 7 | 1.364 | 5/8 | H9 | 870-1050-7LX063-3 | .625 | 1.863 | 3.819 | 1.417 | .067 | 145 | 0.312 | 33000 | 870-1090-7-PM |
| .413 | .433 | 7 | 2.230 | 5/8 | H9 | 870-1050-7LX063-5 | .625 | 2.729 | 4.685 | 2.283 | .067 | 145 | 0.329 | 15000 | |
| .413 | .433 | 7 | 3.528 | 5/8 | H9 | 870-1050-7LX063-8 | .625 | 4.028 | 5.984 | 3.583 | .067 | 217 | 0.354 | 12000 | |
| .413 | .433 | 7 | 4.393 | 5/8 | H10 | 870-1050-7LX063-10 | .625 | 4.894 | 6.850 | 4.449 | .067 | 435 | 0.363 | 9000 | |
| .433 | .452 | 8 | 1.426 | 5/8 | H9 | 870-1100-8LX063-3 | .625 | 1.939 | 3.898 | 1.496 | .069 | 145 | 0.317 | 33000 | 870-1140-8-PM |
| .433 | .452 | 8 | 2.331 | 5/8 | H9 | 870-1100-8LX063-5 | .625 | 2.844 | 4.803 | 2.402 | .069 | 145 | 0.352 | 15000 | |
| .433 | .452 | 8 | 3.688 | 5/8 | H9 | 870-1100-8LX063-8 | .625 | 4.222 | 6.181 | 3.780 | .069 | 217 | 0.363 | 12000 | |
| .433 | .452 | 8 | 4.592 | 5/8 | H10 | 870-1100-8LX063-10 | .625 | 5.128 | 7.087 | 4.685 | .069 | 435 | 0.374 | 9000 | |
| .452 | .472 | 9 | 1.488 | 5/8 | H9 | 870-1150-9LX063-3 | .625 | 2.015 | 3.976 | 1.575 | .072 | 145 | 0.320 | 33000 | 870-1190-9-PM |
| .452 | .472 | 9 | 2.433 | 5/8 | H9 | 870-1150-9LX063-5 | .625 | 2.959 | 4.921 | 2.520 | .072 | 145 | 0.342 | 15000 | |
| .452 | .472 | 9 | 3.849 | 5/8 | H9 | 870-1150-9LX063-8 | .625 | 4.377 | 6.339 | 3.937 | .072 | 217 | 0.374 | 12000 | |
| .452 | .472 | 9 | 4.793 | 5/8 | H10 | 870-1150-9LX063-10 | .625 | 5.322 | 7.283 | 4.882 | .072 | 435 | 0.385 | 9000 | |
| .472 | .492 | 10 | 1.550 | 5/8 | H9 | 870-1200-10LX063-3 | .625 | 2.091 | 4.055 | 1.654 | .075 | 145 | 0.332 | 33000 | 870-1240-10-PM |
| .472 | .492 | 10 | 2.533 | 5/8 | H9 | 870-1200-10LX063-5 | .625 | 3.035 | 5.000 | 2.598 | .075 | 145 | 0.357 | 15000 | |
| .472 | .492 | 10 | 4.009 | 5/8 | H9 | 870-1200-10LX063-8 | .625 | 4.571 | 6.535 | 4.134 | .075 | 217 | 0.391 | 10000 | |
| .472 | .492 | 10 | 4.992 | 5/8 | H10 | 870-1200-10LX063-10 | .625 | 5.555 | 7.520 | 5.118 | .075 | 435 | 0.410 | 7000 | |
| .492 | .511 | 11 | 1.612 | 5/8 | H9 | 870-1250-11LX063-3 | .625 | 2.127 | 4.094 | 1.693 | .078 | 145 | 0.337 | 33000 | 870-1290-11-PM |
| .492 | .511 | 11 | 2.635 | 5/8 | H9 | 870-1250-11LX063-5 | .625 | 3.150 | 5.118 | 2.717 | .078 | 145 | 0.363 | 15000 | |
| .492 | .511 | 11 | 4.170 | 5/8 | H9 | 870-1250-11LX063-8 | .625 | 4.686 | 6.654 | 4.252 | .078 | 217 | 0.405 | 10000 | |
| .492 | .511 | 11 | 5.192 | 5/8 | H10 | 870-1250-11LX063-10 | .625 | 5.709 | 7.677 | 5.276 | .078 | 435 | 0.465 | 7000 | |
| .511 | .531 | 12 | 1.674 | 5/8 | H9 | 870-1300-12LX063-3 | .625 | 2.202 | 4.173 | 1.772 | .081 | 145 | 0.341 | 33000 | 870-1340-12-PM |
| .511 | .531 | 12 | 2.737 | 5/8 | H9 | 870-1300-12LX063-5 | .625 | 3.265 | 5.236 | 2.835 | .081 | 145 | 0.373 | 15000 | |
| .511 | .531 | 12 | 4.330 | 5/8 | H9 | 870-1300-12LX063-8 | .625 | 4.880 | 6.850 | 4.449 | .081 | 217 | 0.410 | 9500 | |
| .511 | .531 | 12 | 5.392 | 5/8 | H10 | 870-1300-12LX063-10 | .625 | 5.943 | 7.913 | 5.512 | .081 | 435 | 0.440 | 6500 | |
| .531 | .551 | 13 | 1.737 | 5/8 | H9 | 870-1350-13LX063-3 | .625 | 2.278 | 4.252 | 1.850 | .084 | 145 | 0.348 | 33000 | 870-1390-13-PM |
| .531 | .551 | 13 | 2.838 | 5/8 | H9 | 870-1350-13LX063-5 | .625 | 3.341 | 5.315 | 2.913 | .084 | 145 | 0.381 | 15000 | |
| .531 | .551 | 13 | 4.491 | 5/8 | H9 | 870-1350-13LX063-8 | .625 | 5.034 | 7.008 | 4.606 | .084 | 217 | 0.440 | 9500 | |
| .531 | .551 | 13 | 5.592 | 5/8 | H10 | 870-1350-13LX063-10 | .625 | 6.136 | 8.110 | 5.709 | .084 | 435 | 0.440 | 6500 | |
| .551 | .590 | 14 | 1.861 | 3/4 | H9 | 870-1400-14LX075-3 | .750 | 2.509 | 4.567 | 1.969 | .090 | 145 | 0.481 | 33000 | 870-1490-14-PM |
| .551 | .590 | 14 | 3.041 | 3/4 | H9 | 870-1400-14LX075-5 | .750 | 3.690 | 5.748 | 3.150 | .090 | 145 | 0.520 | 15000 | |
| .551 | .590 | 14 | 4.811 | 3/4 | H9 | 870-1400-14LX075-8 | .750 | 5.461 | 7.520 | 4.921 | .090 | 217 | 0.596 | 9500 | |
| .551 | .590 | 14 | 5.992 | 3/4 | H10 | 870-1400-14LX075-10 | .750 | 6.643 | 8.701 | 6.102 | .090 | 435 | 0.661 | 6500 | |
| .590 | .630 | 15 | 1.985 | 3/4 | H9 | 870-1500-15LX075-3 | .750 | 2.620 | 4.685 | 2.087 | .096 | 145 | 0.496 | 33000 | 870-1590-15-PM |
| .590 | .630 | 15 | 3.244 | 3/4 | H9 | 870-1500-15LX075-5 | .750 | 3.880 | 5.945 | 3.346 | .096 | 145 | 0.548 | 15000 | |
| .590 | .630 | 15 | 5.132 | 3/4 | H9 | 870-1500-15LX075-8 | .750 | 5.770 | 7.835 | 5.236 | .096 | 217 | 0.661 | 8000 | |
| .590 | .630 | 15 | 6.391 | 3/4 | H10 | 870-1500-15LX075-10 | .750 | 7.030 | 9.094 | 6.496 | .096 | 435 | 0.705 | 5000 | |
| .629 | .669 | 16 | 2.108 | 3/4 | H9 | 870-1600-16LX075-3 | .750 | 2.733 | 4.803 | 2.205 | .102 | 145 | 0.513 | 33000 | 870-1690-16-PM |
| .629 | .669 | 16 | 3.446 | 3/4 | H9 | 870-1600-16LX075-5 | .750 | 4.072 | 6.142 | 3.543 | .102 | 145 | 0.573 | 15000 | |
| .629 | .669 | 16 | 5.453 | 3/4 | H9 | 870-1600-16LX075-8 | .750 | 6.080 | 8.150 | 5.551 | .102 | 217 | 0.704 | 8000 | |
| .629 | .669 | 16 | 6.790 | 3/4 | H10 | 870-1600-16LX075-10 | .750 | 7.418 | 9.488 | 6.890 | .102 | 435 | 0.745 | 5000 | |

J12 L2 N22 N6 N15

# CoroDrill® 870 exchangeable tip drill

**Drill bodies – internal coolant supply**

**Cylindrical shank with flat according to ISO 9766**




## Inch design

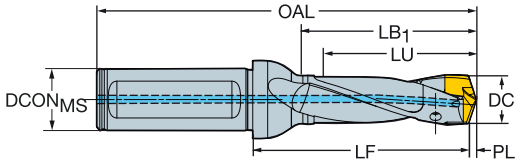
| DCN | DCX | | LU | CZC$_{MS}$ | TCHA | Ordering code | DCON$_{MS}$ | LF | OAL | LB$_1$ | PL | PSI | LBS | RPMX | MIID$_P$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Dimensions, inch | | | | | | | | |
| .669 | .708 | 17 | 2.232 | 3/4 | H9 | 870-1700-17LX075-3 | .750 | 2.885 | 4.961 | 2.323 | .107 | 145 | 0.518 | 30000 | 870-1790-17-PM |
| .669 | .708 | 17 | 3.649 | 3/4 | H9 | 870-1700-17LX075-5 | .750 | 4.302 | 6.378 | 3.740 | .107 | 145 | 0.595 | 13500 | |
| .669 | .708 | 17 | 5.774 | 3/4 | H9 | 870-1700-17LX075-8 | .750 | 6.428 | 8.504 | 5.866 | .107 | 217 | 0.729 | 8000 | |
| .669 | .708 | 17 | 7.190 | 3/4 | H10 | 870-1700-17LX075-10 | .750 | 7.845 | 9.921 | 7.283 | .107 | 435 | 0.806 | 5000 | |
| .708 | .748 | 18 | 2.356 | 3/4 | H9 | 870-1800-18LX075-3 | .750 | 2.997 | 5.079 | 2.441 | .113 | 145 | 0.544 | 30000 | 870-1890-18-PM |
| .708 | .748 | 18 | 3.851 | 3/4 | H9 | 870-1800-18LX075-5 | .750 | 4.454 | 6.535 | 3.937 | .113 | 145 | 0.661 | 13500 | |
| .708 | .748 | 18 | 6.094 | 3/4 | H9 | 870-1800-18LX075-8 | .750 | 6.737 | 8.819 | 6.181 | .113 | 217 | 0.787 | 8000 | |
| .708 | .748 | 18 | 7.590 | 3/4 | H10 | 870-1800-18LX075-10 | .750 | 8.233 | 10.315 | 7.677 | .113 | 435 | 0.857 | 5000 | |
| .748 | .787 | 19 | 2.480 | 1 | H9 | 870-1900-19LX1-3 | 1.000 | 3.267 | 5.591 | 2.598 | .119 | 145 | 0.932 | 30000 | 870-1990-19-PM |
| .748 | .787 | 19 | 4.054 | 1 | H9 | 870-1900-19LX1-5 | 1.000 | 4.842 | 7.165 | 4.173 | .119 | 145 | 1.033 | 13500 | |
| .748 | .787 | 19 | 6.415 | 1 | H9 | 870-1900-19LX1-8 | 1.000 | 7.204 | 9.528 | 6.535 | .119 | 217 | 1.234 | 7000 | |
| .748 | .787 | 19 | 7.989 | 1 | H10 | 870-1900-19LX1-10 | 1.000 | 8.779 | 11.102 | 8.110 | .119 | 435 | 1.320 | 4500 | |
| .787 | .826 | 20 | 2.604 | 1 | H9 | 870-2000-20LX1-3 | 1.000 | 3.419 | 5.748 | 2.717 | .125 | 145 | 0.970 | 21500 | 870-2090-20-PM |
| .787 | .826 | 20 | 4.257 | 1 | H9 | 870-2000-20LX1-5 | 1.000 | 5.072 | 7.402 | 4.370 | .125 | 145 | 1.080 | 12000 | |
| .787 | .826 | 20 | 6.736 | 1 | H9 | 870-2000-20LX1-8 | 1.000 | 7.552 | 9.882 | 6.850 | .125 | 217 | 1.305 | 7000 | |
| .787 | .826 | 20 | 8.389 | 1 | H10 | 870-2000-20LX1-10 | 1.000 | 9.206 | 11.535 | 8.504 | .125 | 435 | 1.397 | 4500 | |
| .826 | .866 | 21 | 2.728 | 1 | H9 | 870-2100-21LX1-3 | 1.000 | 3.531 | 5.866 | 2.835 | .131 | 145 | 1.014 | 21500 | 870-2190-21-PM |
| .826 | .866 | 21 | 4.459 | 1 | H9 | 870-2100-21LX1-5 | 1.000 | 5.263 | 7.598 | 4.567 | .131 | 145 | 1.146 | 12000 | |
| .826 | .866 | 21 | 7.057 | 1 | H9 | 870-2100-21LX1-8 | 1.000 | 7.861 | 10.197 | 7.165 | .131 | 217 | 1.397 | 7000 | |
| .826 | .866 | 21 | 8.788 | 1 | H10 | 870-2100-21LX1-10 | 1.000 | 9.594 | 11.929 | 8.898 | .131 | 435 | 1.510 | 4500 | |
| .866 | .905 | 22 | 2.852 | 1 | H9 | 870-2200-22LX1-3 | 1.000 | 3.682 | 6.024 | 2.992 | .137 | 145 | 1.037 | 16000 | 870-2290-22-PM |
| .866 | .905 | 22 | 4.662 | 1 | H9 | 870-2200-22LX1-5 | 1.000 | 5.493 | 7.835 | 4.803 | .137 | 145 | 1.287 | 12000 | |
| .866 | .905 | 22 | 7.377 | 1 | H9 | 870-2200-22LX1-8 | 1.000 | 8.210 | 10.551 | 7.520 | .137 | 217 | 1.486 | 7000 | |
| .866 | .905 | 22 | 9.188 | 1 | H10 | 870-2200-22LX1-10 | 1.000 | 9.982 | 12.323 | 9.291 | .137 | 435 | 1.543 | 4500 | |
| .905 | .944 | 23 | 2.975 | 1 | H9 | 870-2300-23LX1-3 | 1.000 | 3.834 | 6.181 | 3.110 | .142 | 145 | 1.084 | 21500 | 870-2390-23-PM |
| .905 | .944 | 23 | 4.864 | 1 | H9 | 870-2300-23LX1-5 | 1.000 | 5.724 | 8.071 | 5.000 | .142 | 145 | 1.327 | 12000 | |
| .905 | .944 | 23 | 7.698 | 1 | H9 | 870-2300-23LX1-8 | 1.000 | 8.559 | 10.906 | 7.835 | .142 | 217 | 1.594 | 6000 | |
| .905 | .944 | 23 | 9.587 | 1 | H10 | 870-2300-23LX1-10 | 1.000 | 10.448 | 12.795 | 9.724 | .142 | 435 | 1.715 | 4000 | |
| .944 | .984 | 24 | 3.100 | 1 1/4 | H9 | 870-2400-24LX125-3 | 1.250 | 4.104 | 6.614 | 3.228 | .148 | 145 | 1.744 | 16000 | 870-2490-24-PM |
| .944 | .984 | 24 | 5.068 | 1 1/4 | H9 | 870-2400-24LX125-5 | 1.250 | 6.111 | 8.622 | 5.197 | .148 | 145 | 1.983 | 10500 | |
| .944 | .984 | 24 | 8.019 | 1 1/4 | H9 | 870-2400-24LX125-8 | 1.250 | 9.025 | 11.535 | 8.150 | .148 | 217 | 2.248 | 6000 | |
| .944 | .984 | 24 | 9.987 | 1 1/4 | H10 | 870-2400-24LX125-10 | 1.250 | 10.836 | 13.347 | 10.118 | .148 | 435 | 2.425 | 4000 | |
| .984 | 1.023 | 25 | 3.224 | 1 1/4 | H9 | 870-2500-25LX125-3 | 1.250 | 4.216 | 6.732 | 3.346 | .154 | 145 | 1.792 | 16000 | 870-2590-25-PM |
| .984 | 1.023 | 25 | 5.270 | 1 1/4 | H9 | 870-2500-25LX125-5 | 1.250 | 6.263 | 8.780 | 5.394 | .154 | 145 | 2.028 | 10500 | |
| .984 | 1.023 | 25 | 8.340 | 1 1/4 | H9 | 870-2500-25LX125-8 | 1.250 | 9.334 | 11.850 | 8.465 | .154 | 217 | 2.386 | 6000 | |
| .984 | 1.023 | 25 | 10.387 | 1 1/4 | H10 | 870-2500-25LX125-10 | 1.250 | 11.382 | 13.898 | 10.512 | .154 | 435 | 2.685 | 4000 | |
| 1.023 | 1.063 | 26 | 3.348 | 1 1/4 | H9 | 870-2600-26LX125-3 | 1.250 | 4.408 | 6.929 | 3.504 | .159 | 145 | 1.836 | 16000 | 870-2665-26-PM |
| 1.023 | 1.063 | 26 | 5.473 | 1 1/4 | H9 | 870-2600-26LX125-5 | 1.250 | 6.534 | 9.055 | 5.630 | .159 | 145 | 2.094 | 10500 | |
| 1.023 | 1.063 | 26 | 8.661 | 1 1/4 | H9 | 870-2600-26LX125-8 | 1.250 | 9.684 | 12.205 | 8.780 | .159 | 217 | 2.442 | 6000 | |
| 1.023 | 1.063 | 26 | 10.786 | 1 1/4 | H10 | 870-2600-26LX125-10 | 1.250 | 11.810 | 14.331 | 10.906 | .159 | 145 | 2.733 | 3500 | |
| 1.062 | 1.102 | 27 | 3.472 | 1 1/4 | H9 | 870-2700-27LX125-3 | 1.250 | 4.483 | 7.008 | 3.622 | .163 | 145 | 1.858 | 16000 | 870-2750-27-PM |
| 1.062 | 1.102 | 27 | 5.676 | 1 1/4 | H9 | 870-2700-27LX125-5 | 1.250 | 6.727 | 9.252 | 5.827 | .163 | 145 | 2.160 | 10500 | |
| 1.062 | 1.102 | 27 | 8.982 | 1 1/4 | H9 | 870-2700-27LX125-8 | 1.250 | 9.994 | 12.520 | 9.134 | .163 | 145 | 2.581 | 5000 | |
| 1.102 | 1.141 | 28 | 3.596 | 1 1/4 | H9 | 870-2800-28LX125-3 | 1.250 | 4.594 | 7.126 | 3.740 | .170 | 145 | 1.957 | 16000 | 870-2858-28-PM |
| 1.102 | 1.141 | 28 | 5.879 | 1 1/4 | H9 | 870-2800-28LX125-5 | 1.250 | 6.877 | 9.409 | 6.024 | .170 | 145 | 2.295 | 10500 | |
| 1.102 | 1.141 | 28 | 9.303 | 1 1/4 | H9 | 870-2800-28LX125-8 | 1.250 | 10.302 | 12.835 | 9.449 | .170 | 145 | 2.689 | 5000 | |

J12 L2 N22 N6 N15

# CoroDrill® 870 exchangeable tip drill

**Drill bodies – internal coolant supply**

**Cylindrical shank with flat according to ISO 9766**




## Inch design

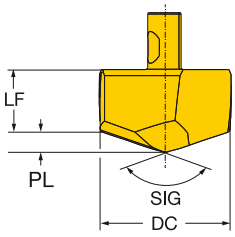
| DCN | DCX | | LU | CZC$_{MS}$ | TCHA | Ordering code | DCON$_{MS}$ | LF | OAL | LB$_1$ | PL | PSI | LBS | RPMX | MIID$_P$ |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Dimensions, inch | | | | | | | | |
| 1.141 | 1.181 | 29 | 3.720 | 1 1/4 | H9 | **870-2900-29LX125-3** | 1.250 | 4.706 | 7.244 | 3.858 | .176 | 145 | 1.851 | 16000 | 870-2965-29-PM |
| 1.141 | 1.181 | 29 | 6.081 | 1 1/4 | H9 | **870-2900-29LX125-5** | 1.250 | 7.107 | 9.646 | 6.220 | .176 | 145 | 2.394 | 10500 | |
| 1.141 | 1.181 | 29 | 9.624 | 1 1/4 | H9 | **870-2900-29LX125-8** | 1.250 | 10.611 | 13.150 | 9.764 | .176 | 145 | 2.915 | 5000 | |
| 1.181 | 1.220 | 30 | 3.844 | 1 1/4 | H9 | **870-3000-30LX125-3** | 1.250 | 4.858 | 7.402 | 4.016 | .181 | 145 | 1.851 | 16000 | 870-3050-30-PM |
| 1.181 | 1.220 | 30 | 6.284 | 1 1/4 | H9 | **870-3000-30LX125-5** | 1.250 | 7.339 | 9.882 | 6.457 | .181 | 145 | 2.513 | 9500 | |
| 1.181 | 1.220 | 30 | 9.944 | 1 1/4 | H9 | **870-3000-30LX125-8** | 1.250 | 10.921 | 13.465 | 10.079 | .181 | 145 | 2.998 | 4000 | |
| 1.220 | 1.299 | 31 | 4.098 | 1 1/4 | H9 | **870-3100-31LX125-3** | 1.250 | 5.076 | 7.638 | 4.252 | .200 | 145 | 2.072 | 16000 | 870-3300-31-PM |
| 1.220 | 1.299 | 31 | 6.696 | 1 1/4 | H9 | **870-3100-31LX125-5** | 1.250 | 7.674 | 10.236 | 6.850 | .200 | 145 | 2.683 | 9500 | |
| 1.220 | 1.299 | 31 | 10.594 | 1 1/4 | H9 | **870-3100-31LX125-8** | 1.250 | 11.572 | 14.134 | 10.748 | .200 | 145 | 3.218 | 4000 | |

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

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

J12 L2 N22 N6 N15

# CoroDrill® 870 drill tip



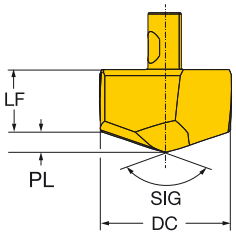

| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | Dimensions, mm, inch LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 10.00 | .393 | 6 | 870-1000-6-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.7 | .183 | 1.5 | .061 | 142° | H9 |
| 10.00 | .393 | | 870-1000-6-MM | | | ★ | | | | | ☆ | | 4.7 | .183 | 1.5 | .061 | 142° | H9 |
| 10.00 | .393 | | 870-1000-6-KM | ☆ | | | | ★ | | | | | 4.4 | .172 | 1.8 | .072 | 142° | H9 |
| 10.00 | .393 | | 870-1000-6-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.6 | .181 | 1.1 | .043 | 152° | F9 |
| 10.10 | .397 | | 870-1010-6-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.7 | .183 | 1.6 | .061 | 142° | H9 |
| 10.10 | .397 | | 870-1010-6-MM | | | ★ | | | | | ☆ | | 4.7 | .183 | 1.6 | .061 | 142° | H9 |
| 10.10 | .397 | | 870-1010-6-KM | ☆ | | | | ★ | | | | | 4.4 | .172 | 1.8 | .072 | 142° | H9 |
| 10.10 | .397 | | 870-1010-6-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.6 | .181 | 1.1 | .043 | 152° | F9 |
| 10.20 | .401 | | 870-1020-6-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.6 | .182 | 1.6 | .062 | 142° | H9 |
| 10.20 | .401 | | 870-1020-6-MM | | | ★ | | | | | ☆ | | 4.6 | .182 | 1.6 | .062 | 142° | H9 |
| 10.20 | .401 | | 870-1020-6-KM | ☆ | | | | ★ | | | | | 4.3 | .171 | 1.9 | .073 | 142° | H9 |
| 10.20 | .401 | | 870-1020-6-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.6 | .180 | 1.1 | .044 | 152° | F9 |
| 10.30 | .405 | | 870-1030-6-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.6 | .181 | 1.6 | .063 | 142° | H9 |
| 10.30 | .405 | | 870-1030-6-MM | | | ★ | | | | | ☆ | | 4.6 | .181 | 1.6 | .063 | 142° | H9 |
| 10.30 | .405 | | 870-1030-6-KM | ☆ | | | | ★ | | | | | 4.3 | .170 | 1.9 | .074 | 142° | H9 |
| 10.30 | .405 | | 870-1030-6-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.6 | .180 | 1.1 | .044 | 152° | F9 |
| 10.40 | .409 | | 870-1040-6-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.6 | .181 | 1.6 | .063 | 142° | H9 |
| 10.40 | .409 | | 870-1040-6-MM | | | ★ | | | | | ☆ | | 4.6 | .181 | 1.6 | .063 | 142° | H9 |
| 10.40 | .409 | | 870-1040-6-KM | ☆ | | | | ★ | | | | | 4.3 | .170 | 1.9 | .074 | 142° | H9 |
| 10.40 | .409 | | 870-1040-6-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.6 | .180 | 1.1 | .045 | 152° | F9 |
| 10.50 | .413 | 7 | 870-1050-7-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.6 | .180 | 1.6 | .064 | 142° | H9 |
| 10.50 | .413 | | 870-1050-7-MM | | | ★ | | | | | ☆ | | 4.6 | .180 | 1.6 | .064 | 142° | H9 |
| 10.50 | .413 | | 870-1050-7-KM | ☆ | | | | ★ | | | | | 4.3 | .169 | 1.9 | .075 | 142° | H9 |
| 10.50 | .413 | | 870-1050-7-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.6 | .179 | 1.2 | .045 | 152° | F9 |
| 10.60 | .417 | | 870-1060-7-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.6 | .180 | 1.6 | .065 | 142° | H9 |
| 10.60 | .417 | | 870-1060-7-MM | | | ★ | | | | | ☆ | | 4.6 | .180 | 1.6 | .065 | 142° | H9 |
| 10.60 | .417 | | 870-1060-7-KM | ☆ | | | | ★ | | | | | 4.3 | .169 | 1.9 | .076 | 142° | H9 |
| 10.60 | .417 | | 870-1060-7-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.6 | .179 | 1.2 | .045 | 152° | F9 |
| 10.70 | .421 | | 870-1070-7-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.6 | .179 | 1.7 | .065 | 142° | H9 |
| 10.70 | .421 | | 870-1070-7-MM | | | ★ | | | | | ☆ | | 4.6 | .179 | 1.7 | .065 | 142° | H9 |
| 10.70 | .421 | | 870-1070-7-KM | ☆ | | | | ★ | | | | | 4.3 | .168 | 1.9 | .076 | 142° | H9 |
| 10.70 | .421 | | 870-1070-7-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.5 | .179 | 1.2 | .046 | 152° | F9 |
| 10.80 | .425 | | 870-1080-7-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.5 | .178 | 1.7 | .066 | 142° | H9 |
| 10.80 | .425 | | 870-1080-7-MM | | | ★ | | | | | ☆ | | 4.5 | .178 | 1.7 | .066 | 142° | H9 |
| 10.80 | .425 | | 870-1080-7-KM | ☆ | | | | ★ | | | | | 4.3 | .167 | 2.0 | .077 | 142° | H9 |
| 10.80 | .425 | | 870-1080-7-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.5 | .178 | 1.2 | .046 | 152° | F9 |
| 10.90 | .429 | | 870-1090-7-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 4.5 | .178 | 1.7 | .067 | 142° | H9 |
| 10.90 | .429 | | 870-1090-7-MM | | | ★ | | | | | ☆ | | 4.5 | .178 | 1.7 | .067 | 142° | H9 |
| 10.90 | .429 | | 870-1090-7-KM | ☆ | | | | ★ | | | | | 4.2 | .167 | 2.0 | .078 | 142° | H9 |
| 10.90 | .429 | | 870-1090-7-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 4.5 | .178 | 1.2 | .046 | 152° | F9 |
| 11.00 | .433 | 8 | 870-1100-8-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.2 | .206 | 1.7 | .066 | 142° | H9 |
| 11.00 | .433 | | 870-1100-8-MM | | | ★ | | | | | ☆ | | 5.2 | .206 | 1.7 | .066 | 142° | H9 |
| 11.00 | .433 | | 870-1100-8-KM | ☆ | | | | ★ | | | | | 4.9 | .194 | 2.0 | .077 | 142° | H9 |
| 11.00 | .433 | | 870-1100-8-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.2 | .206 | 1.2 | .046 | 152° | F9 |
| 11.10 | .437 | | 870-1110-8-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.2 | .205 | 1.7 | .067 | 142° | H9 |
| 11.10 | .437 | | 870-1110-8-MM | | | ★ | | | | | ☆ | | 5.2 | .205 | 1.7 | .067 | 142° | H9 |
| 11.10 | .437 | | 870-1110-8-KM | ☆ | | | | ★ | | | | | 4.9 | .194 | 2.0 | .078 | 142° | H9 |
| 11.10 | .437 | | 870-1110-8-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.2 | .205 | 1.2 | .047 | 152° | F9 |
| 11.11 | .437 | | 870-1111-8-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.2 | .205 | 1.7 | .067 | 142° | H9 |
| 11.11 | .437 | | 870-1111-8-MM | | | ★ | | | | | ☆ | | 5.2 | .205 | 1.7 | .067 | 142° | H9 |
| 11.11 | .437 | | 870-1111-8-KM | ☆ | | | | ★ | | | | | 4.9 | .194 | 2.0 | .078 | 142° | H9 |
| 11.11 | .437 | | 870-1111-8-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.2 | .205 | 1.2 | .047 | 152° | F9 |

J6 J62 J5 N22 N6



SANDVIK Coromant

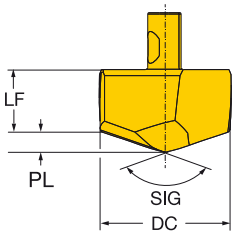
# CoroDrill® 870 drill tip




| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
| 11.20 | .440 | 8 | 870-1120-8-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.2 | .204 | 1.7 | .067 | 142° | H9 |
| 11.20 | .440 | | 870-1120-8-MM | | | ★ | | | | | ☆ | | 5.2 | .204 | 1.7 | .067 | 142° | H9 |
| 11.20 | .440 | | 870-1120-8-KM | ☆ | | | | ★ | | | | | 4.9 | .193 | 2.0 | .079 | 142° | H9 |
| 11.20 | .440 | | 870-1120-8-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.2 | .204 | 1.2 | .048 | 152° | F9 |
| 11.30 | .444 | | 870-1130-8-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.2 | .204 | 1.7 | .068 | 142° | H9 |
| 11.30 | .444 | | 870-1130-8-MM | | | ★ | | | | | ☆ | | 5.2 | .204 | 1.7 | .068 | 142° | H9 |
| 11.30 | .444 | | 870-1130-8-KM | ☆ | | | | ★ | | | | | 4.9 | .193 | 2.0 | .079 | 142° | H9 |
| 11.30 | .444 | | 870-1130-8-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.2 | .204 | 1.2 | .048 | 152° | F9 |
| 11.40 | .448 | | 870-1140-8-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.2 | .203 | 1.8 | .069 | 142° | H9 |
| 11.40 | .448 | | 870-1140-8-MM | | | ★ | | | | | ☆ | | 5.2 | .203 | 1.8 | .069 | 142° | H9 |
| 11.40 | .448 | | 870-1140-8-KM | ☆ | | | | ★ | | | | | 4.9 | .192 | 2.0 | .080 | 142° | H9 |
| 11.40 | .448 | | 870-1140-8-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.2 | .204 | 1.2 | .048 | 152° | F9 |
| 11.50 | .452 | 9 | 870-1150-9-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.1 | .202 | 1.8 | .069 | 142° | H9 |
| 11.50 | .452 | | 870-1150-9-MM | | | ★ | | | | | ☆ | | 5.1 | .202 | 1.8 | .069 | 142° | H9 |
| 11.50 | .452 | | 870-1150-9-KM | ☆ | | | | ★ | | | | | 4.8 | .188 | 2.1 | .083 | 142° | H9 |
| 11.50 | .452 | | 870-1150-9-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.2 | .203 | 1.2 | .049 | 152° | F9 |
| 11.60 | .456 | | 870-1160-9-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.1 | .202 | 1.8 | .070 | 142° | H9 |
| 11.60 | .456 | | 870-1160-9-MM | | | ★ | | | | | ☆ | | 5.1 | .202 | 1.8 | .070 | 142° | H9 |
| 11.60 | .456 | | 870-1160-9-KM | ☆ | | | | ★ | | | | | 4.8 | .188 | 2.1 | .084 | 142° | H9 |
| 11.60 | .456 | | 870-1160-9-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.2 | .203 | 1.3 | .049 | 152° | F9 |
| 11.70 | .460 | | 870-1170-9-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.1 | .201 | 1.8 | .071 | 142° | H9 |
| 11.70 | .460 | | 870-1170-9-MM | | | ★ | | | | | ☆ | | 5.1 | .201 | 1.8 | .071 | 142° | H9 |
| 11.70 | .460 | | 870-1170-9-KM | ☆ | | | | ★ | | | | | 4.8 | .187 | 2.2 | .085 | 142° | H9 |
| 11.70 | .460 | | 870-1170-9-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.1 | .202 | 1.3 | .050 | 152° | F9 |
| 11.80 | .464 | | 870-1180-9-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.1 | .200 | 1.8 | .071 | 142° | H9 |
| 11.80 | .464 | | 870-1180-9-MM | | | ★ | | | | | ☆ | | 5.1 | .200 | 1.8 | .071 | 142° | H9 |
| 11.80 | .464 | | 870-1180-9-KM | ☆ | | | | ★ | | | | | 4.7 | .186 | 2.2 | .085 | 142° | H9 |
| 11.80 | .464 | | 870-1180-9-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.1 | .202 | 1.3 | .050 | 152° | F9 |
| 11.90 | .468 | | 870-1190-9-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.1 | .200 | 1.8 | .072 | 142° | H9 |
| 11.90 | .468 | | 870-1190-9-MM | | | ★ | | | | | ☆ | | 5.1 | .200 | 1.8 | .072 | 142° | H9 |
| 11.90 | .468 | | 870-1190-9-KM | ☆ | | | | ★ | | | | | 4.7 | .186 | 2.2 | .086 | 142° | H9 |
| 11.90 | .468 | | 870-1190-9-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.1 | .202 | 1.3 | .050 | 152° | F9 |
| 12.00 | .472 | 10 | 870-1200-10-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.7 | .223 | 1.8 | .072 | 142° | H9 |
| 12.00 | .472 | | 870-1200-10-MM | | | ★ | | | | | ☆ | | 5.7 | .223 | 1.8 | .072 | 142° | H9 |
| 12.00 | .472 | | 870-1200-10-KM | ☆ | | | | ★ | | | | | 5.3 | .209 | 2.2 | .086 | 142° | H9 |
| 12.00 | .472 | | 870-1200-10-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.7 | .225 | 1.3 | .051 | 152° | F9 |
| 12.10 | .476 | | 870-1210-10-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.7 | .222 | 1.9 | .073 | 142° | H9 |
| 12.10 | .476 | | 870-1210-10-MM | | | ★ | | | | | ☆ | | 5.7 | .222 | 1.9 | .073 | 142° | H9 |
| 12.10 | .476 | | 870-1210-10-KM | ☆ | | | | ★ | | | | | 5.3 | .209 | 2.2 | .087 | 142° | H9 |
| 12.10 | .476 | | 870-1210-10-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.7 | .224 | 1.3 | .051 | 152° | F9 |
| 12.20 | .480 | | 870-1220-10-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.6 | .222 | 1.9 | .073 | 142° | H9 |
| 12.20 | .480 | | 870-1220-10-MM | | | ★ | | | | | ☆ | | 5.6 | .222 | 1.9 | .073 | 142° | H9 |
| 12.20 | .480 | | 870-1220-10-KM | ☆ | | | | ★ | | | | | 5.3 | .208 | 2.2 | .087 | 142° | H9 |
| 12.20 | .480 | | 870-1220-10-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.7 | .224 | 1.3 | .052 | 152° | F9 |
| 12.30 | .484 | | 870-1230-10-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.6 | .221 | 1.9 | .074 | 142° | H9 |
| 12.30 | .484 | | 870-1230-10-MM | | | ★ | | | | | ☆ | | 5.6 | .221 | 1.9 | .074 | 142° | H9 |
| 12.30 | .484 | | 870-1230-10-KM | ☆ | | | | ★ | | | | | 5.3 | .207 | 2.2 | .088 | 142° | H9 |
| 12.30 | .484 | | 870-1230-10-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.7 | .224 | 1.3 | .052 | 152° | F9 |
| 12.40 | .488 | | 870-1240-10-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.6 | .220 | 1.9 | .075 | 142° | H9 |
| 12.40 | .488 | | 870-1240-10-MM | | | ★ | | | | | ☆ | | 5.6 | .220 | 1.9 | .075 | 142° | H9 |
| 12.40 | .488 | | 870-1240-10-KM | ☆ | | | | ★ | | | | | 5.3 | .207 | 2.3 | .089 | 142° | H9 |
| 12.40 | .488 | | 870-1240-10-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.7 | .223 | 1.3 | .052 | 152° | F9 |

J6 J62 J5 N22 N6

# CoroDrill® 870 drill tip



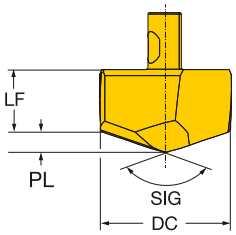

| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | Dimensions, mm, inch LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 12.50 | .492 | 11 | 870-1250-11-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.6 | .220 | 1.9 | .075 | 142° | H9 |
| 12.50 | .492 | | 870-1250-11-MM | | | ★ | | | | | ☆ | | 5.6 | .220 | 1.9 | .075 | 142° | H9 |
| 12.50 | .492 | | 870-1250-11-KM | ☆ | | | | ★ | | | | | 5.2 | .206 | 2.3 | .089 | 142° | H9 |
| 12.50 | .492 | | 870-1250-11-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.7 | .223 | 1.3 | .053 | 152° | F9 |
| 12.60 | .496 | | 870-1260-11-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.6 | .219 | 1.9 | .076 | 142° | H9 |
| 12.60 | .496 | | 870-1260-11-MM | | | ★ | | | | | ☆ | | 5.6 | .219 | 1.9 | .076 | 142° | H9 |
| 12.60 | .496 | | 870-1260-11-KM | ☆ | | | | ★ | | | | | 5.2 | .206 | 2.3 | .090 | 142° | H9 |
| 12.60 | .496 | | 870-1260-11-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.6 | .222 | 1.4 | .054 | 152° | F9 |
| 12.70 | .500 | | 870-1270-11-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.6 | .219 | 2.0 | .077 | 142° | H9 |
| 12.70 | .500 | | 870-1270-11-MM | | | ★ | | | | | ☆ | | 5.6 | .219 | 2.0 | .077 | 142° | H9 |
| 12.70 | .500 | | 870-1270-11-KM | ☆ | | | | ★ | | | | | 5.2 | .205 | 2.3 | .091 | 142° | H9 |
| 12.70 | .500 | | 870-1270-11-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.6 | .222 | 1.4 | .054 | 152° | F9 |
| 12.80 | .503 | | 870-1280-11-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.5 | .218 | 2.0 | .078 | 142° | H9 |
| 12.80 | .503 | | 870-1280-11-MM | | | ★ | | | | | ☆ | | 5.5 | .218 | 2.0 | .078 | 142° | H9 |
| 12.80 | .503 | | 870-1280-11-KM | ☆ | | | | ★ | | | | | 5.2 | .204 | 2.3 | .091 | 142° | H9 |
| 12.80 | .503 | | 870-1280-11-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.6 | .221 | 1.4 | .054 | 152° | F9 |
| 12.90 | .507 | | 870-1290-11-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.5 | .217 | 2.0 | .078 | 142° | H9 |
| 12.90 | .507 | | 870-1290-11-MM | | | ★ | | | | | ☆ | | 5.5 | .217 | 2.0 | .078 | 142° | H9 |
| 12.90 | .507 | | 870-1290-11-KM | ☆ | | | | ★ | | | | | 5.2 | .203 | 2.3 | .092 | 142° | H9 |
| 12.90 | .507 | | 870-1290-11-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 5.6 | .221 | 1.4 | .055 | 152° | F9 |
| 13.00 | .511 | 12 | 870-1300-12-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.0 | .237 | 2.0 | .078 | 142° | H9 |
| 13.00 | .511 | | 870-1300-12-PL | | ☆ | | ★ | | | | | | 5.4 | .213 | 2.6 | .102 | 142° | H9 |
| 13.00 | .511 | | 870-1300-12-MM | | | ★ | | | | | ☆ | | 6.0 | .237 | 2.0 | .078 | 142° | H9 |
| 13.00 | .511 | | 870-1300-12-KM | ☆ | | | | ★ | | | | | 5.6 | .220 | 2.4 | .095 | 142° | H9 |
| 13.00 | .511 | | 870-1300-12-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.1 | .240 | 1.4 | .055 | 152° | F9 |
| 13.10 | .515 | | 870-1310-12-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.0 | .236 | 2.0 | .079 | 142° | H9 |
| 13.10 | .515 | | 870-1310-12-MM | | | ★ | | | | | ☆ | | 6.0 | .236 | 2.0 | .079 | 142° | H9 |
| 13.10 | .515 | | 870-1310-12-KM | ☆ | | | | ★ | | | | | 5.6 | .219 | 2.4 | .096 | 142° | H9 |
| 13.10 | .515 | | 870-1310-12-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.1 | .240 | 1.4 | .056 | 152° | F9 |
| 13.20 | .519 | | 870-1320-12-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.0 | .235 | 2.0 | .080 | 142° | H9 |
| 13.20 | .519 | | 870-1320-12-MM | | | ★ | | | | | ☆ | | 6.0 | .235 | 2.0 | .080 | 142° | H9 |
| 13.20 | .519 | | 870-1320-12-KM | ☆ | | | | ★ | | | | | 5.6 | .219 | 2.5 | .096 | 142° | H9 |
| 13.20 | .519 | | 870-1320-12-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.1 | .239 | 1.4 | .056 | 152° | F9 |
| 13.30 | .523 | | 870-1330-12-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.0 | .235 | 2.0 | .080 | 142° | H9 |
| 13.30 | .523 | | 870-1330-12-MM | | | ★ | | | | | ☆ | | 6.0 | .235 | 2.0 | .080 | 142° | H9 |
| 13.30 | .523 | | 870-1330-12-KM | ☆ | | | | ★ | | | | | 5.5 | .218 | 2.5 | .097 | 142° | H9 |
| 13.30 | .523 | | 870-1330-12-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.1 | .239 | 1.4 | .056 | 152° | F9 |
| 13.40 | .527 | | 870-1340-12-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.9 | .234 | 2.1 | .081 | 142° | H9 |
| 13.40 | .527 | | 870-1340-12-MM | | | ★ | | | | | ☆ | | 5.9 | .234 | 2.1 | .081 | 142° | H9 |
| 13.40 | .527 | | 870-1340-12-KM | ☆ | | | | ★ | | | | | 5.5 | .217 | 2.5 | .098 | 142° | H9 |
| 13.40 | .527 | | 870-1340-12-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.1 | .239 | 1.4 | .057 | 152° | F9 |
| 13.50 | .531 | 13 | 870-1350-13-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.9 | .233 | 2.1 | .082 | 142° | H9 |
| 13.50 | .531 | | 870-1350-13-MM | | | ★ | | | | | ☆ | | 5.9 | .233 | 2.1 | .082 | 142° | H9 |
| 13.50 | .531 | | 870-1350-13-KM | ☆ | | | | ★ | | | | | 5.5 | .217 | 2.5 | .098 | 142° | H9 |
| 13.50 | .531 | | 870-1350-13-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.1 | .238 | 1.5 | .057 | 152° | F9 |
| 13.60 | .535 | | 870-1360-13-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.9 | .233 | 2.1 | .082 | 142° | H9 |
| 13.60 | .535 | | 870-1360-13-MM | | | ★ | | | | | ☆ | | 5.9 | .233 | 2.1 | .082 | 142° | H9 |
| 13.60 | .535 | | 870-1360-13-KM | ☆ | | | | ★ | | | | | 5.5 | .216 | 2.5 | .099 | 142° | H9 |
| 13.60 | .535 | | 870-1360-13-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.0 | .238 | 1.5 | .057 | 152° | F9 |
| 13.70 | .539 | | 870-1370-13-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.9 | .232 | 2.1 | .083 | 142° | H9 |
| 13.70 | .539 | | 870-1370-13-MM | | | ★ | | | | | ☆ | | 5.9 | .232 | 2.1 | .083 | 142° | H9 |
| 13.70 | .539 | | 870-1370-13-KM | ☆ | | | | ★ | | | | | 5.5 | .215 | 2.5 | .100 | 142° | H9 |
| 13.70 | .539 | | 870-1370-13-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.0 | .237 | 1.5 | .058 | 152° | F9 |

J6 J62 J5 N22 N6



SANDVIK Coromant

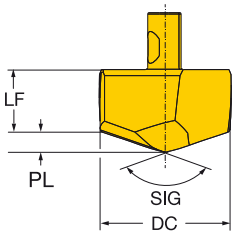
# CoroDrill® 870 drill tip




| DC | DC" | | Ordering code | P | | M | | K | | N | S | | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | 4334 | 2334 | 4334 | LF | LF" | PL | PL" | SIG | TCHA |
| 13.80 | .543 | 13 | 870-1380-13-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.9 | .231 | 2.1 | .084 | 142° | H9 |
| 13.80 | .543 | | 870-1380-13-MM | | | ★ | | | | | ☆ | | 5.9 | .231 | 2.1 | .084 | 142° | H9 |
| 13.80 | .543 | | 870-1380-13-KM | ☆ | | | | ★ | | | | | 5.5 | .215 | 2.6 | .100 | 142° | H9 |
| 13.80 | .543 | | 870-1380-13-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.0 | .237 | 1.5 | .058 | 152° | F9 |
| 13.90 | .547 | | 870-1390-13-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 5.9 | .231 | 2.1 | .084 | 142° | H9 |
| 13.90 | .547 | | 870-1390-13-MM | | | ★ | | | | | ☆ | | 5.9 | .231 | 2.1 | .084 | 142° | H9 |
| 13.90 | .547 | | 870-1390-13-KM | ☆ | | | | ★ | | | | | 5.4 | .214 | 2.6 | .101 | 142° | H9 |
| 13.90 | .547 | | 870-1390-13-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.0 | .237 | 1.5 | .058 | 152° | F9 |
| 14.00 | .551 | 14 | 870-1400-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.6 | .259 | 2.1 | .084 | 142° | H9 |
| 14.00 | .551 | | 870-1400-14-MM | | | ★ | | | | | ☆ | | 6.6 | .259 | 2.1 | .084 | 142° | H9 |
| 14.00 | .551 | | 870-1400-14-KM | ☆ | | | | ★ | | | | | 6.1 | .242 | 2.6 | .101 | 142° | H9 |
| 14.00 | .551 | | 870-1400-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.7 | .264 | 1.5 | .059 | 152° | F9 |
| 14.10 | .555 | | 870-1410-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.6 | .258 | 2.2 | .085 | 142° | H9 |
| 14.10 | .555 | | 870-1410-14-MM | | | ★ | | | | | ☆ | | 6.6 | .258 | 2.2 | .085 | 142° | H9 |
| 14.10 | .555 | | 870-1410-14-KM | ☆ | | | | ★ | | | | | 6.1 | .241 | 2.6 | .102 | 142° | H9 |
| 14.10 | .555 | | 870-1410-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.7 | .264 | 1.5 | .059 | 152° | F9 |
| 14.20 | .559 | | 870-1420-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.5 | .257 | 2.2 | .085 | 142° | H9 |
| 14.20 | .559 | | 870-1420-14-MM | | | ★ | | | | | ☆ | | 6.5 | .257 | 2.2 | .085 | 142° | H9 |
| 14.20 | .559 | | 870-1420-14-KM | ☆ | | | | ★ | | | | | 6.1 | .241 | 2.6 | .102 | 142° | H9 |
| 14.20 | .559 | | 870-1420-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.7 | .263 | 1.5 | .059 | 152° | F9 |
| 14.29 | .562 | | 870-1429-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.5 | .257 | 2.2 | .086 | 142° | H9 |
| 14.29 | .562 | | 870-1429-14-MM | | | ★ | | | | | ☆ | | 6.5 | .257 | 2.2 | .086 | 142° | H9 |
| 14.29 | .562 | | 870-1429-14-KM | ☆ | | | | ★ | | | | | 6.1 | .240 | 2.6 | .102 | 142° | H9 |
| 14.29 | .562 | | 870-1429-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.7 | .263 | 1.5 | .060 | 152° | F9 |
| 14.30 | .563 | | 870-1430-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.5 | .257 | 2.2 | .086 | 142° | H9 |
| 14.30 | .563 | | 870-1430-14-MM | | | ★ | | | | | ☆ | | 6.5 | .257 | 2.2 | .086 | 142° | H9 |
| 14.30 | .563 | | 870-1430-14-KM | ☆ | | | | ★ | | | | | 6.1 | .240 | 2.6 | .103 | 142° | H9 |
| 14.30 | .563 | | 870-1430-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.7 | .263 | 1.5 | .060 | 152° | F9 |
| 14.40 | .566 | | 870-1440-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.5 | .256 | 2.2 | .087 | 142° | H9 |
| 14.40 | .566 | | 870-1440-14-MM | | | ★ | | | | | ☆ | | 6.5 | .256 | 2.2 | .087 | 142° | H9 |
| 14.40 | .566 | | 870-1440-14-KM | ☆ | | | | ★ | | | | | 6.1 | .239 | 2.6 | .104 | 142° | H9 |
| 14.40 | .566 | | 870-1440-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.7 | .262 | 1.5 | .061 | 152° | F9 |
| 14.50 | .570 | | 870-1450-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.5 | .255 | 2.2 | .087 | 142° | H9 |
| 14.50 | .570 | | 870-1450-14-MM | | | ★ | | | | | ☆ | | 6.5 | .255 | 2.2 | .087 | 142° | H9 |
| 14.50 | .570 | | 870-1450-14-KM | ☆ | | | | ★ | | | | | 6.1 | .239 | 2.6 | .104 | 142° | H9 |
| 14.50 | .570 | | 870-1450-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.7 | .262 | 1.6 | .061 | 152° | F9 |
| 14.60 | .574 | | 870-1460-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.5 | .255 | 2.2 | .088 | 142° | H9 |
| 14.60 | .574 | | 870-1460-14-MM | | | ★ | | | | | ☆ | | 6.5 | .255 | 2.2 | .088 | 142° | H9 |
| 14.60 | .574 | | 870-1460-14-KM | ☆ | | | | ★ | | | | | 6.0 | .238 | 2.7 | .105 | 142° | H9 |
| 14.60 | .574 | | 870-1460-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.6 | .261 | 1.6 | .061 | 152° | F9 |
| 14.70 | .578 | | 870-1470-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.5 | .254 | 2.3 | .089 | 142° | H9 |
| 14.70 | .578 | | 870-1470-14-MM | | | ★ | | | | | ☆ | | 6.5 | .254 | 2.3 | .089 | 142° | H9 |
| 14.70 | .578 | | 870-1470-14-KM | ☆ | | | | ★ | | | | | 6.0 | .237 | 2.7 | .105 | 142° | H9 |
| 14.70 | .578 | | 870-1470-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.6 | .261 | 1.6 | .062 | 152° | F9 |
| 14.80 | .582 | | 870-1480-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.4 | .253 | 2.3 | .089 | 142° | H9 |
| 14.80 | .582 | | 870-1480-14-MM | | | ★ | | | | | ☆ | | 6.4 | .253 | 2.3 | .089 | 142° | H9 |
| 14.80 | .582 | | 870-1480-14-KM | ☆ | | | | ★ | | | | | 6.0 | .237 | 2.7 | .106 | 142° | H9 |
| 14.80 | .582 | | 870-1480-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.6 | .261 | 1.6 | .062 | 152° | F9 |
| 14.90 | .586 | | 870-1490-14-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.4 | .253 | 2.3 | .090 | 142° | H9 |
| 14.90 | .586 | | 870-1490-14-MM | | | ★ | | | | | ☆ | | 6.4 | .253 | 2.3 | .090 | 142° | H9 |
| 14.90 | .586 | | 870-1490-14-KM | ☆ | | | | ★ | | | | | 6.0 | .236 | 2.7 | .107 | 142° | H9 |
| 14.90 | .586 | | 870-1490-14-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 6.6 | .260 | 1.6 | .063 | 152° | F9 |

J6 J62 J5 N22 N6

# CoroDrill® 870 drill tip



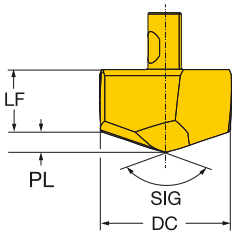

| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | Dimensions, mm, inch LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 15.00 | .590 | 15 | 870-1500-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.0 | .276 | 2.3 | .090 | 142° | H9 |
| 15.00 | .590 | | 870-1500-15-MM | | | ★ | | | | | ☆ | | 7.0 | .276 | 2.3 | .090 | 142° | H9 |
| 15.00 | .590 | | 870-1500-15-KM | ☆ | | | | ★ | | | | | 6.5 | .257 | 2.8 | .109 | 142° | H9 |
| 15.00 | .590 | | 870-1500-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.2 | .284 | 1.6 | .063 | 152° | F9 |
| 15.10 | .594 | | 870-1510-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.0 | .276 | 2.3 | .091 | 142° | H9 |
| 15.10 | .594 | | 870-1510-15-MM | | | ★ | | | | | ☆ | | 7.0 | .276 | 2.3 | .091 | 142° | H9 |
| 15.10 | .594 | | 870-1510-15-KM | ☆ | | | | ★ | | | | | 6.5 | .256 | 2.8 | .110 | 142° | H9 |
| 15.10 | .594 | | 870-1510-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.2 | .283 | 1.6 | .063 | 152° | F9 |
| 15.20 | .598 | | 870-1520-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.0 | .275 | 2.3 | .091 | 142° | H9 |
| 15.20 | .598 | | 870-1520-15-MM | | | ★ | | | | | ☆ | | 7.0 | .275 | 2.3 | .091 | 142° | H9 |
| 15.20 | .598 | | 870-1520-15-KM | ☆ | | | | ★ | | | | | 6.5 | .255 | 2.8 | .111 | 142° | H9 |
| 15.20 | .598 | | 870-1520-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.2 | .283 | 1.6 | .063 | 152° | F9 |
| 15.30 | .602 | | 870-1530-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.0 | .274 | 2.3 | .092 | 142° | H9 |
| 15.30 | .602 | | 870-1530-15-MM | | | ★ | | | | | ☆ | | 7.0 | .274 | 2.3 | .092 | 142° | H9 |
| 15.30 | .602 | | 870-1530-15-KM | ☆ | | | | ★ | | | | | 6.5 | .255 | 2.8 | .111 | 142° | H9 |
| 15.30 | .602 | | 870-1530-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.2 | .282 | 1.6 | .064 | 152° | F9 |
| 15.40 | .606 | | 870-1540-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.0 | .274 | 2.4 | .093 | 142° | H9 |
| 15.40 | .606 | | 870-1540-15-MM | | | ★ | | | | | ☆ | | 7.0 | .274 | 2.4 | .093 | 142° | H9 |
| 15.40 | .606 | | 870-1540-15-KM | ☆ | | | | ★ | | | | | 6.5 | .254 | 2.9 | .112 | 142° | H9 |
| 15.40 | .606 | | 870-1540-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.2 | .282 | 1.6 | .065 | 152° | F9 |
| 15.50 | .610 | | 870-1550-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.9 | .273 | 2.4 | .093 | 142° | H9 |
| 15.50 | .610 | | 870-1550-15-MM | | | ★ | | | | | ☆ | | 6.9 | .273 | 2.4 | .093 | 142° | H9 |
| 15.50 | .610 | | 870-1550-15-KM | ☆ | | | | ★ | | | | | 6.4 | .253 | 2.9 | .113 | 142° | H9 |
| 15.50 | .610 | | 870-1550-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.2 | .281 | 1.7 | .065 | 152° | F9 |
| 15.60 | .614 | | 870-1560-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.9 | .272 | 2.4 | .094 | 142° | H9 |
| 15.60 | .614 | | 870-1560-15-MM | | | ★ | | | | | ☆ | | 6.9 | .272 | 2.4 | .094 | 142° | H9 |
| 15.60 | .614 | | 870-1560-15-KM | ☆ | | | | ★ | | | | | 6.4 | .252 | 2.9 | .114 | 142° | H9 |
| 15.60 | .614 | | 870-1560-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.1 | .281 | 1.7 | .065 | 152° | F9 |
| 15.70 | .618 | | 870-1570-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.9 | .272 | 2.4 | .094 | 142° | H9 |
| 15.70 | .618 | | 870-1570-15-MM | | | ★ | | | | | ☆ | | 6.9 | .272 | 2.4 | .094 | 142° | H9 |
| 15.70 | .618 | | 870-1570-15-KM | ☆ | | | | ★ | | | | | 6.4 | .252 | 2.9 | .114 | 142° | H9 |
| 15.70 | .618 | | 870-1570-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.1 | .281 | 1.7 | .065 | 152° | F9 |
| 15.80 | .622 | | 870-1580-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.9 | .271 | 2.4 | .095 | 142° | H9 |
| 15.80 | .622 | | 870-1580-15-MM | | | ★ | | | | | ☆ | | 6.9 | .271 | 2.4 | .095 | 142° | H9 |
| 15.80 | .622 | | 870-1580-15-KM | ☆ | | | | ★ | | | | | 6.4 | .251 | 2.9 | .115 | 142° | H9 |
| 15.80 | .622 | | 870-1580-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.1 | .281 | 1.7 | .066 | 152° | F9 |
| 15.88 | .625 | | 870-1588-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.9 | .270 | 2.4 | .096 | 142° | H9 |
| 15.88 | .625 | | 870-1588-15-PL | | ☆ | | ★ | | | | | | 6.0 | .236 | 3.3 | .130 | 142° | H9 |
| 15.88 | .625 | | 870-1588-15-MM | | | ★ | | | | | ☆ | | 6.9 | .270 | 2.4 | .096 | 142° | H9 |
| 15.88 | .625 | | 870-1588-15-KM | ☆ | | | | ★ | | | | | 6.4 | .251 | 2.9 | .115 | 142° | H9 |
| 15.88 | .625 | | 870-1588-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.1 | .280 | 1.7 | .066 | 152° | F9 |
| 15.90 | .626 | | 870-1590-15-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 6.9 | .270 | 2.4 | .096 | 142° | H9 |
| 15.90 | .626 | | 870-1590-15-MM | | | ★ | | | | | ☆ | | 6.9 | .270 | 2.4 | .096 | 142° | H9 |
| 15.90 | .626 | | 870-1590-15-KM | ☆ | | | | ★ | | | | | 6.4 | .250 | 2.9 | .116 | 142° | H9 |
| 15.90 | .626 | | 870-1590-15-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.1 | .280 | 1.7 | .067 | 152° | F9 |
| 16.00 | .629 | 16 | 870-1600-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.6 | .298 | 2.4 | .096 | 142° | H9 |
| 16.00 | .629 | | 870-1600-16-MM | | | ★ | | | | | ☆ | | 7.6 | .298 | 2.4 | .096 | 142° | H9 |
| 16.00 | .629 | | 870-1600-16-KM | ☆ | | | | ★ | | | | | 7.0 | .276 | 3.0 | .118 | 142° | H9 |
| 16.00 | .629 | | 870-1600-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.8 | .307 | 1.7 | .067 | 152° | F9 |
| 16.10 | .633 | | 870-1610-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.6 | .298 | 2.4 | .096 | 142° | H9 |
| 16.10 | .633 | | 870-1610-16-MM | | | ★ | | | | | ☆ | | 7.6 | .298 | 2.4 | .096 | 142° | H9 |
| 16.10 | .633 | | 870-1610-16-KM | ☆ | | | | ★ | | | | | 7.0 | .275 | 3.0 | .119 | 142° | H9 |
| 16.10 | .633 | | 870-1610-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.8 | .307 | 1.7 | .067 | 152° | F9 |

J6 J62 J5 N22 N6



SANDVIK Coromant

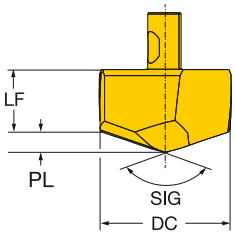
# CoroDrill® 870 drill tip




| DC | DC" | | Ordering code | P | | M | | K | | N | S | | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | 4334 | 2334 | 4334 | LF | LF" | PL | PL" | SIG | TCHA |
| 16.13 | .635 | 16 | 870-1613-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.6 | .297 | 2.5 | .096 | 142° | H9 |
| 16.13 | .635 | | 870-1613-16-PL | | ☆ | | ★ | | | | | | 6.7 | .264 | 3.3 | .130 | 142° | H9 |
| 16.13 | .635 | | 870-1613-16-MM | | | ★ | | | | | ☆ | | 7.6 | .297 | 2.5 | .096 | 142° | H9 |
| 16.13 | .635 | | 870-1613-16-KM | ☆ | | | | ★ | | | | | 7.0 | .275 | 3.0 | .119 | 142° | H9 |
| 16.13 | .635 | | 870-1613-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.8 | .307 | 1.7 | .067 | 152° | F9 |
| 16.20 | .637 | | 870-1620-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.5 | .297 | 2.5 | .097 | 142° | H9 |
| 16.20 | .637 | | 870-1620-16-MM | | | ★ | | | | | ☆ | | 7.5 | .297 | 2.5 | .097 | 142° | H9 |
| 16.20 | .637 | | 870-1620-16-KM | ☆ | | | | ★ | | | | | 7.0 | .274 | 3.0 | .119 | 142° | H9 |
| 16.20 | .637 | | 870-1620-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.8 | .306 | 1.7 | .068 | 152° | F9 |
| 16.30 | .641 | | 870-1630-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.5 | .296 | 2.5 | .098 | 142° | H9 |
| 16.30 | .641 | | 870-1630-16-MM | | | ★ | | | | | ☆ | | 7.5 | .296 | 2.5 | .098 | 142° | H9 |
| 16.30 | .641 | | 870-1630-16-KM | ☆ | | | | ★ | | | | | 7.0 | .274 | 3.1 | .120 | 142° | H9 |
| 16.30 | .641 | | 870-1630-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.8 | .306 | 1.7 | .068 | 152° | F9 |
| 16.40 | .645 | | 870-1640-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.5 | .296 | 2.5 | .098 | 142° | H9 |
| 16.40 | .645 | | 870-1640-16-MM | | | ★ | | | | | ☆ | | 7.5 | .296 | 2.5 | .098 | 142° | H9 |
| 16.40 | .645 | | 870-1640-16-KM | ☆ | | | | ★ | | | | | 6.9 | .273 | 3.1 | .121 | 142° | H9 |
| 16.40 | .645 | | 870-1640-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.8 | .306 | 1.7 | .069 | 152° | F9 |
| 16.50 | .649 | | 870-1650-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.5 | .295 | 2.5 | .099 | 142° | H9 |
| 16.50 | .649 | | 870-1650-16-MM | | | ★ | | | | | ☆ | | 7.5 | .295 | 2.5 | .099 | 142° | H9 |
| 16.50 | .649 | | 870-1650-16-KM | ☆ | | | | ★ | | | | | 6.9 | .272 | 3.1 | .121 | 142° | H9 |
| 16.50 | .649 | | 870-1650-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.8 | .305 | 1.8 | .069 | 152° | F9 |
| 16.60 | .653 | | 870-1660-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.5 | .294 | 2.5 | .100 | 142° | H9 |
| 16.60 | .653 | | 870-1660-16-MM | | | ★ | | | | | ☆ | | 7.5 | .294 | 2.5 | .100 | 142° | H9 |
| 16.60 | .653 | | 870-1660-16-KM | ☆ | | | | ★ | | | | | 6.9 | .272 | 3.1 | .122 | 142° | H9 |
| 16.60 | .653 | | 870-1660-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.7 | .305 | 1.8 | .069 | 152° | F9 |
| 16.70 | .657 | | 870-1670-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.5 | .294 | 2.5 | .100 | 142° | H9 |
| 16.70 | .657 | | 870-1670-16-MM | | | ★ | | | | | ☆ | | 7.5 | .294 | 2.5 | .100 | 142° | H9 |
| 16.70 | .657 | | 870-1670-16-KM | ☆ | | | | ★ | | | | | 6.9 | .271 | 3.1 | .123 | 142° | H9 |
| 16.70 | .657 | | 870-1670-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.7 | .304 | 1.8 | .070 | 152° | F9 |
| 16.80 | .661 | | 870-1680-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.4 | .293 | 2.6 | .101 | 142° | H9 |
| 16.80 | .661 | | 870-1680-16-MM | | | ★ | | | | | ☆ | | 7.4 | .293 | 2.6 | .101 | 142° | H9 |
| 16.80 | .661 | | 870-1680-16-KM | ☆ | | | | ★ | | | | | 6.9 | .270 | 3.1 | .123 | 142° | H9 |
| 16.80 | .661 | | 870-1680-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.7 | .304 | 1.8 | .070 | 152° | F9 |
| 16.90 | .665 | | 870-1690-16-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.4 | .292 | 2.6 | .102 | 142° | H9 |
| 16.90 | .665 | | 870-1690-16-MM | | | ★ | | | | | ☆ | | 7.4 | .292 | 2.6 | .102 | 142° | H9 |
| 16.90 | .665 | | 870-1690-16-KM | ☆ | | | | ★ | | | | | 6.9 | .270 | 3.2 | .124 | 142° | H9 |
| 16.90 | .665 | | 870-1690-16-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 7.7 | .304 | 1.8 | .070 | 152° | F9 |
| 17.00 | .669 | 17 | 870-1700-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.0 | .316 | 2.6 | .102 | 142° | H9 |
| 17.00 | .669 | | 870-1700-17-MM | | | ★ | | | | | ☆ | | 8.0 | .316 | 2.6 | .102 | 142° | H9 |
| 17.00 | .669 | | 870-1700-17-KM | ☆ | | | | ★ | | | | | 7.4 | .291 | 3.2 | .127 | 142° | H9 |
| 17.00 | .669 | | 870-1700-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.2 | .323 | 1.8 | .070 | 152° | F9 |
| 17.10 | .673 | | 870-1710-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.0 | .315 | 2.6 | .102 | 142° | H9 |
| 17.10 | .673 | | 870-1710-17-MM | | | ★ | | | | | ☆ | | 8.0 | .315 | 2.6 | .102 | 142° | H9 |
| 17.10 | .673 | | 870-1710-17-KM | ☆ | | | | ★ | | | | | 7.4 | .290 | 3.2 | .128 | 142° | H9 |
| 17.10 | .673 | | 870-1710-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.2 | .323 | 1.8 | .071 | 152° | F9 |
| 17.20 | .677 | | 870-1720-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.0 | .315 | 2.6 | .103 | 142° | H9 |
| 17.20 | .677 | | 870-1720-17-MM | | | ★ | | | | | ☆ | | 8.0 | .315 | 2.6 | .103 | 142° | H9 |
| 17.20 | .677 | | 870-1720-17-KM | ☆ | | | | ★ | | | | | 7.3 | .289 | 3.3 | .128 | 142° | H9 |
| 17.20 | .677 | | 870-1720-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.2 | .322 | 1.8 | .071 | 152° | F9 |
| 17.30 | .681 | | 870-1730-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.0 | .314 | 2.6 | .104 | 142° | H9 |
| 17.30 | .681 | | 870-1730-17-MM | | | ★ | | | | | ☆ | | 8.0 | .314 | 2.6 | .104 | 142° | H9 |
| 17.30 | .681 | | 870-1730-17-KM | ☆ | | | | ★ | | | | | 7.3 | .289 | 3.3 | .129 | 142° | H9 |
| 17.30 | .681 | | 870-1730-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.2 | .322 | 1.8 | .072 | 152° | F9 |

J6 J62 J5 N22 N6

# CoroDrill® 870 drill tip



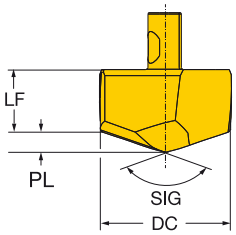

| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | Dimensions, mm, inch LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 17.40 | .685 | 17 | 870-1740-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.0 | .313 | 2.7 | .104 | 142° | H9 |
| 17.40 | .685 | | 870-1740-17-MM | | | ★ | | | | | ☆ | | 8.0 | .313 | 2.7 | .104 | 142° | H9 |
| 17.40 | .685 | | 870-1740-17-KM | ☆ | | | | ★ | | | | | 7.3 | .288 | 3.3 | .130 | 142° | H9 |
| 17.40 | .685 | | 870-1740-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.2 | .322 | 1.8 | .072 | 152° | F9 |
| 17.46 | .687 | | 870-1746-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.9 | .313 | 2.7 | .105 | 142° | H9 |
| 17.46 | .687 | | 870-1746-17-MM | | | ★ | | | | | ☆ | | 7.9 | .313 | 2.7 | .105 | 142° | H9 |
| 17.46 | .687 | | 870-1746-17-KM | ☆ | | | | ★ | | | | | 7.3 | .288 | 3.3 | .130 | 142° | H9 |
| 17.46 | .687 | | 870-1746-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.2 | .321 | 1.8 | .072 | 152° | F9 |
| 17.50 | .689 | | 870-1750-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.9 | .313 | 2.7 | .105 | 142° | H9 |
| 17.50 | .689 | | 870-1750-17-MM | | | ★ | | | | | ☆ | | 7.9 | .313 | 2.7 | .105 | 142° | H9 |
| 17.50 | .689 | | 870-1750-17-KM | ☆ | | | | ★ | | | | | 7.3 | .287 | 3.3 | .130 | 142° | H9 |
| 17.50 | .689 | | 870-1750-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.2 | .321 | 1.9 | .073 | 152° | F9 |
| 17.60 | .692 | | 870-1760-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.9 | .312 | 2.7 | .106 | 142° | H9 |
| 17.60 | .692 | | 870-1760-17-MM | | | ★ | | | | | ☆ | | 7.9 | .312 | 2.7 | .106 | 142° | H9 |
| 17.60 | .692 | | 870-1760-17-KM | ☆ | | | | ★ | | | | | 7.3 | .287 | 3.3 | .131 | 142° | H9 |
| 17.60 | .692 | | 870-1760-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.1 | .320 | 1.9 | .073 | 152° | F9 |
| 17.70 | .696 | | 870-1770-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.9 | .311 | 2.7 | .106 | 142° | H9 |
| 17.70 | .696 | | 870-1770-17-MM | | | ★ | | | | | ☆ | | 7.9 | .311 | 2.7 | .106 | 142° | H9 |
| 17.70 | .696 | | 870-1770-17-KM | ☆ | | | | ★ | | | | | 7.3 | .286 | 3.3 | .131 | 142° | H9 |
| 17.70 | .696 | | 870-1770-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.1 | .320 | 1.9 | .074 | 152° | F9 |
| 17.80 | .700 | | 870-1780-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.9 | .311 | 2.7 | .107 | 142° | H9 |
| 17.80 | .700 | | 870-1780-17-MM | | | ★ | | | | | ☆ | | 7.9 | .311 | 2.7 | .107 | 142° | H9 |
| 17.80 | .700 | | 870-1780-17-KM | ☆ | | | | ★ | | | | | 7.2 | .285 | 3.4 | .132 | 142° | H9 |
| 17.80 | .700 | | 870-1780-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.1 | .320 | 1.9 | .074 | 152° | F9 |
| 17.90 | .704 | | 870-1790-17-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 7.9 | .310 | 2.7 | .107 | 142° | H9 |
| 17.90 | .704 | | 870-1790-17-MM | | | ★ | | | | | ☆ | | 7.9 | .310 | 2.7 | .107 | 142° | H9 |
| 17.90 | .704 | | 870-1790-17-KM | ☆ | | | | ★ | | | | | 7.2 | .285 | 3.4 | .133 | 142° | H9 |
| 17.90 | .704 | | 870-1790-17-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.1 | .320 | 1.9 | .074 | 152° | F9 |
| 18.00 | .708 | 18 | 870-1800-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.6 | .338 | 2.7 | .107 | 142° | H9 |
| 18.00 | .708 | | 870-1800-18-MM | | | ★ | | | | | ☆ | | 8.6 | .338 | 2.7 | .107 | 142° | H9 |
| 18.00 | .708 | | 870-1800-18-KM | ☆ | | | | ★ | | | | | 7.9 | .313 | 3.4 | .132 | 142° | H9 |
| 18.00 | .708 | | 870-1800-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.8 | .347 | 1.9 | .074 | 152° | F9 |
| 18.10 | .712 | | 870-1810-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.6 | .337 | 2.7 | .108 | 142° | H9 |
| 18.10 | .712 | | 870-1810-18-MM | | | ★ | | | | | ☆ | | 8.6 | .337 | 2.7 | .108 | 142° | H9 |
| 18.10 | .712 | | 870-1810-18-KM | ☆ | | | | ★ | | | | | 7.9 | .312 | 3.4 | .133 | 142° | H9 |
| 18.10 | .712 | | 870-1810-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.8 | .346 | 1.9 | .075 | 152° | F9 |
| 18.20 | .716 | | 870-1820-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.6 | .337 | 2.8 | .108 | 142° | H9 |
| 18.20 | .716 | | 870-1820-18-MM | | | ★ | | | | | ☆ | | 8.6 | .337 | 2.8 | .108 | 142° | H9 |
| 18.20 | .716 | | 870-1820-18-KM | ☆ | | | | ★ | | | | | 7.9 | .311 | 3.4 | .134 | 142° | H9 |
| 18.20 | .716 | | 870-1820-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.8 | .346 | 1.9 | .075 | 152° | F9 |
| 18.30 | .720 | | 870-1830-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.5 | .336 | 2.8 | .109 | 142° | H9 |
| 18.30 | .720 | | 870-1830-18-MM | | | ★ | | | | | ☆ | | 8.5 | .336 | 2.8 | .109 | 142° | H9 |
| 18.30 | .720 | | 870-1830-18-KM | ☆ | | | | ★ | | | | | 7.9 | .310 | 3.4 | .135 | 142° | H9 |
| 18.30 | .720 | | 870-1830-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.8 | .346 | 1.9 | .076 | 152° | F9 |
| 18.40 | .724 | | 870-1840-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.5 | .335 | 2.8 | .110 | 142° | H9 |
| 18.40 | .724 | | 870-1840-18-MM | | | ★ | | | | | ☆ | | 8.5 | .335 | 2.8 | .110 | 142° | H9 |
| 18.40 | .724 | | 870-1840-18-KM | ☆ | | | | ★ | | | | | 7.9 | .310 | 3.4 | .135 | 142° | H9 |
| 18.40 | .724 | | 870-1840-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.8 | .345 | 1.9 | .076 | 152° | F9 |
| 18.50 | .728 | | 870-1850-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.5 | .335 | 2.8 | .110 | 142° | H9 |
| 18.50 | .728 | | 870-1850-18-MM | | | ★ | | | | | ☆ | | 8.5 | .335 | 2.8 | .110 | 142° | H9 |
| 18.50 | .728 | | 870-1850-18-KM | ☆ | | | | ★ | | | | | 7.9 | .309 | 3.5 | .136 | 142° | H9 |
| 18.50 | .728 | | 870-1850-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.8 | .345 | 1.9 | .076 | 152° | F9 |

J6 J62 J5 N22 N6



SANDVIK Coromant

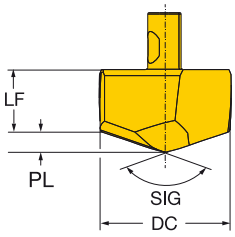
# CoroDrill® 870 drill tip




| DC | DC" | | Ordering code | P | | M | | K | | N | S | | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | 4334 | 2334 | 4334 | LF | LF" | PL | PL" | SIG | TCHA |
| 18.60 | .732 | 18 | 870-1860-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.5 | .334 | 2.8 | .111 | 142° | H9 |
| 18.60 | .732 | | 870-1860-18-MM | | | ★ | | | | | ☆ | | 8.5 | .334 | 2.8 | .111 | 142° | H9 |
| 18.60 | .732 | | 870-1860-18-KM | ☆ | | | | ★ | | | | | 7.8 | .308 | 3.5 | .137 | 142° | H9 |
| 18.60 | .732 | | 870-1860-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.8 | .344 | 2.0 | .077 | 152° | F9 |
| 18.70 | .736 | | 870-1870-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.5 | .333 | 2.8 | .112 | 142° | H9 |
| 18.70 | .736 | | 870-1870-18-MM | | | ★ | | | | | ☆ | | 8.5 | .333 | 2.8 | .112 | 142° | H9 |
| 18.70 | .736 | | 870-1870-18-KM | ☆ | | | | ★ | | | | | 7.8 | .308 | 3.5 | .137 | 142° | H9 |
| 18.70 | .736 | | 870-1870-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.7 | .344 | 2.0 | .077 | 152° | F9 |
| 18.80 | .740 | | 870-1880-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.5 | .333 | 2.9 | .112 | 142° | H9 |
| 18.80 | .740 | | 870-1880-18-MM | | | ★ | | | | | ☆ | | 8.5 | .333 | 2.9 | .112 | 142° | H9 |
| 18.80 | .740 | | 870-1880-18-KM | ☆ | | | | ★ | | | | | 7.8 | .307 | 3.5 | .138 | 142° | H9 |
| 18.80 | .740 | | 870-1880-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.7 | .344 | 2.0 | .078 | 152° | F9 |
| 18.90 | .744 | | 870-1890-18-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.4 | .332 | 2.9 | .113 | 142° | H9 |
| 18.90 | .744 | | 870-1890-18-MM | | | ★ | | | | | ☆ | | 8.4 | .332 | 2.9 | .113 | 142° | H9 |
| 18.90 | .744 | | 870-1890-18-KM | ☆ | | | | ★ | | | | | 7.8 | .306 | 3.5 | .139 | 142° | H9 |
| 18.90 | .744 | | 870-1890-18-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 8.7 | .343 | 2.0 | .078 | 152° | F9 |
| 19.00 | .748 | 19 | 870-1900-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.0 | .356 | 2.9 | .113 | 142° | H9 |
| 19.00 | .748 | | 870-1900-19-MM | | | ★ | | | | | ☆ | | 9.0 | .356 | 2.9 | .113 | 142° | H9 |
| 19.00 | .748 | | 870-1900-19-KM | ☆ | | | | ★ | | | | | 8.3 | .327 | 3.6 | .141 | 142° | H9 |
| 19.00 | .748 | | 870-1900-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.2 | .363 | 2.0 | .078 | 152° | F9 |
| 19.05 | .750 | | 870-1905-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.0 | .355 | 2.9 | .113 | 142° | H9 |
| 19.05 | .750 | | 870-1905-19-PL | | ☆ | | ★ | | | | | | 8.0 | .315 | 3.8 | .150 | 142° | H9 |
| 19.05 | .750 | | 870-1905-19-MM | | | ★ | | | | | ☆ | | 9.0 | .355 | 2.9 | .113 | 142° | H9 |
| 19.05 | .750 | | 870-1905-19-KM | ☆ | | | | ★ | | | | | 8.3 | .327 | 3.6 | .142 | 142° | H9 |
| 19.05 | .750 | | 870-1905-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.2 | .363 | 2.0 | .078 | 152° | F9 |
| 19.10 | .752 | | 870-1910-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.0 | .355 | 2.9 | .114 | 142° | H9 |
| 19.10 | .752 | | 870-1910-19-MM | | | ★ | | | | | ☆ | | 9.0 | .355 | 2.9 | .114 | 142° | H9 |
| 19.10 | .752 | | 870-1910-19-KM | ☆ | | | | ★ | | | | | 8.3 | .327 | 3.6 | .142 | 142° | H9 |
| 19.10 | .752 | | 870-1910-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.2 | .362 | 2.0 | .079 | 152° | F9 |
| 19.20 | .755 | | 870-1920-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.0 | .354 | 2.9 | .115 | 142° | H9 |
| 19.20 | .755 | | 870-1920-19-PL | | ☆ | | ★ | | | | | | 8.0 | .315 | 3.9 | .154 | 142° | H9 |
| 19.20 | .755 | | 870-1920-19-MM | | | ★ | | | | | ☆ | | 9.0 | .354 | 2.9 | .115 | 142° | H9 |
| 19.20 | .755 | | 870-1920-19-KM | ☆ | | | | ★ | | | | | 8.3 | .326 | 3.6 | .143 | 142° | H9 |
| 19.20 | .755 | | 870-1920-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.2 | .362 | 2.0 | .079 | 152° | F9 |
| 19.25 | .757 | | 870-1925-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.0 | .354 | 2.9 | .115 | 142° | H9 |
| 19.25 | .757 | | 870-1925-19-PL | | ☆ | | ★ | | | | | | 8.0 | .315 | 3.9 | .154 | 142° | H9 |
| 19.25 | .757 | | 870-1925-19-MM | | | ★ | | | | | ☆ | | 9.0 | .354 | 2.9 | .115 | 142° | H9 |
| 19.25 | .757 | | 870-1925-19-KM | ☆ | | | | ★ | | | | | 8.3 | .326 | 3.6 | .143 | 142° | H9 |
| 19.25 | .757 | | 870-1925-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.2 | .361 | 2.0 | .080 | 152° | F9 |
| 19.30 | .759 | | 870-1930-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.0 | .354 | 2.9 | .115 | 142° | H9 |
| 19.30 | .759 | | 870-1930-19-PL | | ☆ | | ★ | | | | | | 8.0 | 8.0 | 4.0 | 4.0 | 142° | H9 |
| 19.30 | .759 | | 870-1930-19-MM | | | ★ | | | | | ☆ | | 9.0 | .354 | 2.9 | .115 | 142° | H9 |
| 19.30 | .759 | | 870-1930-19-KM | ☆ | | | | ★ | | | | | 8.3 | .325 | 3.6 | .143 | 142° | H9 |
| 19.30 | .759 | | 870-1930-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.2 | .361 | 2.0 | .080 | 152° | F9 |
| 19.40 | .763 | | 870-1940-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.0 | .353 | 2.9 | .116 | 142° | H9 |
| 19.40 | .763 | | 870-1940-19-MM | | | ★ | | | | | ☆ | | 9.0 | .353 | 2.9 | .116 | 142° | H9 |
| 19.40 | .763 | | 870-1940-19-KM | ☆ | | | | ★ | | | | | 8.2 | .324 | 3.7 | .144 | 142° | H9 |
| 19.40 | .763 | | 870-1940-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.2 | .361 | 2.0 | .080 | 152° | F9 |
| 19.50 | .767 | | 870-1950-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.9 | .352 | 3.0 | .117 | 142° | H9 |
| 19.50 | .767 | | 870-1950-19-MM | | | ★ | | | | | ☆ | | 8.9 | .352 | 3.0 | .117 | 142° | H9 |
| 19.50 | .767 | | 870-1950-19-KM | ☆ | | | | ★ | | | | | 8.2 | .324 | 3.7 | .144 | 142° | H9 |
| 19.50 | .767 | | 870-1950-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.2 | .360 | 2.1 | .081 | 152° | F9 |

J6 J62 J5 N22 N6

# CoroDrill® 870 drill tip



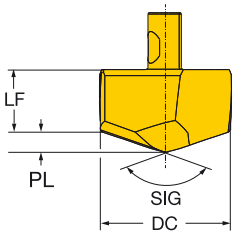

| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | Dimensions, mm, inch LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 19.60 | .771 | 19 | 870-1960-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.9 | .352 | 3.0 | .117 | 142° | H9 |
| 19.60 | .771 | | 870-1960-19-MM | | | ★ | | | | | ☆ | | 8.9 | .352 | 3.0 | .117 | 142° | H9 |
| 19.60 | .771 | | 870-1960-19-KM | ☆ | | | | ★ | | | | | 8.2 | .323 | 3.7 | .145 | 142° | H9 |
| 19.60 | .771 | | 870-1960-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.1 | .360 | 2.1 | .081 | 152° | F9 |
| 19.70 | .775 | | 870-1970-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.9 | .351 | 3.0 | .118 | 142° | H9 |
| 19.70 | .775 | | 870-1970-19-MM | | | ★ | | | | | ☆ | | 8.9 | .351 | 3.0 | .118 | 142° | H9 |
| 19.70 | .775 | | 870-1970-19-KM | ☆ | | | | ★ | | | | | 8.2 | .322 | 3.7 | .146 | 142° | H9 |
| 19.70 | .775 | | 870-1970-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.1 | .360 | 2.1 | .081 | 152° | F9 |
| 19.80 | .779 | | 870-1980-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.9 | .350 | 3.0 | .119 | 142° | H9 |
| 19.80 | .779 | | 870-1980-19-MM | | | ★ | | | | | ☆ | | 8.9 | .350 | 3.0 | .119 | 142° | H9 |
| 19.80 | .779 | | 870-1980-19-KM | ☆ | | | | ★ | | | | | 8.2 | .322 | 3.7 | .146 | 142° | H9 |
| 19.80 | .779 | | 870-1980-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.1 | .359 | 2.1 | .081 | 152° | F9 |
| 19.90 | .783 | | 870-1990-19-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 8.9 | .350 | 3.0 | .119 | 142° | H9 |
| 19.90 | .783 | | 870-1990-19-MM | | | ★ | | | | | ☆ | | 8.9 | .350 | 3.0 | .119 | 142° | H9 |
| 19.90 | .783 | | 870-1990-19-KM | ☆ | | | | ★ | | | | | 8.2 | .321 | 3.7 | .147 | 142° | H9 |
| 19.90 | .783 | | 870-1990-19-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.1 | .359 | 2.1 | .082 | 152° | F9 |
| 20.00 | .787 | 20 | 870-2000-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.5 | .373 | 3.0 | .119 | 142° | H9 |
| 20.00 | .787 | | 870-2000-20-MM | | | ★ | | | | | ☆ | | 9.5 | .373 | 3.0 | .119 | 142° | H9 |
| 20.00 | .787 | | 870-2000-20-KM | ☆ | | | | ★ | | | | | 8.7 | .342 | 3.8 | .150 | 142° | H9 |
| 20.00 | .787 | | 870-2000-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.7 | .382 | 2.1 | .082 | 152° | F9 |
| 20.10 | .791 | | 870-2010-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.5 | .372 | 3.0 | .120 | 142° | H9 |
| 20.10 | .791 | | 870-2010-20-MM | | | ★ | | | | | ☆ | | 9.5 | .372 | 3.0 | .120 | 142° | H9 |
| 20.10 | .791 | | 870-2010-20-KM | ☆ | | | | ★ | | | | | 8.7 | .341 | 3.8 | .151 | 142° | H9 |
| 20.10 | .791 | | 870-2010-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.7 | .382 | 2.1 | .083 | 152° | F9 |
| 20.20 | .795 | | 870-2020-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.4 | .372 | 3.1 | .120 | 142° | H9 |
| 20.20 | .795 | | 870-2020-20-MM | | | ★ | | | | | ☆ | | 9.4 | .372 | 3.1 | .120 | 142° | H9 |
| 20.20 | .795 | | 870-2020-20-KM | ☆ | | | | ★ | | | | | 8.7 | .341 | 3.9 | .152 | 142° | H9 |
| 20.20 | .795 | | 870-2020-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.7 | .381 | 2.1 | .083 | 152° | F9 |
| 20.30 | .799 | | 870-2030-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.4 | .371 | 3.1 | .121 | 142° | H9 |
| 20.30 | .799 | | 870-2030-20-MM | | | ★ | | | | | ☆ | | 9.4 | .371 | 3.1 | .121 | 142° | H9 |
| 20.30 | .799 | | 870-2030-20-KM | ☆ | | | | ★ | | | | | 8.6 | .340 | 3.9 | .152 | 142° | H9 |
| 20.30 | .799 | | 870-2030-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.7 | .381 | 2.1 | .084 | 152° | F9 |
| 20.40 | .803 | | 870-2040-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.4 | .370 | 3.1 | .122 | 142° | H9 |
| 20.40 | .803 | | 870-2040-20-MM | | | ★ | | | | | ☆ | | 9.4 | .370 | 3.1 | .122 | 142° | H9 |
| 20.40 | .803 | | 870-2040-20-KM | ☆ | | | | ★ | | | | | 8.6 | .339 | 3.9 | .153 | 142° | H9 |
| 20.40 | .803 | | 870-2040-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.7 | .380 | 2.1 | .084 | 152° | F9 |
| 20.50 | .807 | | 870-2050-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.4 | .370 | 3.1 | .122 | 142° | H9 |
| 20.50 | .807 | | 870-2050-20-MM | | | ★ | | | | | ☆ | | 9.4 | .370 | 3.1 | .122 | 142° | H9 |
| 20.50 | .807 | | 870-2050-20-KM | ☆ | | | | ★ | | | | | 8.6 | .339 | 3.9 | .154 | 142° | H9 |
| 20.50 | .807 | | 870-2050-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.7 | .380 | 2.2 | .085 | 152° | F9 |
| 20.60 | .811 | | 870-2060-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.4 | .369 | 3.1 | .123 | 142° | H9 |
| 20.60 | .811 | | 870-2060-20-MM | | | ★ | | | | | ☆ | | 9.4 | .369 | 3.1 | .123 | 142° | H9 |
| 20.60 | .811 | | 870-2060-20-KM | ☆ | | | | ★ | | | | | 8.6 | .338 | 3.9 | .154 | 142° | H9 |
| 20.60 | .811 | | 870-2060-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.7 | .380 | 2.2 | .085 | 152° | F9 |
| 20.64 | .812 | | 870-2064-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.4 | .369 | 3.1 | .123 | 142° | H9 |
| 20.64 | .812 | | 870-2064-20-MM | | | ★ | | | | | ☆ | | 9.4 | .369 | 3.1 | .123 | 142° | H9 |
| 20.64 | .812 | | 870-2064-20-KM | ☆ | | | | ★ | | | | | 8.6 | .337 | 3.9 | .155 | 142° | H9 |
| 20.64 | .812 | | 870-2064-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.6 | .380 | 2.2 | .085 | 152° | F9 |
| 20.70 | .815 | | 870-2070-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.4 | .369 | 3.1 | .124 | 142° | H9 |
| 20.70 | .815 | | 870-2070-20-MM | | | ★ | | | | | ☆ | | 9.4 | .369 | 3.1 | .124 | 142° | H9 |
| 20.70 | .815 | | 870-2070-20-KM | ☆ | | | | ★ | | | | | 8.6 | .337 | 3.9 | .155 | 142° | H9 |
| 20.70 | .815 | | 870-2070-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.6 | .379 | 2.2 | .085 | 152° | F9 |

J6 J62 J5 N22 N6



SANDVIK Coromant

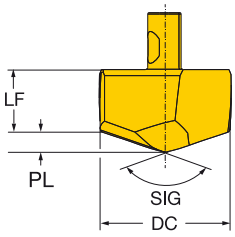
# CoroDrill® 870 drill tip




| DC | DC" | | Ordering code | P | | M | | K | | N | S | | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | 4334 | 2334 | 4334 | LF | LF" | PL | PL" | SIG | TCHA |
| 20.80 | .818 | 20 | 870-2080-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.3 | .368 | 3.2 | .124 | 142° | H9 |
| 20.80 | .818 | | 870-2080-20-MM | | | ★ | | | | | ☆ | | 9.3 | .368 | 3.2 | .124 | 142° | H9 |
| 20.80 | .818 | | 870-2080-20-KM | ☆ | | | | ★ | | | | | 8.6 | .337 | 4.0 | .156 | 142° | H9 |
| 20.80 | .818 | | 870-2080-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.6 | .379 | 2.2 | .086 | 152° | F9 |
| 20.90 | .822 | | 870-2090-20-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.3 | .367 | 3.2 | .125 | 142° | H9 |
| 20.90 | .822 | | 870-2090-20-MM | | | ★ | | | | | ☆ | | 9.3 | .367 | 3.2 | .125 | 142° | H9 |
| 20.90 | .822 | | 870-2090-20-KM | ☆ | | | | ★ | | | | | 8.5 | .336 | 4.0 | .156 | 142° | H9 |
| 20.90 | .822 | | 870-2090-20-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 9.6 | .378 | 2.2 | .086 | 152° | F9 |
| 21.00 | .826 | 21 | 870-2100-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.0 | .395 | 3.2 | .124 | 142° | H9 |
| 21.00 | .826 | | 870-2100-21-MM | | | ★ | | | | | ☆ | | 10.0 | .395 | 3.2 | .124 | 142° | H9 |
| 21.00 | .826 | | 870-2100-21-KM | ☆ | | | | ★ | | | | | 9.2 | .364 | 4.0 | .156 | 142° | H9 |
| 21.00 | .826 | | 870-2100-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.3 | .406 | 2.2 | .086 | 152° | F9 |
| 21.10 | .830 | | 870-2110-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.0 | .394 | 3.2 | .125 | 142° | H9 |
| 21.10 | .830 | | 870-2110-21-MM | | | ★ | | | | | ☆ | | 10.0 | .394 | 3.2 | .125 | 142° | H9 |
| 21.10 | .830 | | 870-2110-21-KM | ☆ | | | | ★ | | | | | 9.2 | .363 | 4.0 | .157 | 142° | H9 |
| 21.10 | .830 | | 870-2110-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.3 | .406 | 2.2 | .087 | 152° | F9 |
| 21.20 | .834 | | 870-2120-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.0 | .394 | 3.2 | .126 | 142° | H9 |
| 21.20 | .834 | | 870-2120-21-MM | | | ★ | | | | | ☆ | | 10.0 | .394 | 3.2 | .126 | 142° | H9 |
| 21.20 | .834 | | 870-2120-21-KM | ☆ | | | | ★ | | | | | 9.2 | .362 | 4.0 | .157 | 142° | H9 |
| 21.20 | .834 | | 870-2120-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.3 | .405 | 2.2 | .087 | 152° | F9 |
| 21.30 | .838 | | 870-2130-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.0 | .393 | 3.2 | .126 | 142° | H9 |
| 21.30 | .838 | | 870-2130-21-MM | | | ★ | | | | | ☆ | | 10.0 | .393 | 3.2 | .126 | 142° | H9 |
| 21.30 | .838 | | 870-2130-21-KM | ☆ | | | | ★ | | | | | 9.2 | .362 | 4.0 | .158 | 142° | H9 |
| 21.30 | .838 | | 870-2130-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.3 | .405 | 2.2 | .087 | 152° | F9 |
| 21.40 | .842 | | 870-2140-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.0 | .393 | 3.2 | .127 | 142° | H9 |
| 21.40 | .842 | | 870-2140-21-MM | | | ★ | | | | | ☆ | | 10.0 | .393 | 3.2 | .127 | 142° | H9 |
| 21.40 | .842 | | 870-2140-21-KM | ☆ | | | | ★ | | | | | 9.2 | .361 | 4.0 | .159 | 142° | H9 |
| 21.40 | .842 | | 870-2140-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.3 | .404 | 2.2 | .088 | 152° | F9 |
| 21.50 | .846 | | 870-2150-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.0 | .392 | 3.3 | .128 | 142° | H9 |
| 21.50 | .846 | | 870-2150-21-MM | | | ★ | | | | | ☆ | | 10.0 | .392 | 3.3 | .128 | 142° | H9 |
| 21.50 | .846 | | 870-2150-21-KM | ☆ | | | | ★ | | | | | 9.2 | .361 | 4.0 | .159 | 142° | H9 |
| 21.50 | .846 | | 870-2150-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.3 | .404 | 2.2 | .088 | 152° | F9 |
| 21.60 | .850 | | 870-2160-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.9 | .391 | 3.3 | .129 | 142° | H9 |
| 21.60 | .850 | | 870-2160-21-MM | | | ★ | | | | | ☆ | | 9.9 | .391 | 3.3 | .129 | 142° | H9 |
| 21.60 | .850 | | 870-2160-21-KM | ☆ | | | | ★ | | | | | 9.1 | .360 | 4.1 | .160 | 142° | H9 |
| 21.60 | .850 | | 870-2160-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.3 | .404 | 2.3 | .089 | 152° | F9 |
| 21.70 | .854 | | 870-2170-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.9 | .391 | 3.3 | .129 | 142° | H9 |
| 21.70 | .854 | | 870-2170-21-MM | | | ★ | | | | | ☆ | | 9.9 | .391 | 3.3 | .129 | 142° | H9 |
| 21.70 | .854 | | 870-2170-21-KM | ☆ | | | | ★ | | | | | 9.1 | .359 | 4.1 | .161 | 142° | H9 |
| 21.70 | .854 | | 870-2170-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.2 | .403 | 2.3 | .089 | 152° | F9 |
| 21.80 | .858 | | 870-2180-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.9 | .390 | 3.3 | .130 | 142° | H9 |
| 21.80 | .858 | | 870-2180-21-MM | | | ★ | | | | | ☆ | | 9.9 | .390 | 3.3 | .130 | 142° | H9 |
| 21.80 | .858 | | 870-2180-21-KM | ☆ | | | | ★ | | | | | 9.1 | .358 | 4.1 | .161 | 142° | H9 |
| 21.80 | .858 | | 870-2180-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.2 | .403 | 2.3 | .089 | 152° | F9 |
| 21.90 | .862 | | 870-2190-21-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 9.9 | .389 | 3.3 | .131 | 142° | H9 |
| 21.90 | .862 | | 870-2190-21-MM | | | ★ | | | | | ☆ | | 9.9 | .389 | 3.3 | .131 | 142° | H9 |
| 21.90 | .862 | | 870-2190-21-KM | ☆ | | | | ★ | | | | | 9.1 | .358 | 4.1 | .162 | 142° | H9 |
| 21.90 | .862 | | 870-2190-21-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.2 | .402 | 2.3 | .090 | 152° | F9 |
| 22.00 | .866 | 22 | 870-2200-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.5 | .413 | 3.3 | .131 | 142° | H9 |
| 22.00 | .866 | | 870-2200-22-MM | | | ★ | | | | | ☆ | | 10.5 | .413 | 3.3 | .131 | 142° | H9 |
| 22.00 | .866 | | 870-2200-22-KM | ☆ | | | | ★ | | | | | 9.6 | .379 | 4.2 | .165 | 142° | H9 |
| 22.00 | .866 | | 870-2200-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.8 | .426 | 2.3 | .090 | 152° | F9 |

J6 J62 J5 N22 N6

# CoroDrill® 870 drill tip



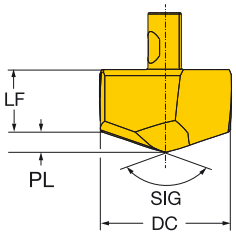

| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | Dimensions, mm, inch LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 22.10 | .870 | 22 | 870-2210-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.5 | .412 | 3.3 | .131 | 142° | H9 |
| 22.10 | .870 | | 870-2210-22-MM | | | ★ | | | | | ☆ | | 10.5 | .412 | 3.3 | .131 | 142° | H9 |
| 22.10 | .870 | | 870-2210-22-KM | ☆ | | | | ★ | | | | | 9.6 | .378 | 4.2 | .165 | 142° | H9 |
| 22.10 | .870 | | 870-2210-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.8 | .425 | 2.3 | .091 | 152° | F9 |
| 22.20 | .874 | | 870-2220-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.5 | .411 | 3.4 | .132 | 142° | H9 |
| 22.20 | .874 | | 870-2220-22-PL | | ☆ | | ★ | | | | | | 9.3 | .366 | 4.5 | .177 | 142° | H9 |
| 22.20 | .874 | | 870-2220-22-MM | | | ★ | | | | | ☆ | | 10.5 | .411 | 3.4 | .132 | 142° | H9 |
| 22.20 | .874 | | 870-2220-22-KM | ☆ | | | | ★ | | | | | 9.6 | .378 | 4.2 | .166 | 142° | H9 |
| 22.20 | .874 | | 870-2220-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.8 | .425 | 2.3 | .091 | 152° | F9 |
| 22.23 | .875 | | 870-2223-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.5 | .411 | 3.4 | .132 | 142° | H9 |
| 22.23 | .875 | | 870-2223-22-MM | | | ★ | | | | | ☆ | | 10.5 | .411 | 3.4 | .132 | 142° | H9 |
| 22.23 | .875 | | 870-2223-22-KM | ☆ | | | | ★ | | | | | 9.6 | .378 | 4.2 | .166 | 142° | H9 |
| 22.23 | .875 | | 870-2223-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.8 | .424 | 2.3 | .091 | 152° | F9 |
| 22.30 | .878 | | 870-2230-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.4 | .411 | 3.4 | .133 | 142° | H9 |
| 22.30 | .878 | | 870-2230-22-MM | | | ★ | | | | | ☆ | | 10.4 | .411 | 3.4 | .133 | 142° | H9 |
| 22.30 | .878 | | 870-2230-22-KM | ☆ | | | | ★ | | | | | 9.6 | .377 | 4.2 | .167 | 142° | H9 |
| 22.30 | .878 | | 870-2230-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.8 | .424 | 2.3 | .092 | 152° | F9 |
| 22.40 | .881 | | 870-2240-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.4 | .410 | 3.4 | .133 | 142° | H9 |
| 22.40 | .881 | | 870-2240-22-MM | | | ★ | | | | | ☆ | | 10.4 | .410 | 3.4 | .133 | 142° | H9 |
| 22.40 | .881 | | 870-2240-22-KM | ☆ | | | | ★ | | | | | 9.6 | .376 | 4.2 | .167 | 142° | H9 |
| 22.40 | .881 | | 870-2240-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.8 | .424 | 2.3 | .092 | 152° | F9 |
| 22.50 | .885 | | 870-2250-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.4 | .409 | 3.4 | .134 | 142° | H9 |
| 22.50 | .885 | | 870-2250-22-MM | | | ★ | | | | | ☆ | | 10.4 | .409 | 3.4 | .134 | 142° | H9 |
| 22.50 | .885 | | 870-2250-22-KM | ☆ | | | | ★ | | | | | 9.5 | .375 | 4.3 | .168 | 142° | H9 |
| 22.50 | .885 | | 870-2250-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.8 | .423 | 2.4 | .093 | 152° | F9 |
| 22.60 | .889 | | 870-2260-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.4 | .409 | 3.4 | .135 | 142° | H9 |
| 22.60 | .889 | | 870-2260-22-MM | | | ★ | | | | | ☆ | | 10.4 | .409 | 3.4 | .135 | 142° | H9 |
| 22.60 | .889 | | 870-2260-22-KM | ☆ | | | | ★ | | | | | 9.5 | .375 | 4.3 | .169 | 142° | H9 |
| 22.60 | .889 | | 870-2260-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.7 | .423 | 2.4 | .093 | 152° | F9 |
| 22.70 | .893 | | 870-2270-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.4 | .408 | 3.4 | .135 | 142° | H9 |
| 22.70 | .893 | | 870-2270-22-MM | | | ★ | | | | | ☆ | | 10.4 | .408 | 3.4 | .135 | 142° | H9 |
| 22.70 | .893 | | 870-2270-22-KM | ☆ | | | | ★ | | | | | 9.5 | .374 | 4.3 | .169 | 142° | H9 |
| 22.70 | .893 | | 870-2270-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.7 | .423 | 2.4 | .093 | 152° | F9 |
| 22.80 | .897 | | 870-2280-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.4 | .407 | 3.5 | .136 | 142° | H9 |
| 22.80 | .897 | | 870-2280-22-MM | | | ★ | | | | | ☆ | | 10.4 | .407 | 3.5 | .136 | 142° | H9 |
| 22.80 | .897 | | 870-2280-22-KM | ☆ | | | | ★ | | | | | 9.5 | .374 | 4.3 | .170 | 142° | H9 |
| 22.80 | .897 | | 870-2280-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.7 | .422 | 2.4 | .093 | 152° | F9 |
| 22.90 | .901 | | 870-2290-22-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.3 | .407 | 3.5 | .137 | 142° | H9 |
| 22.90 | .901 | | 870-2290-22-MM | | | ★ | | | | | ☆ | | 10.3 | .407 | 3.5 | .137 | 142° | H9 |
| 22.90 | .901 | | 870-2290-22-KM | ☆ | | | | ★ | | | | | 9.5 | .373 | 4.3 | .170 | 142° | H9 |
| 22.90 | .901 | | 870-2290-22-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 10.7 | .422 | 2.4 | .094 | 152° | F9 |
| 23.00 | .905 | 23 | 870-2300-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.0 | .435 | 3.5 | .136 | 142° | H9 |
| 23.00 | .905 | | 870-2300-23-MM | | | ★ | | | | | ☆ | | 11.0 | .435 | 3.5 | .136 | 142° | H9 |
| 23.00 | .905 | | 870-2300-23-KM | ☆ | | | | ★ | | | | | 10.1 | .398 | 4.4 | .173 | 142° | H9 |
| 23.00 | .905 | | 870-2300-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.4 | .450 | 2.4 | .094 | 152° | F9 |
| 23.10 | .909 | | 870-2310-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.0 | .434 | 3.5 | .137 | 142° | H9 |
| 23.10 | .909 | | 870-2310-23-MM | | | ★ | | | | | ☆ | | 11.0 | .434 | 3.5 | .137 | 142° | H9 |
| 23.10 | .909 | | 870-2310-23-KM | ☆ | | | | ★ | | | | | 10.1 | .397 | 4.4 | .174 | 142° | H9 |
| 23.10 | .909 | | 870-2310-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.4 | .449 | 2.4 | .094 | 152° | F9 |
| 23.20 | .913 | | 870-2320-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.0 | .433 | 3.5 | .137 | 142° | H9 |
| 23.20 | .913 | | 870-2320-23-MM | | | ★ | | | | | ☆ | | 11.0 | .433 | 3.5 | .137 | 142° | H9 |
| 23.20 | .913 | | 870-2320-23-KM | ☆ | | | | ★ | | | | | 10.1 | .396 | 4.4 | .174 | 142° | H9 |
| 23.20 | .913 | | 870-2320-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.4 | .448 | 2.4 | .095 | 152° | F9 |

J6 J62 J5 N22 N6



SANDVIK Coromant

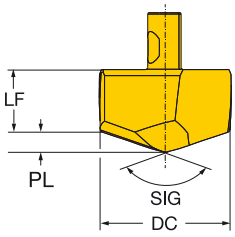
# CoroDrill® 870 drill tip




| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | Dimensions, mm, inch LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 23.30 | .917 | 23 | 870-2330-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.0 | .433 | 3.5 | .138 | 142° | H9 |
| 23.30 | .917 | | 870-2330-23-MM | | | ★ | | | | | ☆ | | 11.0 | .433 | 3.5 | .138 | 142° | H9 |
| 23.30 | .917 | | 870-2330-23-KM | ☆ | | | | ★ | | | | | 10.1 | .396 | 4.5 | .175 | 142° | H9 |
| 23.30 | .917 | | 870-2330-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.4 | .448 | 2.4 | .095 | 152° | F9 |
| 23.40 | .921 | | 870-2340-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.0 | .432 | 3.5 | .139 | 142° | H9 |
| 23.40 | .921 | | 870-2340-23-MM | | | ★ | | | | | ☆ | | 11.0 | .432 | 3.5 | .139 | 142° | H9 |
| 23.40 | .921 | | 870-2340-23-KM | ☆ | | | | ★ | | | | | 10.0 | .395 | 4.5 | .176 | 142° | H9 |
| 23.40 | .921 | | 870-2340-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.4 | .448 | 2.4 | .096 | 152° | F9 |
| 23.50 | .925 | | 870-2350-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.0 | .431 | 3.5 | .139 | 142° | H9 |
| 23.50 | .925 | | 870-2350-23-MM | | | ★ | | | | | ☆ | | 11.0 | .431 | 3.5 | .139 | 142° | H9 |
| 23.50 | .925 | | 870-2350-23-KM | ☆ | | | | ★ | | | | | 10.0 | .394 | 4.5 | .176 | 142° | H9 |
| 23.50 | .925 | | 870-2350-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.4 | .447 | 2.4 | .096 | 152° | F9 |
| 23.60 | .929 | | 870-2360-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.9 | .431 | 3.6 | .140 | 142° | H9 |
| 23.60 | .929 | | 870-2360-23-MM | | | ★ | | | | | ☆ | | 10.9 | .431 | 3.6 | .140 | 142° | H9 |
| 23.60 | .929 | | 870-2360-23-KM | ☆ | | | | ★ | | | | | 10.0 | .394 | 4.5 | .177 | 142° | H9 |
| 23.60 | .929 | | 870-2360-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.4 | .447 | 2.4 | .096 | 152° | F9 |
| 23.70 | .933 | | 870-2370-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.9 | .430 | 3.6 | .141 | 142° | H9 |
| 23.70 | .933 | | 870-2370-23-MM | | | ★ | | | | | ☆ | | 10.9 | .430 | 3.6 | .141 | 142° | H9 |
| 23.70 | .933 | | 870-2370-23-KM | ☆ | | | | ★ | | | | | 10.0 | .393 | 4.5 | .178 | 142° | H9 |
| 23.70 | .933 | | 870-2370-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.4 | .447 | 2.5 | .096 | 152° | F9 |
| 23.80 | .937 | | 870-2380-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.9 | .430 | 3.6 | .141 | 142° | H9 |
| 23.80 | .937 | | 870-2380-23-PL | | ☆ | | ★ | | | | | | 9.7 | .382 | 4.8 | .189 | 142° | H9 |
| 23.80 | .937 | | 870-2380-23-MM | | | ★ | | | | | ☆ | | 10.9 | .430 | 3.6 | .141 | 142° | H9 |
| 23.80 | .937 | | 870-2380-23-KM | ☆ | | | | ★ | | | | | 10.0 | .393 | 4.5 | .178 | 142° | H9 |
| 23.80 | .937 | | 870-2380-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.3 | .446 | 2.5 | .097 | 152° | F9 |
| 23.81 | .937 | | 870-2381-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.9 | .430 | 3.6 | .141 | 142° | H9 |
| 23.81 | .937 | | 870-2381-23-MM | | | ★ | | | | | ☆ | | 10.9 | .430 | 3.6 | .141 | 142° | H9 |
| 23.81 | .937 | | 870-2381-23-KM | ☆ | | | | ★ | | | | | 10.0 | .393 | 4.5 | .178 | 142° | H9 |
| 23.81 | .937 | | 870-2381-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.3 | .446 | 2.5 | .097 | 152° | F9 |
| 23.90 | .940 | | 870-2390-23-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 10.9 | .429 | 3.6 | .142 | 142° | H9 |
| 23.90 | .940 | | 870-2390-23-MM | | | ★ | | | | | ☆ | | 10.9 | .429 | 3.6 | .142 | 142° | H9 |
| 23.90 | .940 | | 870-2390-23-KM | ☆ | | | | ★ | | | | | 10.0 | .392 | 4.6 | .179 | 142° | H9 |
| 23.90 | .940 | | 870-2390-23-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.3 | .446 | 2.5 | .098 | 152° | F9 |
| 24.00 | .944 | 24 | 870-2400-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.4 | .448 | 3.6 | .143 | 142° | H9 |
| 24.00 | .944 | | 870-2400-24-MM | | | ★ | | | | | ☆ | | 11.4 | .448 | 3.6 | .143 | 142° | H9 |
| 24.00 | .944 | | 870-2400-24-KM | ☆ | | | | ★ | | | | | 10.4 | .408 | 4.6 | .182 | 142° | H9 |
| 24.00 | .944 | | 870-2400-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.8 | .465 | 2.5 | .098 | 152° | F9 |
| 24.10 | .948 | | 870-2410-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.4 | .447 | 3.6 | .143 | 142° | H9 |
| 24.10 | .948 | | 870-2410-24-MM | | | ★ | | | | | ☆ | | 11.4 | .447 | 3.6 | .143 | 142° | H9 |
| 24.10 | .948 | | 870-2410-24-KM | ☆ | | | | ★ | | | | | 10.4 | .407 | 4.7 | .183 | 142° | H9 |
| 24.10 | .948 | | 870-2410-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.8 | .464 | 2.5 | .099 | 152° | F9 |
| 24.20 | .952 | | 870-2420-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.4 | .447 | 3.7 | .144 | 142° | H9 |
| 24.20 | .952 | | 870-2420-24-MM | | | ★ | | | | | ☆ | | 11.4 | .447 | 3.7 | .144 | 142° | H9 |
| 24.20 | .952 | | 870-2420-24-KM | ☆ | | | | ★ | | | | | 10.3 | .407 | 4.7 | .183 | 142° | H9 |
| 24.20 | .952 | | 870-2420-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.8 | .464 | 2.5 | .099 | 152° | F9 |
| 24.30 | .956 | | 870-2430-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.3 | .446 | 3.7 | .144 | 142° | H9 |
| 24.30 | .956 | | 870-2430-24-MM | | | ★ | | | | | ☆ | | 11.3 | .446 | 3.7 | .144 | 142° | H9 |
| 24.30 | .956 | | 870-2430-24-KM | ☆ | | | | ★ | | | | | 10.3 | .406 | 4.7 | .184 | 142° | H9 |
| 24.30 | .956 | | 870-2430-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.8 | .463 | 2.5 | .100 | 152° | F9 |
| 24.40 | .960 | | 870-2440-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.3 | .445 | 3.7 | .145 | 142° | H9 |
| 24.40 | .960 | | 870-2440-24-MM | | | ★ | | | | | ☆ | | 11.3 | .445 | 3.7 | .145 | 142° | H9 |
| 24.40 | .960 | | 870-2440-24-KM | ☆ | | | | ★ | | | | | 10.3 | .406 | 4.7 | .185 | 142° | H9 |
| 24.40 | .960 | | 870-2440-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.8 | .463 | 2.6 | .100 | 152° | F9 |

J6 J62 J5 N22 N6

# CoroDrill® 870 drill tip



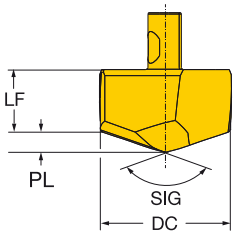

| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | Dimensions, mm, inch LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 24.50 | .964 | 24 | 870-2450-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.3 | .445 | 3.7 | .146 | 142° | H9 |
| 24.50 | .964 | | 870-2450-24-MM | | | ★ | | | | | ☆ | | 11.3 | .445 | 3.7 | .146 | 142° | H9 |
| 24.50 | .964 | | 870-2450-24-KM | ☆ | | | | ★ | | | | | 10.3 | .405 | 4.7 | .185 | 142° | H9 |
| 24.50 | .964 | | 870-2450-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.7 | .462 | 2.6 | .101 | 152° | F9 |
| 24.60 | .968 | | 870-2460-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.3 | .444 | 3.7 | .146 | 142° | H9 |
| 24.60 | .968 | | 870-2460-24-MM | | | ★ | | | | | ☆ | | 11.3 | .444 | 3.7 | .146 | 142° | H9 |
| 24.60 | .968 | | 870-2460-24-KM | ☆ | | | | ★ | | | | | 10.3 | .404 | 4.7 | .186 | 142° | H9 |
| 24.60 | .968 | | 870-2460-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.7 | .461 | 2.6 | .102 | 152° | F9 |
| 24.70 | .972 | | 870-2470-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.3 | .443 | 3.7 | .147 | 142° | H9 |
| 24.70 | .972 | | 870-2470-24-MM | | | ★ | | | | | ☆ | | 11.3 | .443 | 3.7 | .147 | 142° | H9 |
| 24.70 | .972 | | 870-2470-24-KM | ☆ | | | | ★ | | | | | 10.3 | .404 | 4.8 | .187 | 142° | H9 |
| 24.70 | .972 | | 870-2470-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.7 | .461 | 2.6 | .102 | 152° | F9 |
| 24.80 | .976 | | 870-2480-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.3 | .443 | 3.8 | .148 | 142° | H9 |
| 24.80 | .976 | | 870-2480-24-MM | | | ★ | | | | | ☆ | | 11.3 | .443 | 3.8 | .148 | 142° | H9 |
| 24.80 | .976 | | 870-2480-24-KM | ☆ | | | | ★ | | | | | 10.2 | .403 | 4.8 | .188 | 142° | H9 |
| 24.80 | .976 | | 870-2480-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.7 | .460 | 2.6 | .103 | 152° | F9 |
| 24.90 | .980 | | 870-2490-24-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.2 | .442 | 3.8 | .148 | 142° | H9 |
| 24.90 | .980 | | 870-2490-24-MM | | | ★ | | | | | ☆ | | 11.2 | .442 | 3.8 | .148 | 142° | H9 |
| 24.90 | .980 | | 870-2490-24-KM | ☆ | | | | ★ | | | | | 10.2 | .402 | 4.8 | .188 | 142° | H9 |
| 24.90 | .980 | | 870-2490-24-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 11.7 | .460 | 2.6 | .103 | 152° | F9 |
| 25.00 | .984 | 25 | 870-2500-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.9 | .470 | 3.8 | .148 | 142° | H9 |
| 25.00 | .984 | | 870-2500-25-MM | | | ★ | | | | | ☆ | | 11.9 | .470 | 3.8 | .148 | 142° | H9 |
| 25.00 | .984 | | 870-2500-25-KM | ☆ | | | | ★ | | | | | 10.9 | .430 | 4.8 | .188 | 142° | H9 |
| 25.00 | .984 | | 870-2500-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.3 | .483 | 2.6 | .104 | 152° | F9 |
| 25.10 | .988 | | 870-2510-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.9 | .469 | 3.8 | .149 | 142° | H9 |
| 25.10 | .988 | | 870-2510-25-MM | | | ★ | | | | | ☆ | | 11.9 | .469 | 3.8 | .149 | 142° | H9 |
| 25.10 | .988 | | 870-2510-25-KM | ☆ | | | | ★ | | | | | 10.9 | .430 | 4.8 | .189 | 142° | H9 |
| 25.10 | .988 | | 870-2510-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.3 | .482 | 2.7 | .104 | 152° | F9 |
| 25.20 | .992 | | 870-2520-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.9 | .469 | 3.8 | .149 | 142° | H9 |
| 25.20 | .992 | | 870-2520-25-MM | | | ★ | | | | | ☆ | | 11.9 | .469 | 3.8 | .149 | 142° | H9 |
| 25.20 | .992 | | 870-2520-25-KM | ☆ | | | | ★ | | | | | 10.9 | .429 | 4.8 | .189 | 142° | H9 |
| 25.20 | .992 | | 870-2520-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.2 | .481 | 2.7 | .105 | 152° | F9 |
| 25.30 | .996 | | 870-2530-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.9 | .468 | 3.8 | .150 | 142° | H9 |
| 25.30 | .996 | | 870-2530-25-MM | | | ★ | | | | | ☆ | | 11.9 | .468 | 3.8 | .150 | 142° | H9 |
| 25.30 | .996 | | 870-2530-25-KM | ☆ | | | | ★ | | | | | 10.9 | .428 | 4.8 | .190 | 142° | H9 |
| 25.30 | .996 | | 870-2530-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.2 | .481 | 2.7 | .106 | 152° | F9 |
| 25.40 | 1.000 | | 870-2540-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.9 | .467 | 3.8 | .151 | 142° | H9 |
| 25.40 | 1.000 | | 870-2540-25-MM | | | ★ | | | | | ☆ | | 11.9 | .467 | 3.8 | .151 | 142° | H9 |
| 25.40 | 1.000 | | 870-2540-25-KM | ☆ | | | | ★ | | | | | 10.9 | .428 | 4.8 | .191 | 142° | H9 |
| 25.40 | 1.000 | | 870-2540-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.2 | .480 | 2.7 | .106 | 152° | F9 |
| 25.50 | 1.003 | | 870-2550-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.9 | .467 | 3.8 | .151 | 142° | H9 |
| 25.50 | 1.003 | | 870-2550-25-MM | | | ★ | | | | | ☆ | | 11.9 | .467 | 3.8 | .151 | 142° | H9 |
| 25.50 | 1.003 | | 870-2550-25-KM | ☆ | | | | ★ | | | | | 10.9 | .427 | 4.9 | .191 | 142° | H9 |
| 25.50 | 1.003 | | 870-2550-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.2 | .480 | 2.7 | .107 | 152° | F9 |
| 25.60 | 1.007 | | 870-2560-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.8 | .466 | 3.9 | .152 | 142° | H9 |
| 25.60 | 1.007 | | 870-2560-25-MM | | | ★ | | | | | ☆ | | 11.8 | .466 | 3.9 | .152 | 142° | H9 |
| 25.60 | 1.007 | | 870-2560-25-KM | ☆ | | | | ★ | | | | | 10.8 | .426 | 4.9 | .192 | 142° | H9 |
| 25.60 | 1.007 | | 870-2560-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.2 | .480 | 2.7 | .107 | 152° | F9 |
| 25.65 | 1.009 | | 870-2565-25-PL | | ☆ | | ★ | | | | | | 10.5 | 10.5 | 5.2 | 5.2 | 142° | H9 |
| 25.70 | 1.011 | | 870-2570-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.8 | .465 | 3.9 | .153 | 142° | H9 |
| 25.70 | 1.011 | | 870-2570-25-MM | | | ★ | | | | | ☆ | | 11.8 | .465 | 3.9 | .153 | 142° | H9 |
| 25.70 | 1.011 | | 870-2570-25-KM | ☆ | | | | ★ | | | | | 10.8 | .426 | 4.9 | .193 | 142° | H9 |
| 25.70 | 1.011 | | 870-2570-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.2 | .479 | 2.7 | .108 | 152° | F9 |

J6 J62 J5 N22 N6



SANDVIK Coromant

# CoroDrill® 870 drill tip

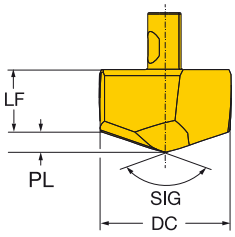



| DC | DC" | | Ordering code | P | | M | | K | | N | S | | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 3334 | 4334 | 2334 | 4334 | 3334 | 4334 | 4334 | 2334 | 4334 | LF | LF" | PL | PL" | SIG | TCHA |
| 25.80 | 1.015 | 25 | 870-2580-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.8 | .465 | 3.9 | .153 | 142° | H9 |
| 25.80 | 1.015 | | 870-2580-25-MM | | | ★ | | | | | ☆ | | 11.8 | .465 | 3.9 | .153 | 142° | H9 |
| 25.80 | 1.015 | | 870-2580-25-KM | ☆ | | | | ★ | | | | | 10.8 | .425 | 4.9 | .193 | 142° | H9 |
| 25.80 | 1.015 | | 870-2580-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.1 | .478 | 2.8 | .109 | 152° | F9 |
| 25.90 | 1.019 | | 870-2590-25-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 11.8 | .464 | 3.9 | .154 | 142° | H9 |
| 25.90 | 1.019 | | 870-2590-25-MM | | | ★ | | | | | ☆ | | 11.8 | .464 | 3.9 | .154 | 142° | H9 |
| 25.90 | 1.019 | | 870-2590-25-KM | ☆ | | | | ★ | | | | | 10.8 | .424 | 4.9 | .194 | 142° | H9 |
| 25.90 | 1.019 | | 870-2590-25-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.1 | .478 | 2.8 | .109 | 152° | F9 |
| 26.00 | 1.023 | 26 | 870-2600-26-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 12.5 | .492 | 3.9 | .154 | 142° | H9 |
| 26.00 | 1.023 | | 870-2600-26-MM | | | ★ | | | | | ☆ | | 12.5 | .492 | 3.9 | .154 | 142° | H9 |
| 26.00 | 1.023 | | 870-2600-26-KM | ☆ | | | | ★ | | | | | 11.4 | .449 | 5.0 | .196 | 142° | H9 |
| 26.00 | 1.023 | | 870-2600-26-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.9 | .507 | 2.7 | .107 | 152° | F9 |
| 26.50 | 1.043 | | 870-2650-26-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 12.4 | .489 | 4.0 | .157 | 142° | H9 |
| 26.50 | 1.043 | | 870-2650-26-MM | | | ★ | | | | | ☆ | | 12.4 | .489 | 4.0 | .157 | 142° | H9 |
| 26.50 | 1.043 | | 870-2650-26-KM | ☆ | | | | ★ | | | | | 11.3 | .446 | 5.1 | .200 | 142° | H9 |
| 26.50 | 1.043 | | 870-2650-26-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.8 | .505 | 2.8 | .109 | 152° | F9 |
| 26.65 | 1.049 | | 870-2665-26-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 12.4 | .487 | 4.0 | .159 | 142° | H9 |
| 26.65 | 1.049 | | 870-2665-26-MM | | | ★ | | | | | ☆ | | 12.4 | .487 | 4.0 | .159 | 142° | H9 |
| 26.65 | 1.049 | | 870-2665-26-KM | ☆ | | | | ★ | | | | | 11.3 | .444 | 5.1 | .201 | 142° | H9 |
| 26.65 | 1.049 | | 870-2665-26-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 12.8 | .504 | 2.8 | .110 | 152° | F9 |
| 27.00 | 1.063 | 27 | 870-2700-27-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 13.0 | .510 | 4.1 | .159 | 142° | H9 |
| 27.00 | 1.063 | | 870-2700-27-MM | | | ★ | | | | | ☆ | | 13.0 | .510 | 4.1 | .159 | 142° | H9 |
| 27.00 | 1.063 | | 870-2700-27-KM | ☆ | | | | ★ | | | | | 11.8 | .464 | 5.2 | .205 | 142° | H9 |
| 27.00 | 1.063 | | 870-2700-27-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 13.3 | .522 | 2.8 | .111 | 152° | F9 |
| 27.50 | 1.082 | | 870-2750-27-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 12.9 | .506 | 4.1 | .163 | 142° | H9 |
| 27.50 | 1.082 | | 870-2750-27-MM | | | ★ | | | | | ☆ | | 12.9 | .506 | 4.1 | .163 | 142° | H9 |
| 27.50 | 1.082 | | 870-2750-27-KM | ☆ | | | | ★ | | | | | 11.7 | .461 | 5.3 | .208 | 142° | H9 |
| 27.50 | 1.082 | | 870-2750-27-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 13.2 | .520 | 2.9 | .114 | 152° | F9 |
| 28.00 | 1.102 | 28 | 870-2800-28-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 13.4 | .527 | 4.2 | .166 | 142° | H9 |
| 28.00 | 1.102 | | 870-2800-28-MM | | | ★ | | | | | ☆ | | 13.4 | .527 | 4.2 | .166 | 142° | H9 |
| 28.00 | 1.102 | | 870-2800-28-KM | ☆ | | | | ★ | | | | | 12.2 | .481 | 5.4 | .211 | 142° | H9 |
| 28.00 | 1.102 | | 870-2800-28-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 13.8 | .542 | 2.9 | .116 | 152° | F9 |
| 28.50 | 1.122 | | 870-2850-28-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 13.3 | .524 | 4.3 | .169 | 142° | H9 |
| 28.50 | 1.122 | | 870-2850-28-MM | | | ★ | | | | | ☆ | | 13.3 | .524 | 4.3 | .169 | 142° | H9 |
| 28.50 | 1.122 | | 870-2850-28-KM | ☆ | | | | ★ | | | | | 12.1 | .478 | 5.5 | .215 | 142° | H9 |
| 28.50 | 1.122 | | 870-2850-28-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 13.7 | .540 | 3.0 | .118 | 152° | F9 |
| 28.58 | 1.125 | | 870-2858-28-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 13.3 | .523 | 4.3 | .170 | 142° | H9 |
| 28.58 | 1.125 | | 870-2858-28-MM | | | ★ | | | | | ☆ | | 13.3 | .523 | 4.3 | .170 | 142° | H9 |
| 28.58 | 1.125 | | 870-2858-28-KM | ☆ | | | | ★ | | | | | 12.1 | .478 | 5.5 | .215 | 142° | H9 |
| 28.58 | 1.125 | | 870-2858-28-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 13.7 | .539 | 3.0 | .118 | 152° | F9 |
| 29.00 | 1.141 | 29 | 870-2900-29-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 13.9 | .549 | 4.4 | .172 | 142° | H9 |
| 29.00 | 1.141 | | 870-2900-29-MM | | | ★ | | | | | ☆ | | 13.9 | .549 | 4.4 | .172 | 142° | H9 |
| 29.00 | 1.141 | | 870-2900-29-KM | ☆ | | | | ★ | | | | | 12.7 | .500 | 5.6 | .220 | 142° | H9 |
| 29.00 | 1.141 | | 870-2900-29-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 14.3 | .561 | 3.0 | .120 | 152° | F9 |
| 29.50 | 1.161 | | 870-2950-29-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 13.9 | .545 | 4.5 | .175 | 142° | H9 |
| 29.50 | 1.161 | | 870-2950-29-MM | | | ★ | | | | | ☆ | | 13.9 | .545 | 4.5 | .175 | 142° | H9 |
| 29.50 | 1.161 | | 870-2950-29-KM | ☆ | | | | ★ | | | | | 12.6 | .497 | 5.7 | .223 | 142° | H9 |
| 29.50 | 1.161 | | 870-2950-29-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 14.2 | .559 | 3.1 | .122 | 152° | F9 |
| 29.65 | 1.167 | | 870-2965-29-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 13.8 | .544 | 4.5 | .176 | 142° | H9 |
| 29.65 | 1.167 | | 870-2965-29-MM | | | ★ | | | | | ☆ | | 13.8 | .544 | 4.5 | .176 | 142° | H9 |
| 29.65 | 1.167 | | 870-2965-29-KM | ☆ | | | | ★ | | | | | 12.6 | .496 | 5.7 | .224 | 142° | H9 |
| 29.65 | 1.167 | | 870-2965-29-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 14.2 | .559 | 3.1 | .122 | 152° | F9 |

J6 J62 J5 N22 N6

SANDVIK Coromant

# CoroDrill® 870 drill tip




| DC | DC" | | Ordering code | P 3334 | P 4334 | M 2334 | M 4334 | K 3334 | K 4334 | N 4334 | S 2334 | S 4334 | Dimensions, mm, inch LF | LF" | PL | PL" | SIG | TCHA |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.00 | 1.181 | 30 | 870-3000-30-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 14.4 | .566 | 4.5 | .178 | 142° | H9 |
| 30.00 | 1.181 | | 870-3000-30-MM | | | ★ | | | | | ☆ | | 14.4 | .566 | 4.5 | .178 | 142° | H9 |
| 30.00 | 1.181 | | 870-3000-30-KM | ☆ | | | | ★ | | | | | 13.1 | .515 | 5.8 | .229 | 142° | H9 |
| 30.00 | 1.181 | | 870-3000-30-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 14.7 | .577 | 3.2 | .124 | 152° | F9 |
| 30.50 | 1.200 | | 870-3050-30-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 14.3 | .563 | 4.6 | .181 | 142° | H9 |
| 30.50 | 1.200 | | 870-3050-30-MM | | | ★ | | | | | ☆ | | 14.3 | .563 | 4.6 | .181 | 142° | H9 |
| 30.50 | 1.200 | | 870-3050-30-KM | ☆ | | | | ★ | | | | | 13.0 | .512 | 5.9 | .232 | 142° | H9 |
| 30.50 | 1.200 | | 870-3050-30-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 14.6 | .574 | 3.2 | .126 | 152° | F9 |
| 31.00 | 1.220 | 31 | 870-3100-31-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 14.8 | .581 | 4.8 | .187 | 142° | H9 |
| 31.00 | 1.220 | | 870-3100-31-MM | | | ★ | | | | | ☆ | | 14.8 | .581 | 4.8 | .187 | 142° | H9 |
| 31.00 | 1.220 | | 870-3100-31-KM | ☆ | | | | ★ | | | | | 13.4 | .527 | 6.1 | .241 | 142° | H9 |
| 31.00 | 1.220 | | 870-3100-31-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 15.1 | .593 | 3.3 | .131 | 152° | F9 |
| 31.50 | 1.240 | | 870-3150-31-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 14.7 | .578 | 4.8 | .190 | 142° | H9 |
| 31.50 | 1.240 | | 870-3150-31-MM | | | ★ | | | | | ☆ | | 14.7 | .578 | 4.8 | .190 | 142° | H9 |
| 31.50 | 1.240 | | 870-3150-31-KM | ☆ | | | | ★ | | | | | 13.3 | .524 | 6.2 | .244 | 142° | H9 |
| 31.50 | 1.240 | | 870-3150-31-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 15.0 | .591 | 3.4 | .133 | 152° | F9 |
| 31.75 | 1.250 | | 870-3175-31-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 14.6 | .576 | 4.9 | .192 | 142° | H9 |
| 31.75 | 1.250 | | 870-3175-31-MM | | | ★ | | | | | ☆ | | 14.6 | .576 | 4.9 | .192 | 142° | H9 |
| 31.75 | 1.250 | | 870-3175-31-KM | ☆ | | | | ★ | | | | | 13.3 | .522 | 6.2 | .245 | 142° | H9 |
| 31.75 | 1.250 | | 870-3175-31-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 15.0 | .590 | 3.4 | .134 | 152° | F9 |
| 32.00 | 1.259 | | 870-3200-31-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 14.6 | .574 | 4.9 | .194 | 142° | H9 |
| 32.00 | 1.259 | | 870-3200-31-MM | | | ★ | | | | | ☆ | | 14.6 | .574 | 4.9 | .194 | 142° | H9 |
| 32.00 | 1.259 | | 870-3200-31-KM | ☆ | | | | ★ | | | | | 13.2 | .521 | 6.3 | .247 | 142° | H9 |
| 32.00 | 1.259 | | 870-3200-31-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 15.0 | .589 | 3.4 | .135 | 152° | F9 |
| 32.15 | 1.265 | | 870-3215-31-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 14.6 | .573 | 5.0 | .195 | 142° | H9 |
| 32.15 | 1.265 | | 870-3215-31-MM | | | ★ | | | | | ☆ | | 14.6 | .573 | 5.0 | .195 | 142° | H9 |
| 32.15 | 1.265 | | 870-3215-31-KM | ☆ | | | | ★ | | | | | 13.2 | .519 | 6.3 | .249 | 142° | H9 |
| 32.15 | 1.265 | | 870-3215-31-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 14.9 | .588 | 3.5 | .136 | 152° | F9 |
| 32.50 | 1.279 | | 870-3250-31-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 14.5 | .571 | 5.0 | .197 | 142° | H9 |
| 32.50 | 1.279 | | 870-3250-31-MM | | | ★ | | | | | ☆ | | 14.5 | .571 | 5.0 | .197 | 142° | H9 |
| 32.50 | 1.279 | | 870-3250-31-KM | ☆ | | | | ★ | | | | | 13.1 | .516 | 6.4 | .252 | 142° | H9 |
| 32.50 | 1.279 | | 870-3250-31-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 14.9 | .587 | 3.5 | .138 | 152° | F9 |
| 33.00 | 1.299 | | 870-3300-31-PM | | ★ | | ☆ | | ☆ | ☆ | | ☆ | 14.4 | .568 | 5.1 | .200 | 142° | H9 |
| 33.00 | 1.299 | | 870-3300-31-MM | | | ★ | | | | | ☆ | | 14.4 | .568 | 5.1 | .200 | 142° | H9 |
| 33.00 | 1.299 | | 870-3300-31-KM | ☆ | | | | ★ | | | | | 13.0 | .511 | 6.5 | .256 | 142° | H9 |
| 33.00 | 1.299 | | 870-3300-31-GP | | ★ | | ★ | | ★ | ☆ | | ☆ | 14.8 | .584 | 3.6 | .140 | 152° | F9 |

J6 J62 J5 N22 N6



SANDVIK Coromant

# CoroDrill® DS20

## Indexable insert drills

### 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

### Modular Drilling Interface

The MDI adapters are available in Coromant Capto® and HSK and offer high precision, excellent centering capabilities and reduction of tool inventory. See page L2

www.sandvik.coromant.com/DS20

### Drill bodies

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

### Inserts

- Inserts with optimized geometries for all materials

| | | | | Achievable lower tolerance (TCHAL) | | | | | | | | Achievable upper tolerance (TCHAU) | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $D_c$ min | | $D_c$ max | | 4xD | | 5xD | | 6xD | | 7xD | | 4xD | | 5xD | | 6xD | | 7xD | |
| mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch |
| 15.00 | .590 | 18.00 | .708 | 0 | 0 | 0 | 0 | -0.1 | -.0039 | -0.1 | -.0039 | 0.27 | .0106 | 0.27 | .0106 | 0.4 | .0157 | 0.4 | .0157 |
| 18.01 | .709 | 30.00 | 1.181 | 0 | 0 | 0 | 0 | -0.1 | -.0039 | -0.1 | -.0039 | 0.33 | .0129 | 0.33 | .0129 | 0.4 | .0157 | 0.4 | .0157 |
| 30.01 | 1.181 | 40.00 | 1.575 | 0 | 0 | 0 | 0 | -0.1 | -.0039 | -0.1 | -.0039 | 0.39 | .0153 | 0.39 | .0153 | 0.4 | .0157 | 0.4 | .0157 |

J29 J37 N6

# Insert overview

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

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

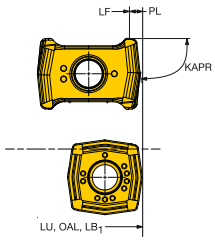
| Central insert | | | Grade information |
|---|---|---|---|
| | | P K S H | **GC1344**<br>- PVD-coated with Zertivo® technology<br>- Excellent wear resistance and toughness |
| | | M S | **GC1144**<br>- PVD-coated grade for all types of ISO M and titanium materials |
| | | N S | **H13A**<br>- Universal,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

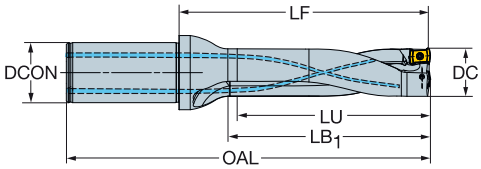
| Peripheral insert | | | Grade information |
|---|---|---|---|
| | | P M K H | **GC4334**<br>- Good to average conditions<br>- CVD coating with Inveio® technology provides a high level of wear resistance |
| | | M S | **GC2044**<br>- PVD-oxide coating for excellent wear resistance |
| | | P M K N S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

# CoroDrill® DS20 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**




## Metric design

| 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 |

| | 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 |

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

J37

L2

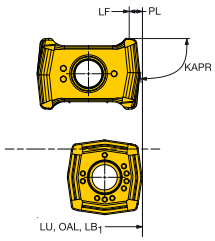
N22

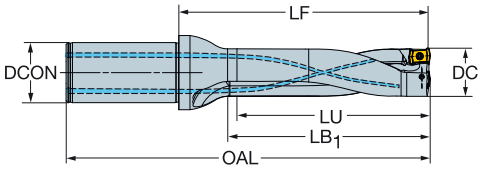
N15

# CoroDrill® DS20 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**




## Metric design

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

| | 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 |

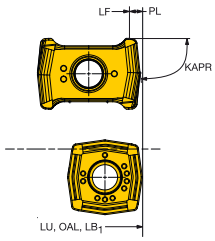
For the complete list of spare parts, visit www.sandvik.coromant.com

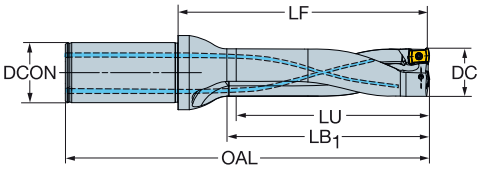
J37 L2 N22 N15

# CoroDrill® DS20 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**




## Metric design

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

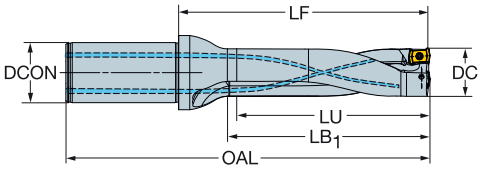
For the complete list of spare parts, visit www.sandvik.coromant.com

J37 L2 N22 N15

# CoroDrill® DS20 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**




## Inch design

| DC | | | LU | CZC$_{MS}$ | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, inch DCON$_{MS}$ | LF | OAL | LB$_1$ | PL | KAPR | PSI | LBS | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .625 | 01C | 01P | 2.500 | 3/4 | .030 | .000 | .011 | DS20-D1588LX19-04 | .750 | 3.298 | 5.285 | 2.611 | .018 | 81° | 145 | 0.480 | 22000 |
| | | | 3.125 | 3/4 | .030 | .000 | .011 | DS20-D1588LX19-05 | .750 | 3.923 | 5.910 | 3.236 | .018 | 81° | 145 | 0.504 | 14000 |
| | | | 3.750 | 3/4 | .030 | -.004 | .016 | DS20-D1588LX19-06 | .750 | 4.548 | 6.535 | 3.861 | .018 | 81° | 145 | 0.540 | 10000 |
| | | | 4.375 | 3/4 | .030 | -.004 | .016 | DS20-D1588LX19-07 | .750 | 5.173 | 7.160 | 4.486 | .018 | 81° | 145 | 0.440 | 7000 |
| .655 | 01C | 01P | 2.624 | 3/4 | .023 | .000 | .011 | DS20-D1666LX19-04 | .750 | 3.420 | 5.407 | 2.735 | .018 | 81° | 145 | 0.500 | 21000 |
| | | | 3.280 | 3/4 | .023 | .000 | .011 | DS20-D1666LX19-05 | .750 | 4.076 | 6.063 | 3.391 | .018 | 81° | 145 | 0.529 | 14000 |
| | | | 3.936 | 3/4 | .023 | -.004 | .016 | DS20-D1666LX19-06 | .750 | 4.732 | 6.719 | 4.047 | .018 | 81° | 145 | 0.570 | 10000 |
| | | | 4.592 | 3/4 | .023 | -.004 | .016 | DS20-D1666LX19-07 | .750 | 5.388 | 7.375 | 4.703 | .018 | 81° | 145 | 0.599 | 7000 |
| .687 | 01C | 01P | 2.748 | 1 | .015 | .000 | .011 | DS20-D1745LX25-04 | 1.000 | 3.692 | 5.915 | 2.859 | .018 | 81° | 145 | 0.661 | 21000 |
| | | | 3.435 | 1 | .015 | .000 | .011 | DS20-D1745LX25-05 | 1.000 | 4.379 | 6.602 | 3.546 | .018 | 81° | 145 | 0.800 | 13000 |
| | | | 4.122 | 1 | .015 | -.004 | .016 | DS20-D1745LX25-06 | 1.000 | 5.066 | 7.289 | 4.233 | .018 | 81° | 145 | 0.881 | 9000 |
| | | | 4.809 | 1 | .015 | -.004 | .016 | DS20-D1745LX25-07 | 1.000 | 5.753 | 7.976 | 4.920 | .018 | 81° | 145 | 1.018 | 7000 |
| .750 | 02C | 02P | 3.000 | 1 | .041 | .000 | .013 | DS20-D1905LX25-04 | 1.000 | 3.943 | 6.170 | 3.119 | .022 | 81° | 145 | 0.870 | 19000 |
| | | | 3.750 | 1 | .041 | .000 | .013 | DS20-D1905LX25-05 | 1.000 | 4.693 | 6.920 | 3.869 | .022 | 81° | 145 | 0.921 | 12000 |
| | | | 4.500 | 1 | .041 | -.004 | .016 | DS20-D1905LX25-06 | 1.000 | 5.443 | 7.670 | 4.619 | .022 | 81° | 145 | 0.870 | 8000 |
| | | | 5.250 | 1 | .041 | -.004 | .016 | DS20-D1905LX25-07 | 1.000 | 6.193 | 8.420 | 5.369 | .022 | 81° | 145 | 1.051 | 6000 |
| .812 | 02C | 02P | 3.248 | 1 | .026 | .000 | .013 | DS20-D2062LX25-04 | 1.000 | 4.186 | 6.413 | 3.367 | .022 | 81° | 145 | 0.939 | 17000 |
| | | | 4.060 | 1 | .026 | .000 | .013 | DS20-D2062LX25-05 | 1.000 | 4.998 | 7.225 | 4.179 | .022 | 81° | 145 | 0.881 | 11000 |
| | | | 4.872 | 1 | .026 | -.004 | .016 | DS20-D2062LX25-06 | 1.000 | 5.810 | 8.037 | 4.991 | .022 | 81° | 145 | 1.102 | 8000 |
| | | | 5.684 | 1 | .026 | -.004 | .016 | DS20-D2062LX25-07 | 1.000 | 6.622 | 8.849 | 5.803 | .022 | 81° | 145 | 1.322 | 6000 |
| .875 | 03C | 03P | 3.500 | 1 | .057 | .000 | .013 | DS20-D2223LX25-04 | 1.000 | 4.436 | 6.667 | 3.626 | .026 | 81° | 145 | 0.899 | 16000 |
| | | | 4.375 | 1 | .057 | .000 | .013 | DS20-D2223LX25-05 | 1.000 | 5.311 | 7.542 | 4.501 | .026 | 81° | 145 | 1.075 | 10000 |
| | | | 5.250 | 1 | .057 | -.004 | .016 | DS20-D2223LX25-06 | 1.000 | 6.186 | 8.417 | 5.376 | .026 | 81° | 145 | 1.102 | 7000 |
| | | | 6.125 | 1 | .057 | -.004 | .016 | DS20-D2223LX25-07 | 1.000 | 7.061 | 9.292 | 6.251 | .026 | 81° | 145 | 1.102 | 5000 |
| .937 | 03C | 03P | 3.748 | 1 | .044 | .000 | .013 | DS20-D2380LX25-04 | 1.000 | 4.679 | 6.910 | 3.874 | .026 | 81° | 145 | 1.073 | 15000 |
| | | | 4.685 | 1 | .044 | .000 | .013 | DS20-D2380LX25-05 | 1.000 | 5.616 | 7.847 | 4.811 | .026 | 81° | 145 | 1.322 | 10000 |
| | | | 5.622 | 1 | .044 | -.004 | .016 | DS20-D2380LX25-06 | 1.000 | 6.553 | 8.784 | 5.748 | .026 | 81° | 145 | 1.322 | 7000 |
| | | | 6.559 | 1 | .044 | -.004 | .016 | DS20-D2380LX25-07 | 1.000 | 7.490 | 9.721 | 6.685 | .026 | 81° | 145 | 1.234 | 5000 |
| 1.000 | 03C | 03P | 4.000 | 1 | .032 | .000 | .013 | DS20-D2540LX25-04 | 1.000 | 4.926 | 7.157 | 4.126 | .026 | 81° | 145 | 1.155 | 14000 |
| | | | 5.000 | 1 | .032 | .000 | .013 | DS20-D2540LX25-05 | 1.000 | 5.926 | 8.157 | 5.126 | .026 | 81° | 145 | 1.309 | 9000 |
| | | | 6.000 | 1 | .032 | -.004 | .016 | DS20-D2540LX25-06 | 1.000 | 6.926 | 9.157 | 6.126 | .026 | 81° | 145 | 1.543 | 6000 |
| | | | 7.000 | 1 | .032 | -.004 | .016 | DS20-D2540LX25-07 | 1.000 | 7.926 | 10.157 | 7.126 | .026 | 81° | 145 | 1.543 | 4000 |
| 1.062 | 03C | 03P | 4.248 | 1 1/4 | .020 | .000 | .013 | DS20-D2697LX31-04 | 1.250 | 5.331 | 7.719 | 4.374 | .026 | 81° | 145 | 1.984 | 13000 |
| | | | 5.310 | 1 1/4 | .020 | .000 | .013 | DS20-D2697LX31-05 | 1.250 | 6.393 | 8.781 | 5.436 | .026 | 81° | 145 | 1.984 | 8000 |
| | | | 6.372 | 1 1/4 | .020 | -.004 | .016 | DS20-D2697LX31-06 | 1.250 | 7.455 | 9.843 | 6.498 | .026 | 81° | 145 | 2.425 | 6000 |
| | | | 7.434 | 1 1/4 | .020 | -.004 | .016 | DS20-D2697LX31-07 | 1.250 | 8.517 | 10.905 | 7.560 | .026 | 81° | 145 | 2.204 | 4000 |
| 1.125 | 04C | 04P | 4.500 | 1 1/4 | .077 | .000 | .013 | DS20-D2858LX31-04 | 1.250 | 5.587 | 7.982 | 4.642 | .033 | 81° | 145 | 1.660 | 13000 |
| | | | 5.625 | 1 1/4 | .077 | .000 | .013 | DS20-D2858LX31-05 | 1.250 | 6.712 | 9.107 | 5.767 | .033 | 81° | 145 | 1.814 | 8000 |
| | | | 6.750 | 1 1/4 | .077 | -.004 | .016 | DS20-D2858LX31-06 | 1.250 | 7.837 | 10.232 | 6.892 | .033 | 81° | 145 | 1.966 | 5000 |
| | | | 7.875 | 1 1/4 | .077 | -.004 | .016 | DS20-D2858LX31-07 | 1.250 | 8.962 | 11.357 | 8.017 | .033 | 81° | 145 | 2.120 | 4000 |

| | Spare parts |
|---|---|
| DC" | Insert screw |
| .625-.687 | 5513 020-27 |
| .750-.812 | 5513 020-88 |
| .875-1.062 | 5513 020-58 |
| 1.125-1.250 | 5513 020-57 |
| 1.312-1.562 | 416.1-833 |

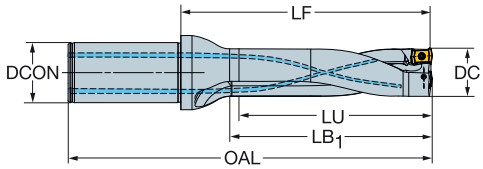
For the complete list of spare parts, visit www.sandvik.coromant.com

J37 L2 N22 N15

# CoroDrill® DS20 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**




## Inch design

| DC | | | LU | CZC$_{MS}$ | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, inch DCON$_{MS}$ | LF | OAL | LB$_1$ | PL | KAPR | PSI | LBS | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.187 | 04C | 04P | 4.748 | 1 1/4 | .059 | .000 | .013 | DS20-D3015LX31-04 | 1.250 | 5.830 | 8.225 | 4.890 | .033 | 81° | 145 | 1.768 | 12000 |
| | | | 5.935 | 1 1/4 | .059 | .000 | .013 | DS20-D3015LX31-05 | 1.250 | 7.017 | 9.412 | 6.077 | .033 | 81° | 145 | 1.948 | 8000 |
| | | | 7.122 | 1 1/4 | .059 | -.004 | .016 | DS20-D3015LX31-06 | 1.250 | 8.204 | 10.599 | 7.264 | .033 | 81° | 145 | 2.127 | 5000 |
| | | | 8.309 | 1 1/4 | .059 | -.004 | .016 | DS20-D3015LX31-07 | 1.250 | 9.391 | 11.786 | 8.451 | .033 | 81° | 145 | 2.308 | 4000 |
| 1.250 | 04C | 04P | 5.000 | 1 1/2 | .042 | .000 | .014 | DS20-D3175LX38-04 | 1.500 | 6.292 | 9.081 | 5.142 | .033 | 81° | 145 | 2.680 | 11000 |
| | | | 6.250 | 1 1/2 | .042 | .000 | .014 | DS20-D3175LX38-05 | 1.500 | 7.542 | 10.331 | 6.392 | .033 | 81° | 145 | 2.890 | 7000 |
| | | | 7.500 | 1 1/2 | .042 | -.004 | .016 | DS20-D3175LX38-06 | 1.500 | 8.792 | 11.581 | 7.642 | .033 | 81° | 145 | 3.101 | 5000 |
| | | | 8.750 | 1 1/2 | .042 | -.004 | .016 | DS20-D3175LX38-07 | 1.500 | 10.042 | 12.831 | 8.892 | .033 | 81° | 145 | 3.311 | 3000 |
| 1.312 | 05C | 05P | 5.248 | 1 1/2 | .091 | .000 | .014 | DS20-D3332LX38-04 | 1.500 | 6.541 | 9.336 | 5.402 | .039 | 81° | 145 | 3.306 | 11000 |
| | | | 6.560 | 1 1/2 | .091 | .000 | .014 | DS20-D3332LX38-05 | 1.500 | 7.853 | 10.648 | 6.714 | .039 | 81° | 145 | 3.306 | 7000 |
| | | | 7.872 | 1 1/2 | .091 | -.004 | .016 | DS20-D3332LX38-06 | 1.500 | 9.165 | 11.960 | 8.026 | .039 | 81° | 145 | 3.747 | 5000 |
| | | | 9.184 | 1 1/2 | .091 | -.004 | .016 | DS20-D3332LX38-07 | 1.500 | 10.477 | 13.272 | 9.338 | .039 | 81° | 145 | 3.747 | 3000 |
| 1.375 | 05C | 05P | 5.500 | 1 1/2 | .076 | .000 | .014 | DS20-D3493LX38-04 | 1.500 | 6.788 | 9.583 | 5.654 | .039 | 81° | 145 | 3.306 | 10000 |
| | | | 6.875 | 1 1/2 | .076 | .000 | .014 | DS20-D3493LX38-05 | 1.500 | 8.163 | 10.958 | 7.029 | .039 | 81° | 145 | 3.527 | 6000 |
| | | | 8.250 | 1 1/2 | .076 | -.004 | .016 | DS20-D3493LX38-06 | 1.500 | 9.538 | 12.333 | 8.404 | .039 | 81° | 145 | 3.747 | 4000 |
| | | | 9.625 | 1 1/2 | .076 | -.004 | .016 | DS20-D3493LX38-07 | 1.500 | 10.913 | 13.708 | 9.779 | .039 | 81° | 145 | 4.409 | 3000 |
| 1.437 | 05C | 05P | 5.748 | 1 1/2 | .061 | .000 | .014 | DS20-D3650LX38-04 | 1.500 | 7.031 | 9.826 | 5.902 | .039 | 81° | 145 | 3.527 | 10000 |
| | | | 7.185 | 1 1/2 | .061 | .000 | .014 | DS20-D3650LX38-05 | 1.500 | 8.468 | 11.263 | 7.339 | .039 | 81° | 145 | 3.437 | 6000 |
| | | | 8.622 | 1 1/2 | .061 | -.004 | .016 | DS20-D3650LX38-06 | 1.500 | 9.905 | 12.700 | 8.776 | .039 | 81° | 145 | 4.188 | 4000 |
| | | | 10.059 | 1 1/2 | .061 | -.004 | .016 | DS20-D3650LX38-07 | 1.500 | 11.342 | 14.137 | 10.213 | .039 | 81° | 145 | 4.629 | 3000 |
| 1.500 | 05C | 05P | 6.000 | 1 1/2 | .046 | .000 | .014 | DS20-D3810LX38-04 | 1.500 | 7.278 | 10.073 | 6.154 | .039 | 81° | 145 | 3.527 | 9000 |
| | | | 7.500 | 1 1/2 | .046 | .000 | .014 | DS20-D3810LX38-05 | 1.500 | 8.778 | 11.573 | 7.654 | .039 | 81° | 145 | 3.747 | 6000 |
| | | | 9.000 | 1 1/2 | .046 | -.004 | .016 | DS20-D3810LX38-06 | 1.500 | 10.278 | 13.073 | 9.154 | .039 | 81° | 145 | 4.629 | 4000 |
| | | | 10.500 | 1 1/2 | .046 | -.004 | .016 | DS20-D3810LX38-07 | 1.500 | 11.778 | 14.573 | 10.654 | .039 | 81° | 145 | 5.291 | 3000 |
| 1.562 | 05C | 05P | 6.248 | 1 1/2 | .031 | .000 | .014 | DS20-D3967LX38-04 | 1.500 | 7.522 | 10.317 | 6.402 | .039 | 81° | 145 | 3.968 | 9000 |
| | | | 7.810 | 1 1/2 | .031 | .000 | .014 | DS20-D3967LX38-05 | 1.500 | 9.084 | 11.879 | 7.964 | .039 | 81° | 145 | 4.188 | 6000 |
| | | | 9.372 | 1 1/2 | .031 | -.004 | .016 | DS20-D3967LX38-06 | 1.500 | 10.646 | 13.441 | 9.526 | .039 | 81° | 145 | 5.070 | 4000 |
| | | | 10.934 | 1 1/2 | .031 | -.004 | .016 | DS20-D3967LX38-07 | 1.500 | 12.208 | 15.003 | 11.088 | .039 | 81° | 145 | 5.732 | 3000 |

| | Spare parts |
|---|---|
| DC" | Insert screw |
| .625-.687 | 5513 020-27 |
| .750-.812 | 5513 020-88 |
| .875-1.062 | 5513 020-58 |
| 1.125-1.250 | 5513 020-57 |
| 1.312-1.562 | 416.1-833 |

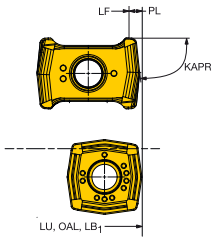
For the complete list of spare parts, visit www.sandvik.coromant.com

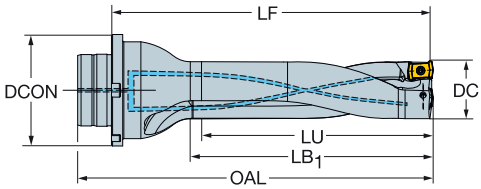
J37 L2 N22 N15

# CoroDrill® DS20 indexable insert drill

**Modular drill interface**

**Internal coolant supply**




## Metric design

| 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 | 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 |

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

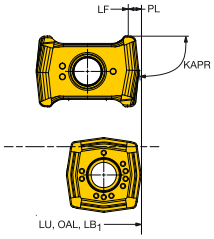
For the complete list of spare parts, visit www.sandvik.coromant.com

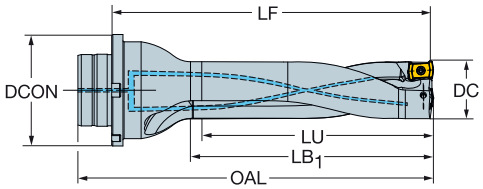
J37 L2 N22 N15

# CoroDrill® DS20 indexable insert drill

**Modular drill interface**

**Internal coolant supply**




## Metric design

| DC | | | 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 |

| DC | Spare parts<br>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 |

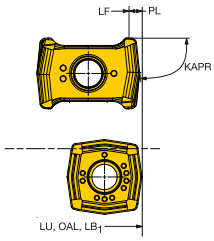
For the complete list of spare parts, visit www.sandvik.coromant.com

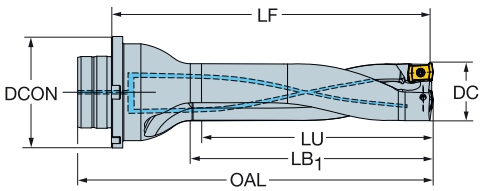
J37 L2 N22 N15

# CoroDrill® DS20 indexable insert drill

**Modular drill interface**

**Internal coolant supply**




## Inch design

| DC | | | LU | CZC$_{MS}$ | ADJLX | TCHAL | TCHAU | Ordering code | DCON$_{MS}$ | LF | OAL | LB$_1$ | PL | KAPR | PSI | LBS | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Dimensions, inch | | | | | | | | |
| .625 | 01C | 01P | 2.500 | MDI-20 | .030 | .000 | .011 | DS20-D1588DM20-04 | .787 | 3.613 | 4.222 | 2.611 | .018 | 81° | 145 | 0.399 | 22000 |
| | | | 4.375 | MDI-20 | .030 | -.004 | .016 | DS20-D1588DM20-07 | .787 | 5.488 | 6.097 | 4.486 | .018 | 81° | 145 | 0.478 | 7000 |
| .656 | 01C | 01P | 2.624 | MDI-20 | .023 | .000 | .011 | DS20-D1666DM20-04 | .787 | 3.735 | 4.344 | 2.735 | .018 | 81° | 145 | 0.414 | 21000 |
| | | | 4.592 | MDI-20 | .023 | -.004 | .016 | DS20-D1666DM20-07 | .787 | 5.703 | 6.312 | 4.703 | .018 | 81° | 145 | 0.507 | 7000 |
| .687 | 01C | 01P | 2.748 | MDI-25 | .015 | .000 | .011 | DS20-D1745DM25-04 | .984 | 4.007 | 4.616 | 2.859 | .018 | 81° | 145 | 0.643 | 21000 |
| | | | 4.809 | MDI-25 | .015 | -.004 | .016 | DS20-D1745DM25-07 | .984 | 6.068 | 6.677 | 4.920 | .018 | 81° | 145 | 0.749 | 7000 |
| .750 | 02C | 02P | 3.000 | MDI-25 | .041 | .000 | .013 | DS20-D1905DM25-04 | .984 | 4.258 | 4.871 | 3.119 | .022 | 81° | 145 | 0.685 | 19000 |
| | | | 5.250 | MDI-25 | .041 | -.004 | .016 | DS20-D1905DM25-07 | .984 | 6.508 | 7.121 | 5.369 | .022 | 81° | 145 | 0.822 | 6000 |
| .812 | 02C | 02P | 3.248 | MDI-25 | .026 | .000 | .013 | DS20-D2062DM25-04 | .984 | 4.501 | 5.114 | 3.367 | .022 | 81° | 145 | 0.734 | 17000 |
| | | | 5.684 | MDI-25 | .026 | -.004 | .016 | DS20-D2062DM25-07 | .984 | 6.937 | 7.550 | 5.803 | .022 | 81° | 145 | 0.908 | 6000 |
| .875 | 03C | 03P | 3.500 | MDI-25 | .057 | .000 | .013 | DS20-D2223DM25-04 | .984 | 4.751 | 5.368 | 3.626 | .026 | 81° | 145 | 0.793 | 16000 |
| | | | 6.125 | MDI-25 | .057 | -.004 | .016 | DS20-D2223DM25-07 | .984 | 7.376 | 7.993 | 6.251 | .026 | 81° | 145 | 1.009 | 5000 |
| .937 | 03C | 03P | 3.748 | MDI-25 | .044 | .000 | .013 | DS20-D2380DM25-04 | .984 | 4.994 | 5.611 | 3.874 | .026 | 81° | 145 | 0.859 | 15000 |
| | | | 6.559 | MDI-25 | .044 | -.004 | .016 | DS20-D2380DM25-07 | .984 | 7.805 | 8.422 | 6.685 | .026 | 81° | 145 | 1.124 | 5000 |
| 1.000 | 03C | 03P | 4.000 | MDI-25 | .032 | .000 | .013 | DS20-D2540DM25-04 | .984 | 5.241 | 5.858 | 4.126 | .026 | 81° | 145 | 0.881 | 14000 |
| | | | 7.000 | MDI-25 | .032 | -.004 | .016 | DS20-D2540DM25-07 | .984 | 8.241 | 8.858 | 7.126 | .026 | 81° | 145 | 1.258 | 4000 |
| 1.062 | 03C | 03P | 4.248 | MDI-32 | .020 | .000 | .013 | DS20-D2697DM32-04 | 1.260 | 5.721 | 6.338 | 4.374 | .026 | 81° | 145 | 1.485 | 13000 |
| | | | 7.434 | MDI-32 | .020 | -.004 | .016 | DS20-D2697DM32-07 | 1.260 | 8.907 | 9.524 | 7.560 | .026 | 81° | 145 | 1.871 | 4000 |
| 1.312 | 05C | 05P | 5.248 | MDI-40 | .091 | .000 | .014 | DS20-D3332DM40-04 | 1.575 | 7.074 | 7.704 | 5.402 | .039 | 81° | 145 | 2.872 | 11000 |
| | | | 9.184 | MDI-40 | .091 | -.004 | .016 | DS20-D3332DM40-07 | 1.575 | 11.010 | 11.640 | 9.338 | .039 | 81° | 145 | 3.602 | 3000 |
| 1.375 | 05C | 05P | 5.500 | MDI-40 | .076 | .000 | .014 | DS20-D3493DM40-04 | 1.575 | 7.321 | 7.951 | 5.654 | .039 | 81° | 145 | 3.020 | 10000 |
| | | | 9.625 | MDI-40 | .076 | -.004 | .016 | DS20-D3493DM40-07 | 1.575 | 11.446 | 12.076 | 9.779 | .039 | 81° | 145 | 3.858 | 3000 |
| 1.437 | 05C | 05P | 5.748 | MDI-40 | .061 | .000 | .014 | DS20-D3650DM40-04 | 1.575 | 7.565 | 8.195 | 5.902 | .039 | 81° | 145 | 3.176 | 10000 |
| | | | 10.059 | MDI-40 | .061 | -.004 | .016 | DS20-D3650DM40-07 | 1.575 | 11.876 | 12.506 | 10.213 | .039 | 81° | 145 | 4.135 | 3000 |
| 1.500 | 05C | 05P | 6.000 | MDI-40 | .046 | .000 | .014 | DS20-D3810DM40-04 | 1.575 | 7.812 | 8.442 | 6.154 | .039 | 81° | 145 | 3.351 | 9000 |
| | | | 10.500 | MDI-40 | .046 | -.004 | .016 | DS20-D3810DM40-07 | 1.575 | 12.312 | 12.942 | 10.654 | .039 | 81° | 145 | 4.442 | 3000 |
| 1.562 | 05C | 05P | 6.248 | MDI-40 | .031 | .000 | .014 | DS20-D3967DM40-04 | 1.575 | 8.055 | 8.685 | 6.402 | .039 | 81° | 145 | 3.538 | 9000 |
| | | | 10.934 | MDI-40 | .031 | -.004 | .016 | DS20-D3967DM40-07 | 1.575 | 12.741 | 13.371 | 11.088 | .039 | 81° | 145 | 4.768 | 3000 |

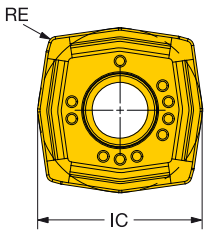
| DC" | Spare parts<br>Insert screw |
|---|---|
| .625-.687 | 5513 020-27 |
| .750-.812 | 5513 020-88 |
| .875-1.062 | 5513 020-58 |
| 1.312-1.562 | 416.1-833 |

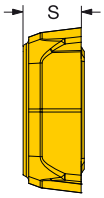
For the complete list of spare parts, visit www.sandvik.coromant.com

J37 L2 N22 N15

# CoroDrill® DS20 insert for drilling

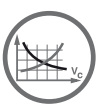
**Central insert**




| | INSUC | Ordering code | P | | | M | K | N | | S | | H | Dimensions, mm, inch | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | 1344 | | | 1144 | 1344 | H13A | 1344 | 1344 | H13A | 1344 | S | RE | IC |
| 01C | C | DS20-0104-C-L5 | ★ | | | ★ | | ★ | ☆ | ★ | ☆ | ★ | 2.30 | 0.35 | 6.0 |
| | | | | | | | | | | | | | *.091* | *.014* | *.237* |
| 01C | C | DS20-0104-C-M7 | ★ | | | | ★ | | | | | ☆ | 2.30 | 0.35 | 6.0 |
| | | | | | | | | | | | | | *.091* | *.014* | *.237* |
| 02C | C | DS20-0205-C-L5 | ★ | | | ★ | | ★ | ☆ | ★ | ☆ | ★ | 2.60 | 0.35 | 7.3 |
| | | | | | | | | | | | | | *.102* | *.014* | *.289* |
| 02C | C | DS20-0205-C-M7 | ★ | | | | ★ | | | | | ☆ | 2.60 | 0.35 | 7.3 |
| | | | | | | | | | | | | | *.102* | *.014* | *.289* |
| 03C | C | DS20-0306-C-L5 | ★ | | | ★ | | ★ | ☆ | ★ | ☆ | ★ | 3.00 | 0.35 | 8.9 |
| | | | | | | | | | | | | | *.118* | *.014* | *.350* |
| 03C | C | DS20-0306-C-M7 | ★ | | | | ★ | | | | | ☆ | 3.00 | 0.35 | 8.9 |
| | | | | | | | | | | | | | *.118* | *.014* | *.350* |
| 04C | C | DS20-0407-C-L5 | ★ | | | ★ | | ★ | ☆ | ★ | ☆ | ★ | 3.20 | 0.35 | 11.1 |
| | | | | | | | | | | | | | *.126* | *.014* | *.436* |
| 04C | C | DS20-0407-C-M7 | ★ | | | | ★ | | | | | ☆ | 3.20 | 0.35 | 11.1 |
| | | | | | | | | | | | | | *.126* | *.014* | *.436* |
| 05C | C | DS20-0508-C-L5 | ★ | | | ★ | | ★ | ☆ | ★ | ☆ | ★ | 3.50 | 0.35 | 13.4 |
| | | | | | | | | | | | | | *.138* | *.014* | *.526* |
| 05C | C | DS20-0508-C-M7 | ★ | | | | ★ | | | | | ☆ | 3.50 | 0.35 | 13.4 |
| | | | | | | | | | | | | | *.138* | *.014* | *.526* |

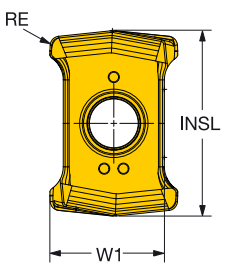
J29

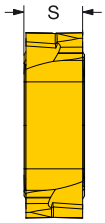

L2

N22

# CoroDrill® DS20 insert for drilling

**Peripheral insert**




| | INSUC | Ordering code | P | | | M | | | K | | | N | | S | | | H | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | 4324 | 4334 | 4344 | 2044 | 4334 | 4344 | 4324 | 4334 | 4344 | 4344 | H13A | 2044 | 4344 | H13A | 4334 | 4344 | S | RE | W1 | INSL |
| 01P | P | DS20-0104-P-H5W | | ☆ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 2.73 | 0.40 | 5.0 | 8.5 |
| | | | | | | | | | | | | | | | | | | | .107 | .016 | .197 | .335 |
| 01P | P | DS20-0104-P-L5W | ☆ | ★ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ☆ | | | | 2.73 | 0.40 | 5.0 | 8.5 |
| | | | | | | | | | | | | | | | | | | | .107 | .016 | .197 | .335 |
| 01P | P | DS20-0104-P-L6W | | | ☆ | | | ☆ | | | ☆ | ☆ | | | ★ | | | ★ | 2.73 | 0.40 | 5.0 | 8.5 |
| | | | | | | | | | | | | | | | | | | | .107 | .016 | .197 | .335 |
| 01P | P | DS20-0104-P-M7W | ☆ | ★ | ☆ | | | | ☆ | ★ | ☆ | | | | | | ☆ | ☆ | 2.73 | 0.40 | 5.0 | 8.5 |
| | | | | | | | | | | | | | | | | | | | .107 | .016 | .197 | .335 |
| 01P | P | DS20-0104-P-S5W | | | | | | ☆ | | | | ☆ | ★ | | ★ | ☆ | | | 2.73 | 0.40 | 5.0 | 8.5 |
| | | | | | | | | | | | | | | | | | | | .107 | .016 | .197 | .335 |
| 02P | P | DS20-0205-P-H5W | | ☆ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 3.10 | 0.50 | 6.1 | 9.8 |
| | | | | | | | | | | | | | | | | | | | .122 | .020 | .240 | .386 |
| 02P | P | DS20-0205-P-L5W | ☆ | ★ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ☆ | | | | 3.10 | 0.50 | 6.1 | 9.8 |
| | | | | | | | | | | | | | | | | | | | .122 | .020 | .240 | .386 |
| 02P | P | DS20-0205-P-L6W | | | ☆ | | | ☆ | | | ☆ | ☆ | | | ★ | | | ★ | 3.10 | 0.50 | 6.1 | 9.8 |
| | | | | | | | | | | | | | | | | | | | .122 | .020 | .240 | .386 |
| 02P | P | DS20-0205-P-M7W | ☆ | ★ | ☆ | | | | ☆ | ★ | ☆ | | | | | | ☆ | ☆ | 3.10 | 0.50 | 6.1 | 9.8 |
| | | | | | | | | | | | | | | | | | | | .122 | .020 | .240 | .386 |
| 02P | P | DS20-0205-P-S5W | | | | | | ☆ | | | | ☆ | ★ | | ★ | ☆ | | | 3.10 | 0.50 | 6.1 | 9.8 |
| | | | | | | | | | | | | | | | | | | | .122 | .020 | .240 | .386 |
| 03P | P | DS20-0306-P-H5W | | ☆ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 3.53 | 0.60 | 7.3 | 11.3 |
| | | | | | | | | | | | | | | | | | | | .139 | .024 | .289 | .445 |
| 03P | P | DS20-0306-P-L5W | ☆ | ★ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ☆ | | | | 3.53 | 0.60 | 7.3 | 11.3 |
| | | | | | | | | | | | | | | | | | | | .139 | .024 | .289 | .445 |
| 03P | P | DS20-0306-P-L6W | | | ☆ | | | ☆ | | | ☆ | ☆ | | | ★ | | | ★ | 3.53 | 0.60 | 7.3 | 11.3 |
| | | | | | | | | | | | | | | | | | | | .139 | .024 | .289 | .445 |
| 03P | P | DS20-0306-P-M7W | ☆ | ★ | ☆ | | | | ☆ | ★ | ☆ | | | | | | ☆ | ☆ | 3.53 | 0.60 | 7.3 | 11.3 |
| | | | | | | | | | | | | | | | | | | | .139 | .024 | .289 | .445 |
| 03P | P | DS20-0306-P-S5W | | | | | | ☆ | | | | ☆ | ★ | | ★ | ☆ | | | 3.53 | 0.60 | 7.3 | 11.3 |
| | | | | | | | | | | | | | | | | | | | .139 | .024 | .289 | .445 |
| 04P | P | DS20-0407-P-H5W | | ☆ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 4.25 | 0.70 | 9.2 | 13.4 |
| | | | | | | | | | | | | | | | | | | | .167 | .028 | .366 | .528 |
| 04P | P | DS20-0407-P-L5W | ☆ | ★ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ☆ | | | | 4.25 | 0.70 | 9.2 | 13.4 |
| | | | | | | | | | | | | | | | | | | | .167 | .028 | .366 | .528 |
| 04P | P | DS20-0407-P-L6W | | | ☆ | | | ☆ | | | ☆ | ☆ | | | ★ | | | ★ | 4.25 | 0.70 | 9.2 | 13.4 |
| | | | | | | | | | | | | | | | | | | | .167 | .028 | .366 | .528 |
| 04P | P | DS20-0407-P-M7W | ☆ | ★ | ☆ | | | | ☆ | ★ | ☆ | | | | | | ☆ | ☆ | 4.25 | 0.70 | 9.2 | 13.4 |
| | | | | | | | | | | | | | | | | | | | .167 | .028 | .366 | .528 |
| 04P | P | DS20-0407-P-S5W | | | | | | ☆ | | | | ☆ | ★ | | ★ | ☆ | | | 4.25 | 0.70 | 9.2 | 13.4 |
| | | | | | | | | | | | | | | | | | | | .167 | .028 | .366 | .528 |
| 05P | P | DS20-0508-P-H5W | | ☆ | ☆ | ☆ | ☆ | ☆ | | | | | | | | | | | 4.75 | 0.80 | 11.2 | 15.2 |
| | | | | | | | | | | | | | | | | | | | .187 | .031 | .443 | .598 |
| 05P | P | DS20-0508-P-L5W | ☆ | ★ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ☆ | | | | 4.75 | 0.80 | 11.2 | 15.2 |
| | | | | | | | | | | | | | | | | | | | .187 | .031 | .443 | .598 |
| 05P | P | DS20-0508-P-L6W | | | ☆ | | | ☆ | | | ☆ | ☆ | | | ★ | | | ★ | 4.75 | 0.80 | 11.2 | 15.2 |
| | | | | | | | | | | | | | | | | | | | .187 | .031 | .443 | .598 |
| 05P | P | DS20-0508-P-M7W | ☆ | ★ | ☆ | | | | ☆ | ★ | ☆ | | | | | | ☆ | ☆ | 4.75 | 0.80 | 11.2 | 15.2 |
| | | | | | | | | | | | | | | | | | | | .187 | .031 | .443 | .598 |
| 05P | P | DS20-0508-P-S5W | | | | | | ☆ | | | | ☆ | ★ | | ★ | ☆ | | | 4.75 | 0.80 | 11.2 | 15.2 |
| | | | | | | | | | | | | | | | | | | | .187 | .031 | .443 | .598 |

J29 L2 N22



SANDVIK Coromant

# CoroDrill® 880

## Indexable insert drills

**ISO application area:**

P M K N S H

**Benefits and features for hole diameters 12.00–63.50 mm (.500 - 2.5 inch)**

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

**Benefits and features for hole diameters 65.00–84.00 mm (2.560 - 3.307 inch)**

- 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 as a result of replaceable fixed cartridge system
- User-friendly, economical solution with exchangeable cartridges and indexable inserts

www.sandvik.coromant.com/corodrill880

**Drill bodies**

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

**Inserts**

- Inserts with optimized geometries for all materials

**Tolerances:**

**2 – 3 x DC**

| | | | |
|---|---|---|---|
| Diameter range, mm, inch | 12.00-43.99 (.500 - 1.750) | 44.00-52.99 (1.750 - 2.025) | 53.00-63.50 (2.125 - 2.500) |
| Hole tolerance, mm (inch) | 0/+0.25 (0/+.0098) | 0/+0.28 (0/+.0110) | 0/+0.30 (/+.0118) |

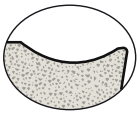
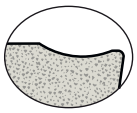
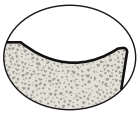
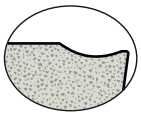
J41

J53

N6

# CoroDrill® 880

## Geometry overview

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

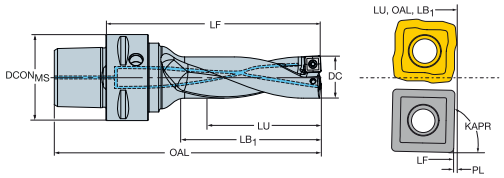
### H13A

- Uncoated grade

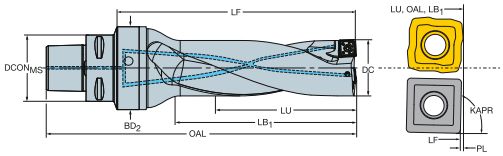
# CoroDrill® 880 indexable insert drill

**Coromant Capto® - Internal coolant supply**

DSGN 1




DSGN 2




## Metric design

| DC | | | LU | CZC$_{MS}$ | ADJLX | TCHAL | TCHAU | DSGN | Ordering code | Dimensions, mm 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 |

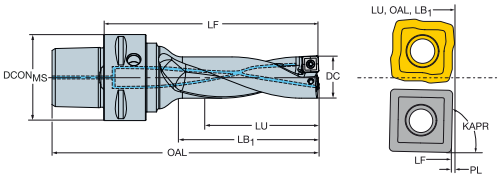
For the complete list of spare parts, visit www.sandvik.coromant.com

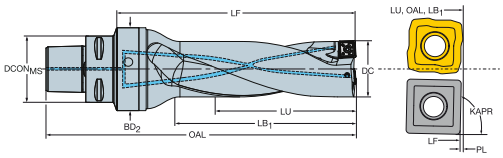
J53 L2 J86 J40 N22 N6 N15

# CoroDrill® 880 indexable insert drill

**Coromant Capto® - Internal coolant supply**

DSGN 1 2




## Metric design

| 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 |

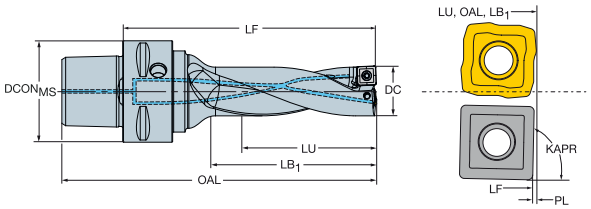
For the complete list of spare parts, visit www.sandvik.coromant.com

J53 L2 J86 J40 N22 N6 N15

# CoroDrill® 880 indexable insert drill

**Coromant Capto® - Internal coolant supply**

DSGN 1




## Inch design

| DC | | | LU | $CZC_{MS}$ | ADJLX | TCHAL | TCHAU | DSGN | Ordering code | Dimensions, inch $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | KAPR | PSI | LBS | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .625 | 02C | 02P | 1.875 | C4 | .009 | .000 | .010 | 1 | A880-D0625C4-03 | 1.575 | 3.339 | 4.297 | 2.008 | .013 | 88° | 145 | 0.824 | 33000 |
| .750 | 03C | 03P | 2.250 | C4 | .009 | .000 | .010 | 1 | A880-D0750C4-03 | 1.575 | 3.806 | 4.766 | 2.402 | .015 | 88° | 145 | 0.943 | 30000 |
| .812 | 04C | 04P | 2.436 | C4 | .031 | .000 | .010 | 1 | A880-D0812C4-03 | 1.575 | 4.037 | 4.999 | 2.598 | .017 | 88° | 145 | 0.881 | 21500 |
| .875 | 04C | 04P | 2.625 | C4 | .022 | .000 | .010 | 1 | A880-D0875C4-03 | 1.575 | 4.232 | 5.195 | 2.756 | .018 | 88° | 145 | 1.033 | 21500 |
| | | | 2.625 | C5 | .022 | .000 | .010 | 1 | A880-D0875C5-03 | 1.969 | 4.232 | 5.431 | 2.756 | .018 | 88° | 145 | 1.565 | 21500 |
| | | | 2.625 | C6 | .022 | .000 | .010 | 1 | A880-D0875C6-03 | 2.480 | 4.311 | 5.825 | 2.756 | .018 | 88° | 145 | 2.204 | 21500 |
| .937 | 04C | 04P | 2.811 | C4 | .013 | .000 | .010 | 1 | A880-D0937C4-03 | 1.575 | 4.466 | 5.429 | 2.953 | .018 | 88° | 145 | 0.967 | 21500 |
| | | | 2.811 | C5 | .013 | .000 | .010 | 1 | A880-D0937C5-03 | 1.969 | 4.466 | 5.665 | 2.953 | .018 | 88° | 145 | 1.587 | 21500 |
| | | | 2.811 | C6 | .013 | .000 | .010 | 1 | A880-D0937C6-03 | 2.480 | 4.545 | 6.059 | 2.953 | .018 | 88° | 145 | 2.392 | 21500 |
| 1.000 | 05C | 05P | 3.000 | C4 | .037 | .000 | .010 | 1 | A880-D1000C4-03 | 1.575 | 4.699 | 5.664 | 3.150 | .020 | 88° | 145 | 1.172 | 16000 |
| | | | 3.000 | C5 | .037 | .000 | .010 | 1 | A880-D1000C5-03 | 1.969 | 4.699 | 5.900 | 3.150 | .020 | 88° | 145 | 1.708 | 16000 |
| | | | 3.000 | C6 | .037 | .000 | .010 | 1 | A880-D1000C6-03 | 2.480 | 4.778 | 6.294 | 3.150 | .020 | 88° | 145 | 2.491 | 16000 |
| 1.062 | 05C | 05P | 3.186 | C4 | .029 | .000 | .010 | 1 | A880-D1062C4-03 | 1.575 | 4.892 | 5.896 | 3.307 | .021 | 88° | 145 | 1.102 | 16000 |
| 1.125 | 05C | 05P | 3.375 | C4 | .019 | .000 | .010 | 1 | A880-D1125C4-03 | 1.575 | 5.127 | 6.133 | 3.504 | .021 | 88° | 145 | 1.461 | 16000 |
| | | | 3.375 | C6 | .019 | .000 | .010 | 1 | A880-D1125C6-03 | 2.480 | 5.206 | 6.723 | 3.504 | .021 | 88° | 145 | 2.760 | 16000 |
| 1.187 | 06C | 06P | 3.561 | C4 | .043 | .000 | .010 | 1 | A880-D1187C4-03 | 1.575 | 5.358 | 6.330 | 3.700 | .023 | 88° | 145 | 1.499 | 16000 |
| 1.250 | 06C | 06P | 3.750 | C5 | .035 | .000 | .010 | 1 | A880-D1250C5-03 | 1.969 | 5.593 | 6.798 | 3.898 | .024 | 88° | 145 | 2.226 | 16000 |
| | | | 3.750 | C6 | .035 | .000 | .010 | 1 | A880-D1250C6-03 | 2.480 | 5.672 | 7.192 | 3.898 | .024 | 88° | 145 | 2.998 | 16000 |
| 1.500 | 07C | 07P | 4.500 | C5 | .043 | .000 | .010 | 1 | A880-D1500C5-03 | 1.969 | 6.488 | 7.696 | 4.646 | .027 | 88° | 145 | 2.645 | 16000 |
| | | | 4.500 | C6 | .043 | .000 | .010 | 1 | A880-D1500C6-03 | 2.480 | 6.567 | 8.090 | 4.646 | .027 | 88° | 145 | 3.571 | 16000 |
| 1.562 | 07C | 07P | 4.686 | C5 | .036 | .000 | .010 | 1 | A880-D1562C5-03 | 1.969 | 6.721 | 7.930 | 4.843 | .028 | 88° | 145 | 2.934 | 16000 |
| | | | 4.686 | C6 | .036 | .000 | .010 | 1 | A880-D1562C6-03 | 2.480 | 6.800 | 8.324 | 4.843 | .028 | 88° | 145 | 3.723 | 16000 |
| 1.687 | 07C | 07P | 5.061 | C6 | .020 | .000 | .010 | 1 | A880-D1687C6-03 | 2.480 | 7.976 | 9.501 | 5.236 | .029 | 88° | 145 | 5.467 | 16000 |

| | | Spare parts |
|---|---|---|
| DC | | Insert screw |
| .625 | 02 | 5513 020-28 |
| .750 | 03 | 5513 020-33 |
| .875-.937 | 04 | 5513 020-58 |
| 1.000-1.125 | 05 | 5513 020-57 |
| 1.187-1.687 | 06-07 | 416.1-833 |

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

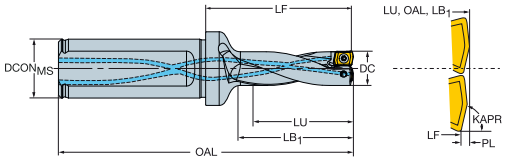
J53 L2 J86 J40 N22 N6 N15

# CoroDrill® 880 indexable insert drill

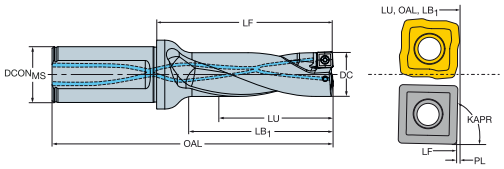
**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**

SSC=01




SSC=02 - 09




## Metric design

| | | | | | | | | | Dimensions, mm | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DC | | | LU | $CZC_{MS}$ | ADJLX | TCHAL | TCHAU | Ordering code | $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | KAPR | BAR | KG | RPMX |
| 12.00 | 01C | 01P | 24.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1200L20-02 | 20.00 | 38.61 | 89.00 | 27.00 | 0.38 | 79° | 10 | 0.189 | 33000 |
| | | | 36.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1200L20-03 | 20.00 | 50.61 | 101.00 | 39.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| 12.50 | 01C | 01P | 25.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1250L20-02 | 20.00 | 40.61 | 91.00 | 28.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| | | | 38.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1250L20-03 | 20.00 | 52.61 | 103.00 | 40.00 | 0.38 | 79° | 10 | 0.198 | 33000 |
| 12.70 | 01C | 01P | 25.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1270L20-02 | 20.00 | 40.61 | 91.00 | 28.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| | | | 38.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1270L20-03 | 20.00 | 53.61 | 104.00 | 41.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| 13.00 | 01C | 01P | 26.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1300L20-02 | 20.00 | 41.61 | 92.00 | 29.00 | 0.38 | 79° | 10 | 0.194 | 33000 |
| | | | 39.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1300L20-03 | 20.00 | 54.61 | 105.00 | 42.00 | 0.38 | 79° | 10 | 0.202 | 33000 |
| 13.50 | 01C | 01P | 27.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1350L20-02 | 20.00 | 42.61 | 93.00 | 30.00 | 0.38 | 79° | 10 | 0.200 | 33000 |
| | | | 41.00 | 20 | 0.25 | 0.00 | 0.25 | 880-D1350L20-03 | 20.00 | 55.61 | 106.00 | 43.00 | 0.38 | 79° | 10 | 0.204 | 33000 |
| 14.00 | 02C | 02P | 28.00 | 20 | 0.50 | 0.00 | 0.25 | 880-D1400L20-02 | 20.00 | 43.67 | 94.00 | 31.00 | 0.32 | 88° | 10 | 0.200 | 33000 |
| | | | 42.00 | 20 | 0.50 | 0.00 | 0.25 | 880-D1400L20-03 | 20.00 | 57.67 | 108.00 | 45.00 | 0.32 | 88° | 10 | 0.211 | 33000 |
| 14.50 | 02C | 02P | 29.00 | 20 | 0.45 | 0.00 | 0.25 | 880-D1450L20-02 | 20.00 | 45.67 | 96.00 | 32.00 | 0.32 | 88° | 10 | 0.210 | 33000 |
| | | | 44.00 | 20 | 0.45 | 0.00 | 0.25 | 880-D1450L20-03 | 20.00 | 59.67 | 110.00 | 46.00 | 0.32 | 88° | 10 | 0.217 | 33000 |
| 15.00 | 02C | 02P | 30.00 | 20 | 0.40 | 0.00 | 0.25 | 880-D1500L20-02 | 20.00 | 46.67 | 97.00 | 33.00 | 0.32 | 88° | 10 | 0.212 | 33000 |
| | | | 45.00 | 20 | 0.40 | 0.00 | 0.25 | 880-D1500L20-03 | 20.00 | 61.67 | 112.00 | 48.00 | 0.32 | 88° | 10 | 0.210 | 33000 |
| 15.50 | 02C | 02P | 31.00 | 20 | 0.30 | 0.00 | 0.25 | 880-D1550L20-02 | 20.00 | 48.66 | 99.00 | 35.00 | 0.33 | 88° | 10 | 0.208 | 33000 |
| | | | 47.00 | 20 | 0.30 | 0.00 | 0.25 | 880-D1550L20-03 | 20.00 | 63.66 | 114.00 | 50.00 | 0.33 | 88° | 10 | 0.225 | 33000 |
| 16.00 | 02C | 02P | 32.00 | 20 | 0.30 | 0.00 | 0.25 | 880-D1600L20-02 | 20.00 | 50.66 | 101.00 | 36.00 | 0.33 | 88° | 10 | 0.215 | 33000 |
| | | | 48.00 | 20 | 0.30 | 0.00 | 0.25 | 880-D1600L20-03 | 20.00 | 65.66 | 116.00 | 51.00 | 0.33 | 88° | 10 | 0.229 | 33000 |
| 16.50 | 03C | 03P | 33.00 | 20 | 0.60 | 0.00 | 0.25 | 880-D1650L20-02 | 20.00 | 51.63 | 102.00 | 37.00 | 0.36 | 88° | 10 | 0.224 | 33000 |
| | | | 50.00 | 20 | 0.60 | 0.00 | 0.25 | 880-D1650L20-03 | 20.00 | 67.63 | 118.00 | 53.00 | 0.36 | 88° | 10 | 0.235 | 30000 |
| 17.00 | 03C | 03P | 34.00 | 20 | 0.60 | 0.00 | 0.25 | 880-D1700L20-02 | 20.00 | 52.63 | 103.00 | 38.00 | 0.36 | 88° | 10 | 0.225 | 33000 |
| | | | 51.00 | 20 | 0.60 | 0.00 | 0.25 | 880-D1700L20-03 | 20.00 | 68.63 | 119.00 | 54.00 | 0.36 | 88° | 10 | 0.232 | 30000 |
| 17.50 | 03C | 03P | 35.00 | 25 | 0.50 | 0.00 | 0.25 | 880-D1750L25-02 | 25.00 | 54.62 | 111.00 | 39.00 | 0.37 | 88° | 10 | 0.347 | 33000 |
| | | | 53.00 | 25 | 0.50 | 0.00 | 0.25 | 880-D1750L25-03 | 25.00 | 71.62 | 128.00 | 56.00 | 0.37 | 88° | 10 | 0.362 | 30000 |
| 18.00 | 03C | 03P | 36.00 | 25 | 0.40 | 0.00 | 0.25 | 880-D1800L25-02 | 25.00 | 55.62 | 112.00 | 40.00 | 0.37 | 88° | 10 | 0.352 | 33000 |
| | | | 54.00 | 25 | 0.40 | 0.00 | 0.25 | 880-D1800L25-03 | 25.00 | 72.62 | 129.00 | 57.00 | 0.37 | 88° | 10 | 0.363 | 30000 |
| 18.50 | 03C | 03P | 37.00 | 25 | 0.40 | 0.00 | 0.25 | 880-D1850L25-02 | 25.00 | 56.62 | 113.00 | 41.00 | 0.37 | 88° | 10 | 0.354 | 33000 |
| | | | 56.00 | 25 | 0.40 | 0.00 | 0.25 | 880-D1850L25-03 | 25.00 | 74.62 | 131.00 | 59.00 | 0.37 | 88° | 10 | 0.369 | 30000 |
| 19.00 | 03C | 03P | 38.00 | 25 | 0.30 | 0.00 | 0.25 | 880-D1900L25-02 | 25.00 | 57.61 | 114.00 | 42.00 | 0.38 | 88° | 10 | 0.359 | 33000 |
| | | | 57.00 | 25 | 0.30 | 0.00 | 0.25 | 880-D1900L25-03 | 25.00 | 75.61 | 132.00 | 60.00 | 0.38 | 88° | 10 | 0.375 | 30000 |
| 19.50 | 03C | 03P | 39.00 | 25 | 0.30 | 0.00 | 0.25 | 880-D1950L25-02 | 25.00 | 59.61 | 116.00 | 43.00 | 0.38 | 88° | 10 | 0.371 | 33000 |
| | | | 59.00 | 25 | 0.30 | 0.00 | 0.25 | 880-D1950L25-03 | 25.00 | 78.61 | 135.00 | 62.00 | 0.38 | 88° | 10 | 0.387 | 30000 |
| 20.00 | 04C | 04P | 40.00 | 25 | 0.90 | 0.00 | 0.25 | 880-D2000L25-02 | 25.00 | 60.56 | 117.00 | 44.00 | 0.43 | 88° | 10 | 0.367 | 21500 |
| | | | 60.00 | 25 | 0.90 | 0.00 | 0.25 | 880-D2000L25-03 | 25.00 | 80.56 | 137.00 | 64.00 | 0.43 | 88° | 10 | 0.340 | 21500 |
| 20.50 | 04C | 04P | 62.00 | 25 | 0.80 | 0.00 | 0.25 | 880-D2050L25-03 | 25.00 | 81.56 | 138.00 | 65.00 | 0.43 | 88° | 10 | 0.392 | 21500 |
| 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 |

J53 L2 J86 J40 N22 N6 N15

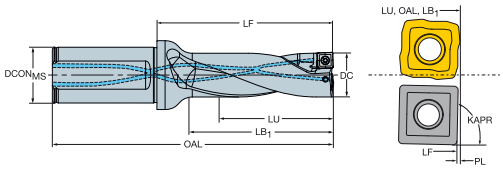


SANDVIK Coromant

# CoroDrill® 880 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**

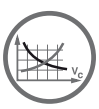



## Metric design

| DC | | | LU | $CZC_{MS}$ | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, mm | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | KAPR | BAR | KG | RPMX |
| 25.50 | 05C | 05P | 77.00 | 25 | 0.90 | 0.00 | 0.25 | 880-D2550L25-03 | 25.00 | 99.48 | 156.00 | 80.00 | 0.51 | 88° | 10 | 0.501 | 16000 |
| 26.00 | 05C | 05P | 52.00 | 32 | 0.90 | 0.00 | 0.25 | 880-D2600L32-02 | 32.00 | 76.47 | 137.00 | 56.00 | 0.52 | 88° | 10 | 0.650 | 16000 |
| | | | 78.00 | 32 | 0.90 | 0.00 | 0.25 | 880-D2600L32-03 | 32.00 | 101.47 | 162.00 | 81.00 | 0.52 | 88° | 10 | 0.700 | 16000 |
| 26.40 | 05C | 05P | 79.00 | 32 | 0.80 | 0.00 | 0.25 | 880-D2640L32-03 | 32.00 | 103.47 | 164.00 | 83.00 | 0.52 | 88° | 10 | 0.707 | 16000 |
| 26.50 | 05C | 05P | 80.00 | 32 | 0.80 | 0.00 | 0.25 | 880-D2650L32-03 | 32.00 | 103.47 | 164.00 | 83.00 | 0.52 | 88° | 10 | 0.717 | 16000 |
| 27.00 | 05C | 05P | 54.00 | 32 | 0.70 | 0.00 | 0.25 | 880-D2700L32-02 | 32.00 | 78.46 | 139.00 | 58.00 | 0.53 | 88° | 10 | 0.669 | 16000 |
| | | | 81.00 | 32 | 0.70 | 0.00 | 0.25 | 880-D2700L32-03 | 32.00 | 104.46 | 165.00 | 84.00 | 0.53 | 88° | 10 | 0.724 | 16000 |
| 27.50 | 05C | 05P | 83.00 | 32 | 0.60 | 0.00 | 0.25 | 880-D2750L32-03 | 32.00 | 107.46 | 168.00 | 86.00 | 0.53 | 88° | 10 | 0.761 | 16000 |
| 28.00 | 05C | 05P | 56.00 | 32 | 0.60 | 0.00 | 0.25 | 880-D2800L32-02 | 32.00 | 81.46 | 142.00 | 60.00 | 0.53 | 88° | 10 | 0.693 | 16000 |
| | | | 84.00 | 32 | 0.60 | 0.00 | 0.25 | 880-D2800L32-03 | 32.00 | 108.46 | 169.00 | 87.00 | 0.53 | 88° | 10 | 0.755 | 16000 |
| 28.50 | 05C | 05P | 86.00 | 32 | 0.50 | 0.00 | 0.25 | 880-D2850L32-03 | 32.00 | 110.45 | 171.00 | 89.00 | 0.54 | 88° | 10 | 0.770 | 16000 |
| 29.00 | 05C | 05P | 58.00 | 32 | 0.50 | 0.00 | 0.25 | 880-D2900L32-02 | 32.00 | 83.45 | 144.00 | 62.00 | 0.54 | 88° | 10 | 0.710 | 16000 |
| | | | 87.00 | 32 | 0.50 | 0.00 | 0.25 | 880-D2900L32-03 | 32.00 | 111.45 | 172.00 | 90.00 | 0.54 | 88° | 10 | 0.784 | 16000 |
| 29.40 | 05C | 05P | 88.00 | 32 | 0.40 | 0.00 | 0.25 | 880-D2940L32-03 | 32.00 | 114.44 | 175.00 | 92.00 | 0.55 | 88° | 10 | 0.845 | 16000 |
| 29.50 | 05C | 05P | 89.00 | 32 | 0.40 | 0.00 | 0.25 | 880-D2950L32-03 | 32.00 | 114.44 | 175.00 | 92.00 | 0.55 | 88° | 10 | 0.809 | 16000 |
| 30.00 | 06C | 06P | 60.00 | 32 | 1.12 | 0.00 | 0.25 | 880-D3000L32-02 | 32.00 | 86.41 | 147.00 | 64.00 | 0.58 | 88° | 10 | 0.699 | 16000 |
| | | | 90.00 | 32 | 1.12 | 0.00 | 0.25 | 880-D3000L32-03 | 32.00 | 116.41 | 177.00 | 94.00 | 0.58 | 88° | 10 | 0.790 | 16000 |
| 30.50 | 06C | 06P | 92.00 | 32 | 1.05 | 0.00 | 0.25 | 880-D3050L32-03 | 32.00 | 117.40 | 178.00 | 95.00 | 0.59 | 88° | 10 | 0.800 | 16000 |
| 31.00 | 06C | 06P | 62.00 | 40 | 0.99 | 0.00 | 0.25 | 880-D3100L40-02 | 40.00 | 89.40 | 160.00 | 66.00 | 0.59 | 88° | 10 | 1.136 | 16000 |
| | | | 93.00 | 40 | 0.99 | 0.00 | 0.25 | 880-D3100L40-03 | 40.00 | 120.40 | 191.00 | 97.00 | 0.59 | 88° | 10 | 1.210 | 16000 |
| 31.50 | 06C | 06P | 95.00 | 40 | 0.93 | 0.00 | 0.25 | 880-D3150L40-03 | 40.00 | 121.39 | 192.00 | 98.00 | 0.60 | 88° | 10 | 1.230 | 16000 |
| 32.00 | 06C | 06P | 64.00 | 40 | 0.87 | 0.00 | 0.25 | 880-D3200L40-02 | 40.00 | 91.39 | 162.00 | 68.00 | 0.60 | 88° | 10 | 1.156 | 16000 |
| | | | 96.00 | 40 | 0.87 | 0.00 | 0.25 | 880-D3200L40-03 | 40.00 | 123.39 | 194.00 | 100.00 | 0.60 | 88° | 10 | 1.252 | 16000 |
| 32.50 | 06C | 06P | 98.00 | 40 | 0.81 | 0.00 | 0.25 | 880-D3250L40-03 | 40.00 | 125.39 | 196.00 | 101.00 | 0.60 | 88° | 10 | 1.278 | 16000 |
| 33.00 | 06C | 06P | 66.00 | 40 | 0.75 | 0.00 | 0.25 | 880-D3300L40-02 | 40.00 | 94.38 | 165.00 | 70.00 | 0.61 | 88° | 10 | 1.200 | 16000 |
| | | | 99.00 | 40 | 0.75 | 0.00 | 0.25 | 880-D3300L40-03 | 40.00 | 127.38 | 198.00 | 103.00 | 0.61 | 88° | 10 | 1.303 | 16000 |
| 33.50 | 06C | 06P | 101.00 | 40 | 0.68 | 0.00 | 0.25 | 880-D3350L40-03 | 40.00 | 129.38 | 200.00 | 105.00 | 0.61 | 88° | 10 | 1.317 | 16000 |
| 34.00 | 06C | 06P | 68.00 | 40 | 0.62 | 0.00 | 0.25 | 880-D3400L40-02 | 40.00 | 97.37 | 168.00 | 73.00 | 0.62 | 88° | 10 | 1.227 | 16000 |
| | | | 102.00 | 40 | 0.62 | 0.00 | 0.25 | 880-D3400L40-03 | 40.00 | 130.37 | 201.00 | 106.00 | 0.62 | 88° | 10 | 1.340 | 16000 |
| 34.50 | 06C | 06P | 104.00 | 40 | 0.56 | 0.00 | 0.25 | 880-D3450L40-03 | 40.00 | 133.37 | 204.00 | 108.00 | 0.62 | 88° | 10 | 1.380 | 16000 |
| 35.00 | 06C | 06P | 70.00 | 40 | 0.50 | 0.00 | 0.25 | 880-D3500L40-02 | 40.00 | 100.37 | 171.00 | 75.00 | 0.62 | 88° | 10 | 1.270 | 16000 |
| | | | 105.00 | 40 | 0.50 | 0.00 | 0.25 | 880-D3500L40-03 | 40.00 | 134.37 | 205.00 | 109.00 | 0.62 | 88° | 10 | 1.400 | 16000 |
| 35.50 | 06C | 06P | 107.00 | 40 | 0.44 | 0.00 | 0.25 | 880-D3550L40-03 | 40.00 | 136.36 | 207.00 | 111.00 | 0.63 | 88° | 10 | 1.415 | 16000 |
| 36.00 | 07C | 07C | 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 |

J53

L2


J86

J40

N22

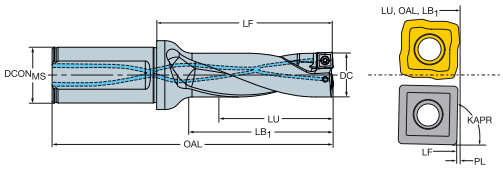
N6

N15

# CoroDrill® 880 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**




## Metric design

| DC | | | LU | $CZC_{MS}$ | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, mm $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | KAPR | BAR | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 46.00 | 08C | 08P | 92.00 | 40 | 1.30 | 0.00 | 0.28 | 880-D4600L40-02 | 40.00 | 129.22 | 200.00 | 97.00 | 0.78 | 88° | 10 | 1.610 | 15000 |
| | | | 138.00 | 40 | 1.30 | 0.00 | 0.28 | 880-D4600L40-03 | 40.00 | 175.22 | 246.00 | 143.00 | 0.78 | 88° | 10 | 1.881 | 15000 |
| 47.00 | 08C | 08P | 94.00 | 40 | 1.10 | 0.00 | 0.28 | 880-D4700L40-02 | 40.00 | 131.21 | 202.00 | 99.00 | 0.78 | 88° | 10 | 1.800 | 15000 |
| | | | 141.00 | 40 | 1.10 | 0.00 | 0.28 | 880-D4700L40-03 | 40.00 | 178.21 | 249.00 | 146.00 | 0.78 | 88° | 10 | 2.140 | 15000 |
| 48.00 | 08C | 08P | 96.00 | 40 | 1.00 | 0.00 | 0.28 | 880-D4800L40-02 | 40.00 | 134.20 | 205.00 | 101.00 | 0.79 | 88° | 10 | 1.925 | 15000 |
| | | | 144.00 | 40 | 1.00 | 0.00 | 0.28 | 880-D4800L40-03 | 40.00 | 182.20 | 253.00 | 149.00 | 0.79 | 88° | 10 | 2.235 | 15000 |
| 49.00 | 08C | 08P | 98.00 | 40 | 0.90 | 0.00 | 0.28 | 880-D4900L40-02 | 40.00 | 136.19 | 207.00 | 103.00 | 0.80 | 88° | 10 | 1.970 | 15000 |
| | | | 147.00 | 40 | 0.90 | 0.00 | 0.28 | 880-D4900L40-03 | 40.00 | 185.19 | 256.00 | 152.00 | 0.80 | 88° | 10 | 2.275 | 15000 |
| 50.00 | 08C | 08P | 100.00 | 40 | 0.80 | 0.00 | 0.28 | 880-D5000L40-02 | 40.00 | 139.18 | 210.00 | 105.00 | 0.81 | 88° | 10 | 2.031 | 15000 |
| | | | 150.00 | 40 | 0.80 | 0.00 | 0.28 | 880-D5000L40-03 | 40.00 | 189.18 | 260.00 | 155.00 | 0.81 | 88° | 10 | 2.430 | 15000 |
| 51.00 | 08C | 08P | 102.00 | 40 | 0.60 | 0.00 | 0.28 | 880-D5100L40-02 | 40.00 | 143.18 | 214.00 | 108.00 | 0.82 | 88° | 10 | 2.110 | 15000 |
| | | | 153.00 | 40 | 0.60 | 0.00 | 0.28 | 880-D5100L40-03 | 40.00 | 193.18 | 264.00 | 158.00 | 0.82 | 88° | 10 | 2.480 | 15000 |
| 52.00 | 08C | 08P | 104.00 | 40 | 0.50 | 0.00 | 0.28 | 880-D5200L40-02 | 40.00 | 145.17 | 216.00 | 110.00 | 0.82 | 88° | 10 | 2.180 | 15000 |
| | | | 156.00 | 40 | 0.50 | 0.00 | 0.28 | 880-D5200L40-03 | 40.00 | 196.17 | 267.00 | 161.00 | 0.82 | 88° | 10 | 2.595 | 15000 |
| 53.00 | 09C | 09P | 106.00 | 40 | 2.00 | 0.00 | 0.30 | 880-D5300L40-02 | 40.00 | 148.12 | 219.00 | 112.00 | 0.87 | 88° | 10 | 2.307 | 5000 |
| | | | 159.00 | 40 | 2.00 | 0.00 | 0.30 | 880-D5300L40-03 | 40.00 | 200.12 | 271.00 | 164.00 | 0.87 | 88° | 10 | 2.600 | 5000 |
| 54.00 | 09C | 09P | 108.00 | 40 | 1.90 | 0.00 | 0.30 | 880-D5400L40-02 | 40.00 | 150.11 | 221.00 | 114.00 | 0.88 | 88° | 10 | 2.380 | 5000 |
| | | | 162.00 | 40 | 1.90 | 0.00 | 0.30 | 880-D5400L40-03 | 40.00 | 203.11 | 274.00 | 167.00 | 0.88 | 88° | 10 | 2.714 | 5000 |
| 55.00 | 09C | 09P | 110.00 | 40 | 1.70 | 0.00 | 0.30 | 880-D5500L40-02 | 40.00 | 153.10 | 224.00 | 116.00 | 0.89 | 88° | 10 | 2.349 | 5000 |
| | | | 165.00 | 40 | 1.70 | 0.00 | 0.30 | 880-D5500L40-03 | 40.00 | 208.10 | 279.00 | 171.00 | 0.89 | 88° | 10 | 2.850 | 5000 |
| 56.00 | 09C | 09P | 112.00 | 40 | 1.60 | 0.00 | 0.30 | 880-D5600L40-02 | 40.00 | 156.10 | 227.00 | 118.00 | 0.89 | 88° | 10 | 2.451 | 5000 |
| | | | 168.00 | 40 | 1.60 | 0.00 | 0.30 | 880-D5600L40-03 | 40.00 | 212.10 | 283.00 | 174.00 | 0.89 | 88° | 10 | 2.977 | 5000 |
| 57.00 | 09C | 09P | 114.00 | 40 | 1.50 | 0.00 | 0.30 | 880-D5700L40-02 | 40.00 | 158.09 | 229.00 | 120.00 | 0.90 | 88° | 10 | 2.530 | 5000 |
| | | | 171.00 | 40 | 1.50 | 0.00 | 0.30 | 880-D5700L40-03 | 40.00 | 215.09 | 286.00 | 177.00 | 0.90 | 88° | 10 | 3.120 | 5000 |
| 58.00 | 09C | 09P | 116.00 | 40 | 1.40 | 0.00 | 0.30 | 880-D5800L40-02 | 40.00 | 161.08 | 232.00 | 122.00 | 0.91 | 88° | 10 | 2.650 | 5000 |
| | | | 174.00 | 40 | 1.40 | 0.00 | 0.30 | 880-D5800L40-03 | 40.00 | 219.08 | 290.00 | 180.00 | 0.91 | 88° | 10 | 3.593 | 5000 |
| 59.00 | 09C | 09P | 118.00 | 40 | 1.20 | 0.00 | 0.30 | 880-D5900L40-02 | 40.00 | 163.07 | 234.00 | 124.00 | 0.92 | 88° | 10 | 2.703 | 5000 |
| | | | 177.00 | 40 | 1.20 | 0.00 | 0.30 | 880-D5900L40-03 | 40.00 | 222.07 | 293.00 | 183.00 | 0.92 | 88° | 10 | 3.346 | 5000 |
| 60.00 | 09C | 09P | 120.00 | 40 | 1.10 | 0.00 | 0.30 | 880-D6000L40-02 | 40.00 | 166.06 | 237.00 | 126.00 | 0.93 | 88° | 10 | 2.820 | 5000 |
| | | | 180.00 | 40 | 1.10 | 0.00 | 0.30 | 880-D6000L40-03 | 40.00 | 226.06 | 297.00 | 186.00 | 0.93 | 88° | 10 | 3.570 | 5000 |
| 61.00 | 09C | 09P | 122.00 | 40 | 1.00 | 0.00 | 0.30 | 880-D6100L40-02 | 40.00 | 170.06 | 241.00 | 129.00 | 0.93 | 88° | 10 | 3.032 | 5000 |
| | | | 183.00 | 40 | 1.00 | 0.00 | 0.30 | 880-D6100L40-03 | 40.00 | 231.06 | 302.00 | 190.00 | 0.93 | 88° | 10 | 4.039 | 5000 |
| 62.00 | 09C | 09P | 124.00 | 40 | 0.80 | 0.00 | 0.30 | 880-D6200L40-02 | 40.00 | 172.05 | 243.00 | 131.00 | 0.94 | 88° | 10 | 3.020 | 5000 |
| | | | 186.00 | 40 | 0.80 | 0.00 | 0.30 | 880-D6200L40-03 | 40.00 | 234.05 | 305.00 | 193.00 | 0.94 | 88° | 10 | 4.115 | 5000 |
| 63.00 | 09C | 09P | 126.00 | 40 | 0.70 | 0.00 | 0.30 | 880-D6300L40-02 | 40.00 | 175.04 | 246.00 | 133.00 | 0.95 | 88° | 10 | 3.173 | 5000 |
| | | | 189.00 | 40 | 0.70 | 0.00 | 0.30 | 880-D6300L40-03 | 40.00 | 238.04 | 309.00 | 196.00 | 0.95 | 88° | 10 | 4.300 | 5000 |

| 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 the complete list of spare parts, visit www.sandvik.coromant.com

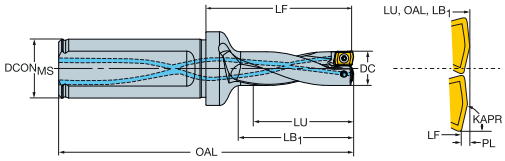
J53 L2 J86 J40 N22 N6 N15

# CoroDrill® 880 indexable insert drill

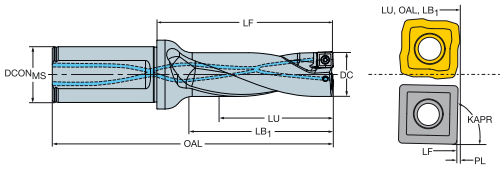
**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**

SSC=01




SSC=02 - 09




## Inch design

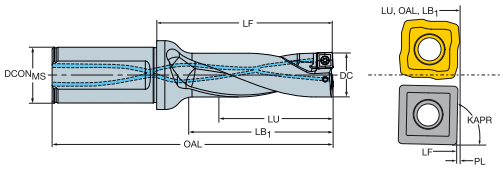
| DC | | | LU | $CZC_{MS}$ | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, inch $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | KAPR | PSI | LBS | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .500 | 01C | 01P | 1.000 | 3/4 | .009 | .000 | .010 | A880-D0500LX19-02 | .750 | 1.567 | 3.551 | 1.100 | .015 | 79° | 145 | 0.427 | 33000 |
| | | | 1.500 | 3/4 | .009 | .000 | .010 | A880-D0500LX19-03 | .750 | 2.067 | 4.051 | 1.600 | .015 | 79° | 145 | 0.427 | 33000 |
| .531 | 01C | 01P | 1.062 | 3/4 | .009 | .000 | .010 | A880-D0531LX19-02 | .750 | 1.653 | 3.637 | 1.168 | .015 | 79° | 145 | 0.425 | 33000 |
| | | | 1.593 | 3/4 | .009 | .000 | .010 | A880-D0531LX19-03 | .750 | 2.184 | 4.168 | 1.699 | .015 | 79° | 145 | 0.427 | 33000 |
| .562 | 02C | 02P | 1.124 | 3/4 | .017 | .000 | .010 | A880-D0562LX19-02 | .750 | 1.743 | 3.725 | 1.237 | .013 | 88° | 145 | 0.427 | 33000 |
| | | | 1.686 | 3/4 | .017 | .000 | .010 | A880-D0562LX19-03 | .750 | 2.317 | 4.299 | 1.811 | .013 | 88° | 145 | 0.440 | 33000 |
| .625 | 02C | 02P | 1.250 | 3/4 | .009 | .000 | .010 | A880-D0625LX19-02 | .750 | 1.919 | 3.901 | 1.375 | .013 | 88° | 145 | 0.453 | 33000 |
| | | | 1.875 | 3/4 | .009 | .000 | .010 | A880-D0625LX19-03 | .750 | 2.552 | 4.534 | 2.008 | .013 | 88° | 145 | 0.467 | 33000 |
| .656 | 03C | 03P | 1.312 | 3/4 | .022 | .000 | .010 | A880-D0656LX19-02 | .750 | 2.004 | 3.987 | 1.443 | .014 | 88° | 145 | 0.429 | 33000 |
| | | | 1.968 | 3/4 | .022 | .000 | .010 | A880-D0656LX19-03 | .750 | 2.687 | 4.669 | 2.126 | .014 | 88° | 145 | 0.617 | 30000 |
| .687 | 03C | 03P | 1.374 | 1 | .020 | .000 | .010 | A880-D0687LX25-02 | 1.000 | 2.077 | 4.297 | 1.498 | .015 | 88° | 145 | 0.782 | 33000 |
| | | | 2.061 | 1 | .020 | .000 | .010 | A880-D0687LX25-03 | 1.000 | 2.784 | 5.004 | 2.205 | .015 | 88° | 145 | 0.822 | 30000 |
| .750 | 03C | 03P | 1.500 | 1 | .009 | .000 | .010 | A880-D0750LX25-02 | 1.000 | 2.252 | 4.472 | 1.635 | .015 | 88° | 145 | 0.811 | 33000 |
| | | | 2.250 | 1 | .009 | .000 | .010 | A880-D0750LX25-03 | 1.000 | 3.019 | 5.239 | 2.402 | .015 | 88° | 145 | 0.848 | 30000 |
| .812 | 04C | 04P | 1.624 | 1 | .031 | .000 | .010 | A880-D0812LX25-02 | 1.000 | 2.422 | 4.644 | 1.770 | .017 | 88° | 145 | 0.856 | 21500 |
| | | | 2.436 | 1 | .031 | .000 | .010 | A880-D0812LX25-03 | 1.000 | 3.250 | 5.472 | 2.598 | .017 | 88° | 145 | 0.908 | 21500 |
| .875 | 04C | 04P | 1.750 | 1 | .022 | .000 | .010 | A880-D0875LX25-02 | 1.000 | 2.618 | 4.841 | 1.929 | .018 | 88° | 145 | 0.890 | 21500 |
| | | | 2.625 | 1 | .022 | .000 | .010 | A880-D0875LX25-03 | 1.000 | 3.445 | 5.668 | 2.756 | .018 | 88° | 145 | 0.943 | 21500 |
| .937 | 04C | 04P | 1.874 | 1 | .013 | .000 | .010 | A880-D0937LX25-02 | 1.000 | 2.769 | 4.992 | 2.043 | .018 | 88° | 145 | 0.992 | 21500 |
| | | | 2.811 | 1 | .013 | .000 | .010 | A880-D0937LX25-03 | 1.000 | 3.679 | 5.902 | 2.953 | .018 | 88° | 145 | 0.970 | 21500 |
| 1.000 | 05C | 05P | 2.000 | 1 | .037 | .000 | .010 | A880-D1000LX25-02 | 1.000 | 2.942 | 5.167 | 2.180 | .020 | 88° | 145 | 1.014 | 16000 |
| | | | 3.000 | 1 | .037 | .000 | .010 | A880-D1000LX25-03 | 1.000 | 3.912 | 6.137 | 3.150 | .020 | 88° | 145 | 1.093 | 16000 |
| 1.062 | 05C | 05P | 2.124 | 1 1/4 | .029 | .000 | .010 | A880-D1062LX31-02 | 1.250 | 3.081 | 5.464 | 2.283 | .021 | 88° | 145 | 1.461 | 16000 |
| | | | 3.186 | 1 1/4 | .029 | .000 | .010 | A880-D1062LX31-03 | 1.250 | 4.143 | 6.526 | 3.345 | .021 | 88° | 145 | 1.587 | 16000 |
| 1.125 | 05C | 05P | 2.250 | 1 1/4 | .019 | .000 | .010 | A880-D1125LX31-02 | 1.250 | 3.276 | 5.659 | 2.440 | .021 | 88° | 145 | 1.587 | 16000 |
| | | | 3.375 | 1 1/4 | .019 | .000 | .010 | A880-D1125LX31-03 | 1.250 | 4.380 | 6.763 | 3.544 | .021 | 88° | 145 | 1.587 | 16000 |
| 1.187 | 06C | 06P | 2.374 | 1 1/4 | .043 | .000 | .010 | A880-D1187LX31-02 | 1.250 | 3.388 | 5.773 | 2.517 | .023 | 88° | 145 | 1.556 | 16000 |
| | | | 3.561 | 1 1/4 | .043 | .000 | .010 | A880-D1187LX31-03 | 1.250 | 4.575 | 6.960 | 3.704 | .023 | 88° | 145 | 1.719 | 16000 |
| 1.250 | 06C | 06P | 2.500 | 1 1/2 | .035 | .000 | .010 | A880-D1250LX38-02 | 1.500 | 3.558 | 6.338 | 2.650 | .024 | 88° | 145 | 2.380 | 16000 |
| | | | 3.750 | 1 1/2 | .035 | .000 | .010 | A880-D1250LX38-03 | 1.500 | 4.808 | 7.588 | 3.900 | .024 | 88° | 145 | 2.566 | 16000 |
| 1.312 | 06C | 06P | 2.624 | 1 1/2 | .027 | .000 | .010 | A880-D1312LX38-02 | 1.500 | 3.727 | 6.507 | 2.782 | .024 | 88° | 145 | 2.493 | 16000 |
| | | | 3.936 | 1 1/2 | .027 | .000 | .010 | A880-D1312LX38-03 | 1.500 | 5.039 | 7.819 | 4.094 | .024 | 88° | 145 | 2.733 | 16000 |
| 1.375 | 06C | 06P | 2.750 | 1 1/2 | .020 | .000 | .010 | A880-D1375LX38-02 | 1.500 | 3.897 | 6.678 | 2.915 | .025 | 88° | 145 | 3.104 | 16000 |
| | | | 4.125 | 1 1/2 | .020 | .000 | .010 | A880-D1375LX38-03 | 1.500 | 5.272 | 8.053 | 4.290 | .025 | 88° | 145 | 2.921 | 16000 |
| 1.437 | 07C | 07P | 2.874 | 1 1/2 | .051 | .000 | .010 | A880-D1437LX38-02 | 1.500 | 4.064 | 6.847 | 3.047 | .027 | 88° | 145 | 2.689 | 16000 |
| | | | 4.311 | 1 1/2 | .051 | .000 | .010 | A880-D1437LX38-03 | 1.500 | 5.500 | 8.283 | 4.483 | .027 | 88° | 145 | 2.967 | 16000 |
| 1.500 | 07C | 07P | 3.000 | 1 1/2 | .043 | .000 | .010 | A880-D1500LX38-02 | 1.500 | 4.205 | 6.988 | 3.150 | .027 | 88° | 145 | 2.821 | 16000 |
| | | | 4.500 | 1 1/2 | .043 | .000 | .010 | A880-D1500LX38-03 | 1.500 | 5.705 | 8.488 | 4.650 | .027 | 88° | 145 | 3.157 | 16000 |
| 1.562 | 07C | 07P | 3.124 | 1 1/2 | .036 | .000 | .010 | A880-D1562LX38-02 | 1.500 | 4.371 | 7.155 | 3.280 | .028 | 88° | 145 | 3.064 | 16000 |
| | | | 4.686 | 1 1/2 | .036 | .000 | .010 | A880-D1562LX38-03 | 1.500 | 5.933 | 8.717 | 4.842 | .028 | 88° | 145 | 3.333 | 16000 |
| 1.625 | 07C | 07P | 3.250 | 1 1/2 | .028 | .000 | .010 | A880-D1625LX38-02 | 1.500 | 4.542 | 7.326 | 3.413 | .028 | 88° | 145 | 3.128 | 16000 |
| | | | 4.875 | 1 1/2 | .028 | .000 | .010 | A880-D1625LX38-03 | 1.500 | 6.166 | 8.950 | 5.037 | .028 | 88° | 145 | 3.562 | 16000 |
| 1.687 | 07C | 07P | 3.374 | 1 1/2 | .020 | .000 | .010 | A880-D1687LX38-02 | 1.500 | 4.708 | 7.493 | 3.543 | .029 | 88° | 145 | 3.258 | 16000 |
| | | | 5.061 | 1 1/2 | .020 | .000 | .010 | A880-D1687LX38-03 | 1.500 | 6.394 | 9.179 | 5.229 | .029 | 88° | 145 | 3.814 | 16000 |
| 1.750 | 08C | 08P | 3.500 | 1 1/2 | .056 | .000 | .012 | A880-D1750LX38-02 | 1.500 | 4.877 | 7.663 | 3.675 | .030 | 88° | 145 | 3.218 | 15000 |
| | | | 5.250 | 1 1/2 | .056 | .000 | .012 | A880-D1750LX38-03 | 1.500 | 6.627 | 9.413 | 5.425 | .030 | 88° | 145 | 3.710 | 15000 |
| 1.875 | 08C | 08P | 3.750 | 1 1/2 | .041 | .000 | .012 | A880-D1875LX38-02 | 1.500 | 5.214 | 8.001 | 3.938 | .031 | 88° | 145 | 4.239 | 15000 |
| | | | 5.625 | 1 1/2 | .041 | .000 | .012 | A880-D1875LX38-03 | 1.500 | 7.089 | 9.876 | 5.813 | .031 | 88° | 145 | 4.834 | 15000 |
| 2.000 | 08C | 08P | 4.000 | 1 1/2 | .025 | .000 | .012 | A880-D2000LX38-02 | 1.500 | 5.550 | 8.338 | 4.200 | .032 | 88° | 145 | 4.541 | 15000 |
| | | | 6.000 | 1 1/2 | .025 | .000 | .012 | A880-D2000LX38-03 | 1.500 | 7.550 | 10.338 | 6.200 | .032 | 88° | 145 | 5.312 | 15000 |
| 2.125 | 09C | 09P | 4.250 | 1 1/2 | .073 | .000 | .012 | A880-D2125LX38-02 | 1.500 | 5.885 | 8.676 | 4.463 | .035 | 88° | 145 | 4.823 | 5000 |
| | | | 6.375 | 1 1/2 | .073 | .000 | .012 | A880-D2125LX38-03 | 1.500 | 8.010 | 10.801 | 6.588 | .035 | 88° | 145 | 5.800 | 5000 |

J53 L2 J86 J40 N22 N6 N15

# CoroDrill® 880 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**




## Inch design

| DC | | | LU | $CZC_{MS}$ | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, inch $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | KAPR | PSI | LBS | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.250 | 09C | 09P | 4.500 | 1 1/2 | .060 | .000 | .012 | **A880-D2250LX38-02** | 1.500 | 6.221 | 9.013 | 4.725 | .036 | 88° | 145 | 5.423 | 5000 |
| | | | 6.750 | 1 1/2 | .060 | .000 | .012 | **A880-D2250LX38-03** | 1.500 | 8.471 | 11.263 | 6.975 | .036 | 88° | 145 | 6.715 | 5000 |
| 2.375 | 09C | 09P | 4.750 | 1 1/2 | .041 | .000 | .012 | **A880-D2375LX38-02** | 1.500 | 6.558 | 9.351 | 4.988 | .037 | 88° | 145 | 6.170 | 5000 |
| | | | 7.125 | 1 1/2 | .041 | .000 | .012 | **A880-D2375LX38-03** | 1.500 | 8.933 | 11.726 | 7.363 | .037 | 88° | 145 | 7.758 | 5000 |
| 2.500 | 09C | 09P | 5.000 | 1 1/2 | .025 | .000 | .012 | **A880-D2500LX38-02** | 1.500 | 6.894 | 9.688 | 5.250 | .038 | 88° | 145 | 6.887 | 5000 |
| | | | 7.500 | 1 1/2 | .025 | .000 | .012 | **A880-D2500LX38-03** | 1.500 | 9.394 | 12.188 | 7.750 | .038 | 88° | 145 | 9.259 | 5000 |

| | Spare parts |
|---|---|
| DC | Insert screw |
| .500-.625 | 5513 020-28 |
| .656-.750 | 5513 020-33 |
| .812-.937 | 5513 020-58 |
| 1.000-1.125 | 5513 020-57 |
| 1.187-1.687 | 416.1-833 |
| 1.750-2.500 | 416.1-834 |

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

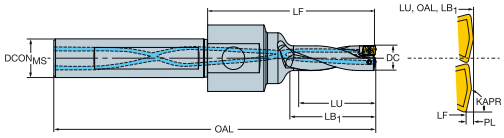
J53 L2 J86 J40 N22 N6 N15

# CoroDrill® 880 indexable insert drill

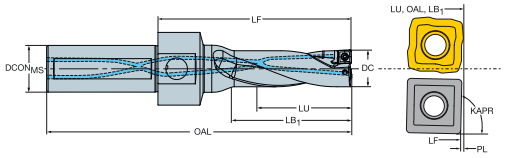
**Cylindrical shank with flat, US P shank**

**Internal coolant supply**

A880..Pxx (SSC=01)




A880..Pxx (SSC=02 - 09)




## Inch design

| DC | | | LU | $CZC_{MS}$ | ADJLX | TCHAL | TCHAU | Ordering code | Dimensions, inch $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | KAPR | PSI | LBS | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .500 | 01C | 01P | 1.500 | 3/4 | .009 | .000 | .010 | A880-D0500P19-03 | .750 | 3.248 | 6.263 | 1.600 | .015 | 79° | 145 | 0.906 | 33000 |
| | | | 2.000 | 3/4 | .009 | .000 | .016 | A880-D0500P19-04 | .750 | 3.748 | 6.763 | 2.100 | .015 | 79° | 145 | 0.908 | 22000 |
| .531 | 01C | 01P | 1.593 | 3/4 | .009 | .000 | .010 | A880-D0531P19-03 | .750 | 3.365 | 6.380 | 1.699 | .015 | 79° | 145 | 0.925 | 33000 |
| | | | 2.124 | 3/4 | .009 | .000 | .016 | A880-D0531P19-04 | .750 | 3.896 | 6.911 | 2.230 | .015 | 79° | 145 | 0.837 | 22000 |
| .562 | 02C | 02P | 1.686 | 3/4 | .017 | .000 | .010 | A880-D0562P19-03 | .750 | 3.498 | 6.511 | 1.811 | .013 | 88° | 145 | 0.945 | 33000 |
| | | | 2.248 | 3/4 | .017 | .000 | .016 | A880-D0562P19-04 | .750 | 4.050 | 7.062 | 2.362 | .012 | 88° | 145 | 0.950 | 22000 |
| .625 | 02C | 02P | 1.875 | 3/4 | .009 | .000 | .010 | A880-D0625P19-03 | .750 | 3.733 | 6.746 | 2.008 | .013 | 88° | 145 | 1.005 | 33000 |
| .656 | 03C | 03P | 1.968 | 3/4 | .022 | .000 | .010 | A880-D0656P19-03 | .750 | 3.829 | 6.843 | 2.126 | .014 | 88° | 145 | 0.978 | 30000 |
| .687 | 03C | 03P | 2.061 | 1 | .020 | .000 | .010 | A880-D0687P25-03 | 1.000 | 4.044 | 7.059 | 2.205 | .015 | 88° | 145 | 1.779 | 30000 |
| .750 | 03C | 03P | 2.250 | 1 | .009 | .000 | .010 | A880-D0750P25-03 | 1.000 | 4.278 | 7.293 | 2.402 | .015 | 88° | 145 | 1.803 | 30000 |
| .812 | 04C | 04P | 2.436 | 1 | .031 | .000 | .010 | A880-D0812P25-03 | 1.000 | 4.510 | 7.527 | 2.598 | .017 | 88° | 145 | 1.851 | 21500 |
| .875 | 04C | 04P | 2.625 | 1 1/4 | .022 | .000 | .010 | A880-D0875P31-03 | 1.250 | 4.704 | 7.722 | 2.756 | .018 | 88° | 145 | 2.238 | 21500 |
| .937 | 04C | 04P | 2.811 | 1 1/4 | .013 | .000 | .010 | A880-D0937P31-03 | 1.250 | 4.939 | 7.957 | 2.953 | .018 | 88° | 145 | 2.218 | 21500 |
| 1.000 | 05C | 05P | 3.000 | 1 1/4 | .037 | .000 | .010 | A880-D1000P31-03 | 1.250 | 5.171 | 8.191 | 3.150 | .020 | 88° | 145 | 2.407 | 16000 |
| 1.062 | 05C | 05P | 3.186 | 1 1/4 | .029 | .000 | .010 | A880-D1062P31-03 | 1.250 | 5.365 | 8.386 | 3.345 | .021 | 88° | 145 | 2.552 | 16000 |
| 1.125 | 05C | 05P | 3.375 | 1 1/4 | .019 | .000 | .010 | A880-D1125P31-03 | 1.250 | 5.599 | 8.620 | 3.544 | .021 | 88° | 145 | 2.667 | 16000 |
| 1.187 | 06C | 06P | 3.561 | 1 1/4 | .043 | .000 | .010 | A880-D1187P31-03 | 1.250 | 5.831 | 8.854 | 3.700 | .023 | 88° | 145 | 2.921 | 16000 |
| 1.250 | 06C | 06P | 3.750 | 1 1/2 | .035 | .000 | .010 | A880-D1250P38-03 | 1.500 | 6.065 | 9.089 | 3.898 | .024 | 88° | 145 | 3.705 | 16000 |
| 1.312 | 06C | 06P | 3.936 | 1 1/2 | .027 | .000 | .010 | A880-D1312P38-03 | 1.500 | 6.300 | 9.324 | 4.095 | .024 | 88° | 145 | 3.891 | 16000 |
| 1.375 | 06C | 06P | 4.125 | 1 1/2 | .020 | .000 | .010 | A880-D1375P38-03 | 1.500 | 6.532 | 9.557 | 4.291 | .025 | 88° | 145 | 4.019 | 16000 |
| 1.437 | 07C | 07P | 4.311 | 1 1/2 | .051 | .000 | .010 | A880-D1437P38-03 | 1.500 | 6.765 | 9.792 | 4.488 | .027 | 88° | 145 | 3.880 | 16000 |
| 1.500 | 07C | 07P | 4.500 | 1 1/2 | .043 | .000 | .010 | A880-D1500P38-03 | 1.500 | 6.960 | 9.987 | 4.646 | .027 | 88° | 145 | 4.254 | 16000 |
| 1.562 | 07C | 07P | 4.686 | 1 1/2 | .036 | .000 | .010 | A880-D1562P38-03 | 1.500 | 7.194 | 10.222 | 4.843 | .028 | 88° | 145 | 4.411 | 16000 |
| 1.625 | 07C | 07P | 4.875 | 1 1/2 | .028 | .000 | .010 | A880-D1625P38-03 | 1.500 | 7.427 | 10.455 | 5.039 | .028 | 88° | 145 | 4.645 | 16000 |
| 1.687 | 07C | 07P | 5.061 | 1 1/2 | .020 | .000 | .010 | A880-D1687P38-03 | 1.500 | 7.857 | 10.886 | 5.236 | .029 | 88° | 145 | 6.702 | 16000 |
| 1.750 | 08C | 08P | 5.250 | 1 1/2 | .056 | .000 | .011 | A880-D1750P38-03 | 1.500 | 8.091 | 11.121 | 5.433 | .030 | 88° | 145 | 6.834 | 15000 |
| 1.875 | 08C | 08P | 5.625 | 1 1/2 | .041 | .000 | .011 | A880-D1875P38-03 | 1.500 | 8.559 | 11.590 | 5.827 | .031 | 88° | 145 | 7.414 | 15000 |
| 2.000 | 08C | 08P | 6.000 | 1 1/2 | .025 | .000 | .011 | A880-D2000P38-03 | 1.500 | 9.026 | 12.058 | 6.220 | .032 | 88° | 145 | 8.068 | 15000 |
| 2.125 | 09C | 09P | 6.375 | 1 1/2 | .073 | .000 | .012 | A880-D2125P38-03 | 1.500 | 9.453 | 12.488 | 6.575 | .035 | 88° | 145 | 8.377 | 5000 |
| 2.250 | 09C | 09P | 6.750 | 1 1/2 | .060 | .000 | .012 | A880-D2250P38-03 | 1.500 | 9.921 | 12.957 | 6.969 | .036 | 88° | 145 | 9.259 | 5000 |
| 2.375 | 09C | 09P | 7.125 | 1 1/2 | .041 | .000 | .012 | A880-D2375P38-03 | 1.500 | 10.389 | 13.426 | 7.363 | .037 | 88° | 145 | 10.185 | 5000 |
| 2.500 | 09C | 09P | 7.500 | 1 1/2 | .025 | .000 | .012 | A880-D2500P38-03 | 1.500 | 10.850 | 13.888 | 7.750 | .038 | 88° | 145 | 11.320 | 5000 |

| | | Spare parts | | |
|---|---|---|---|---|
| DC | | Insert screw | Plug | Plug |
| .500-.531 | 01 | 5513 020-28 | 1/4 NPT | |
| .562-.625 | 02 | 5513 020-28 | 1/4 NPT | |
| .656 | 03 | 5513 020-33 | 1/4 NPT | |
| .687-.750 | 03 | 5513 020-33 | 3/8 NPT | |
| .812 | 04 | 5513 020-58 | 3/8 NPT | |
| .875-.937 | 04 | 5513 020-58 | 3/8 NPT | 1/2 NPT |
| 1.000-1.125 | 05 | 5513 020-57 | 3/8 NPT | 1/2 NPT |
| 1.187 | 06 | 416.1-833 | 3/8 NPT | 1/2 NPT |
| 1.250-1.375 | 06 | 416.1-833 | 3/8 NPT | 3/4 NPT |
| 1.437-1.625 | 07 | 416.1-833 | 3/8 NPT | 3/4 NPT |
| 1.687 | 07 | 416.1-833 | 1/2 NPT | 3/4 NPT |
| 1.750-2.125 | 08 | 416.1-834 | 1/2 NPT | 3/4 NPT |
| 2.125-2.500 | 09 | 416.1-834 | 1/2 NPT | 3/4 NPT |

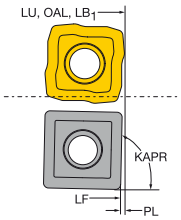
For the complete list of spare parts, visit www.sandvik.coromant.com

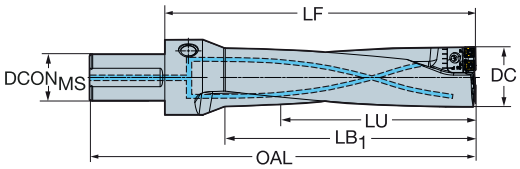
J53 L2 J86 J40 N22 N6 N15

# CoroDrill® 880 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**




## Metric shank

| DC | CIIP | | | | LU | $CZC_{MS}$ | TCHAL | TCHAU | Ordering code | Dimensions, mm DCON | LF | OAL | $LB_1$ | PL | KAPR | BAR | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 65.00 | 06C | 06P | 06P | 06P | 207.00 | 50 | -0.30 | 0.30 | 880-D0650L50-03 | 50.00 | 275.70 | 357.00 | 212.77 | 1.30 | 88° | 10 | 8.495 | 5000 |
| | | | | | 276.00 | 50 | -0.30 | 0.30 | 880-D0650L50-04 | 50.00 | 344.70 | 426.00 | 281.77 | 1.30 | 88° | 10 | 10.125 | 5000 |
| 66.00 | 06C | 06P | 06P | 06P | 207.00 | 50 | -0.30 | 0.30 | 880-D0660L50-03 | 50.00 | 275.70 | 357.00 | 212.77 | 1.30 | 88° | 10 | 8.470 | 5000 |
| | | | | | 276.00 | 50 | -0.30 | 0.30 | 880-D0660L50-04 | 50.00 | 344.70 | 426.00 | 281.77 | 1.30 | 88° | 10 | 7.900 | 5000 |
| 67.00 | 06C | 06P | 06P | 06P | 207.00 | 50 | -0.30 | 0.30 | 880-D0670L50-03 | 50.00 | 275.70 | 357.00 | 212.77 | 1.30 | 88° | 10 | 8.305 | 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 |

Cartridges are included, inserts are sold separately

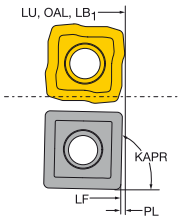
For spare parts, visit www.sandvik.coromant.com

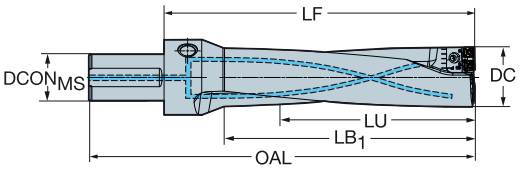
J53 L2 J86 J40 N22 N6 N15 J101

# CoroDrill® 880 indexable insert drill

**Cylindrical shank with flat according to ISO 9766**

**Internal coolant supply**




## Inch shank

| | | | | | | | | | | Dimensions, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DC | C | I | I | P | LU | $CZC_{MS}$ | TCHAL | TCHAU | Ordering code | $DCON_{MS}$ | LF | OAL | $LB_1$ | PL | KAPR | PSI | LBS | RPMX |
| 2.559 | 06C | 06P | 06P | 06P | 8.149 | 2 | -.012 | .012 | 880-D0650LX50-03 | 2.000 | 10.854 | 14.055 | 8.377 | .051 | 88° | 145 | 15.873 | 5000 |
| | | | | | 10.866 | 2 | -.012 | .012 | 880-D0650LX50-04 | 2.000 | 13.571 | 16.772 | 11.093 | .051 | 88° | 145 | 17.416 | 5000 |
| 2.598 | 06C | 06P | 06P | 06P | 8.149 | 2 | -.012 | .012 | 880-D0660LX50-03 | 2.000 | 10.854 | 14.055 | 8.377 | .051 | 88° | 145 | 15.873 | 5000 |
| | | | | | 10.866 | 2 | -.012 | .012 | 880-D0660LX50-04 | 2.000 | 13.571 | 16.772 | 11.093 | .051 | 88° | 145 | 17.416 | 5000 |
| 2.637 | 06C | 06P | 06P | 06P | 8.149 | 2 | -.012 | .012 | 880-D0670LX50-03 | 2.000 | 10.854 | 14.055 | 8.377 | .051 | 88° | 145 | 15.873 | 5000 |
| | | | | | 10.866 | 2 | -.012 | .012 | 880-D0670LX50-04 | 2.000 | 13.571 | 16.772 | 11.093 | .051 | 88° | 145 | 17.416 | 5000 |
| 2.677 | 06C | 06P | 06P | 06P | 8.149 | 2 | -.012 | .012 | 880-D0680LX50-03 | 2.000 | 10.854 | 14.055 | 8.377 | .051 | 88° | 145 | 15.873 | 5000 |
| | | | | | 10.866 | 2 | -.012 | .012 | 880-D0680LX50-04 | 2.000 | 13.571 | 16.772 | 11.093 | .051 | 88° | 145 | 19.841 | 5000 |
| 2.716 | 06C | 06P | 06P | 06P | 8.149 | 2 | -.012 | .012 | 880-D0690LX50-03 | 2.000 | 10.854 | 14.055 | 8.377 | .051 | 88° | 145 | 15.873 | 5000 |
| | | | | | 10.866 | 2 | -.012 | .012 | 880-D0690LX50-04 | 2.000 | 13.571 | 16.772 | 11.093 | .051 | 88° | 145 | 17.416 | 5000 |
| 2.755 | 06C | 06P | 06P | 06P | 8.740 | 2 | -.012 | .012 | 880-D0700LX50-03 | 2.000 | 11.835 | 15.039 | 9.828 | .055 | 88° | 145 | 16.975 | 5000 |
| | | | | | 11.653 | 2 | -.012 | .012 | 880-D0700LX50-04 | 2.000 | 14.748 | 17.953 | 12.741 | .055 | 88° | 145 | 22.487 | 5000 |
| 2.795 | 06C | 06P | 06P | 06P | 8.740 | 2 | -.012 | .012 | 880-D0710LX50-03 | 2.000 | 11.835 | 15.039 | 9.828 | .055 | 88° | 145 | 19.621 | 5000 |
| | | | | | 11.653 | 2 | -.012 | .012 | 880-D0710LX50-04 | 2.000 | 14.748 | 17.953 | 12.741 | .055 | 88° | 145 | 22.487 | 5000 |
| 2.834 | 06C | 06P | 06P | 06P | 8.740 | 2 | -.012 | .012 | 880-D0720LX50-03 | 2.000 | 11.835 | 15.039 | 9.828 | .055 | 88° | 145 | 19.621 | 5000 |
| | | | | | 11.653 | 2 | -.012 | .012 | 880-D0720LX50-04 | 2.000 | 14.748 | 17.953 | 12.741 | .055 | 88° | 145 | 22.487 | 5000 |
| 2.874 | 06C | 06P | 06P | 06P | 8.740 | 2 | -.012 | .012 | 880-D0730LX50-03 | 2.000 | 11.835 | 15.039 | 9.828 | .055 | 88° | 145 | 15.211 | 5000 |
| | | | | | 11.653 | 2 | -.012 | .012 | 880-D0730LX50-04 | 2.000 | 14.748 | 17.953 | 12.741 | .055 | 88° | 145 | 20.408 | 5000 |
| 2.913 | 06C | 06P | 07P | 07P | 8.740 | 2 | -.012 | .012 | 880-D0740LX50-03 | 2.000 | 11.835 | 15.039 | 9.828 | .055 | 88° | 145 | 19.621 | 5000 |
| | | | | | 11.653 | 2 | -.012 | .012 | 880-D0740LX50-04 | 2.000 | 14.748 | 17.953 | 12.741 | .055 | 88° | 145 | 22.487 | 5000 |
| 2.952 | 07C | 07P | 07P | 07P | 9.330 | 2 | -.012 | .012 | 880-D0750LX50-03 | 2.000 | 12.032 | 15.236 | 10.045 | .055 | 88° | 145 | 18.739 | 5000 |
| | | | | | 12.440 | 2 | -.012 | .012 | 880-D0750LX50-04 | 2.000 | 15.142 | 18.347 | 13.156 | .055 | 88° | 145 | 27.998 | 5000 |
| 2.992 | 07C | 07P | 07P | 07P | 9.330 | 2 | -.012 | .012 | 880-D0760LX50-03 | 2.000 | 12.032 | 15.236 | 10.045 | .055 | 88° | 145 | 18.827 | 5000 |
| | | | | | 12.440 | 2 | -.012 | .012 | 880-D0760LX50-04 | 2.000 | 15.142 | 18.347 | 13.156 | .055 | 88° | 145 | 23.159 | 5000 |
| 3.031 | 07C | 07P | 07P | 07P | 9.330 | 2 | -.012 | .012 | 880-D0770LX50-03 | 2.000 | 12.032 | 15.236 | 10.045 | .055 | 88° | 145 | 23.589 | 5000 |
| | | | | | 12.440 | 2 | -.012 | .012 | 880-D0770LX50-04 | 2.000 | 15.142 | 18.347 | 13.156 | .055 | 88° | 145 | 27.998 | 5000 |
| 3.070 | 07C | 07P | 07P | 07P | 9.330 | 2 | -.012 | .012 | 880-D0780LX50-03 | 2.000 | 12.032 | 15.236 | 10.045 | .055 | 88° | 145 | 23.589 | 5000 |
| | | | | | 12.440 | 2 | -.012 | .012 | 880-D0780LX50-04 | 2.000 | 15.142 | 18.347 | 13.156 | .055 | 88° | 145 | 27.998 | 5000 |
| 3.110 | 07C | 07P | 07P | 07P | 9.330 | 2 | -.012 | .012 | 880-D0790LX50-03 | 2.000 | 12.032 | 15.236 | 10.045 | .055 | 88° | 145 | 23.589 | 5000 |
| | | | | | 12.440 | 2 | -.012 | .012 | 880-D0790LX50-04 | 2.000 | 15.142 | 18.347 | 13.156 | .055 | 88° | 145 | 22.965 | 5000 |
| 3.149 | 07C | 07P | 07P | 07P | 9.921 | 2 1/2 | -.012 | .012 | 880-D0800LX63-03 | 2.500 | 13.012 | 17.071 | 11.323 | .059 | 88° | 145 | 30.137 | 5000 |
| | | | | | 13.228 | 2 1/2 | -.012 | .012 | 880-D0800LX63-04 | 2.500 | 16.319 | 20.378 | 14.630 | .059 | 88° | 145 | 36.376 | 5000 |
| 3.188 | 07C | 07P | 07P | 07P | 9.921 | 2 1/2 | -.012 | .012 | 880-D0810LX63-03 | 2.500 | 13.012 | 17.071 | 11.323 | .059 | 88° | 145 | 24.433 | 5000 |
| | | | | | 13.228 | 2 1/2 | -.012 | .012 | 880-D0810LX63-04 | 2.500 | 16.319 | 20.378 | 14.630 | .059 | 88° | 145 | 33.289 | 5000 |
| 3.228 | 07C | 07P | 07P | 07P | 9.921 | 2 1/2 | -.012 | .012 | 880-D0820LX63-03 | 2.500 | 13.012 | 17.071 | 11.323 | .059 | 88° | 145 | 27.998 | 5000 |
| | | | | | 13.228 | 2 1/2 | -.012 | .012 | 880-D0820LX63-04 | 2.500 | 16.319 | 20.378 | 14.630 | .059 | 88° | 145 | 33.289 | 5000 |
| 3.267 | 07C | 07P | 07P | 07P | 9.921 | 2 1/2 | -.012 | .012 | 880-D0830LX63-03 | 2.500 | 13.012 | 17.071 | 11.323 | .059 | 88° | 145 | 27.998 | 5000 |
| | | | | | 13.228 | 2 1/2 | -.012 | .012 | 880-D0830LX63-04 | 2.500 | 16.319 | 20.378 | 14.630 | .059 | 88° | 145 | 33.289 | 5000 |
| 3.307 | 07C | 07P | 07P | 07P | 9.921 | 2 1/2 | -.012 | .012 | 880-D0840LX63-03 | 2.500 | 13.012 | 17.071 | 11.323 | .059 | 88° | 145 | 29.519 | 5000 |
| | | | | | 13.228 | 2 1/2 | -.012 | .012 | 880-D0840LX63-04 | 2.500 | 16.319 | 20.378 | 14.630 | .059 | 88° | 145 | 33.796 | 5000 |

Cartridges are included, inserts are sold separately

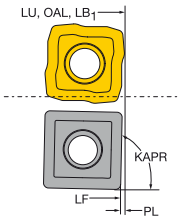
For spare parts, visit www.sandvik.coromant.com

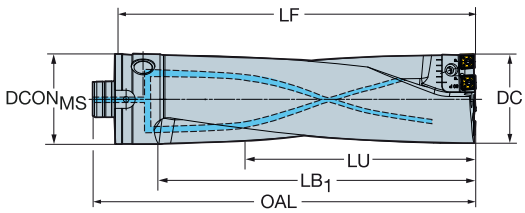
J53 L2 J86 J40 N22 N6 N15 J101

# CoroDrill® 880 indexable insert drill

**Machine side interface VL**

**Internal coolant supply**




Dimensions, mm, inch

| DC | DC" | CIIP | LU | LU" | $CZC_{MS}$ | TCHAL | TCHAU | Ordering code | DCON | DCON" | LF | LF" | OAL | OAL" | $LB_1$ | $LB_1$" | PL | PL" | KAPR | BAR | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 80.00 | 3.150 | 07P 07P 07P 07P | 252.00 | 9.921 | 80 | -0.30 | 0.30 | 880-D0800V80-03 | 80.00 | 3.150 | 330.5 | 13.012 | 350.00 | 13.780 | 287.61 | 11.323 | 1.50 | .059 | 88° | 10 | 10.5 | 5000 |
| | 3.150 | | 336.00 | 13.228 | 80 | -0.30 | 0.30 | 880-D0800V80-04 | 80.00 | 3.150 | 414.5 | 16.319 | 434.00 | 17.087 | 371.61 | 14.630 | 1.50 | .059 | 88° | 10 | 13.3 | 5000 |
| 81.00 | 3.189 | 07P 07P 07P 07P | 252.00 | 9.921 | 80 | -0.30 | 0.30 | 880-D0810V80-03 | 80.00 | 3.150 | 330.5 | 13.012 | 350.00 | 13.780 | 287.61 | 11.323 | 1.50 | .059 | 88° | 10 | 12.7 | 5000 |
| | 3.189 | | 336.00 | 13.228 | 80 | -0.30 | 0.30 | 880-D0810V80-04 | 80.00 | 3.150 | 414.5 | 16.319 | 434.00 | 17.087 | 371.61 | 14.630 | 1.50 | .059 | 88° | 10 | 13.1 | 5000 |
| 82.00 | 3.228 | 07P 07P 07P 07P | 252.00 | 9.921 | 80 | -0.30 | 0.30 | 880-D0820V80-03 | 80.00 | 3.150 | 330.5 | 13.012 | 350.00 | 13.780 | 287.61 | 11.323 | 1.50 | .059 | 88° | 10 | 12.7 | 5000 |
| | 3.228 | | 336.00 | 13.228 | 80 | -0.30 | 0.30 | 880-D0820V80-04 | 80.00 | 3.150 | 414.5 | 16.319 | 434.00 | 17.087 | 371.61 | 14.630 | 1.50 | .059 | 88° | 10 | 13.2 | 5000 |
| 83.00 | 3.268 | 07P 07P 07P 07P | 252.00 | 9.921 | 80 | -0.30 | 0.30 | 880-D0830V80-03 | 80.00 | 3.150 | 330.5 | 13.012 | 350.00 | 13.780 | 287.61 | 11.323 | 1.50 | .059 | 88° | 10 | 12.7 | 5000 |
| | 3.268 | | 336.00 | 13.228 | 80 | -0.30 | 0.30 | 880-D0830V80-04 | 80.00 | 3.150 | 414.5 | 16.319 | 434.00 | 17.087 | 371.61 | 14.630 | 1.50 | .059 | 88° | 10 | 15.1 | 5000 |
| 84.00 | 3.307 | 07P 07P 07P 07P | 252.00 | 9.921 | 80 | -0.30 | 0.30 | 880-D0840V80-03 | 80.00 | 3.150 | 330.5 | 13.012 | 350.00 | 13.780 | 287.61 | 11.323 | 1.50 | .059 | 88° | 10 | 12.7 | 5000 |
| | 3.307 | | 336.00 | 13.228 | 80 | -0.30 | 0.30 | 880-D0840V80-04 | 80.00 | 3.150 | 414.5 | 16.319 | 434.00 | 17.087 | 371.61 | 14.630 | 1.50 | .059 | 88° | 10 | 13.3 | 5000 |

Cartridges are included, inserts are sold separately

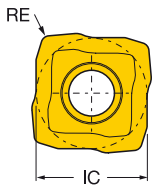
For the complete list of spare parts, visit www.sandvik.coromant.com

J53 L2 J86 J40 N22 N6 N15 J101

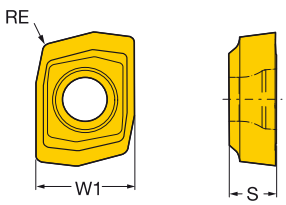
# CoroDrill® 880 insert for drilling

## Central insert

880..C




880-01..C




## Medium feed

| | | INSUC | Ordering code | P | | | M | | K | N | | | S | | | H | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1044 | 1044 | 1144 | 1044 | | 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 |
| | | | | | | | | | | | | | | | | | .087 | .012 | | .189 |
| | 02C | C | 880-02 02 04H-C-GM | ☆ | ☆ | | ☆ | | ☆ | ☆ | | | ☆ | | | ★ | 2.40 | 0.40 | 4.9 | |
| | | | | | | | | | | | | | | | | | .094 | .016 | .193 | |
| | 02C | C | 880-02 02 04H-C-LM | ★ | ☆ | ★ | ★ | | ★ | ☆ | ☆ | ★ | ★ | ☆ | ☆ | ☆ | 2.40 | 0.40 | 4.9 | |
| | | | | | | | | | | | | | | | | | .094 | .016 | .193 | |
| | 03C | C | 880-03 03 05H-C-GM | ☆ | ☆ | | ☆ | | ☆ | ☆ | | | ☆ | | | ★ | 2.60 | 0.50 | 5.7 | |
| | | | | | | | | | | | | | | | | | .102 | .020 | .224 | |
| | 03C | C | 880-03 03 05H-C-LM | ★ | ☆ | ★ | ★ | | ★ | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 2.60 | 0.50 | 5.7 | |
| | | | | | | | | | | | | | | | | | .102 | .020 | .224 | |
| | 04C | C | 880-04 03 05H-C-GM | ☆ | ☆ | | ☆ | | ☆ | ☆ | | | ☆ | | | ★ | 2.80 | 0.50 | 6.8 | |
| | | | | | | | | | | | | | | | | | .110 | .020 | .268 | |
| | 04C | C | 880-04 03 05H-C-LM | ★ | ☆ | ★ | ★ | | ★ | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 2.80 | 0.50 | 6.8 | |
| | | | | | | | | | | | | | | | | | .110 | .020 | .268 | |
| | 05C | C | 880-05 03 05H-C-GM | ☆ | ☆ | | ☆ | | ☆ | ☆ | | | ☆ | | | ★ | 3.00 | 0.50 | 8.4 | |
| | | | | | | | | | | | | | | | | | .118 | .020 | .331 | |
| | 05C | C | 880-05 03 05H-C-LM | ★ | ☆ | ★ | ★ | | ★ | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 3.00 | 0.50 | 8.4 | |
| | | | | | | | | | | | | | | | | | .118 | .020 | .331 | |
| | 06C | C | 880-06 04 06H-C-GM | ☆ | ☆ | | ☆ | | ☆ | ☆ | | | ☆ | | | ★ | 3.50 | 0.60 | 10.2 | |
| | | | | | | | | | | | | | | | | | .138 | .024 | .402 | |
| | 06C | C | 880-06 04 06H-C-LM | ★ | ☆ | ★ | ★ | | ★ | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 3.50 | 0.60 | 10.2 | |
| | | | | | | | | | | | | | | | | | .138 | .024 | .402 | |
| | 07C | C | 880-07 04 06H-C-GM | ☆ | ☆ | | ☆ | | ☆ | ☆ | | | ☆ | | | ★ | 4.00 | 0.60 | 12.4 | |
| | | | | | | | | | | | | | | | | | .157 | .024 | .486 | |
| | 07C | C | 880-07 04 06H-C-LM | ★ | ☆ | ★ | ★ | | ★ | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 4.00 | 0.60 | 12.4 | |
| | | | | | | | | | | | | | | | | | .157 | .024 | .486 | |
| | 08C | C | 880-08 05 08H-C-GM | ☆ | ☆ | | ☆ | | ☆ | ☆ | | | ☆ | | | ★ | 4.50 | 0.80 | 14.9 | |
| | | | | | | | | | | | | | | | | | .177 | .031 | .585 | |
| | 08C | C | 880-08 05 08H-C-LM | ★ | ☆ | ★ | ★ | | ★ | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 4.50 | 0.80 | 14.9 | |
| | | | | | | | | | | | | | | | | | .177 | .031 | .585 | |
| | 09C | C | 880-09 06 08H-C-GM | ☆ | ☆ | | ☆ | | ☆ | ☆ | | | ☆ | | | ★ | 5.50 | 0.80 | 17.9 | |
| | | | | | | | | | | | | | | | | | .217 | .031 | .705 | |
| | 09C | C | 880-09 06 08H-C-LM | ★ | ☆ | ★ | ★ | | ★ | ☆ | ★ | ★ | ★ | ☆ | ☆ | ☆ | 5.50 | 0.80 | 17.9 | |
| | | | | | | | | | | | | | | | | | .217 | .031 | .705 | |

## High feed

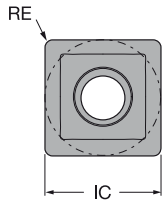
| | | INSUC | Ordering code | P | M | K | N | S | H | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1044 | 1044 | 1044 | 1044 | 1044 | 1044 | S | RE | IC | W1 |
| High feed | 01C | C | 880-01 02 03H-C-GR | ★ | | ★ | ☆ | ☆ | ★ | 2.20 | 0.30 | | 4.8 |
| | | | | | | | | | | .087 | .012 | | .189 |
| | 02C | C | 880-02 02 04H-C-GR | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 2.40 | 0.40 | 4.9 | |
| | | | | | | | | | | .094 | .016 | .193 | |
| | 03C | C | 880-03 03 05H-C-GR | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 2.60 | 0.50 | 5.7 | |
| | | | | | | | | | | .102 | .020 | .224 | |
| | 04C | C | 880-04 03 05H-C-GR | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 2.80 | 0.50 | 6.8 | |
| | | | | | | | | | | .110 | .020 | .268 | |
| | 05C | C | 880-05 03 05H-C-GR | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 3.00 | 0.50 | 8.4 | |
| | | | | | | | | | | .118 | .020 | .331 | |
| | 06C | C | 880-06 04 06H-C-GR | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 3.50 | 0.60 | 10.2 | |
| | | | | | | | | | | .138 | .024 | .402 | |
| | 07C | C | 880-07 04 06H-C-GR | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 4.00 | 0.60 | 12.4 | |
| | | | | | | | | | | .157 | .024 | .486 | |
| | 08C | C | 880-08 05 08H-C-GR | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 4.50 | 0.80 | 14.9 | |
| | | | | | | | | | | .177 | .031 | .585 | |
| | 09C | C | 880-09 06 08H-C-GR | ★ | ☆ | ★ | ☆ | ☆ | ☆ | 5.50 | 0.80 | 17.9 | |
| | | | | | | | | | | .217 | .031 | .705 | |

J41 J86 J40 N22

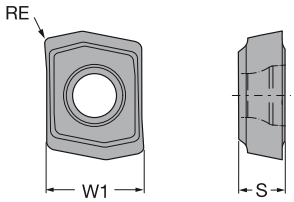
# CoroDrill® 880 insert for drilling

**Peripheral insert**

880..P




880-01..P




## Medium feed

| | | INSUC | Ordering code | P | | | M | | | K | | | N | | | S | | | H | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 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 |
| | | | | | | | | | | | | | | | | | | | | | .087 | .016 | | .189 |
| | 01P | P | 880-01 02 W04H-P-MS | | | | ★ | | | | | | | | ★ | ★ | | | | | 2.20 | 0.40 | | 4.8 |
| | | | | | | | | | | | | | | | | | | | | | .087 | .016 | | .189 |
| | 02P | P | 880-02 02 W04H-P-GM | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ★ | 2.40 | 0.40 | 5.1 | |
| | | | | | | | | | | | | | | | | | | | | | .094 | .016 | .201 | |
| | 02P | P | 880-02 02 W05H-P-LM | ☆ | ★ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | | | | ★ | | ☆ | ☆ | 2.40 | 0.50 | 5.1 | |
| | | | | | | | | | | | | | | | | | | | | | .094 | .020 | .201 | |
| | 02P | P | 880-02 02 W05H-P-MS | | | | ★ | | | | | | | | ★ | ★ | | | | | 2.40 | 0.50 | 5.1 | |
| | | | | | | | | | | | | | | | | | | | | | .094 | .020 | .201 | |
| | 03P | P | 880-03 03 W05H-P-GM | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ★ | 2.60 | 0.50 | 6.0 | |
| | | | | | | | | | | | | | | | | | | | | | .102 | .020 | .236 | |
| | 03P | P | 880-03 03 W06H-P-LM | ☆ | ★ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | 2.60 | 0.60 | 6.0 | |
| | | | | | | | | | | | | | | | | | | | | | .102 | .024 | .236 | |
| | 03P | P | 880-03 03 W06H-P-MS | | | | ★ | | | | | | | | ★ | ★ | | | | | 2.60 | 0.60 | 6.0 | |
| | | | | | | | | | | | | | | | | | | | | | .102 | .024 | .236 | |
| | 04P | P | 880-04 03 W05H-P-GM | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ★ | 2.80 | 0.50 | 7.4 | |
| | | | | | | | | | | | | | | | | | | | | | .110 | .020 | .291 | |
| | 04P | P | 880-04 03 W07H-P-LM | ☆ | ★ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | 2.80 | 0.70 | 7.4 | |
| | | | | | | | | | | | | | | | | | | | | | .110 | .028 | .291 | |
| | 04P | P | 880-04 03 W07H-P-MS | | | | ★ | | | | | | | | ★ | ★ | | | | | 2.80 | 0.70 | 7.4 | |
| | | | | | | | | | | | | | | | | | | | | | .110 | .028 | .291 | |
| | 05P | P | 880-05 03 W05H-P-GM | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ★ | 3.00 | 0.50 | 8.9 | |
| | | | | | | | | | | | | | | | | | | | | | .118 | .020 | .350 | |
| | 05P | P | 880-05 03 W08H-P-LM | ☆ | ★ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | 3.00 | 0.80 | 8.9 | |
| | | | | | | | | | | | | | | | | | | | | | .118 | .031 | .350 | |
| | 05P | P | 880-05 03 W08H-P-MS | | | | ★ | | | | | | | | ★ | ★ | | | | | 3.00 | 0.80 | 8.9 | |
| | | | | | | | | | | | | | | | | | | | | | .118 | .031 | .350 | |
| | 06P | P | 880-06 04 W06H-P-GM | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ★ | 3.50 | 0.60 | 10.7 | |
| | | | | | | | | | | | | | | | | | | | | | .138 | .024 | .419 | |
| | 06P | P | 880-06 04 W08H-P-LM | ☆ | ★ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | 3.50 | 0.80 | 10.7 | |
| | | | | | | | | | | | | | | | | | | | | | .138 | .031 | .419 | |
| | 06P | P | 880-06 04 W08H-P-MS | | | | ★ | | | | | | | | ★ | ★ | | | | | 3.50 | 0.80 | 10.7 | |
| | | | | | | | | | | | | | | | | | | | | | .138 | .031 | .419 | |
| | 07P | P | 880-07 04 W06H-P-GM | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ★ | 4.00 | 0.60 | 12.7 | |
| | | | | | | | | | | | | | | | | | | | | | .157 | .024 | .498 | |
| | 07P | P | 880-07 04 W10H-P-LM | ☆ | ★ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | 4.00 | 1.00 | 12.7 | |
| | | | | | | | | | | | | | | | | | | | | | .157 | .039 | .498 | |
| | 07P | P | 880-07 04 W10H-P-MS | | | | ★ | | | | | | | | ★ | ★ | | | | | 4.00 | 1.00 | 12.7 | |
| | | | | | | | | | | | | | | | | | | | | | .157 | .039 | .498 | |
| | 08P | P | 880-08 05 W08H-P-GM | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ★ | 4.50 | 0.80 | 15.5 | |
| | | | | | | | | | | | | | | | | | | | | | .177 | .031 | .608 | |
| | 08P | P | 880-08 05 W10H-P-LM | ☆ | ★ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | 4.50 | 1.00 | 15.5 | |
| | | | | | | | | | | | | | | | | | | | | | .177 | .039 | .608 | |
| | 08P | P | 880-08 05 W10H-P-MS | | | | ★ | | | | | | | | ★ | ★ | | | | | 4.50 | 1.00 | 15.5 | |
| | | | | | | | | | | | | | | | | | | | | | .177 | .039 | .608 | |
| | 09P | P | 880-09 06 W08H-P-GM | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | | | | ☆ | | ☆ | ★ | 5.50 | 0.80 | 18.6 | |
| | | | | | | | | | | | | | | | | | | | | | .217 | .031 | .732 | |
| | 09P | P | 880-09 06 W10H-P-LM | ☆ | ★ | ☆ | | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | | | ★ | ☆ | ☆ | ☆ | 5.50 | 1.00 | 18.6 | |
| | | | | | | | | | | | | | | | | | | | | | .217 | .039 | .732 | |
| | 09P | P | 880-09 06 W10H-P-MS | | | | ★ | | | | | | | | ★ | ★ | | | | | 5.50 | 1.00 | 18.6 | |
| | | | | | | | | | | | | | | | | | | | | | .217 | .039 | .732 | |

J41 J86 J40 N22

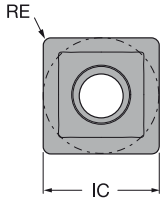


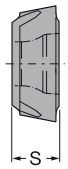
SANDVIK Coromant

# CoroDrill® 880 insert for drilling

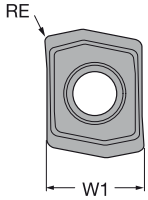
**Peripheral insert**

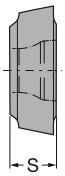
880..P




880-01..P




## High feed

| | | INSUC | Ordering code | P | | | M | | K | | | N | S | H | | Dimensions, mm, inch | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 4324 | 4334 | 4344 | 4334 | 4344 | 4324 | 4334 | 4344 | 4344 | 4344 | 4334 | 4344 | S | RE | IC | W1 |
| High feed | 01P | P | 880-01 02 W04H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | 2.20 | 0.40 | | 4.8 |
| | | | | | | | | | | | | | | | | .087 | .016 | | .189 |
| | 02P | P | 880-02 02 W05H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.40 | 0.50 | 5.1 | |
| | | | | | | | | | | | | | | | | .094 | .020 | .201 | |
| | 02P | P | 880-02 02 W05H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.40 | 0.50 | 5.1 | |
| | | | | | | | | | | | | | | | | .094 | .020 | .201 | |
| | 03P | P | 880-03 03 W06H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.60 | 0.60 | 6.0 | |
| | | | | | | | | | | | | | | | | .102 | .024 | .236 | |
| | 03P | P | 880-03 03 W06H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.60 | 0.60 | 6.0 | |
| | | | | | | | | | | | | | | | | .102 | .024 | .236 | |
| | 04P | P | 880-04 03 W07H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.80 | 0.70 | 7.4 | |
| | | | | | | | | | | | | | | | | .110 | .028 | .291 | |
| | 04P | P | 880-04 03 W07H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 2.80 | 0.70 | 7.4 | |
| | | | | | | | | | | | | | | | | .110 | .028 | .291 | |
| | 05P | P | 880-05 03 W08H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.00 | 0.80 | 8.9 | |
| | | | | | | | | | | | | | | | | .118 | .031 | .350 | |
| | 05P | P | 880-05 03 W08H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.00 | 0.80 | 8.9 | |
| | | | | | | | | | | | | | | | | .118 | .031 | .350 | |
| | 06P | P | 880-06 04 W10H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.50 | 1.00 | 10.7 | |
| | | | | | | | | | | | | | | | | .138 | .039 | .419 | |
| | 06P | P | 880-06 04 W10H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 3.50 | 1.00 | 10.7 | |
| | | | | | | | | | | | | | | | | .138 | .039 | .419 | |
| | 07P | P | 880-07 04 W12H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.00 | 1.20 | 12.7 | |
| | | | | | | | | | | | | | | | | .157 | .047 | .498 | |
| | 07P | P | 880-07 04 W12H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.00 | 1.20 | 12.7 | |
| | | | | | | | | | | | | | | | | .157 | .047 | .498 | |
| | 08P | P | 880-08 05 W12H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.50 | 1.20 | 15.5 | |
| | | | | | | | | | | | | | | | | .177 | .047 | .608 | |
| | 08P | P | 880-08 05 W12H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 4.50 | 1.20 | 15.5 | |
| | | | | | | | | | | | | | | | | .177 | .047 | .608 | |
| | 09P | P | 880-09 06 W12H-P-GR | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ★ | ☆ | ☆ | ☆ | ☆ | ☆ | 5.50 | 1.20 | 18.6 | |
| | | | | | | | | | | | | | | | | .217 | .047 | .732 | |
| | 09P | P | 880-09 06 W12H-P-GT | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | ☆ | 5.50 | 1.20 | 18.6 | |
| | | | | | | | | | | | | | | | | .217 | .047 | .732 | |

J41 J86 J40 N22

# 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 the 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.

J57 J58

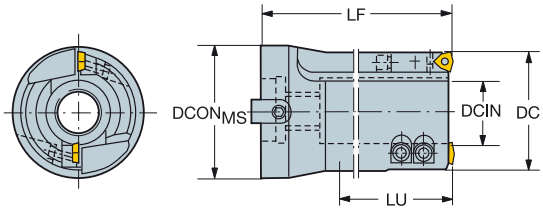


SANDVIK Coromant

# Trepanning tool

**VL coupling**

**Internal coolant supply**




| DC | DC" | DCIN | DCIN" | | LU | LU" | $CZC_{MS}$ | TCHAL | TCHAU | Ordering code | Dimensions, mm, inch DCON | DCON" | LF | LF" | KAPR | BAR | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 60.00 | 2.362 | 24.00 | .945 | 06 | 150.00 | 5.906 | 80 | -0.20 | 0.20 | **R416.7-0600-25-01** | 80.00 | 3.150 | 195.0 | 7.677 | 85° | 20 | 3.1 |
| 65.00 | 2.559 | 29.00 | 1.142 | 06 | 165.00 | 6.496 | 80 | -0.20 | 0.20 | **R416.7-0650-25-01** | 80.00 | 3.150 | 210.0 | 8.268 | 85° | 20 | 3.8 |
| 70.00 | 2.756 | 34.00 | 1.339 | 06 | 175.00 | 6.890 | 80 | -0.20 | 0.20 | **R416.7-0700-25-01** | 80.00 | 3.150 | 220.0 | 8.661 | 85° | 20 | 4.0 |
| 75.00 | 2.953 | 39.00 | 1.535 | 06 | 190.00 | 7.480 | 80 | -0.20 | 0.20 | **R416.7-0750-25-01** | 80.00 | 3.150 | 235.0 | 9.252 | 85° | 20 | 4.7 |
| 80.00 | 3.150 | 44.00 | 1.732 | 06 | 200.00 | 7.874 | 80 | -0.20 | 0.20 | **R416.7-0800-25-01** | 80.00 | 3.150 | 245.0 | 9.646 | 85° | 20 | 5.5 |
| 85.00 | 3.346 | 49.00 | 1.929 | 06 | 215.00 | 8.465 | 80 | -0.20 | 0.20 | **R416.7-0850-25-01** | 80.00 | 3.150 | 260.0 | 10.236 | 85° | 20 | 6.0 |
| 90.00 | 3.543 | 54.00 | 2.126 | 06 | 225.00 | 8.858 | 80 | -0.20 | 0.20 | **R416.7-0900-25-01** | 80.00 | 3.150 | 270.0 | 10.630 | 85° | 20 | 6.9 |
| 95.00 | 3.740 | 59.00 | 2.323 | 06 | 240.00 | 9.449 | 80 | -0.20 | 0.20 | **R416.7-0950-25-01** | 80.00 | 3.150 | 285.0 | 11.221 | 85° | 20 | 7.7 |
| 100.00 | 3.937 | 64.00 | 2.520 | 06 | 250.00 | 9.843 | 80 | -0.20 | 0.20 | **R416.7-1000-25-01** | 80.00 | 3.150 | 295.0 | 11.614 | 85° | 20 | 8.6 |
| 110.00 | 4.331 | 74.00 | 2.913 | 06 | 275.00 | 10.827 | 80 | -0.20 | 0.20 | **R416.7-1100-25-01** | 80.00 | 3.150 | 320.0 | 12.598 | 85° | 20 | 10.0 |

For mounting information see page M40

| Spare parts | | |
|---|---|---|
| Driving key | Screw | Screw |
| 5631 010-03 | 3212 010-360 | 430.21-825 |

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

## Accessories

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

Accessories, must be ordered separately.

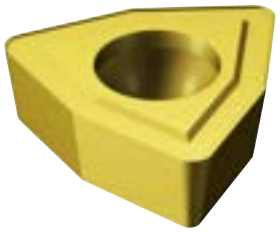
J58

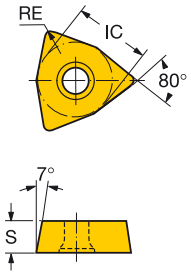
L2

N22

N15

# Trepanning inserts



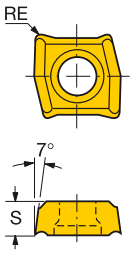



| | | | | | P | | | | | M | | | | | K | | | | | N | | | S | | | H | | Dimensions, mm, inch | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1020 | 1125 | 235 | 3040 | 4235 | 1020 | 1105 | 235 | 3040 | 4235 | 1020 | 1105 | 1125 | 3040 | 4235 | 1020 | 4235 | H13A | 1020 | 1125 | H13A | 1020 | 3040 | S | RE | IC |
| | 06 | P | INSUC | WCMX 06 T3 08 R-51 | | | ☆ | | | | | ☆ | | | | | | | | | | ★ | | | ☆ | | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | P+C | | WCMX 06 T3 08 R-53 | ☆ | | ☆ | ☆ | | ☆ | | ☆ | ☆ | | ☆ | | | ☆ | | ☆ | | ☆ | ☆ | | ☆ | ☆ | ☆ | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | P | | WCMX 06 T3 08-56 | | | ☆ | | | | | ☆ | | | | | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | P | | WCMX 06 T3 08-58 | | | ☆ | ☆ | | | | ☆ | ☆ | | | | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | P+C | | WCMX 06 T3 08-GM | | ☆ | | | ☆ | | | | | ☆ | | | ☆ | | ☆ | | ☆ | ☆ | | ☆ | ☆ | | | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 08 | P+C | | WCMX 08 04 12-GM | | ☆ | | | ☆ | | ☆ | | | ☆ | | ☆ | ☆ | | ☆ | | ☆ | ☆ | | ☆ | ☆ | | | | 4.76 | 1.20 | 12.7 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | .188 | .047 | .500 |

Medium feed

J57 J100 N22

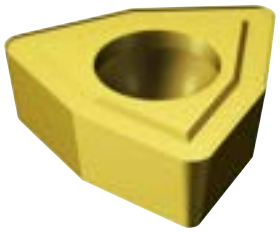
# Coromant U insert for drilling

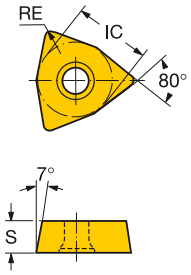



| | | INSUC | Ordering code | P | | | | M | | | | K | | | N | | | S | | | H | | | Dimensions, mm, inch | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | 1020 | 1120 | 235 | 3040 | 1020 | 1120 | 235 | 3040 | 1020 | 1120 | 3040 | 1020 | 1120 | H13A | 1020 | 1120 | H13A | 1020 | 1120 | 3040 | S | RE |
| Medium feed | 02 | C | LCMX 02 02 04C-53 | ★ | | | | ★ | | | | ★ | | | ★ | | | ★ | | | ★ | | | 2.38 | 0.40 |
| | | | | | | | | | | | | | | | | | | | | | | | | .094 | .016 |
| | 02 | P | LCMX 02 02 04P-53 | | ☆ | | ☆ | | ☆ | | ☆ | | ☆ | ☆ | | ☆ | | | ☆ | | | ☆ | ☆ | 2.38 | 0.40 |
| | | | | | | | | | | | | | | | | | | | | | | | | .094 | .016 |
| | 02 | C | LCMX 02 02 04TC-53 | ☆ | | | | | | | | ☆ | | | | | | | | | ☆ | | | 2.38 | 0.40 |
| | | | | | | | | | | | | | | | | | | | | | | | | .094 | .016 |
| | 03 | P | LCMX 03 03 04-58 | | | ☆ | ☆ | | | ☆ | ☆ | | | | | | | | | | | | | 3.18 | 0.40 |
| | | | | | | | | | | | | | | | | | | | | | | | | .125 | .016 |
| | 03 | P | LCMX 03 03 04R-WM | ☆ | | | ☆ | ☆ | | | ☆ | ☆ | | ☆ | | | | | | | | | | 3.18 | 0.45 |
| | | | | | | | | | | | | | | | | | | | | | | | | .125 | .018 |
| | 03 | P+C | LCMX 03 03 08-53 | ☆ | | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | | ☆ | ☆ | | ☆ | ☆ | | ☆ | ☆ | | ☆ | 3.18 | 0.80 |
| | | | | | | | | | | | | | | | | | | | | | | | | .125 | .031 |
| | 03 | P+C | LCMX 03 03 08T-53 | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | ☆ | | | ☆ | | | 3.18 | 0.80 |
| | | | | | | | | | | | | | | | | | | | | | | | | .125 | .031 |
| | 04 | P | LCMX 04 03 04-58 | | | ☆ | ☆ | | | ☆ | ☆ | | | | | | | | | | | | | 3.18 | 0.40 |
| | | | | | | | | | | | | | | | | | | | | | | | | .125 | .016 |
| | 04 | P | LCMX 04 03 04R-WM | ☆ | | | ☆ | ☆ | | | ☆ | ☆ | | ☆ | | | | | | | | | | 3.18 | 0.40 |
| | | | | | | | | | | | | | | | | | | | | | | | | .125 | .016 |
| | 04 | P+C | LCMX 04 03 08-53 | ☆ | | ☆ | ☆ | ☆ | | ☆ | ☆ | ☆ | | ☆ | ☆ | | ☆ | ☆ | | ☆ | ☆ | | ☆ | 3.18 | 0.80 |
| | | | | | | | | | | | | | | | | | | | | | | | | .125 | .031 |
| | 04 | P+C | LCMX 04 03 08T-53 | ☆ | | | | ☆ | | | | ☆ | | | ☆ | | | ☆ | | | ☆ | | | 3.18 | 0.80 |
| | | | | | | | | | | | | | | | | | | | | | | | | .125 | .031 |

J96 N22

# Coromant U insert for drilling






| | | | | | P | | | | | M | | | | | K | | | | | N | | | S | | | H | | Dimensions, mm, inch | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 1020 | 1125 | 235 | 3040 | 4235 | 1020 | 1105 | 235 | 3040 | 4235 | 1020 | 1105 | 1125 | 235 | 3040 | 4235 | 1020 | 4235 | H13A | 1020 | 1125 | H13A | 1020 | 3040 | | | |
| | | INSUC | Ordering code | | | | | | | | | | | | | | | | | | | | | | | | | | S | RE | IC |
| Medium feed | 05 | P | WCMX 05 03 04R-WM | | ☆ | | | ☆ | | ☆ | | | ☆ | | ☆ | | | | ☆ | | | | | | | | | | 3.18 | 0.40 | 7.9 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .125 | .016 | .313 |
| | 05 | P | WCMX 05 03 08 R-51 | | | | ☆ | | | | | ☆ | | | | | | | | | | | | | | | | | 3.18 | 0.80 | 7.9 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .125 | .031 | .313 |
| | 05 | P+C | WCMX 05 03 08 R-53 | | ☆ | | ☆ | ☆ | | ☆ | | ☆ | ☆ | | ☆ | | | | ☆ | | ☆ | | ☆ | ☆ | | ☆ | ☆ | ☆ | 3.18 | 0.80 | 7.9 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .125 | .031 | .313 |
| | 05 | P+C | WCMX 05 03 08 T-53 | | ☆ | | | | | ☆ | | | | | ☆ | | | | | | ☆ | | | ☆ | | | ☆ | | 3.18 | 0.80 | 7.9 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .125 | .031 | .313 |
| | 05 | P | WCMX 05 03 08-56 | | | | ☆ | | | | | ☆ | | | | | | | | | | | | | | | | | 3.18 | 0.80 | 7.9 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .125 | .031 | .313 |
| | 05 | P | WCMX 05 03 08-58 | | | | ☆ | ☆ | | | | ☆ | ☆ | | | | | | | | | | | | | | | | 3.18 | 0.80 | 7.9 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .125 | .031 | .313 |
| | 05 | C | WCMX 05 03 S R-54 | | | | ☆ | | | | | | | | | | | ☆ | | | | | | | | | | | 3.18 | 0.40 | 7.9 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .125 | .016 | .313 |
| | 06 | P | WCMX 06 T3 04R-WM | | ☆ | | | ☆ | | ☆ | | | ☆ | | ☆ | | | | ☆ | | | | | | | | | | 3.97 | 0.40 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .016 | .375 |
| | 06 | P | WCMX 06 T3 08 R-51 | | | | ☆ | | | | | ☆ | | | | | | | | | | | ★ | | | ☆ | | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | P+C | WCMX 06 T3 08 R-53 | | ☆ | | ☆ | ☆ | | ☆ | | ☆ | ☆ | | ☆ | | | | ☆ | | ☆ | | ☆ | ☆ | | ☆ | ☆ | ☆ | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | P+C | WCMX 06 T3 08 T-53 | | ☆ | | | | | ☆ | | | | | ☆ | | | | | | ☆ | | | ☆ | | | ☆ | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | P | WCMX 06 T3 08-56 | | | | ☆ | | | | | ☆ | | | | | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | P | WCMX 06 T3 08-58 | | | | ☆ | ☆ | | | | ☆ | ☆ | | | | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | P+C | WCMX 06 T3 08-GM | | | ☆ | | | ☆ | | | | | ☆ | | | ☆ | | | ☆ | | ☆ | ☆ | | ☆ | ☆ | | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 06 | C | WCMX 06 T3 S R-56 | | | | ☆ | | | | | ☆ | | | | | | | | | | | | | | | | | 3.97 | 0.80 | 9.5 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .156 | .031 | .375 |
| | 08 | P | WCMX 08 04 12 R-51 | | | | ☆ | | | | | ☆ | | | | | | | | | | | ★ | | | ☆ | | | 4.76 | 1.20 | 12.7 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .188 | .047 | .500 |
| | 08 | P+C | WCMX 08 04 12 R-53 | | ☆ | | ☆ | ☆ | | ☆ | | ☆ | ☆ | | ☆ | | | | ☆ | | ☆ | | ☆ | ☆ | | ☆ | ☆ | ☆ | 4.76 | 1.20 | 12.7 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .188 | .047 | .500 |
| | 08 | P+C | WCMX 08 04 12 T-53 | | ☆ | | | | | ☆ | | | | | ☆ | | | | | | ☆ | | | ☆ | | | ☆ | | 4.76 | 1.20 | 12.7 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .188 | .047 | .500 |
| | 08 | P | WCMX 08 04 12-56 | | | | ☆ | | | | | ☆ | | | | | | | | | | | | | | | | | 4.76 | 1.20 | 12.7 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .188 | .047 | .500 |
| | 08 | P | WCMX 08 04 12-58 | | | | ☆ | ☆ | | | | ☆ | ☆ | | | | | | | | | | | | | | | | 4.76 | 1.20 | 12.7 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .188 | .047 | .500 |
| | 08 | P+C | WCMX 08 04 12-GM | | | ☆ | | | ☆ | | ☆ | | | ☆ | | ☆ | ☆ | | | ☆ | | ☆ | ☆ | | ☆ | ☆ | | | 4.76 | 1.20 | 12.7 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .188 | .047 | .500 |
| | 08 | C | WCMX 08 04 S R-56 | | | | ☆ | | | | | ☆ | | | | | | | | | | | | | | | | | 4.76 | 0.40 | 12.7 |
| | | | | | | | | | | | | | | | | | | | | | | | | | | | | | .188 | .016 | .500 |

J96 N22

# 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 cause 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 – $v_c$**

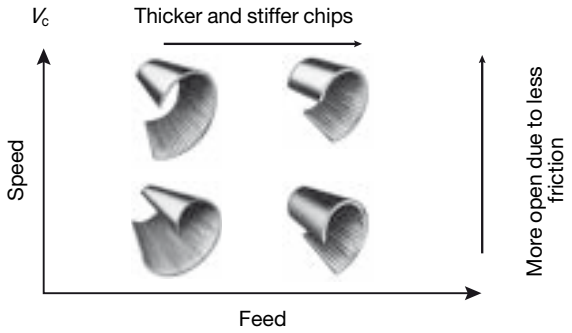
**Cutting speed that is too high:**
Rapid flank wear
Plastic deformation
Poor hole quality and bad hole tolerance

**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 of 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 to use 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 the best possible hole quality is needed when drilling 6-7xD holes with CoroDrill® DS20, it is important to use a reduced feed rate at entry (first 1-2 mm) (.039-.787 inch) and exit (last 5 mm) (.197 inch).

# CoroDrill® 870

**< 6 x DC**

**Metric values**

| ISO | MC No. | CMC No. | Material | Hardness Brinell (HB) | Cutting speed ($V_c$) m/min correlating with drill diameter | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 10.00-20.99mm | | | 21.00-33.00mm | | |
| | | | | | Min. | Rec. | Max | 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 |
| | | | **Gray 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 | | | **Aluminum 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

# CoroDrill® 870

**< 6 x DC**

**Metric values**

| 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 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 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 -PM, -MM 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

**Metric values**

| ISO | MC No. | CMC No. | Material | Hardness Brinell (HB) | Cutting speed ($V_c$) m/min correlating with drill diameter | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | 10.00-20.99mm | | | 21.00-33.00mm | | |
| | | | | | Min. | Rec. | Max | 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 |
| | | | **Gray 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 | | | **Aluminum 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 |

# CoroDrill® 870

≥ 6 x DC

Metric values

| 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® 870

**< 6 x DC**

**Inch values**

| ISO | MC No. | CMC No. | Material | Hardness Brinell (HB) | Cutting speed ($V_c$) ft/min correlating with drill diameter .3937-.8264" Min. | Rec. | Max | .8268-1.2992" Min. | Rec. | Max |
|---|---|---|---|---|---|---|---|---|---|---|
| P | | | **Unalloyed steel** | | | | **Grade 4334** | | | |
| | P1.1.Z.AN | 01.1 | C=0.10-0.25% | 125 | 260 | 395 | 525 | 260 | 395 | 525 |
| | P1.2.Z.AN | 01.2 | C=0.25-0.55% | 190 | 260 | 395 | 525 | 260 | 395 | 525 |
| | P1.3.Z.AN | 01.3 | C=0.55-0.80% | 190 | 230 | 330 | 425 | 230 | 330 | 425 |
| | P1.5.C.UT | 06.1 | Cast - untreated | 150 | 260 | 360 | 460 | 260 | 360 | 460 |
| | | | **Low alloy steel** | | | | **Grade 4334 and 3334** | | | |
| | P2.1.Z.AN | 02.1 | Annealed | 175 | 260 | 360 | 460 | 260 | 360 | 460 |
| | P2.2.Z.AN | 02.1 | Annealed | 240 | 260 | 360 | 460 | 260 | 360 | 460 |
| | P2.4.Z.AN | 02.1 | Annealed | 225 | 260 | 360 | 460 | 260 | 360 | 460 |
| | P2.5.Z.HT | 02.2 | Hardened and tempered | 330 | 230 | 330 | 425 | 165 | 245 | 330 |
| | P2.6.C.UT | 06.2 | Cast - untreated | 200 | 230 | 330 | 425 | 230 | 330 | 425 |
| | | | **High alloy steel** | | | | | | | |
| | P3.0.Z.AN | 03.11 | Annealed | 200 | 195 | 260 | 330 | 195 | 260 | 330 |
| | P3.0.Z.HT | 03.21 | Hardened and tempered | 380 | 130 | 195 | 260 | 130 | 195 | 260 |
| M | | | **Ferritic/martensitic stainless steel** | | | | **Grade 4334 and 2334** | | | |
| | P5.0.Z.AN | 05.11 | Annealed | 200 | 100 | 130 | 165 | 100 | 130 | 165 |
| | P5.0.Z.HT | 05.13 | Hardened and tempered | 330 | 230 | 295 | 360 | 195 | 245 | 295 |
| | | | **Austenitic stainless steel** | | | | **Grade 2334 and 4334** | | | |
| | M1.0.Z.AQ | 05.21 | Annealed/quenched | 200 | 130 | 165 | 195 | 130 | 165 | 195 |
| | M1.0.C.UT | 15.21 | Cast+untreated | 200 | 165 | 195 | 230 | 165 | 195 | 230 |
| | M1.1.Z.AQ | 05.21 | Machinability improved | 200 | 195 | 245 | 295 | 195 | 245 | 295 |
| | | | **Super-austenitic (Ni≥20%) stainless steel** | | | | | | | |
| | M2.0.Z.AQ | 05.23 | Annealed/quenched | 200 | 65 | 130 | 195 | 65 | 130 | 195 |
| | M2.0.C.AQ | 15.23 | Cast+annealed/quenched | 200 | 65 | 130 | 195 | 65 | 130 | 195 |
| | | | **Duplex (austenitic/ferritic) stainless steel** | | | | | | | |
| | M3.1.Z.AQ | 05.51 | >60% ferrite (N<0.10%) | 230 | 130 | 180 | 230 | 130 | 180 | 230 |
| | M3.2.Z.AQ | 05.52 | <60% ferrite (N≥0.10%) | 260 | 65 | 130 | 195 | 65 | 130 | 195 |
| K | | | **Malleable cast iron** | | | | **Grade 3334 and 4334** | | | |
| | K1.1.C.NS | 07.1 | Ferritic (short chipping) | 130 | 330 | 475 | 620 | 330 | 475 | 620 |
| | K1.1.C.NS | 07.2 | Pearlitic (long chipping) | 200 | 295 | 410 | 525 | 295 | 410 | 525 |
| | | | **Gray cast iron** | | | | | | | |
| | K2.1.C.UT | 08.1 | Low tensile strength | 180 | 330 | 490 | 655 | 330 | 490 | 655 |
| | K2.2.C.UT | 08.2 | High tensile strength | 245 | 295 | 425 | 560 | 295 | 425 | 560 |
| | | | **Nodular cast iron** | | | | | | | |
| | K3.1.C.UT | 09.1 | Ferritic | 155 | 330 | 475 | 620 | 330 | 475 | 620 |
| | K3.3.C.UT | 09.2 | Pearlitic | 265 | 295 | 410 | 525 | 295 | 410 | 525 |
| N | | | **Aluminum based alloys** | | | | **Grade 4334** | | | |
| | N1.2.Z.AG | 30.12 | AlSi alloys, Si ≤ 1% | 100 | 490 | 650 | 820 | 490 | 650 | 820 |
| | N1.3.C.AG | 30.22 | AlSi cast alloys, Si > 1% and < 13% | 80 | 490 | 650 | 820 | 490 | 650 | 820 |
| S | | | **Heat resistant super alloys** | | | | **Grade 2334 and 4334** | | | |
| | S2.0.Z.AG | 20.22 | Ni based | 350 | 60 | 65 | 100 | 60 | 65 | 100 |
| | S4.3.Z.AN | 23.21 | Titanium based | 330 | 80 | 130 | 195 | 80 | 130 | 195 |



SANDVIK Coromant

# CoroDrill® 870

**< 6 x DC**

**Inch values**

| Feed ($f_n$) inch/rev. correlating with drill diameter | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .3937-.4720" | | | .4724-.5508" | | | .5512-.6295" | | | .6299-.8264" | | | .8268-1.0232" | | | 1.0237-1.2992" | | |
| Min. | Rec. | Max | Min. | Rec. | Max | Min. | Rec. | Max | Min. | Rec. | Max | Min. | Rec. | Max | Min. | Rec. | Max |
| **Geometry -PM and -GP** | | | | | | | | | | | | | | | | | |
| 0.0047 | 0.0071 | 0.0110 | 0.0055 | 0.0079 | 0.0138 | 0.0063 | 0.0098 | 0.0161 | 0.0079 | 0.0126 | 0.0177 | 0.0079 | 0.0134 | 0.0177 | 0.0079 | 0.0134 | 0.0177 |
| 0.0047 | 0.0071 | 0.0110 | 0.0055 | 0.0079 | 0.0138 | 0.0063 | 0.0098 | 0.0161 | 0.0079 | 0.0126 | 0.0177 | 0.0079 | 0.0134 | 0.0177 | 0.0079 | 0.0134 | 0.0177 |
| 0.0047 | 0.0071 | 0.0110 | 0.0055 | 0.0079 | 0.0138 | 0.0063 | 0.0098 | 0.0161 | 0.0079 | 0.0126 | 0.0177 | 0.0079 | 0.0134 | 0.0177 | 0.0079 | 0.0134 | 0.0177 |
| 0.0047 | 0.0074 | 0.0110 | 0.0055 | 0.0079 | 0.0138 | 0.0063 | 0.0098 | 0.0161 | 0.0079 | 0.0126 | 0.0177 | 0.0079 | 0.0134 | 0.0177 | 0.0079 | 0.0134 | 0.0177 |
| **Geometry -PM, -KM and -GP** | | | | | | | | | | | | | | | | | |
| 0.0047 | 0.0071 | 0.0118 | 0.0055 | 0.0079 | 0.0146 | 0.0063 | 0.0098 | 0.0177 | 0.0079 | 0.0126 | 0.0189 | 0.0079 | 0.0142 | 0.0197 | 0.0079 | 0.0157 | 0.0205 |
| 0.0047 | 0.0071 | 0.0118 | 0.0055 | 0.0079 | 0.0146 | 0.0063 | 0.0098 | 0.0177 | 0.0079 | 0.0126 | 0.0189 | 0.0079 | 0.0142 | 0.0197 | 0.0079 | 0.0157 | 0.0205 |
| 0.0047 | 0.0071 | 0.0118 | 0.0055 | 0.0079 | 0.0146 | 0.0063 | 0.0098 | 0.0177 | 0.0079 | 0.0126 | 0.0189 | 0.0079 | 0.0142 | 0.0197 | 0.0079 | 0.0157 | 0.0205 |
| 0.0047 | 0.0071 | 0.0118 | 0.0055 | 0.0079 | 0.0146 | 0.0063 | 0.0098 | 0.0177 | 0.0079 | 0.0126 | 0.0189 | 0.0079 | 0.0142 | 0.0197 | 0.0079 | 0.0157 | 0.0205 |
| 0.0047 | 0.0074 | 0.0118 | 0.0055 | 0.0079 | 0.0146 | 0.0063 | 0.0098 | 0.0177 | 0.0079 | 0.0126 | 0.0189 | 0.0079 | 0.0142 | 0.0197 | 0.0079 | 0.0142 | 0.0197 |
| 0.0039 | 0.0063 | 0.0094 | 0.0047 | 0.0075 | 0.0130 | 0.0055 | 0.0087 | 0.0150 | 0.0071 | 0.0098 | 0.0157 | 0.0071 | 0.0118 | 0.0177 | 0.0071 | 0.0118 | 0.0177 |
| 0.0039 | 0.0063 | 0.0094 | 0.0047 | 0.0075 | 0.0130 | 0.0055 | 0.0087 | 0.0150 | 0.0071 | 0.0098 | 0.0157 | 0.0071 | 0.0118 | 0.0177 | 0.0071 | 0.0118 | 0.0177 |
| **Geometry -PM, -MM and -GP** | | | | | | | | | | | | | | | | | |
| 0.0047 | 0.0055 | 0.0075 | 0.0055 | 0.0063 | 0.0087 | 0.0055 | 0.0071 | 0.0094 | 0.0071 | 0.0094 | 0.0118 | 0.0087 | 0.0110 | 0.0134 | 0.0087 | 0.0110 | 0.0134 |
| 0.0039 | 0.0047 | 0.0063 | 0.0039 | 0.0047 | 0.0063 | 0.0047 | 0.0055 | 0.0071 | 0.0055 | 0.0071 | 0.0087 | 0.0063 | 0.0087 | 0.0102 | 0.0063 | 0.0087 | 0.0102 |
| **Geometry -MM, PM and -GP** | | | | | | | | | | | | | | | | | |
| 0.0039 | 0.0047 | 0.0055 | 0.0039 | 0.0047 | 0.0055 | 0.0047 | 0.0055 | 0.0063 | 0.0047 | 0.0063 | 0.0079 | 0.0055 | 0.0071 | 0.0087 | 0.0055 | 0.0071 | 0.0087 |
| 0.0039 | 0.0047 | 0.0055 | 0.0039 | 0.0047 | 0.0055 | 0.0047 | 0.0055 | 0.0063 | 0.0047 | 0.0063 | 0.0079 | 0.0055 | 0.0071 | 0.0087 | 0.0055 | 0.0071 | 0.0087 |
| 0.0039 | 0.0047 | 0.0063 | 0.0039 | 0.0047 | 0.0063 | 0.0047 | 0.0055 | 0.0071 | 0.0055 | 0.0063 | 0.0087 | 0.0055 | 0.0071 | 0.0094 | 0.0055 | 0.0071 | 0.0094 |
| 0.0039 | 0.0047 | 0.0055 | 0.0039 | 0.0047 | 0.0063 | 0.0039 | 0.0047 | 0.0063 | 0.0039 | 0.0055 | 0.0063 | 0.0047 | 0.0055 | 0.0071 | 0.0047 | 0.0055 | 0.0071 |
| 0.0039 | 0.0047 | 0.0055 | 0.0039 | 0.0047 | 0.0063 | 0.0039 | 0.0047 | 0.0063 | 0.0039 | 0.0055 | 0.0063 | 0.0047 | 0.0055 | 0.0071 | 0.0047 | 0.0055 | 0.0071 |
| **Geometry -MM and -GP** | | | | | | | | | | | | | | | | | |
| 0.0039 | 0.0047 | 0.0063 | 0.0039 | 0.0047 | 0.0063 | 0.0039 | 0.0055 | 0.0071 | 0.0055 | 0.0063 | 0.0087 | 0.0055 | 0.0063 | 0.0087 | 0.0055 | 0.0063 | 0.0087 |
| 0.0039 | 0.0047 | 0.0055 | 0.0039 | 0.0047 | 0.0055 | 0.0047 | 0.0055 | 0.0063 | 0.0047 | 0.0063 | 0.0079 | 0.0047 | 0.0063 | 0.0079 | 0.0047 | 0.0063 | 0.0079 |
| **Geometry -KM, PM and -GP** | | | | | | | | | | | | | | | | | |
| 0.0063 | 0.0098 | 0.0142 | 0.0071 | 0.0118 | 0.0165 | 0.0083 | 0.0146 | 0.0189 | 0.0098 | 0.0173 | 0.0217 | 0.0118 | 0.0189 | 0.0236 | 0.0118 | 0.0197 | 0.0236 |
| 0.0063 | 0.0098 | 0.0142 | 0.0071 | 0.0118 | 0.0165 | 0.0083 | 0.0146 | 0.0189 | 0.0098 | 0.0173 | 0.0217 | 0.0118 | 0.0189 | 0.0236 | 0.0118 | 0.0197 | 0.0236 |
| 0.0063 | 0.0098 | 0.0142 | 0.0071 | 0.0118 | 0.0165 | 0.0083 | 0.0146 | 0.0189 | 0.0098 | 0.0173 | 0.0217 | 0.0118 | 0.0189 | 0.0236 | 0.0118 | 0.0197 | 0.0236 |
| 0.0063 | 0.0098 | 0.0142 | 0.0071 | 0.0118 | 0.0165 | 0.0083 | 0.0146 | 0.0189 | 0.0098 | 0.0173 | 0.0217 | 0.0118 | 0.0189 | 0.0236 | 0.0118 | 0.0197 | 0.0236 |
| 0.0063 | 0.0098 | 0.0142 | 0.0071 | 0.0118 | 0.0165 | 0.0083 | 0.0146 | 0.0189 | 0.0098 | 0.0173 | 0.0217 | 0.0118 | 0.0189 | 0.0236 | 0.0118 | 0.0197 | 0.0236 |
| 0.0063 | 0.0098 | 0.0142 | 0.0071 | 0.0118 | 0.0165 | 0.0083 | 0.0146 | 0.0189 | 0.0098 | 0.0173 | 0.0217 | 0.0118 | 0.0189 | 0.0236 | 0.0118 | 0.0197 | 0.0236 |
| **Geometry -PM and -GP** | | | | | | | | | | | | | | | | | |
| 0.0079 | 0.0098 | 0.0118 | 0.0087 | 0.0126 | 0.0157 | 0.0102 | 0.0134 | 0.0165 | 0.0118 | 0.0142 | 0.0173 | 0.0126 | 0.0150 | 0.0197 | 0.0126 | 0.0150 | 0.0197 |
| 0.0079 | 0.0098 | 0.0118 | 0.0087 | 0.0126 | 0.0157 | 0.0102 | 0.0134 | 0.0165 | 0.0118 | 0.0142 | 0.0173 | 0.0126 | 0.0150 | 0.0197 | 0.0126 | 0.0150 | 0.0197 |
| **Geometry -MM, -PM and -GP** | | | | | | | | | | | | | | | | | |
| 0.0031 | 0.0039 | 0.0055 | 0.0031 | 0.0043 | 0.0055 | 0.0039 | 0.0047 | 0.0055 | 0.0043 | 0.0051 | 0.0063 | 0.0047 | 0.0059 | 0.0079 | 0.0047 | 0.0059 | 0.0079 |
| 0.0035 | 0.0047 | 0.0059 | 0.0039 | 0.0055 | 0.0063 | 0.0047 | 0.0063 | 0.0079 | 0.0055 | 0.0071 | 0.0087 | 0.0063 | 0.0079 | 0.0098 | 0.0071 | 0.0087 | 0.0106 |

# CoroDrill® 870

≥ 6 x DC

**Inch values**

| ISO | MC No. | CMC No. | Material | Hardness Brinell (HB) | Cutting speed ($V_c$) ft/min correlating with drill diameter .3937-.8264" Min. | Rec. | Max | .8268-1.2992" Min. | Rec. | Max |
|---|---|---|---|---|---|---|---|---|---|---|
| P | | | **Unalloyed steel** | | | | **Grade 4334** | | | |
| | P1.1.Z.AN | 01.1 | C=0.10-0.25% | 125 | 260 | 395 | 525 | 260 | 395 | 525 |
| | P1.2.Z.AN | 01.2 | C=0.25-0.55% | 190 | 260 | 395 | 525 | 260 | 395 | 525 |
| | P1.3.Z.AN | 01.3 | C=0.55-0.80% | 190 | 230 | 330 | 425 | 230 | 330 | 425 |
| | P1.5.C.UT | 06.1 | Cast - untreated | 150 | 260 | 360 | 460 | 260 | 360 | 460 |
| | | | **Low alloy steel** | | | | **Grade 4334 and 3334** | | | |
| | P2.1.Z.AN | 02.1 | Annealed | 175 | 260 | 360 | 460 | 260 | 360 | 460 |
| | P2.2.Z.AN | 02.1 | Annealed | 240 | 260 | 360 | 460 | 260 | 360 | 460 |
| | P2.4.Z.AN | 02.1 | Annealed | 225 | 260 | 360 | 460 | 260 | 360 | 460 |
| | P2.5.Z.HT | 02.2 | Hardened and tempered | 330 | 230 | 330 | 425 | 165 | 245 | 330 |
| | P2.6.C.UT | 06.2 | Cast - untreated | 200 | 230 | 330 | 425 | 230 | 330 | 425 |
| | | | **High alloy steel** | | | | | | | |
| | P3.0.Z.AN | 03.11 | Annealed | 200 | 195 | 260 | 330 | 195 | 260 | 330 |
| | P3.0.Z.HT | 03.21 | Hardened and tempered | 380 | 130 | 195 | 260 | 130 | 195 | 260 |
| M | | | **Ferritic/martensitic stainless steel** | | | | **Grade 4334 and 2334** | | | |
| | P5.0.Z.AN | 05.11 | Annealed | 200 | 100 | 130 | 165 | 100 | 130 | 165 |
| | P5.0.Z.HT | 05.13 | Hardened and tempered | 330 | 230 | 295 | 360 | 195 | 245 | 295 |
| | | | **Austenitic stainless steel** | | | | **Grade 2334 and 4334** | | | |
| | M1.0.Z.AQ | 05.21 | Annealed/quenched | 200 | 130 | 165 | 195 | 130 | 165 | 195 |
| | M1.0.C.UT | 15.21 | Cast+untreated | 200 | 165 | 195 | 230 | 165 | 195 | 230 |
| | M1.1.Z.AQ | 05.21 | Machinability improved | 200 | 195 | 245 | 295 | 195 | 245 | 295 |
| | | | **Super-austenitic (Ni≥20%) stainless steel** | | | | | | | |
| | M2.0.Z.AQ | 05.23 | Annealed/quenched | 200 | 65 | 130 | 195 | 65 | 130 | 195 |
| | M2.0.C.AQ | 15.23 | Cast+annealed/quenched | 200 | 65 | 130 | 195 | 65 | 130 | 195 |
| | | | **Duplex (austenitic/ferritic) stainless steel** | | | | **Grade 2334** | | | |
| | M3.1.Z.AQ | 05.51 | >60% ferrite (N<0.10%) | 230 | 130 | 180 | 230 | 130 | 180 | 230 |
| | M3.2.Z.AQ | 05.52 | <60% ferrite (N≥0.10%) | 260 | 65 | 130 | 195 | 65 | 130 | 195 |
| K | | | **Malleable cast iron** | | | | **Grade 3334 and 4334** | | | |
| | K1.1.C.NS | 07.1 | Ferritic (short chipping) | 130 | 330 | 425 | 560 | 330 | 425 | 560 |
| | K1.1.C.NS | 07.2 | Pearlitic (long chipping) | 200 | 295 | 380 | 475 | 295 | 380 | 475 |
| | | | **Gray cast iron** | | | | | | | |
| | K2.1.C.UT | 08.1 | Low tensile strength | 180 | 330 | 440 | 590 | 330 | 440 | 590 |
| | K2.2.C.UT | 08.2 | High tensile strength | 245 | 295 | 395 | 510 | 295 | 395 | 510 |
| | | | **Nodular cast iron** | | | | | | | |
| | K3.1.C.UT | 09.1 | Ferritic | 155 | 330 | 425 | 560 | 330 | 425 | 560 |
| | K3.3.C.UT | 09.2 | Pearlitic | 265 | 295 | 380 | 475 | 295 | 380 | 475 |
| N | | | **Aluminum based alloys** | | | | **Grade 4334** | | | |
| | N1.2.Z.AG | 30.12 | AlSi alloys, Si ≤ 1% | 100 | 490 | 650 | 820 | 490 | 650 | 820 |
| | N1.3.C.AG | 30.22 | AlSi cast alloys, Si > 1% and < 13% | 80 | 490 | 650 | 820 | 490 | 650 | 820 |
| S | | | **Heat resistant super alloys** | | | | **Grade 2334 and 4334** | | | |
| | S2.0.Z.AG | 20.22 | Ni based | 350 | 60 | 65 | 100 | 60 | 65 | 100 |
| | S4.3.Z.AN | 23.21 | Titanium based | 330 | 80 | 130 | 195 | 80 | 130 | 195 |



SANDVIK Coromant

# CoroDrill® 870

≥ 6 x DC

Inch values

| Feed ($f_n$) inch/rev. correlating with drill diameter | | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| .3937-.4720" | | | .4724-.5508" | | | .5512-.6295" | | | .6299-.8264" | | | .8268-1.0232" | | | 1.0237-1.2992" | | |
| Min. | Rec. | Max | Min. | Rec. | Max | Min. | Rec. | Max | Min. | Rec. | Max | Min. | Rec. | Max | Min. | Rec. | Max |
| **Geometry -PM** | | | | | | | | | | | | | | | | | |
| 0.0047 | 0.0057 | 0.0088 | 0.0055 | 0.0063 | 0.0110 | 0.0063 | 0.0079 | 0.0129 | 0.0079 | 0.0101 | 0.0142 | 0.0079 | 0.0107 | 0.0142 | 0.0079 | 0.0107 | 0.0142 |
| 0.0047 | 0.0057 | 0.0088 | 0.0055 | 0.0063 | 0.0110 | 0.0063 | 0.0079 | 0.0129 | 0.0079 | 0.0101 | 0.0142 | 0.0079 | 0.0107 | 0.0142 | 0.0079 | 0.0107 | 0.0142 |
| 0.0047 | 0.0057 | 0.0088 | 0.0055 | 0.0063 | 0.0110 | 0.0063 | 0.0079 | 0.0129 | 0.0079 | 0.0101 | 0.0142 | 0.0079 | 0.0107 | 0.0142 | 0.0079 | 0.0107 | 0.0142 |
| 0.0047 | 0.0057 | 0.0088 | 0.0055 | 0.0063 | 0.0110 | 0.0063 | 0.0079 | 0.0129 | 0.0079 | 0.0101 | 0.0142 | 0.0079 | 0.0107 | 0.0142 | 0.0079 | 0.0107 | 0.0142 |
| **Geometry -PM and -KM** | | | | | | | | | | | | | | | | | |
| 0.0047 | 0.0057 | 0.0094 | 0.0055 | 0.0063 | 0.0117 | 0.0063 | 0.0079 | 0.0142 | 0.0079 | 0.0101 | 0.0151 | 0.0079 | 0.0113 | 0.0157 | 0.0079 | 0.0126 | 0.0164 |
| 0.0047 | 0.0057 | 0.0094 | 0.0055 | 0.0063 | 0.0117 | 0.0063 | 0.0079 | 0.0142 | 0.0079 | 0.0101 | 0.0151 | 0.0079 | 0.0113 | 0.0157 | 0.0079 | 0.0126 | 0.0164 |
| 0.0047 | 0.0057 | 0.0094 | 0.0055 | 0.0063 | 0.0117 | 0.0063 | 0.0079 | 0.0142 | 0.0079 | 0.0101 | 0.0151 | 0.0079 | 0.0113 | 0.0157 | 0.0079 | 0.0126 | 0.0164 |
| 0.0047 | 0.0050 | 0.0083 | 0.0055 | 0.0059 | 0.0102 | 0.0063 | 0.0069 | 0.0124 | 0.0079 | 0.0088 | 0.0132 | 0.0079 | 0.0099 | 0.0138 | 0.0079 | 0.0110 | 0.0143 |
| 0.0047 | 0.0057 | 0.0094 | 0.0055 | 0.0063 | 0.0117 | 0.0063 | 0.0079 | 0.0142 | 0.0079 | 0.0101 | 0.0151 | 0.0079 | 0.0113 | 0.0157 | 0.0079 | 0.0126 | 0.0164 |
| 0.0039 | 0.0050 | 0.0076 | 0.0047 | 0.0060 | 0.0104 | 0.0055 | 0.0069 | 0.0120 | 0.0071 | 0.0079 | 0.0126 | 0.0071 | 0.0094 | 0.0142 | 0.0071 | 0.0094 | 0.0142 |
| 0.0039 | 0.0044 | 0.0066 | 0.0047 | 0.0052 | 0.0091 | 0.0055 | 0.0061 | 0.0105 | 0.0071 | 0.0075 | 0.0110 | 0.0071 | 0.0083 | 0.0124 | 0.0071 | 0.0083 | 0.0124 |
| **Geometry -PM and -MM** | | | | | | | | | | | | | | | | | |
| 0.0047 | 0.0051 | 0.0060 | 0.0055 | 0.0059 | 0.0069 | 0.0055 | 0.0059 | 0.0076 | 0.0071 | 0.0076 | 0.0094 | 0.0087 | 0.0091 | 0.0107 | 0.0087 | 0.0091 | 0.0107 |
| 0.0039 | 0.0043 | 0.0047 | 0.0039 | 0.0043 | 0.0047 | 0.0047 | 0.0051 | 0.0055 | 0.0055 | 0.0059 | 0.0063 | 0.0063 | 0.0067 | 0.0072 | 0.0063 | 0.0067 | 0.0072 |
| **Geometry -MM and -PM** | | | | | | | | | | | | | | | | | |
| 0.0039 | 0.0043 | 0.0047 | 0.0039 | 0.0043 | 0.0047 | 0.0047 | 0.0051 | 0.0055 | 0.0047 | 0.0050 | 0.0063 | 0.0055 | 0.0059 | 0.0069 | 0.0055 | 0.0059 | 0.0069 |
| 0.0039 | 0.0043 | 0.0047 | 0.0039 | 0.0043 | 0.0047 | 0.0047 | 0.0051 | 0.0055 | 0.0047 | 0.0050 | 0.0063 | 0.0055 | 0.0059 | 0.0069 | 0.0055 | 0.0059 | 0.0069 |
| 0.0039 | 0.0043 | 0.0050 | 0.0039 | 0.0043 | 0.0050 | 0.0047 | 0.0051 | 0.0057 | 0.0055 | 0.0059 | 0.0069 | 0.0055 | 0.0059 | 0.0076 | 0.0055 | 0.0059 | 0.0076 |
| 0.0039 | 0.0043 | 0.0047 | 0.0039 | 0.0043 | 0.0050 | 0.0039 | 0.0043 | 0.0050 | 0.0039 | 0.0044 | 0.0050 | 0.0047 | 0.0051 | 0.0057 | 0.0047 | 0.0051 | 0.0057 |
| 0.0039 | 0.0043 | 0.0047 | 0.0039 | 0.0043 | 0.0050 | 0.0039 | 0.0043 | 0.0050 | 0.0039 | 0.0044 | 0.0050 | 0.0047 | 0.0051 | 0.0057 | 0.0047 | 0.0051 | 0.0057 |
| **Geometry -MM** | | | | | | | | | | | | | | | | | |
| 0.0039 | 0.0043 | 0.0050 | 0.0039 | 0.0043 | 0.0050 | 0.0047 | 0.0051 | 0.0057 | 0.0055 | 0.0059 | 0.0069 | 0.0055 | 0.0059 | 0.0069 | 0.0055 | 0.0059 | 0.0069 |
| 0.0039 | 0.0043 | 0.0047 | 0.0039 | 0.0043 | 0.0050 | 0.0047 | 0.0051 | 0.0055 | 0.0047 | 0.0050 | 0.0063 | 0.0047 | 0.0050 | 0.0063 | 0.0047 | 0.0050 | 0.0063 |
| **Geometry -KM and -PM** | | | | | | | | | | | | | | | | | |
| 0.0063 | 0.0079 | 0.0113 | 0.0071 | 0.0094 | 0.0132 | 0.0083 | 0.0117 | 0.0151 | 0.0098 | 0.0139 | 0.0173 | 0.0118 | 0.0151 | 0.0189 | 0.0118 | 0.0157 | 0.0189 |
| 0.0063 | 0.0079 | 0.0113 | 0.0071 | 0.0094 | 0.0132 | 0.0083 | 0.0117 | 0.0151 | 0.0098 | 0.0139 | 0.0173 | 0.0118 | 0.0151 | 0.0189 | 0.0118 | 0.0157 | 0.0189 |
| 0.0063 | 0.0079 | 0.0113 | 0.0071 | 0.0094 | 0.0132 | 0.0083 | 0.0117 | 0.0151 | 0.0098 | 0.0139 | 0.0173 | 0.0118 | 0.0151 | 0.0189 | 0.0118 | 0.0157 | 0.0189 |
| 0.0063 | 0.0079 | 0.0113 | 0.0071 | 0.0094 | 0.0132 | 0.0083 | 0.0117 | 0.0151 | 0.0098 | 0.0139 | 0.0173 | 0.0118 | 0.0151 | 0.0189 | 0.0118 | 0.0157 | 0.0189 |
| 0.0063 | 0.0079 | 0.0113 | 0.0071 | 0.0094 | 0.0132 | 0.0083 | 0.0117 | 0.0151 | 0.0098 | 0.0139 | 0.0173 | 0.0118 | 0.0151 | 0.0189 | 0.0118 | 0.0157 | 0.0189 |
| 0.0063 | 0.0079 | 0.0113 | 0.0071 | 0.0094 | 0.0132 | 0.0083 | 0.0117 | 0.0151 | 0.0098 | 0.0139 | 0.0173 | 0.0118 | 0.0151 | 0.0189 | 0.0118 | 0.0157 | 0.0189 |
| **Geometry -PM** | | | | | | | | | | | | | | | | | |
| 0.0079 | 0.0087 | 0.0110 | 0.0087 | 0.0094 | 0.0138 | 0.0102 | 0.0110 | 0.0150 | 0.0118 | 0.0126 | 0.0157 | 0.0126 | 0.0134 | 0.0177 | 0.0126 | 0.0134 | 0.0177 |
| 0.0079 | 0.0087 | 0.0110 | 0.0087 | 0.0094 | 0.0138 | 0.0102 | 0.0110 | 0.0150 | 0.0118 | 0.0126 | 0.0157 | 0.0126 | 0.0134 | 0.0177 | 0.0126 | 0.0134 | 0.0177 |
| **Geometry -MM and -PM** | | | | | | | | | | | | | | | | | |
| 0.0031 | 0.0039 | 0.0055 | 0.0031 | 0.0043 | 0.0055 | 0.0039 | 0.0047 | 0.0055 | 0.0043 | 0.0051 | 0.0063 | 0.0047 | 0.0059 | 0.0079 | 0.0047 | 0.0059 | 0.0079 |
| 0.0035 | 0.0043 | 0.0055 | 0.0039 | 0.0047 | 0.0059 | 0.0047 | 0.0055 | 0.0071 | 0.0055 | 0.0063 | 0.0079 | 0.0063 | 0.0071 | 0.0087 | 0.0071 | 0.0079 | 0.0098 |

# CoroDrill® DS20

**4-5xD**

**Metric values**

| 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 starting value at middle of feed range | | | | | | | | | |
| | | | | | | | | | $f_n$ 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 |
| P | 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

# CoroDrill® DS20

## 4-5xD

### Metric values

| 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 starting value at middle of feed range | | | | | | | | | |
| P | P3.0.Z.HT | High alloy steel Hardened and tempered | 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** | - |
| | | | | 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 Annealed | 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 |
| | | | | 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 Hardened and tempered | 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 |
| | | | | 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 Annealed/quenched | 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 |
| | | | | 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 Machinability improved | 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 |
| | | | | 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 Annealed/quenched | 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 |
| | | | | | | | | 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 >60% ferrite (N<0.10%) | 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 |
| | | | | 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 <60% ferrite (N>0.10%) | 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 |
| | | | | 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 S2.0.Z.AG S2.0.Z.NS | Heat resistant super alloys Ni based | 350 | 4334 | 20 | 40 | 50 | 15.00-18.00 | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 | - | - | 0.04-0.07 | **0.04-0.07** | 0.04-0.07 | - | - |
| | | | | 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 | - | - |
| | | | | 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 S4.3.Z.AG | Heat resistant super alloys Ti based | 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 | - | - |
| | | | | 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

**4-5xD**

**Metric values**

| 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 starting value at middle of feed range | | | | | | | | | |
| K | K1.1.C.NS | Malleable cast iron Low tensile strength | 200 | 4324 | 140 | 210 | 245 | 15.00-18.00 | - | 0.08-0.15 | 0.08-0.15 | **0.08-0.2** | - | - | 0.08-0.13 | 0.08-0.13 | **0.08-0.17** | - |
| | | | | 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 Low tensile strength | 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** | - |
| | | | | 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 High tensile strength | 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** | - |
| | | | | 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 Ferritic | 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** | - |
| | | | | 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 Pearlitic | 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** | - |
| | | | | 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 High tensile strength (Pearlite>90%) | 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** | - |
| | | | | 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 Hardened & tempered | 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 | - |
| | | | | 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 | - |

# CoroDrill® DS20

## 4-5xD

### Metric values

| 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 starting value at middle of feed range | | | | | | | | | |
| N | N1.2.Z.AG | Aluminum based alloys AlSi alloys (Si<1%) | 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 | - | - |
| | | | | 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 AlSi cast alloys (1%< Si >13%) | 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 | - | - |
| | | | | 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 AlSi cast and aged alloys (1%< Si >13%) | 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 | - | - |
| | | | | 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 Free cutting 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 | - | - |
| | | | | 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 Leaded brass and bronzes (Pb<1%) | 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 | - | - |
| | | | | 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

## 6-7xD

## Metric values

| 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 starting value at middle of feed range | | | | | | | | | |
| | | | | | | | | | $f_n$ 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 |
| P | P1.0.Z.AN | Unalloyed steel C=0.05-0.10% | 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 |
| | | | | 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 C=0.05-0.25% | 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 |
| | | | | 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 C=0.25-0.55% | 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** | - |
| | | | | 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 C=0.55-0.80% | 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** | - |
| | | | | 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 Cast - untreated | 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** | - |
| | | | | 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 Annealed | 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** | - |
| | | | | 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 Annealed | 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** | - |
| | | | | 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 Hardened and tempered | 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** | - |
| | | | | 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 Cast - untreated | 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** | - |
| | | | | 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 Annealed | 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** | - |
| | | | | 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

# CoroDrill® DS20

## 6-7xD

## Metric values

| 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 starting value at middle of feed range | | | | | | | | | |
| P | P3.0.Z.HT | High alloy steel Hardened & tempered | 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** | - |
| | | | | 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 Annealed | 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 |
| | | | | 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 Hardened & tempered | 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 |
| | | | | 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 Annealed/quenched | 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 |
| | | | | 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 Machinability improved | 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 |
| | | | | 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 Annealed/quenched | 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 |
| | | | | | | | | 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 >60% ferrite (N<0.10%) | 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 |
| | | | | 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 <60% ferrite (N>0.10%) | 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 |
| | | | | 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 S2.0.Z.AG S2.0.Z.NS | Heat resistant super alloys Ni based | 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 | - | - |
| | | | | 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 | - | - |
| | | | | 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 S4.3.Z.AG | Heat resistant super alloys Ti based | 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 | - | - |
| | | | | 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. For feed at hole exit, use 0.05 mm/rev.

# CoroDrill® DS20

## 6-7xD

## Metric values

| ISO | MC No. | Material | HB | Grade | Cutting speed recommendations 6-7xD | | | Drill diameter | Drill length 6xD Recommended starting value at middle of feed range | | | | | Drill length 7xD Recommended starting value at middle of feed range | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | -S5W | -L5W | -L6W | -M7W | -H5W | -S5W | -L5W | -L6W | -M7W | -H5W |
| K | K1.1.C.NS | Malleable cast iron Low tensile strength | 200 | 4324 | 140 | 190 | 220 | 15.00-18.00 | - | 0.08-0.1 | 0.08-0.1 | **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** | - |

# CoroDrill® DS20

## 6-7xD

### Metric values

| 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 starting value at middle of feed range | | | | | | | | | |
| N | N1.2.Z.AG | Aluminum based alloys AlSi alloys (Si<1%) | 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 | - | - |
| | | | | 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 AlSi cast alloys (1%< Si >13%) | 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 | - | - |
| | | | | 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 AlSi cast and aged alloys (1%< Si >13%) | 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 | - | - |
| | | | | 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 Free cutting 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 | - | - |
| | | | | 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 Leaded brass and bronzes (Pb<1%) | 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 | - | - |
| | | | | 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. For feed at hole exit, use 0.05 mm/rev.

# CoroDrill® DS20

**4-5xD**

**Inch values**

| 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 starting value at middle of feed range | | | | | Recommended starting value at middle of feed range | | | | |
| P | | | | | | | | | $f_n$ inch/rev | $f_n$ inch/rev | $f_n$ inch/rev | $f_n$ inch/rev | $f_n$ inch/rev | $f_n$ inch/rev | $f_n$ inch/rev | $f_n$ inch/rev | $f_n$ inch/rev | $f_n$ inch/rev |
| | P1.0.Z.AN | Unalloyed steel | 110 | 4324 | 755 | 1115 | 1310 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.004 |
| | | C=0.05-0.10% | | 4334 | 690 | 935 | 1065 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.004 |
| | | | | 4344 | 625 | 740 | 805 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | | | | | 1.063-1.299 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.005 |
| | | | | | | | | 1.299-1.575 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.006 |
| | | | | | | | | 1.575-2.047 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.006 |
| | | | | | | | | 2.047-2.559 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.006 |
| | P1.1.Z.AN | Unalloyed steel | 125 | 4324 | 755 | 1055 | 1215 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | C=0.05-0.25% | | 4334 | 655 | 880 | 1000 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 560 | 695 | 770 | 0.866-1.063 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | | | | | 1.063-1.299 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.299-1.575 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 |
| | | | | | | | | 1.575-2.047 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 |
| | | | | | | | | 2.047-2.559 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.006 |
| | P1.2.Z.AN | Unalloyed steel | 190 | 4324 | 625 | 870 | 1000 | 0.591-0.709 | - | 0.002-0.005 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.004 | 0.002-0.005 | **0.002-0.005** | - |
| | | C=0.25-0.55% | | 4334 | 510 | 710 | 820 | 0.709-0.866 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.007** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 395 | 545 | 625 | 0.866-1.063 | - | 0.002-0.007 | 0.002-0.008 | **0.002-0.009** | - | - | 0.002-0.006 | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.009 | 0.003-0.009 | **0.003-0.01** | - | - | 0.003-0.007 | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.009 | 0.003-0.01 | **0.003-0.011** | - | - | 0.003-0.008 | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.009 | 0.004-0.01 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.009 | 0.004-0.01 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.009 | **0.004-0.009** | - |
| | P1.3.Z.AN | Unalloyed steel | 190 | 4324 | 560 | 815 | 950 | 0.591-0.709 | - | 0.002-0.005 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.004 | 0.002-0.005 | **0.002-0.005** | - |
| | | C=0.55-0.80% | | 4334 | 460 | 670 | 785 | 0.709-0.866 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.007** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 345 | 515 | 605 | 0.866-1.063 | - | 0.002-0.007 | 0.002-0.008 | **0.002-0.009** | - | - | 0.002-0.006 | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.009 | 0.003-0.009 | **0.003-0.01** | - | - | 0.003-0.007 | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.009 | 0.003-0.01 | **0.003-0.011** | - | - | 0.003-0.008 | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.009 | 0.004-0.01 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.009 | 0.004-0.01 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.009 | **0.004-0.009** | - |
| | P1.5.C.UT | Unalloyed steel | 150 | 4324 | 460 | 855 | 1065 | 0.591-0.709 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - |
| | | Cast - untreated | | 4334 | 445 | 720 | 870 | 0.709-0.866 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - |
| | | | | 4344 | 410 | 570 | 655 | 0.866-1.063 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 1.299-1.575 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 1.575-2.047 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 2.047-2.559 | - | 0.002-0.006 | 0.002-0.006 | **0.002-0.006** | - | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | - |
| | P2.1.Z.AN | Low alloy steel | 175 | 4324 | 590 | 855 | 1000 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | Annealed | | 4334 | 490 | 705 | 820 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 375 | 540 | 625 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | P2.2.Z.AN | Low alloy steel | 240 | 4324 | 590 | 825 | 950 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | Annealed | | 4334 | 490 | 655 | 740 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 375 | 565 | 670 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | 0.003-0.009 | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | P2.5.Z.HT | Low alloy steel | 330 | 4324 | 295 | 625 | 805 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | Hardened and tempered | | 4334 | 280 | 515 | 640 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 245 | 405 | 490 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | P2.6.C.UT | Low alloy steel | 200 | 4324 | 360 | 690 | 870 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | Cast - untreated | | 4334 | 345 | 570 | 690 | 0.709-0.866 | - | - | 0.002-0.007 | **0.002-0.008** | - | - | - | 0.002-0.006 | **0.002-0.007** | - |
| | | | | 4344 | 330 | 455 | 525 | 0.866-1.063 | - | - | 0.002-0.009 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.011 | **0.003-0.012** | - | - | - | 0.003-0.009 | **0.003-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.011 | **0.004-0.012** | - | - | - | 0.004-0.009 | **0.004-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.011 | **0.004-0.012** | - | - | - | 0.004-0.009 | **0.004-0.01** | - |
| | P3.0.Z.AN | High alloy steel | 200 | 4324 | 525 | 800 | 950 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | Annealed | | 4334 | 425 | 660 | 785 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 330 | 500 | 590 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |



SANDVIK Coromant

# CoroDrill® DS20

## 4-5xD

## Inch values

| 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 starting value at middle of feed range | | | | | Recommended starting value at middle of feed range | | | | |
| P | P3.0.Z.HT | High alloy steel | 380 | 4324 | 260 | 540 | 690 | 0.591-0.709 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | Hardened and tempered | | 4334 | 245 | 460 | 575 | 0.709-0.866 | - | - | 0.002-0.006 | **0.002-0.007** | - | - | - | 0.002-0.005 | **0.002-0.006** | - |
| | | | | 4344 | 230 | 355 | 425 | 0.866-1.063 | - | - | 0.002-0.008 | **0.002-0.009** | - | - | - | 0.002-0.007 | **0.002-0.007** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.009 | **0.003-0.01** | - | - | - | 0.003-0.008 | **0.003-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.01 | **0.003-0.011** | - | - | - | 0.003-0.009 | **0.003-0.009** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.01 | **0.004-0.011** | - | - | - | 0.004-0.009 | **0.004-0.009** | - |
| | P5.0.Z.AN | Ferritic/martensitic stainless steel | 200 | 4334 | 375 | 610 | 740 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 375 | 505 | 575 | 0.709-0.866 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | Annealed | | 2044 | 375 | 480 | 540 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.007 | **0.003-0.007** | 0.003-0.007 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | P5.0.Z.HT | Ferritic/martensitic stainless steel | 330 | 4334 | 245 | 450 | 560 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 230 | 380 | 460 | 0.709-0.866 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | Hardened and tempered | | 2044 | 230 | 380 | 460 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.006 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.007 | **0.003-0.007** | 0.003-0.007 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| M | M1.0.Z.AQ | Austenitic stainless steel | 200 | 4334 | 375 | 610 | 740 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 375 | 540 | 625 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | Annealed/quenched | | 2044 | 375 | 515 | 590 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | M1.1.Z.AQ | Austenitic Stainless steel | 200 | 4334 | 375 | 640 | 785 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 375 | 580 | 690 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | Machinability improved | | 2044 | 375 | 555 | 655 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | M2.0.Z.AQ | Super austenitic (Ni>20%) stainless steel | 200 | 4334 | 260 | 410 | 490 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | | | 4344 | 260 | 360 | 410 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 260 | 360 | 410 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | Annealed/quenched | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | M3.1.Z.AQ | Duplex stainless steel | 230 | 4334 | 280 | 405 | 475 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | >60% ferrite (N<0.10%) | | 4344 | 280 | 375 | 425 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 280 | 365 | 410 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | M3.2.Z.AQ | Duplex stainless steel | 260 | 4334 | 245 | 345 | 395 | 0.591-0.709 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 |
| | | <60% ferrite (N≥0.10%) | | 4344 | 245 | 330 | 375 | 0.709-0.866 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.004 |
| | | | | 2044 | 245 | 330 | 375 | 0.866-1.063 | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | 0.002-0.005 |
| | | | | | | | | 1.063-1.299 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 |
| | | | | | | | | 1.299-1.575 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | 0.003-0.005 |
| | | | | | | | | 1.575-2.047 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| | | | | | | | | 2.047-2.559 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - | 0.004-0.005 |
| S | S2.0.Z.AN | Heat resistant super alloys | 350 | 4334 | 65 | 130 | 165 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | S2.0.Z.AG | Ni based | | 4344 | 65 | 130 | 165 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | S2.0.Z.NS | | | 2044 | 65 | 130 | 165 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | | | | | | | | 1.299-1.575 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | | | | | | | | 1.575-2.047 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | | | | | | | | 2.047-2.559 | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - |
| | S4.2.Z.AN | Heat resistant super alloys | 330 | H13A | 130 | 300 | 395 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | S4.3.Z.AG | Ti-based | | 4344 | 130 | 300 | 395 | 0.709-0.866 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | | | 2044 | 130 | 300 | 395 | 0.866-1.063 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - |

# CoroDrill® DS20

**4-5xD**

**Inch values**

| 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 starting value at middle of feed range | | | | | Recommended starting value at middle of feed range | | | | |
| K | K1.1.C.NS | Malleable cast iron | 200 | 4324 | 460 | 685 | 805 | 0.591-0.709 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | Low tensile strength | | 4334 | 360 | 550 | 655 | 0.709-0.866 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | 4344 | 590 | 540 | 510 | 0.866-1.063 | - | 0.003-0.008 | 0.003-0.008 | **0.003-0.01** | - | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.011 | 0.004-0.011 | **0.004-0.013** | - | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.011 | 0.005-0.011 | **0.005-0.013** | - | - | 0.005-0.009 | 0.005-0.009 | **0.005-0.011** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.011 | 0.005-0.011 | **0.005-0.013** | - | - | 0.005-0.009 | 0.005-0.009 | **0.005-0.011** | - |
| | K2.1.C.UT | Gray cast iron | 180 | 4324 | 690 | 935 | 1065 | 0.591-0.709 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | Low tensile strength | | 4334 | 560 | 770 | 885 | 0.709-0.866 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | 4344 | 425 | 585 | 670 | 0.866-1.063 | - | 0.003-0.008 | 0.003-0.008 | **0.003-0.01** | - | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.011 | 0.004-0.011 | **0.004-0.013** | - | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.011 | 0.005-0.011 | **0.005-0.013** | - | - | 0.005-0.009 | 0.005-0.009 | **0.005-0.011** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.011 | 0.005-0.011 | **0.005-0.013** | - | - | 0.005-0.009 | 0.005-0.009 | **0.005-0.011** | - |
| | K2.2.C.UT | Gray cast iron | 245 | 4324 | 410 | 665 | 805 | 0.591-0.709 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.006** | - |
| | | High tensile strength | | 4334 | 330 | 530 | 640 | 0.709-0.866 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4344 | 245 | 405 | 490 | 0.866-1.063 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.01 | 0.004-0.01 | **0.004-0.012** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | K3.1.C.UT | Nodular cast iron | 155 | 4324 | 410 | 625 | 740 | 0.591-0.709 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.006** | - |
| | | Ferritic | | 4334 | 330 | 510 | 605 | 0.709-0.866 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4344 | 260 | 400 | 475 | 0.866-1.063 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.01 | 0.004-0.01 | **0.004-0.012** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | K3.3.C.UT | Nodular cast iron | 265 | 4324 | 360 | 575 | 690 | 0.591-0.709 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.006** | - |
| | | Ferritic | | 4334 | 295 | 475 | 575 | 0.709-0.866 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4344 | 230 | 355 | 425 | 0.866-1.063 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.01 | 0.004-0.01 | **0.004-0.012** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | K4.2.C.UT | Compacted graphite iron | 230 | 4324 | 425 | 680 | 820 | 0.591-0.709 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.006** | - |
| | | High tensile strength | | 4334 | 360 | 550 | 655 | 0.709-0.866 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - |
| | | | | 4344 | 280 | 415 | 490 | 0.866-1.063 | - | 0.003-0.007 | 0.003-0.007 | **0.003-0.009** | - | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.008** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.009 | 0.004-0.009 | **0.004-0.011** | - | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.009** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.01 | 0.004-0.01 | **0.004-0.012** | - | - | 0.004-0.008 | 0.004-0.008 | **0.004-0.01** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.01 | 0.005-0.01 | **0.005-0.012** | - | - | 0.005-0.008 | 0.005-0.008 | **0.005-0.01** | - |
| H | H1.3.Z.HA | Extra hard steel | 60 (HRC) | 4324 | 100 | 215 | 280 | 0.591-0.709 | - | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - |
| | | Hardened and tempered | | 4334 | 100 | 215 | 280 | 0.709-0.866 | - | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | - | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - |
| | | | | 4344 | 100 | 215 | 280 | 0.866-1.063 | - | 0.002-0.006 | **0.002-0.006** | 0.002-0.006 | - | - | 0.002-0.005 | **0.002-0.005** | 0.002-0.005 | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - | - | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.007 | **0.003-0.007** | 0.003-0.007 | - | - | 0.003-0.006 | **0.003-0.006** | 0.003-0.006 | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | - | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.007 | **0.004-0.007** | 0.004-0.007 | - | - | 0.004-0.006 | **0.004-0.006** | 0.004-0.006 | - |



SANDVIK Coromant

# CoroDrill® DS20

## 4-5xD

## Inch values

| 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 starting value at middle of feed range | | | | | Recommended starting value at middle of feed range | | | | |
| N | N1.2.Z.AG | Aluminum based alloys | 100 | H13A | 985 | 1195 | 1310 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | AlSi alloys, Si ≤ 1% | | 4344 | 985 | 1195 | 1310 | 0.709-0.866 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.008** | 0.002-0.008 | 0.002-0.008 | - | - | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.01** | 0.003-0.01 | 0.003-0.01 | - | - | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | N1.3.C.UT | Aluminum based alloys | 75 | H13A | 820 | 1140 | 1310 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | AlSi alloys, Si ≤ 1% | | 4344 | 820 | 1140 | 1310 | 0.709-0.866 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.009** | 0.004-0.009 | 0.004-0.009 | - | - | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.009** | 0.004-0.009 | 0.004-0.009 | - | - | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - |
| | N1.3.C.AG | Aluminum based alloys | 90 | H13A | 820 | 1035 | 1150 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | AlSi cast and aged alloys (1%< Si >13%) | | 4344 | 820 | 1035 | 1150 | 0.709-0.866 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.009** | 0.004-0.009 | 0.004-0.009 | - | - | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.009** | 0.004-0.009 | 0.004-0.009 | - | - | **0.004-0.007** | 0.004-0.007 | 0.004-0.007 | - | - |
| | N3.3.U.UT | Copper based alloys | 110 | H13A | 820 | 1140 | 1310 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | Free cutting copper based alloys | | 4344 | 820 | 1140 | 1310 | 0.709-0.866 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.008** | 0.002-0.008 | 0.002-0.008 | - | - | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.01** | 0.003-0.01 | 0.003-0.01 | - | - | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | N3.2.C.UT | Copper based alloys | 90 | H13A | 590 | 715 | 785 | 0.591-0.709 | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - |
| | | Leaded brass & bronzes (Pb ≤ 1%) | | 4344 | 590 | 715 | 785 | 0.709-0.866 | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - | **0.002-0.006** | 0.002-0.006 | 0.002-0.006 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.008** | 0.002-0.008 | 0.002-0.008 | - | - | **0.002-0.007** | 0.002-0.007 | 0.002-0.007 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.009** | 0.003-0.009 | 0.003-0.009 | - | - | **0.003-0.007** | 0.003-0.007 | 0.003-0.007 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.01** | 0.003-0.01 | 0.003-0.01 | - | - | **0.003-0.008** | 0.003-0.008 | 0.003-0.008 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.01** | 0.004-0.01 | 0.004-0.01 | - | - | **0.004-0.008** | 0.004-0.008 | 0.004-0.008 | - | - |

# CoroDrill® DS20

**6-7xD**

**Inch values**

| ISO | MC No. | Material | HB | Grade | Cutting data recommendations 6-7xD Min. | Rec. | Max | Drill diameter | Drill length 6xD -S5W fn inch/rev | -L5W fn inch/rev | -L6W fn inch/rev | -M7W fn inch/rev | -H5W fn inch/rev | Drill length 7xD -S5W fn inch/rev | -L5W fn inch/rev | -L6W fn inch/rev | -M7W fn inch/rev | -H5W fn inch/rev |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Recommended starting value at middle of feed range | | | | | Recommended starting value at middle of feed range | | | | |
| P | P1.0.Z.AN | Unalloyed steel C=0.05-0.10% | 110 | 4324 | 755 | 1005 | 1180 | 0.591-0.709 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 | **0.002-0.002** | 0.002-0.002 | 0.002-0.002 | - | 0.002-0.003 |
| | | | | 4334 | 690 | 840 | 960 | 0.709-0.866 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 | **0.002-0.002** | 0.002-0.002 | 0.002-0.002 | - | 0.002-0.003 |
| | | | | 4344 | 625 | 665 | 725 | 0.866-1.063 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.299-1.575 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 |
| | | | | | | | | 1.575-2.047 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 |
| | | | | | | | | 2.047-2.559 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.004 |
| | P1.1.Z.AN | Unalloyed steel C=0.05-0.25% | 125 | 4324 | 755 | 950 | 1095 | 0.591-0.709 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4334 | 655 | 790 | 900 | 0.709-0.866 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 560 | 625 | 695 | 0.866-1.063 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.299-1.575 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 |
| | | | | | | | | 1.575-2.047 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 |
| | | | | | | | | 2.047-2.559 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.005 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | 0.002-0.004 |
| | P1.2.Z.AN | Unalloyed steel C=0.25-0.55% | 190 | 4324 | 625 | 785 | 900 | 0.591-0.709 | - | 0.002-0.003 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 510 | 640 | 740 | 0.709-0.866 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.005** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 395 | 490 | 565 | 0.866-1.063 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.006** | - | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.006 | 0.003-0.006 | 0.003-0.007 | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.006 | 0.003-0.007 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.006 | 0.004-0.007 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.006 | 0.004-0.007 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.006 | **0.004-0.006** | - |
| | P1.3.Z.AN | Unalloyed steel C=0.55-0.80% | 190 | 4324 | 560 | 735 | 855 | 0.591-0.709 | - | 0.002-0.003 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 460 | 605 | 705 | 0.709-0.866 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.005** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 345 | 465 | 545 | 0.866-1.063 | - | 0.002-0.005 | 0.002-0.005 | **0.002-0.006** | - | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.006 | 0.003-0.006 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.006 | 0.003-0.007 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.006 | 0.004-0.007 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.006 | 0.004-0.007 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.006 | **0.004-0.006** | - |
| | P1.5.C.UT | Unalloyed steel Cast - untreated | 150 | 4324 | 460 | 770 | 960 | 0.591-0.709 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 445 | 650 | 785 | 0.709-0.866 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4344 | 410 | 515 | 590 | 0.866-1.063 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | | | | | 1.063-1.299 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | | | | | 1.299-1.575 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | | | | | 1.575-2.047 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | | | | | | | | 2.047-2.559 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | - | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | - |
| | P2.1.Z.AN | Low alloy steel Annealed | 175 | 4324 | 590 | 770 | 900 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 490 | 635 | 740 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 375 | 485 | 565 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | **0.003-0.007** | - | - | - | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P2.2.Z.AN | Low alloy steel Annealed | 240 | 4324 | 590 | 745 | 855 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 490 | 590 | 665 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 375 | 510 | 605 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | **0.003-0.007** | - | - | - | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P2.5.Z.HT | Low alloy steel Hardened and tempered | 330 | 4324 | 295 | 565 | 725 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 280 | 465 | 575 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 245 | 365 | 440 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | 0.003-0.007 | - | - | - | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P2.6.C.UT | Low alloy steel Cast - untreated | 200 | 4324 | 360 | 620 | 785 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4334 | 345 | 515 | 620 | 0.709-0.866 | - | - | 0.002-0.005 | **0.002-0.005** | - | - | - | 0.002-0.004 | **0.002-0.004** | - |
| | | | | 4344 | 330 | 410 | 475 | 0.866-1.063 | - | - | 0.002-0.006 | **0.002-0.006** | - | - | - | 0.002-0.005 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.008** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.008** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.008** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P3.0.Z.AN | High alloy steel Annealed | 200 | 4324 | 525 | 720 | 855 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | | | 4334 | 425 | 595 | 705 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 330 | 450 | 530 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | **0.003-0.007** | - | - | - | 0.003-0.005 | 0.003-0.006 | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |



SANDVIK Coromant

# CoroDrill® DS20

## 6-7xD

## Inch values

| ISO | MC No. | Material | HB | Grade | Cutting data recommendations 6-7xD | | | Drill diameter | Drill length 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Drill length 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Recommended starting value at middle of feed range | | | | | Recommended starting value at middle of feed range | | | | |
| P | P3.0.Z.HT | High alloy steel | 380 | 4324 | 260 | 485 | 620 | 0.591-0.709 | - | - | 0.002-0.004 | **0.002-0.004** | - | - | - | 0.002-0.003 | **0.002-0.003** | - |
| | | Hardened and tempered | | 4334 | 245 | 415 | 520 | 0.709-0.866 | - | - | 0.002-0.004 | **0.002-0.005** | - | - | - | 0.002-0.003 | **0.002-0.004** | - |
| | | | | 4344 | 230 | 320 | 385 | 0.866-1.063 | - | - | 0.002-0.005 | **0.002-0.006** | - | - | - | 0.002-0.004 | **0.002-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | - | 0.003-0.006 | **0.003-0.007** | - | - | - | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | - | 0.003-0.007 | **0.003-0.007** | - | - | - | 0.003-0.006 | **0.003-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | - | 0.004-0.007 | **0.004-0.007** | - | - | - | 0.004-0.006 | **0.004-0.006** | - |
| | P5.0.Z.AN | Ferritic/martensitic stainless steel | 200 | 4334 | 375 | 550 | 665 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 375 | 455 | 520 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | Annealed | | 2044 | 375 | 430 | 485 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 | 0.003-0.003 | **0.003-0.003** | 0.003-0.003 | - | 0.003-0.003 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.003 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.004 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.003 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.004 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.003 |
| | P5.0.Z.HT | Ferritic/martensitic stainless steel | 330 | 4334 | 245 | 405 | 505 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 230 | 340 | 415 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | Hardened and tempered | | 2044 | 230 | 340 | 415 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 | 0.003-0.003 | **0.003-0.003** | 0.003-0.003 | - | 0.003-0.003 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.003 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.004 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.003 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.004 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.003 |
| | M1.0.Z.AQ | Austenitic stainless steel | 200 | 4334 | 375 | 550 | 665 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 375 | 485 | 565 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | Annealed/quenched | | 2044 | 375 | 465 | 530 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| M | M1.1.Z.AQ | Austenitic Stainless steel | 200 | 4334 | 375 | 575 | 705 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 375 | 520 | 620 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | Machinability improved | | 2044 | 375 | 500 | 590 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | M2.0.Z.AQ | Super austenitic (Ni>20%) stainless steel | 200 | 4334 | 260 | 370 | 440 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 260 | 325 | 370 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 260 | 325 | 370 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | Annealed/quenched | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | M3.1.Z.AQ | Duplex stainless steel >60% ferrite (N<0.10%) | 230 | 4334 | 280 | 365 | 430 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 280 | 340 | 385 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 280 | 330 | 370 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | M3.2.Z.AQ | Duplex stainless steel <60% ferrite (N≥0.10%) | 260 | 4334 | 245 | 310 | 355 | 0.591-0.709 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 4344 | 245 | 295 | 340 | 0.709-0.866 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | 0.002-0.003 |
| | | | | 2044 | 245 | 295 | 340 | 0.866-1.063 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.004 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | 0.002-0.003 |
| | | | | | | | | 1.063-1.299 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.299-1.575 | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | 0.003-0.005 | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | 0.003-0.004 |
| | | | | | | | | 1.575-2.047 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| | | | | | | | | 2.047-2.559 | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | 0.004-0.005 | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - | 0.004-0.004 |
| S | S2.0.Z.AN | Heat resistant super alloys | 350 | 4334 | 65 | 115 | 150 | 0.591-0.709 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.002 | **0.002-0.002** | 0.002-0.002 | - | - |
| | S2.0.Z.AG | Ni based | | 4344 | 65 | 115 | 150 | 0.709-0.866 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.002 | **0.002-0.002** | 0.002-0.002 | - | - |
| | S2.0.Z.NS | | | 2044 | 65 | 115 | 150 | 0.866-1.063 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | | | | | 1.063-1.299 | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | | | | | 1.299-1.575 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | | | | | 1.575-2.047 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | | | | | | | | 2.047-2.559 | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - |
| | S4.2.Z.AN | Heat resistant super alloys | 330 | H13A | 130 | 270 | 355 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | S4.3.Z.AG | Ti-based | | 4344 | 130 | 270 | 355 | 0.709-0.866 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | 2044 | 130 | 270 | 355 | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - | **0.003-0.004** | 0.003-0.004 | 0.003-0.004 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |

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

# CoroDrill® DS20

**6-7xD**

**Inch values**

| ISO | MC No. | Material | HB | Grade | Cutting data recommendations 6-7xD | | | Drill diameter | Drill length 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Drill length 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Recommended starting value at middle of feed range | | | | | Recommended starting value at middle of feed range | | | | |
| K | K1.1.C.NS | Malleable cast iron | 200 | 4324 | 460 | 615 | 725 | 0.591-0.709 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Low tensile strength | | 4334 | 360 | 495 | 590 | 0.709-0.866 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | 4344 | 590 | 485 | 460 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.008** | - | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.007 | 0.005-0.007 | **0.005-0.008** | - | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.007** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.007 | 0.005-0.007 | **0.005-0.008** | - | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.007** | - |
| | K2.1.C.UT | Gray cast iron | 180 | 4324 | 690 | 840 | 960 | 0.591-0.709 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Low tensile strength | | 4334 | 560 | 695 | 795 | 0.709-0.866 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | 4344 | 425 | 525 | 605 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.007** | - | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.007 | 0.004-0.007 | **0.004-0.008** | - | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.007 | 0.005-0.007 | **0.005-0.008** | - | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.007** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.007 | 0.005-0.007 | **0.005-0.008** | - | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.007** | - |
| | K2.2.C.UT | Gray cast iron | 245 | 4324 | 410 | 600 | 725 | 0.591-0.709 | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | High tensile strength | | 4334 | 330 | 475 | 575 | 0.709-0.866 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - |
| | | | | 4344 | 245 | 365 | 440 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.008** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | K3.1.C.UT | Nodular cast iron | 155 | 4324 | 410 | 565 | 665 | 0.591-0.709 | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Ferritic | | 4334 | 330 | 460 | 545 | 0.709-0.866 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - |
| | | | | 4344 | 260 | 360 | 430 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.008** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | K3.3.C.UT | Nodular cast iron | 265 | 4324 | 360 | 520 | 620 | 0.591-0.709 | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | Ferritic | | 4334 | 295 | 430 | 520 | 0.709-0.866 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - |
| | | | | 4344 | 230 | 320 | 385 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.008** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | K4.2.C.UT | Compacted graphite iron | 230 | 4324 | 425 | 610 | 740 | 0.591-0.709 | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.004** | - |
| | | High tensile strength | | 4334 | 360 | 495 | 590 | 0.709-0.866 | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - | - | 0.003-0.003 | 0.003-0.003 | **0.003-0.005** | - |
| | | | | 4344 | 280 | 375 | 440 | 0.866-1.063 | - | 0.003-0.005 | 0.003-0.005 | **0.003-0.006** | - | - | 0.003-0.004 | 0.003-0.004 | **0.003-0.005** | - |
| | | | | | | | | 1.063-1.299 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.007** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.299-1.575 | - | 0.004-0.006 | 0.004-0.006 | **0.004-0.008** | - | - | 0.004-0.005 | 0.004-0.005 | **0.004-0.006** | - |
| | | | | | | | | 1.575-2.047 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| | | | | | | | | 2.047-2.559 | - | 0.005-0.006 | 0.005-0.006 | **0.005-0.008** | - | - | 0.005-0.005 | 0.005-0.005 | **0.005-0.006** | - |
| H | H1.3.Z.HA | Extra hard steel | 60 (HRC) | 4324 | 100 | 195 | 250 | 0.591-0.709 | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - |
| | | Hardened and tempered | | 4334 | 100 | 195 | 250 | 0.709-0.866 | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - |
| | | | | 4344 | 100 | 195 | 250 | 0.866-1.063 | - | 0.002-0.004 | **0.002-0.004** | 0.002-0.004 | - | - | 0.002-0.003 | **0.002-0.003** | 0.002-0.003 | - |
| | | | | | | | | 1.063-1.299 | - | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - | - | 0.003-0.003 | **0.003-0.003** | 0.003-0.003 | - |
| | | | | | | | | 1.299-1.575 | - | 0.003-0.005 | **0.003-0.005** | 0.003-0.005 | - | - | 0.003-0.004 | **0.003-0.004** | 0.003-0.004 | - |
| | | | | | | | | 1.575-2.047 | - | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | - | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - |
| | | | | | | | | 2.047-2.559 | - | 0.004-0.005 | **0.004-0.005** | 0.004-0.005 | - | - | 0.004-0.004 | **0.004-0.004** | 0.004-0.004 | - |



SANDVIK Coromant

# CoroDrill® DS20

## 6-7xD

## Inch values

| ISO | MC No. | Material | HB | Grade | Cutting data recommendations 6-7xD | | | Drill diameter | Drill length 6xD -S5W | -L5W | -L6W | -M7W | -H5W | Drill length 7xD -S5W | -L5W | -L6W | -M7W | -H5W |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | | | Recommended starting value at middle of feed range | | | | | Recommended starting value at middle of feed range | | | | |
| N | N1.2.Z.AG | Aluminum based alloys | 100 | H13A | 985 | 1075 | 1180 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | AlSi alloys, Si ≤ 1% | | 4344 | 985 | 1075 | 1180 | 0.709-0.866 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | N1.3.C.UT | Aluminum based alloys | 75 | H13A | 820 | 1025 | 1180 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | AlSi alloys, Si ≤ 1% | | 4344 | 820 | 1025 | 1180 | 0.709-0.866 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - | **0.003-0.004** | 0.003-0.004 | 0.003-0.004 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | N1.3.C.AG | Aluminum based alloys | 90 | H13A | 820 | 930 | 1035 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | AlSi cast and aged alloys (1%< Si >13%) | | 4344 | 820 | 930 | 1035 | 0.709-0.866 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - | **0.003-0.004** | 0.003-0.004 | 0.003-0.004 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | N3.3.U.UT | Copper based alloys | 110 | H13A | 820 | 1025 | 1180 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | Free cutting copper based alloys | | 4344 | 820 | 1025 | 1180 | 0.709-0.866 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | N3.2.C.UT | Copper based alloys | 90 | H13A | 590 | 645 | 705 | 0.591-0.709 | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - | **0.002-0.003** | 0.002-0.003 | 0.002-0.003 | - | - |
| | | Leaded brass & bronzes (Pb ≤ 1%) | | 4344 | 590 | 645 | 705 | 0.709-0.866 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 0.866-1.063 | **0.002-0.005** | 0.002-0.005 | 0.002-0.005 | - | - | **0.002-0.004** | 0.002-0.004 | 0.002-0.004 | - | - |
| | | | | | | | | 1.063-1.299 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.299-1.575 | **0.003-0.006** | 0.003-0.006 | 0.003-0.006 | - | - | **0.003-0.005** | 0.003-0.005 | 0.003-0.005 | - | - |
| | | | | | | | | 1.575-2.047 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |
| | | | | | | | | 2.047-2.559 | **0.004-0.006** | 0.004-0.006 | 0.004-0.006 | - | - | **0.004-0.005** | 0.004-0.005 | 0.004-0.005 | - | - |

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

# CoroDrill® 880

**2 – 3 x DC**

**Metric values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed $v_c$ (m/min) | Drill diameter $D_c$ 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 4334 4344 | 230-400 210-325 190-245 | 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 |
| | | | | | | 24.00-29.99 | **0.04-0.12** | 0.04-0.08 | 0.04-0.08 | 0.04-0.08 |
| | | | | | | 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 4334 4344 | 230-370 200-305 170-235 | 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 |
| | | | | | | 24.00-29.99 | **0.04-0.14** | 0.04-0.10 | 0.04-0.10 | 0.04-0.10 |
| | | | | | | 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 4334 4344 | 190-305 155-250 120-190 | 12.00-13.99 | 0.04-0.10 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | **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 |
| | | | | | | 24.00-29.99 | 0.06-0.18 | 0.06-0.18 | **0.06-0.18** | 0.06-0.18 |
| | | | | | | 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 4334 4344 | 170-290 140-240 105-185 | 12.00-13.99 | 0.04-0.10 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | **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 |
| | | | | | | 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 | 0.08-0.24 | **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 and carbon tool steel | 180-275 | 4324 4334 4344 | 200-290 155-240 105-180 | 12.00-13.99 | 0.04-0.10 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | **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 |
| | | | | | | 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 | 0.08-0.24 | **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 4334 4344 | 180-305 150-250 115-190 | 12.00-13.99 | 0.04-0.10 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | **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 |
| | | | | | | 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 |
| | P2.5.Z.HT (02.2) | Hardened steel | 220-450 | 4324 4334 4344 | 90-245 85-195 75-150 | 12.00-13.99 | 0.04-0.10 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.10 | 0.04-0.10 | **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 |
| | | | | | | 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 |

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

# CoroDrill® 880

**2 – 3 x DC**

**Metric values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed $v_c$ (m/min) | Drill diameter $D_c$ 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 4334 4044 | 160-280 130-240 100-170 | 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 |
| | | | | | | 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 4334 4044 | 80-210 75-175 70-125 | 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 |
| | | | | | | 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 |
| | P1.5.C.UT 06.1 | Steel castings (Unalloyed) | 90-225 | 4324 4334 4044 | 140-365 135-265 125-190 | 12.00-13.99 | 0.04-0.08 | | | |
| | | | | | | 14.00-16.49 | 0.04-0.08 | 0.04-0.08 | **0.04-0.08** | 0.04-0.08 |
| | | | | | | 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 |
| | P2.6.C.UT (06.2) | Low alloyed (alloying elements less than 5%) | 150-250 | 4324 4334 4044 | 110-265 105-210 100-150 | 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 | 0.04-0.14 | 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**

**Metric values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed $v_c$ (m/min) | Drill diameter $D_c$ 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 | |
| | | | | 4334 | 115-225 | 14.00-16.49 | 0.04-0.14 | **0.04-0.14** | 0.04-0.08 | 0.04-0.08 | 0.04-0.14 |
| | | | | 4344 | 115-175 | 16.50-19.99 | 0.06-0.16 | **0.06-0.16** | 0.04-0.08 | 0.04-0.08 | 0.06-0.16 |
| | | | | 2044 | 115-165 | 20.00-23.99 | 0.06-0.18 | **0.06-0.18** | 0.06-0.14 | 0.06-0.14 | 0.06-0.18 |
| | | | | | | 24.00-29.99 | 0.06-0.18 | **0.06-0.18** | 0.06-0.14 | 0.06-0.14 | 0.06-0.18 |
| | | | | | | 30.00-35.99 | 0.06-0.20 | **0.06-0.20** | 0.06-0.16 | 0.06-0.16 | 0.06-0.20 |
| | | | | | | 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 | |
| | | | | 4334 | 115-225 | 14.00-16.49 | 0.04-0.14 | **0.04-0.14** | 0.04-0.08 | 0.04-0.08 | 0.04-0.14 |
| | | | | 4344 | 115-190 | 16.50-19.99 | 0.06-0.14 | **0.06-0.14** | 0.04-0.08 | 0.04-0.08 | 0.06-0.14 |
| | | | | 2044 | 115-180 | 20.00-23.99 | 0.06-0.16 | **0.06-0.16** | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 |
| | | | | | | 24.00-29.99 | 0.06-0.16 | **0.06-0.16** | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 |
| | | | | | | 30.00-35.99 | 0.06-0.18 | **0.06-0.18** | 0.06-0.16 | 0.06-0.16 | 0.06-0.20 |
| | | | | | | 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 | |
| | | | | 4334 | 85-145 | 14.00-16.49 | 0.04-0.14 | **0.04-0.14** | 0.04-0.08 | 0.04-0.08 | 0.04-0.14 |
| | | | | 4344 | 85-130 | 16.50-19.99 | 0.06-0.14 | **0.06-0.14** | 0.04-0.08 | 0.04-0.08 | 0.06-0.14 |
| | | | | 2044 | 85-125 | 20.00-23.99 | 0.06-0.16 | **0.06-0.16** | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 |
| | | | | | | 24.00-29.99 | 0.06-0.16 | **0.06-0.16** | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 |
| | | | | | | 30.00-35.99 | 0.06-0.18 | **0.06-0.18** | 0.06-0.16 | 0.06-0.16 | 0.06-0.18 |
| | | | | | | 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 | |
| | | | | 4334 | 115-185 | 14.00-16.49 | 0.04-0.12 | **0.04-0.12** | 0.04-0.08 | 0.04-0.08 | 0.04-0.12 |
| | | | | 4344 | 80-165 | 16.50-19.99 | 0.06-0.14 | **0.06-0.14** | 0.04-0.08 | 0.04-0.08 | 0.06-0.14 |
| | | | | 2044 | 80-155 | 20.00-23.99 | 0.06-0.16 | **0.06-0.16** | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 |
| | | | | | | 24.00-29.99 | 0.06-0.16 | **0.06-0.16** | 0.06-0.12 | 0.06-0.12 | 0.06-0.16 |
| | | | | | | 30.00-35.99 | 0.06-0.18 | **0.06-0.18** | 0.06-0.16 | 0.06-0.16 | 0.06-0.18 |
| | | | | | | 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 | |
| | | | | H13A | 15-90 | 14.00-16.49 | **0.04-0.08** | 0.04-0.08 | 0.04-0.10 | 0.04-0.08 | 0.04-0.08 |
| | | | | 2044 | 20-90 | 16.50-19.99 | **0.05-0.08** | 0.05-0.08 | 0.05-0.10 | 0.05-0.08 | 0.05-0.08 |
| | | | | | | 20.00-23.99 | **0.05-0.08** | 0.05-0.08 | 0.05-0.10 | 0.05-0.08 | 0.05-0.08 |
| | | | | | | 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: α, near α and α+ β alloys in annealed condition Titanium: α+ β alloys in aged condition, β 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 | |
| | | | | H13A | 40-135 | 14.00-16.49 | **0.06-0.14** | 0.06-0.14 | 0.06-0.12 | 0.06-0.10 | 0.06-0.10 |
| | | | | 2044 | 40-135 | 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 |
| | | | | | | 24.00-29.99 | **0.12-0.18** | 0.12-0.18 | 0.10-0.16 | 0.10-0.14 | 0.10-0.14 |
| | | | | | | 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

# CoroDrill® 880

**2 – 3 x DC**

**Metric values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed $v_c$ (m/min) | Drill diameter $D_c$ mm | Geometry / Feed Drill length 2-3xD -LM $f_n$ mm/rev | -GM $f_n$ mm/rev | -GR $f_n$ mm/rev | -GT $f_n$ mm/rev |
|---|---|---|---|---|---|---|---|---|---|---|
| K | K1.1.C.NS (07.1) | Malleable cast iron Ferritic (Short chipping) | 110-145 | 4324 | 140-245 | 12.00-13.99 | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | **0.06-0.20** | |
| | | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | **0.08-0.22** | 0.08 - 0.22 |
| | | | | 4334 | 110-200 | 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** | |
| | | | | 4344 | 80-155 | 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 | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | **0.06-0.16** | |
| | | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | **0.08-0.18** | 0.08 - 0.18 |
| | | | | 4334 | 85-150 | 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** | |
| | | | | 4344 | 65-110 | 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) | Gray cast iron: Low tensile strength | 150-220 | 4324 | 210-325 | 12.00-13.99 | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | **0.06-0.20** | |
| | | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | **0.08-0.22** | 0.08 - 0.22 |
| | | | | 4334 | 170-270 | 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** | |
| | | | | 4344 | 130-205 | 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 | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | **0.06-0.16** | |
| | | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | **0.08-0.18** | 0.08 - 0.18 |
| | | | | 4334 | 100-195 | 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** | |
| | | | | 4344 | 75-150 | 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 | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | **0.08-0.16** | |
| | | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | **0.10-0.18** | 0.08 - 0.18 |
| | | | | 4334 | 100-185 | 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** | |
| | | | | 4344 | 80-145 | 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 | | | | |
| | | | | | | 14.00-16.49 | 0.06-0.10 | 0.06-0.12 | **0.08-0.16** | |
| | | | | | | 16.50-19.99 | 0.06-0.12 | 0.08-0.14 | **0.10-0.18** | 0.08 - 0.18 |
| | | | | 4334 | 90-175 | 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** | |
| | | | | 4344 | 70-130 | 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**

**Metric values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed $v_c$ (m/min) | Drill diameter $D_c$ 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<br>4334<br>4344 | 30-85<br>30-85<br>30-85 | 12.00-13.99<br>14.00-16.49<br>16.50-19.99<br>20.00-23.99<br>24.00-29.99<br>30.00-35.99<br>36.00-43.99<br>44.00-52.99<br>53.00-63.50 | 0.10-0.16<br>0.04-0.08<br>0.05-0.12<br>0.05-0.14<br>0.05-0.14<br>0.06-0.16<br>0.06-0.16<br>0.10-0.16 | **0.10-0.20**<br>**0.04-0.12**<br>**0.06-0.14**<br>**0.06-0.18**<br>**0.06-0.18**<br>**0.06-0.20**<br>**0.06-0.20**<br>**0.10-0.20** | 0.10-0.32<br>0.04-0.08<br>0.05-0.12<br>0.05-0.14<br>0.05-0.14<br>0.06-0.16<br>0.06-0.16<br>0.10-0.16 | <br>0.04 - 0.08<br>0.05 - 0.12<br>0.05 - 0.14<br>0.05 - 0.14 |
| N | N1.2.Z.AG (30.12) | Al. alloys Wrought or wrought and aged | 30-150 | 4344<br>H13A | 300-405<br>300-400 | 12.00-13.99<br>14.00-16.49<br>16.50-19.99<br>20.00-23.99<br>24.00-29.99<br>30.00-35.99<br>36.00-43.99<br>44.00-52.99<br>53.00-63.50 | **0.04-0.08**<br>**0.04-0.14**<br>**0.04-0.16**<br>**0.06-0.18**<br>**0.10-0.20**<br>**0.10-0.25**<br>**0.10-0.25**<br>**0.12-0.28**<br>**0.12-0.28** | <br>0.04-0.12<br>0.04-0.14<br>0.06-0.16<br>0.10-0.18<br>0.10-0.20<br>0.10-0.20<br>0.12-0.22<br>0.12-0.22 | 0.04-0.08<br>0.04-0.12<br>0.04-0.14<br>0.06-0.16<br>0.10-0.18<br>0.10-0.20<br>0.10-0.20<br>0.12-0.22<br>0.12-0.22 | <br>0.04-0.12<br>0.04 - 0.14<br>0.06 - 0.16<br>0.10-0.18 |
| | N1.3.C.UT (30.21) | Cast, non-aging | 40-100 | 4344<br>H13A | 300-405<br>300-400 | 12.00-13.99<br>14.00-16.49<br>16.50-19.99<br>20.00-23.99<br>24.00-29.99<br>30.00-35.99<br>36.00-43.99<br>44.00-52.99<br>53.00-63.50 | **0.04-0.12**<br>**0.04-0.12**<br>**0.04-0.14**<br>**0.06-0.16**<br>**0.10-0.18**<br>**0.10-0.20**<br>**0.10-0.20**<br>**0.12-0.22**<br>**0.12-0.22** | <br>0.04-0.14<br>0.04-0.16<br>0.06-0.18<br>0.10-0.20<br>0.10-0.22<br>0.10-0.24<br>0.12-0.26<br>0.12-0.26 | 0.04-0.12<br>0.04-0.12<br>0.04-0.14<br>0.06-0.16<br>0.10-0.18<br>0.10-0.20<br>0.10-0.20<br>0.12-0.22<br>0.12-0.22 | <br>0.04-0.12<br>0.04 - 0.14<br>0.06 - 0.16<br>0.10-0.18 |
| | N1.3.C.AG (30.22) | Cast or cast and aged | 70-140 | 4344<br>H13A | 250-350<br>250-350 | 12.00-13.99<br>14.00-16.49<br>16.50-19.99<br>20.00-23.99<br>24.00-29.99<br>30.00-35.99<br>36.00-43.99<br>44.00-52.99<br>53.00-63.50 | **0.04-0.12**<br>**0.04-0.12**<br>**0.04-0.14**<br>**0.06-0.16**<br>**0.10-0.18**<br>**0.10-0.20**<br>**0.10-0.20**<br>**0.12-0.22**<br>**0.12-0.22** | <br>0.04-0.14<br>0.04-0.16<br>0.06-0.18<br>0.10-0.20<br>0.10-0.22<br>0.10-0.24<br>0.12-0.26<br>0.12-0.26 | 0.04-0.12<br>0.04-0.12<br>0.04-0.14<br>0.06-0.16<br>0.10-0.18<br>0.10-0.20<br>0.10-0.20<br>0.12-0.22<br>0.12-0.22 | <br>0.04-0.12<br>0.04 - 0.14<br>0.06 - 0.16<br>0.10-0.18 |
| | N3.3.U.UT (33.1) | Copper and copper alloys | 70-160 | 4344<br>H13A | 250-400<br>250-400 | 12.00-13.99<br>14.00-16.49<br>16.50-19.99<br>20.00-23.99<br>24.00-29.99<br>30.00-35.99<br>36.00-43.99<br>44.00-52.99<br>53.00-63.50 | **0.04-0.14**<br>**0.04-0.14**<br>**0.04-0.16**<br>**0.06-0.18**<br>**0.10-0.20**<br>**0.10-0.25**<br>**0.10-0.25**<br>**0.12-0.28**<br>**0.12-0.28** | <br>0.04-0.12<br>0.04-0.14<br>0.06-0.16<br>0.10-0.18<br>0.10-0.20<br>0.10-0.20<br>0.12-0.22<br>0.12-0.22 | 0.04-0.12<br>0.04-0.12<br>0.04-0.14<br>0.06-0.16<br>0.10-0.18<br>0.10-0.20<br>0.10-0.20<br>0.12-0.22<br>0.12-0.22 | <br>0.04-0.12<br>0.04 - 0.14<br>0.06 - 0.16<br>0.10-0.18 |
| | N3.2.C.UT (33.2) | Brass and leaded alloys (Pb < 1%) | 50-200 | 4344<br>H13A | 180-240<br>180-240 | 12.00-13.99<br>14.00-16.49<br>16.50-19.99<br>20.00-23.99<br>24.00-29.99<br>30.00-35.99<br>36.00-43.99<br>44.00-52.99<br>53.00-63.50 | **0.04-0.14**<br>**0.04-0.14**<br>**0.04-0.16**<br>**0.06-0.18**<br>**0.10-0.20**<br>**0.10-0.25**<br>**0.10-0.25**<br>**0.12-0.28**<br>**0.12-0.28** | <br>0.04-0.12<br>0.04-0.14<br>0.06-0.16<br>0.10-0.18<br>0.10-0.20<br>0.10-0.20<br>0.12-0.22<br>0.12-0.22 | 0.04-0.12<br>0.04-0.12<br>0.04-0.14<br>0.06-0.16<br>0.10-0.18<br>0.10-0.20<br>0.10-0.20<br>0.12-0.22<br>0.12-0.22 | <br>0.04-0.12<br>0.04 - 0.14<br>0.06 - 0.16<br>0.10-0.18 |

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

# CoroDrill® 880

**2 – 3 x DC**

**Inch values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed (ft/min) | Drill diameter $D_c$ inch | Geometry / Feed Drill length 2-3xD -LM $f_n$ inch/rev. | -GM $f_n$ inch/rev. | -GR $f_n$ inch/rev. | -GT $f_n$ inch/rev. |
|---|---|---|---|---|---|---|---|---|---|---|
| P | P1.0.Z.AN (01.0) | Non hardened | 90-200 | | | .472-.550 | **.002-.003** | | .001-.002 | |
| | | | | | | .551-.649 | **.002-.003** | .001-.002 | .001-.002 | .002-.003 |
| | | | | 4324 | 760-1310 | .650-.787 | **.002-.004** | .001-.002 | .001-.002 | .002-.004 |
| | | 0.05-0.10% C | | 4334 | 690-1065 | .788-.944 | **.002-.005** | .002-.003 | .002-.003 | .002-.005 |
| | | | | 4344 | 620-810 | .945-1.181 | **.002-.005** | .002-.003 | .002-.003 | .002-.005 |
| | | | | | | 1.182-1.417 | **.002-.006** | .002-.004 | .002-.004 | |
| | | | | | | 1.418-1.732 | **.002-.006** | .002-.004 | .002-.004 | |
| | | | | | | 1.733-2.086 | **.003-.006** | .003-.005 | .003-.005 | |
| | | | | | | 2.087-2.500 | **.003-.006** | .003-.005 | .003-.005 | |
| | P1.0.Z.AN (01.1) | Non hardened | 90-200 | | | .472-.550 | **.002-.004** | | .001-.002 | |
| | | Non hardened | | | | .551-.649 | **.002-.004** | .001-.002 | .001-.002 | .002-.004 |
| | | | | 4324 | 750-1210 | .650-.787 | **.002-.005** | .001-.002 | .001-.002 | .002-.005 |
| | | 0.05-0.25% C | | 4334 | 650-1000 | .788-.944 | **.002-.006** | .002-.004 | .002-.003 | .002-.006 |
| | | | | 4344 | 550-775 | .945-1.181 | **.002-.006** | .002-.004 | .002-.003 | .002-.006 |
| | | | | | | 1.182-1.417 | **.002-.006** | .002-.005 | .002-.004 | |
| | | | | | | 1.418-1.732 | **.002-.006** | .002-.005 | .002-.004 | |
| | | | | | | 1.733-2.086 | **.003-.006** | .003-.005 | .003-.005 | |
| | | | | | | 2.087-2.500 | **.003-.006** | .003-.005 | .003-.005 | |
| | P1.2.Z.AN (01.2) | Non hardened | 125-225 | | | .472-.550 | .002-.004 | | **.002-.008** | |
| | | Non hardened | | | | .551-.649 | .002-.004 | .002-.004 | **.002-.008** | .002-.006 |
| | | | | 4324 | 620-1000 | .650-.787 | .002-.006 | .002-.006 | **.002-.009** | .002-.009 |
| | | 0.25-0.55% C | | 4334 | 510-820 | .788-.944 | .002-.007 | .002-.007 | **.002-.010** | .002-.010 |
| | | | | 4344 | 395-620 | .945-1.181 | .002-.007 | .003-.007 | **.003-.012** | .003-.012 |
| | | | | | | 1.182-1.417 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 1.418-1.732 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 1.733-2.086 | .004-.009 | .004-.009 | **.004-.013** | |
| | | | | | | 2.087-2.500 | .004-.009 | .004-.009 | **.004-.013** | |
| | P1.3.Z.AN (01.3) | Non hardened | 150-250 | | | .472-.550 | .002-.004 | | **.002-.006** | |
| | | Non hardened | | | | .551-.649 | .002-.004 | .002-.004 | **.002-.008** | .002-.008 |
| | | | | 4324 | 560-950 | .650-.787 | .002-.006 | .002-.006 | **.002-.009** | .002-.009 |
| | | 0.55-0.80% C | | 4334 | 460-790 | .788-.944 | .002-.007 | .002-.007 | **.002-.010** | .002-.010 |
| | | | | 4344 | 345-610 | .945-1.181 | .002-.007 | .003-.007 | **.003-.012** | .003-.012 |
| | | | | | | 1.182-1.417 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 1.418-1.732 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 1.733-2.086 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 2.087-2.500 | .004-.009 | .004-.009 | **.004-.013** | |
| | P1.3.Z.AN (01.4) | High carbon and carbon tool steel | 180-275 | | | .472-.550 | .002-.004 | | **.002-.006** | |
| | | High carbon and carbon tool steel | | | | .551-.649 | .002-.004 | .002-.004 | **.002-.007** | .002-.007 |
| | | | | 4324 | 660-950 | .650-.787 | .002-.006 | .002-.006 | **.002-.009** | .002-.009 |
| | | | | 4334 | 510-790 | .788-.944 | .002-.007 | .002-.007 | **.002-.010** | .002-.010 |
| | | | | 4344 | 345-590 | .945-1.181 | .002-.007 | .003-.007 | **.003-.012** | .003-.012 |
| | | | | | | 1.182-1.417 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 1.418-1.732 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 1.733-2.086 | .004-.009 | .004-.009 | **.004-.013** | |
| | | | | | | 2.087-2.500 | .004-.009 | .004-.009 | **.004-.013** | |
| | P2.1.Z.AN (02.1) | Low alloy steel (Non-hardened) | 150-260 | | | .472-.550 | .002-.004 | | **.002-.006** | |
| | | Low alloy steel (Non-hardened) | | | | .551-.649 | .002-.004 | .002-.004 | **.002-.008** | .002-.008 |
| | | | | 4324 | 590-1000 | .650-.787 | .002-.006 | .002-.006 | **.002-.009** | .002-.009 |
| | | | | 4334 | 490-820 | .788-.944 | .002-.007 | .002-.007 | **.002-.010** | .002-.010 |
| | | | | 4344 | 375-620 | .945-1.181 | .002-.007 | .003-.007 | **.003-.012** | .003-.012 |
| | | | | | | 1.182-1.417 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 1.418-1.732 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 1.733-2.086 | .004-.009 | .004-.009 | **.004-.013** | |
| | | | | | | 2.087-2.500 | .004-.009 | .004-.009 | **.004-.013** | |
| | P2.5.Z.HT (02.2) | Hardened steel | 220-450 | | | .472-.550 | | | | |
| | | Hardened steel | | | | .551-.649 | .002-.004 | .002-.004 | **.002-.006** | .002-.006 |
| | | | | 4324 | 295-805 | .650-.787 | .002-.006 | .002-.006 | **.002-.008** | .002-.008 |
| | | | | 4334 | 280-640 | .788-.944 | .002-.007 | .002-.007 | **.002-.009** | .002-.009 |
| | | | | 4344 | 245-485 | .945-1.181 | .002-.007 | .003-.007 | **.003-.010** | .003-.010 |
| | | | | | | 1.182-1.417 | .002-.009 | .003-.009 | **.003-.012** | |
| | | | | | | 1.418-1.732 | .002-.009 | .003-.009 | **.003-.012** | |
| | | | | | | 1.733-2.086 | .004-.009 | .004-.009 | **.004-.013** | |
| | | | | | | 2.087-2.500 | .004-.009 | .004-.009 | **.004-.013** | |

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

# CoroDrill® 880

**2 – 3 x DC**

**Inch values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed (ft/min) | Drill diameter $D_c$ inch | Geometry / Feed Drill length 2-3xD -LM $f_n$ inch/rev. | -GM $f_n$ inch/rev. | -GR $f_n$ inch/rev. | -GT $f_n$ inch/rev. |
|---|---|---|---|---|---|---|---|---|---|---|
| P | P3.0.Z.AN (03.11) | High alloy steel (Annealed) | 150-250 | 4324 | 520-950 | .472-.550 | .002-.004 | | **.002-.006** | |
| | | | | | | .551-.649 | .002-.004 | .002-.004 | **.002-.006** | .002-.006 |
| | | | | | | .650-.787 | .002-.006 | .002-.006 | **.002-.008** | .002-.008 |
| | | | | 4334 | 425-790 | .788-.944 | .002-.007 | .002-.007 | **.002-.009** | .002-.009 |
| | | | | 4344 | 325-590 | .945-1.181 | .002-.007 | .003-.007 | **.003-.010** | .003-.010 |
| | | | | | | 1.182-1.417 | .002-.009 | .003-.009 | **.003-.012** | |
| | | | | | | 1.418-1.732 | .002-.009 | .003-.009 | **.003-.012** | |
| | | | | | | 1.733-2.086 | .004-.009 | .004-.009 | **.004-.013** | |
| | | | | | | 2.087-2.500 | .004-.009 | .004-.009 | **.004-.013** | |
| | P3.0.Z.HT (03.21) | Hardened steel | 250-350 | 4324 | 265-690 | .472-.550 | .002-.004 | | **.002-.005** | |
| | | | | | | .551-.649 | .002-.004 | .002-.004 | **.002-.006** | .002-.006 |
| | | | | | | .650-.787 | .002-.006 | .002-.006 | **.002-.006** | .002-.006 |
| | | | | 4334 | 245-575 | .788-.944 | .002-.007 | .002-.007 | **.002-.007** | .002-.008 |
| | | | | 4344 | 230-430 | .945-1.181 | .002-.007 | .003-.007 | **.003-.009** | .003-.010 |
| | | | | | | 1.182-1.417 | .002-.008 | .003-.008 | **.003-.009** | |
| | | | | | | 1.418-1.732 | .002-.009 | .003-.009 | **.003-.010** | |
| | | | | | | 1.733-2.086 | .004-.009 | .004-.009 | **.004-.010** | |
| | | | | | | 2.087-2.500 | .004-.009 | .004-.009 | **.004-.010** | |
| | P1.5.C.UT (06.1) | Steel castings (Unalloyed) | 90-225 | 4324 | 455-1065 | .472-.550 | .002-.003 | | **.002-.005** | |
| | | | | | | .551-.649 | .002-.003 | .002-.003 | **.002-.005** | .002-.005 |
| | | | | | | .650-.787 | .002-.003 | .002-.003 | **.002-.005** | .002-.005 |
| | | | | 4334 | 440-870 | .788-.944 | .002-.004 | .002-.004 | **.002-.006** | .002-.006 |
| | | | | 4344 | 405-650 | .945-1.181 | .002-.004 | .002-.004 | **.002-.006** | .003-.009 |
| | | | | | | 1.182-1.417 | .002-.006 | .002-.006 | **.002-.006** | |
| | | | | | | 1.418-1.732 | .002-.006 | .002-.006 | **.002-.006** | |
| | | | | | | 1.733-2.086 | .003-.006 | .003-.006 | **.003-.006** | |
| | | | | | | 2.087-2.500 | .003-.006 | .003-.006 | **.003-.006** | |
| | P2.6.C.UT (06.2) | Low alloyed (alloying elements less than 5%) | 150-250 | 4324 | 360-870 | .472-.550 | .002-.004 | | **.002-.006** | |
| | | | | | | .551-.649 | .002-.004 | .002-.004 | **.002-.008** | .002-.008 |
| | | | | | | .650-.787 | .002-.006 | .002-.006 | **.002-.009** | .002-.009 |
| | | | | 4334 | 345-690 | .788-.944 | .002-.007 | .002-.007 | **.002-.010** | .002-.010 |
| | | | | 4344 | 325-515 | .945-1.181 | .002-.007 | .003-.007 | **.003-.012** | .003-.012 |
| | | | | | | 1.182-1.417 | .002-.008 | .003-.008 | **.003-.013** | |
| | | | | | | 1.418-1.732 | .002-.009 | .003-.009 | **.003-.013** | |
| | | | | | | 1.733-2.086 | .004-.009 | .004-.009 | **.004-.013** | |
| | | | | | | 2.087-2.500 | .004-.009 | .004-.009 | **.004-.013** | |

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

# CoroDrill® 880

**2 – 3 x DC**

**Inch values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed (ft/min) | Drill diameter $D_c$ inch | Geometry/feed ($f_n$ inch/rev.) Drill length 2-3xD -LM | -MS[1] | -GM | -GR | -GT |
|---|---|---|---|---|---|---|---|---|---|---|---|
| P | P5.0.Z.AN (05.11) | Stainless steel Ferritic/Martensitic 13-25% Cr | 150-270 | 4324 | 390-920 | .472-.550 | .002-.005 | **.002-.005** | | .002-.004 | |
| | | | | 4334 | 375-740 | .551-.649 | .002-.006 | **.002-.006** | .002-.004 | .002-.004 | .002-.006 |
| | | | | 4344 | 375-570 | .650-.787 | .002-.007 | **.002-.007** | .002-.004 | .002-.004 | .002-.007 |
| | | | | 2044 | 375-540 | .788-.944 | .002-.008 | **.002-.008** | .002-.006 | .002-.006 | .002-.008 |
| | | | | | | .945-1.181 | .002-.008 | **.002-.008** | .002-.006 | .002-.006 | .002-.008 |
| | | | | | | 1.182-1.417 | .002-.008 | **.002-.008** | .002-.007 | .002-.007 | .002-.008 |
| | | | | | | 1.418-1.732 | .002-.008 | **.002-.008** | .002-.007 | .002-.007 | .002-.008 |
| | | | | | | 1.733-2.086 | .004-.010 | **.004-.010** | .004-.008 | .004-.008 | .004-.010 |
| | | | | | | 2.087-2.500 | .004-.010 | **.004-.010** | .004-.008 | .004-.008 | .004-.010 |
| | M1.0.Z.AQ (05.21) | Austenitic Ni > 8%, 13-25% Cr | 150-275 | 4324 | 390-870 | .472-.550 | .002-.005 | **.002-.005** | | .002-.004 | |
| | | | | 4334 | 375-740 | .551-.649 | .002-.006 | **.002-.006** | .002-.004 | .002-.004 | .002-.006 |
| | | | | 4344 | 375-620 | .650-.787 | .002-.006 | **.002-.006** | .002-.004 | .002-.004 | .002-.006 |
| | | | | 2044 | 375-590 | .788-.944 | .002-.007 | **.002-.007** | .002-.005 | .002-.005 | .002-.007 |
| | | | | | | .945-1.181 | .002-.007 | **.002-.007** | .002-.005 | .002-.005 | .002-.007 |
| | | | | | | 1.182-1.417 | .002-.008 | **.002-.008** | .002-.007 | .002-.007 | .002-.008 |
| | | | | | | 1.418-1.732 | .002-.008 | **.002-.008** | .002-.007 | .002-.007 | .002-.008 |
| | | | | | | 1.733-2.086 | .004-.008 | **.004-.008** | .004-.007 | .004-.007 | .004-.008 |
| | | | | | | 2.087-2.500 | .004-.008 | **.004-.008** | .004-.007 | .004-.007 | .004-.008 |
| | M3.1.Z.AQ (05.51) M3.2.Z.AQ (05.52) | Austenitic/Ferritic (Duplex) | 200-320 | 4324 | 295-510 | .472-.550 | .002-.005 | **.002-.005** | | .002-.004 | |
| | | | | 4334 | 280-475 | .551-.649 | .002-.006 | **.002-.006** | .002-.004 | .002-.004 | .002-.006 |
| | | | | 4344 | 280-430 | .650-.787 | .002-.006 | **.002-.006** | .002-.004 | .002-.004 | .002-.006 |
| | | | | 2044 | 280-410 | .788-.944 | .002-.007 | **.002-.007** | .002-.005 | .002-.005 | .002-.007 |
| | | | | | | .945-1.181 | .002-.007 | **.002-.007** | .002-.005 | .002-.005 | .002-.007 |
| | | | | | | 1.182-1.417 | .002-.008 | **.002-.008** | .002-.007 | .002-.007 | .002-.008 |
| | | | | | | 1.418-1.732 | .002-.008 | **.002-.008** | .002-.007 | .002-.007 | .002-.008 |
| | | | | | | 1.733-2.086 | .004-.008 | **.004-.008** | .004-.007 | .004-.007 | .004-.008 |
| | | | | | | 2.087-2.500 | .004-.008 | **.004-.008** | .004-.007 | .004-.007 | .004-.008 |
| | M1.0.C.UT (15.21) | Austenitic castings | 150-250 | 4324 | 495-690 | .472-.550 | .002-.005 | **.002-.005** | | .002-.004 | |
| | | | | 4334 | 380-605 | .551-.649 | .002-.005 | **.002-.005** | .002-.004 | .002-.004 | .002-.005 |
| | | | | 4344 | 265-535 | .650-.787 | .002-.006 | **.002-.006** | .002-.004 | .002-.004 | .002-.006 |
| | | | | 2044 | 265-510 | .788-.944 | .002-.007 | **.002-.007** | .002-.005 | .002-.005 | .002-.007 |
| | | | | | | .945-1.181 | .002-.007 | **.002-.007** | .002-.005 | .002-.005 | .002-.007 |
| | | | | | | 1.182-1.417 | .002-.008 | **.002-.008** | .002-.007 | .002-.007 | .002-.008 |
| | | | | | | 1.418-1.732 | .002-.008 | **.002-.008** | .002-.007 | .002-.007 | .002-.008 |
| | | | | | | 1.733-2.086 | .004-.008 | **.004-.008** | .004-.007 | .004-.007 | .004-.008 |
| | | | | | | 2.087-2.500 | .004-.008 | **.004-.008** | .004-.007 | .004-.007 | .004-.008 |
| 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 | 65-305 | .472-.550 | **.002-.004** | .002-.004 | | .002-.004 | |
| | | | | H13A | 50-290 | .551-.649 | **.002-.004** | .002-.004 | .002-.004 | .002-.004 | .002-.004 |
| | | | | 2044 | 65-290 | .650-.787 | **.002-.004** | .002-.004 | .002-.004 | .002-.004 | .002-.004 |
| | | | | | | .788-.944 | **.002-.004** | .002-.004 | .002-.004 | .002-.004 | .002-.004 |
| | | | | | | .945-1.181 | **.002-.004** | .002-.004 | .002-.005 | .002-.004 | .002-.004 |
| | | | | | | 1.182-1.417 | **.002-.005** | .002-.005 | .002-.005 | .002-.005 | .002-.005 |
| | | | | | | 1.418-1.732 | **.002-.005** | **.002-.005** | .002-.005 | .002-.005 | .002-.005 |
| | | | | | | 1.733-2.086 | **.002-.005** | **.002-.005** | .002-.005 | .002-.005 | .002-.005 |
| | | | | | | 2.087-2.500 | **.003-.006** | .003-.006 | .003-.006 | .003-.005 | .003-.006 |
| | S4.2.Z.AN (23.21) S4.3.Z.AG (23.22) | Titanium: α, near α and α+ β alloys in annealed condition Titanium: α+ β alloys in aged condition, β alloys in annealed or aged condition | RM (Mpa) 600-1500 | 4344 H13A 2044 | 135-460 135-440 135-440 | .472-.550 | **.002-.006** | .002-.006 | | .002-.004 | |
| | | | | | | .551-.649 | **.002-.006** | .002-.006 | .002-.005 | .002-.004 | .002-.004 |
| | | | | | | .650-.787 | **.003-.007** | .003-.007 | .003-.006 | .003-.005 | .003-.005 |
| | | | | | | .788-.944 | **.003-.007** | .003-.007 | .003-.006 | .003-.005 | .003-.005 |
| | | | | | | .945-1.181 | **.005-.008** | .005-.008 | .004-.007 | .004-.006 | .004-.006 |
| | | | | | | 1.182-1.417 | **.005-.008** | .005-.008 | .004-.008 | .004-.007 | .005-.008 |
| | | | | | | 1.418-1.732 | **.005-.008** | .005-.008 | .004-.008 | .004-.007 | .005-.008 |
| | | | | | | 1.733-2.086 | **.005-.008** | .005-.008 | .004-.008 | .004-.007 | .005-.008 |
| | | | | | | 2.087-2.500 | **.006-.008** | .006-.008 | .006-.008 | .005-.007 | .006-.008 |

Note: Bold text is recommended geometry

[1] -MS geometry is only available in GC2044

GC1044 is the universal central insert grade for all materials

GC1144 is the optimized central insert grade for ISO M materials

# CoroDrill® 880

**2 – 3 x DC**

**Inch values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed (ft/min) | Drill diameter $D_c$ inch | 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 | 460-805 | .472-.550 | | | | |
| | | | | | | .551-.649 | 0.06-0.10 | 0.06-0.12 | **0.06-0.20** | |
| | | | | 4334 | 360-655 | .650-.787 | 0.06-0.12 | 0.08-0.14 | **0.08-0.22** | 0.08 - 0.22 |
| | | | | 4344 | 260-500 | .788-.944 | 0.08-0.14 | 0.10-0.18 | **0.14-0.28** | 0.10 - 0.26 |
| | | | | | | .945-1.181 | 0.08-0.14 | 0.10-0.20 | **0.16-0.32** | |
| | | | | | | 1.182-1.417 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 1.418-1.732 | 0.10-0.16 | 0.10-0.20 | **0.10-0.34** | |
| | | | | | | 1.733-2.086 | 0.12-0.18 | 0.12-0.22 | **0.12-0.34** | |
| | | | | | | 2.087-2.500 | | | | |
| | K1.1.C.NS (07.2) | Pearlitic (long chipping) | 150-270 | 4324 | 345-590 | .472-.550 | | | | |
| | | | | | | .551-.649 | 0.06-0.10 | 0.06-0.12 | **0.06-0.16** | |
| | | | | 4334 | 280-495 | .650-.787 | 0.06-0.12 | 0.08-0.14 | **0.08-0.18** | 0.08 - 0.18 |
| | | | | 4344 | 210-360 | .788-.944 | 0.08-0.14 | 0.10-0.16 | **0.10-0.24** | 0.10 - 0.24 |
| | | | | | | .945-1.181 | 0.08-0.14 | 0.10-0.18 | **0.10-0.28** | |
| | | | | | | 1.182-1.417 | 0.10-0.16 | 0.10-0.20 | **0.10-0.30** | |
| | | | | | | 1.418-1.732 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 1.733-2.086 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 2.087-2.500 | | | | |
| | K2.1.C.UT (08.1) | Gray cast iron: Low tensile strength | 150-220 | 4324 | 690-1065 | .472-.550 | | | | |
| | | | | | | .551-.649 | 0.06-0.10 | 0.06-0.12 | **0.06-0.20** | |
| | | | | 4334 | 560-885 | .650-.787 | 0.06-0.12 | 0.08-0.14 | **0.08-0.22** | 0.08 - 0.22 |
| | | | | 4344 | 430-670 | .788-.944 | 0.08-0.14 | 0.10-0.18 | **0.10-0.28** | 0.10 - 0.28 |
| | | | | | | .945-1.181 | 0.08-0.14 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 1.182-1.417 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 1.418-1.732 | 0.10-0.16 | 0.10-0.20 | **0.10-0.34** | |
| | | | | | | 1.733-2.086 | 0.12-0.18 | 0.12-0.22 | **0.12-0.34** | |
| | | | | | | 2.087-2.500 | | | | |
| | K2.2.C.UT (08.2) | High tensile strength | 200-330 | 4324 | 410-805 | .472-.550 | | | | |
| | | | | | | .551-.649 | 0.06-0.10 | 0.06-0.12 | **0.06-0.16** | |
| | | | | 4334 | 325-640 | .650-.787 | 0.06-0.12 | 0.08-0.14 | **0.08-0.18** | 0.08 - 0.18 |
| | | | | 4344 | 245-485 | .788-.944 | 0.08-0.14 | 0.10-0.16 | **0.10-0.24** | 0.10 - 0.24 |
| | | | | | | .945-1.181 | 0.08-0.14 | 0.10-0.18 | **0.10-0.28** | |
| | | | | | | 1.182-1.417 | 0.10-0.16 | 0.10-0.20 | **0.10-0.30** | |
| | | | | | | 1.418-1.732 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 1.733-2.086 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 2.087-2.500 | | | | |
| | K3.1.C.UT (09.1) | Nodular cast iron (Ferritic) | 150-230 | 4324 | 410-740 | .472-.550 | | | | |
| | | | | | | .551-.649 | 0.06-0.10 | 0.06-0.12 | **0.08-0.16** | |
| | | | | 4334 | 325-605 | .650-.787 | 0.06-0.12 | 0.08-0.14 | **0.10-0.18** | 0.08 - 0.18 |
| | | | | 4344 | 260-460 | .788-.944 | 0.08-0.14 | 0.10-0.16 | **0.12-0.24** | 0.10 - 0.24 |
| | | | | | | .945-1.181 | 0.08-0.14 | 0.10-0.18 | **0.14-0.28** | |
| | | | | | | 1.182-1.417 | 0.10-0.16 | 0.10-0.20 | **0.10-0.30** | |
| | | | | | | 1.418-1.732 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 1.733-2.086 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 2.087-2.500 | | | | |
| | K3.3.C.UT (09.2) | Pearlitic | 200-330 | | | .472-.550 | | | | |
| | | | | | | .551-.649 | 0.06-0.10 | 0.06-0.12 | **0.08-0.16** | |
| | | | | | | .650-.787 | 0.06-0.12 | 0.08-0.14 | **0.10-0.18** | 0.08 - 0.18 |
| | | | | 4324 | 360-690 | .788-.944 | 0.08-0.14 | 0.10-0.16 | **0.12-0.24** | 0.10 - 0.24 |
| | | | | 4334 | 295-575 | .945-1.181 | 0.08-0.14 | 0.10-0.18 | **0.14-0.28** | |
| | | | | 4344 | 230-430 | 1.182-1.417 | 0.10-0.16 | 0.10-0.20 | **0.10-0.30** | |
| | | | | | | 1.418-1.732 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 1.733-2.086 | 0.10-0.16 | 0.10-0.20 | **0.10-0.32** | |
| | | | | | | 2.087-2.500 | | | | |

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

# CoroDrill® 880

**2 – 3 x DC**

**Inch values**

| ISO | MC No. | Material | Hardness Brinell HB | Grade | Cutting speed (ft/min) | Drill diameter $D_c$ inch | Geometry / Feed Drill length 2-3xD -LM $f_n$ inch/rev. | -GM $f_n$ inch/rev. | -GR $f_n$ inch/rev. | -GT $f_n$ inch/rev. |
|---|---|---|---|---|---|---|---|---|---|---|
| H | H1.3.Z.HA (04.1) | Hardened and tempered | 450 | 4324 4334 4344 | 100-280 100-280 100-280 | .472-.550 .551-.649 .650-.787 .788-.944 .945-1.181 1.182-1.417 1.418-1.732 1.733-2.086 2.087-2.500 | .004-.007 .002-.004 .002-.005 .002-.006 .002-.006 .002-.007 .002-.007 .004-.007 | **.004-.008** **.002-.005** **.002-.006** **.002-.008** **.002-.008** **.002-.008** **.002-.008** **.004-.008** | .004-.013 .002-.004 .002-.005 .002-.006 .002-.006 .002-.007 .002-.007 .004-.007 | .002-.005 .002-.006 |
| N | N1.2.Z.AG (30.12) | Al. alloys Wrought or wrought and aged | 30-150 | 4344 H13A | 980-1315 980-1300 | .472-.550 .551-.649 .650-.787 .788-.944 .945-1.181 1.182-1.417 1.418-1.732 1.733-2.086 2.087-2.500 | **.002-.006** **.002-.007** **.002-.008** **.004-.008** **.004-.010** **.004-.010** **.005-.012** | .002-.005 .002-.006 .002-.007 .004-.008 .004-.008 .004-.008 .005-.009 | .002-.005 .002-.006 .002-.007 .004-.008 .004-.008 .004-.008 .005-.009 | .002-.006 .002-.007 |
| | N1.3.C.UT (30.21) | Cast, non-aging | 40-100 | 4344 H13A | 980-1315 980-1300 | .472-.550 .551-.649 .650-.787 .788-.944 .945-1.181 1.182-1.417 1.418-1.732 1.733-2.086 2.087-2.500 | **.002-.005** **.002-.006** **.002-.007** **.004-.008** **.004-.008** **.004-.008** **.005-.009** | .002-.006 .002-.007 .002-.008 .004-.008 .004-.009 .004-.010 .005-.011 | .002-.005 .002-.006 .002-.007 .004-.008 .004-.008 .004-.008 .005-.009 | .002-.006 .002-.007 |
| | N1.3.C.AG (30.22) | Cast or cast and aged | 70-140 | 4344 H13A | 820-1155 820-1150 | .472-.550 .551-.649 .650-.787 .788-.944 .945-1.181 1.182-1.417 1.418-1.732 1.733-2.086 2.087-2.500 | **.002-.005** **.002-.006** **.002-.007** **.004-.008** **.004-.008** **.004-.008** **.005-.009** | .002-.006 .002-.007 .002-.008 .004-.008 .004-.009 .004-.010 .005-.011 | .002-.005 .002-.006 .002-.007 .004-.008 .004-.008 .004-.008 .005-.009 | .002-.006 .002-.007 |
| | N3.3.U.UT (33.1) | Copper and copper alloys | 70-160 | 4344 H13A | 820-1315 820-1300 | .472-.550 .551-.649 .650-.787 .788-.944 .945-1.181 1.182-1.417 1.418-1.732 1.733-2.086 2.087-2.500 | **.002-.006** **.002-.007** **.002-.008** **.004-.008** **.004-.010** **.004-.010** **.005-.012** | .002-.005 .002-.006 .002-.007 .004-.008 .004-.008 .004-.008 .005-.009 | .002-.005 .002-.006 .002-.007 .004-.008 .004-.008 .004-.008 .005-.009 | .002-.006 .002-.007 |
| | N3.2.C.UT (33.2) | Brass and leaded alloys (Pb < 1%) | 50-200 | 4344 H13A | 590-790 590-780 | .472-.550 .551-.649 .650-.787 .788-.944 .945-1.181 1.182-1.417 1.418-1.732 1.733-2.086 2.087-2.500 | **.002-.006** **.002-.007** **.002-.008** **.004-.008** **.004-.010** **.004-.010** **.005-.012** | .002-.005 .002-.006 .002-.007 .004-.008 .004-.008 .004-.008 .005-.009 | .002-.005 .002-.006 .002-.007 .004-.008 .004-.008 .004-.008 .005-.009 | .002-.006 .002-.007 |

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

# Coromant U indexable insert plunge drill

## Metric values

| ISO | CMC No. | Material | Hardness Brinell HB | Drill dia $D_c$ mm | Feed $f_n$ mm/r | Speed $v_c$ m/min | Geometry / Grade FIRST CHOICE Highest productivity P | FIRST CHOICE Highest productivity C | Complementary P | Complementary 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 and 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<br>05.52 | Austenitic<br>Ferritic<br>(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 ($f_n$) by 50%. For easy-to-machine stainless steels in stable conditions, increase feed ($f_n$) by 25%.



SANDVIK Coromant

# Coromant U indexable insert plunge drill

| ISO | CMC No. | Material | Hardness Brinell HB | Drill dia $D_c$ mm | Feed $f_n$ mm/r | Speed $v_c$ m/min | Geometry / Grade FIRST CHOICE Highest productivity P | FIRST CHOICE Highest productivity C | Complementary P | Complementary 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 | $\alpha$, near $\alpha$ and $\alpha+\beta$ alloys. Alloys in annealed or aged conditions. | 600–1500 | 17.5–25.4 | 0.08–0.14 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | 23.22 | | | 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 | |
| | | **Gray 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 | | **Aluminum 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

# Coromant U indexable insert plunge drill

## Inch values

| ISO | CMC No. | Material | Hardness Brinell HB | Drill dia $D_c$ inch | Feed $f_n$ inch/rev. | Speed $v_c$ ft/min | Geometry / Grade FIRST CHOICE Highest productivity P | FIRST CHOICE Highest productivity C | Complementary P | Complementary C |
|---|---|---|---|---|---|---|---|---|---|---|
| P | | **Unalloyed steel** | | .500- .669 | .001–.003 | 950 (755–1245) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | 01.0 | Non hardened 0.05–0.10% C | 80–170 | .689-1.000 | .001–.003 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .002–.003 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .003–.004 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .004–.006 | | | | -53/1020 | |
| | 01.1 | Non hardened 0.05–0.25% C | 90–200 | .500- .669 | .001–.003 | 885 (740–1130) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .001–.003 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .002–.003 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .003–.004 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .004–.006 | | | | -53/1020 | |
| | 01.2 | Non-hardened 0.25–0.55% C | 125–225 | .500- .669 | .001–.004 | 755 (625–950) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .001–.006 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .003–.007 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .004–.008 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .005–.009 | | | | -53/1020 | |
| | 01.3 | Non hardened 0.55–0.80% C | 150–225 | .500- .669 | .001–.004 | 690 (560–900) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .002–.006 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .003–.007 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .004–.008 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .005–.009 | | | | -53/1020 | |
| | 01.4 | High carbon and carbon tool steel | 180–275 | .500- .669 | .001–.004 | 690 (655–900) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .002–.006 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .003–.007 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .004–.008 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .005–.009 | | | | -53/1020 | |
| | | **Low alloy steel** | | .500- .669 | .001–.004 | 720 (590–950) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | 02.1 | Non-hardened | 150–260 | .689-1.000 | .002–.005 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .004–.006 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .004–.007 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .005–.009 | | | | -53/1020 | |
| | 02.2 | Hardened | 220–450 | .500- .669 | .001–.004 | 560 (295–755) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .002–.006 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .004–.007 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .004–.008 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .005–.009 | | | | -53/1020 | |
| | | **High alloy steel** | | .500- .669 | .001–.003 | 590 (525–900) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | 03.11 | Annealed | 50–250 | .689-1.000 | .001–.006 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .003–.007 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .004–.008 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .005–.009 | | | | -53/1020 | |
| | 03.21 | Hardened steel | 250–450 | .500- .669 | .001–.004 | 1425 (260–655) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .002–.005 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .004–.006 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .004–.007 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .005–.009 | | | | -53/1020 | |
| | | **Steel castings** | | .689-1.000 | .001–.003 | 655 (460–1020) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | 06.1 | Unalloyed | 90–225 | .689-1.000 | .001–.003 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .002–.004 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .002–.005 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .003–.006 | | | | -53/1020 | |
| | 06.2 | Low alloyed (alloying elements ≤ 5%) | 150–250 | .500- .669 | .001–.004 | 525 (360–820) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .002–.005 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .004–.006 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .004–.007 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .005–.009 | | | | -53/1020 | |
| M | | **Stainless steel** | | .500- .669 | .001–.004 | 560 (395–870) | 53/3040 | 53/1020 | 53/1120 | 53/1020 |
| | 05.11 | Ferritic, Martensitic 13–25% Cr | 150–270 | .689-1.000 | .001–.006 | | | | 53/1020 | |
| | | | | 1.024-1.181 | .003–.007 | | | | 53/1020 | |
| | | | | 1.220-1.614 | .004–.008 | | | | 53/1020 | |
| | | | | 1.654-3.500 | .005–.009 | | | | 53/1020 | |
| | 05.21 | Austenitic Ni > 8% 13–25% Cr | 150–275 | .500- .669 | .001–.004 | 490 (395–820) | 53/3040 | 53/1020 | 53/1120 | 53/1020 |
| | | | | .689-1.000 | .001–.005 | | | | 53/1020 | |
| | | | | 1.024-1.181 | .003–.006 | | | | 53/1020 | |
| | | | | 1.220-1.614 | .004–.006 | | | | 53/1020 | |
| | | | | 1.654-3.500 | .004–.007 | | | | 53/1020 | |
| | 05.51 05.52 | Austenitic Ferritic (duplex) | 180–320 | .500- .669 | .001–.004 | 360 (295-475) | 53/3040 | 53/1020 | 53/1120 | 53/1020 |
| | | | | .689-1.000 | .001–.005 | | | | 53/1020 | |
| | | | | 1.024-1.181 | .003–.006 | | | | 53/1020 | |
| | | | | 1.220-1.614 | .004–.006 | | | | 53/1020 | |
| | | | | 1.654-3.500 | .004–.007 | | | | 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 ($f_n$) by 50%. For easy-to-machine stainless steels in stable conditions, increase feed ($f_n$) by 25%.



SANDVIK Coromant

# Coromant U indexable insert plunge drill

| ISO | CMC No. | Material | Hardness Brinell HB | Drill dia $D_c$ inch | Feed $f_n$ inch/rev. | Speed $v_c$ ft/min | Geometry / Grade FIRST CHOICE Highest productivity P | FIRST CHOICE Highest productivity C | Complementary P | Complementary C |
|---|---|---|---|---|---|---|---|---|---|---|
| M | | **Stainless steel** | | .500- .669 | .001-.004 | | -53/1120 | | -53/1120 | -53/1020 |
| | 15.21 | Austenitic castings | 150–250 | .689-1.000 | .001-.005 | | | -53/1020 | -53/1020 | |
| | | | | 1.024-1.181 | .003-.006 | 360 (260–510) | -53/1020 | -53/1020 | -53/1020 | |
| | | | | 1.220-1.614 | .002-.006 | | | -53/1020 | -53/1020 | |
| | | | | 1.654-3.500 | .002-.006 | | | -53/1020 | -53/1020 | |
| S | | **Heat resistant alloys** | | .500- .669 | .001-.003 | | -53/1120 | | -53/1120 | -53/1020 |
| | 20.21 | Ni based | 140–425 | .689-1.000 | .001-.004 | | | -53/1020 | -53/1020 | |
| | 20.22 | | | 1.024-1.181 | .002-.004 | 165 ( 65–290) | -53/1020 | -53/1020 | -53/1020 | |
| | 20.24 | | | 1.220-1.614 | .003-.005 | | | -53/1020 | -53/1020 | |
| | | | | 1.654-3.500 | .004-.006 | | | -53/1020 | -53/1020 | |
| | | **Titanium alloys** | | .500- .669 | .001-.004 | | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | 23.21 | $\alpha$, near $\alpha$ and $\alpha+\beta$ alloys. Alloys in annealed or aged conditions. | 600–1500 | .689-1.000 | .003-.006 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | 23.22 | | | 1.024-1.181 | .005-.006 | 195 (130–430) | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.220-1.614 | .006-.007 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.654-3.500 | .006-.008 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| K | | **Malleable cast iron** | | .500- .669 | .001-.006 | 560 (460–755) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | 07.1 | Ferritic (short chipping) | 110–145 | .689-1.000 | .004-.007 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .006-.008 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .006-.010 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .007-.011 | | | | -53/1020 | |
| | 07.2 | Pearlitic (long chipping) | 150–270 | .500- .669 | .001-.004 | 460 (345–560) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .003-.006 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .005-.007 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .006-.008 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .006-.009 | | | | -53/1020 | |
| | | **Gray cast iron** | | .500- .669 | .001-.006 | 820 (690–1020) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | 08.1 | Low tensile strength | 150–220 | .689-1.000 | .004-.007 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .006-.008 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .006-.010 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .007-.011 | | | | -53/1020 | |
| | 08.2 | High tensile strength | 200–330 | .500- .669 | .001-.004 | 560 (410–755) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .003-.006 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .005-.007 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .006-.008 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .006-.009 | | | | -53/1020 | |
| | | **Nodular cast iron** | | .500- .669 | .001-.004 | 560 (410–705) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | 09.1 | Ferritic | 125–230 | .689-1.000 | .003-.006 | | | | -53/1020 | T-53/1020 |
| | | | | 1.024-1.181 | .005-.007 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .006-.008 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .006-.009 | | | | -53/1020 | |
| | 09.2 | Pearlitic | 200–300 | .500- .669 | .001-.004 | 490 (360–655) | -53/3040 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .003-.006 | | | | -53/1020 | |
| | | | | 1.024-1.181 | .005-.007 | | | | -53/1020 | |
| | | | | 1.220-1.614 | .006-.008 | | | | -53/1020 | |
| | | | | 1.654-3.500 | .006-.009 | | | | -53/1020 | |
| H | | **Extra hard steel** | | .500- .669 | .003-.004 | | | | | |
| | 04.1 | Hardened and tempered | 450 | .689-1.000 | .003-.006 | | | | | |
| | | | | 1.024-1.181 | .003-.006 | 130 (100–260) | -53/3040 | -53/1020 | -53/1020 | -53/1020 |
| | | | | 1.220-1.614 | .004-.006 | | | | -53/1120 | |
| | | | | 1.654-3.500 | .004-.006 | | | | | |
| N | | **Aluminum alloys** | | .500- .669 | .001-.005 | 1150 (985–1440) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | 30.12 | Wrought or wrought and aged | 30–150 | .689-1.000 | .002-.006 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.024-1.181 | .004-.007 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.220-1.614 | .005-.009 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.654-3.500 | .006-.010 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | 30.21 | Cast, non-aging | 40–100 | .500- .669 | .001-.005 | 490 (100–1440) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .002-.006 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.024-1.181 | .004-.007 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.220-1.614 | .005-.009 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.654-3.500 | .006-.010 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | 30.22 | Cast or cast and aged | 70–140 | .500- .669 | .001-.005 | 985 (820–1260) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .002-.006 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.024-1.181 | .004-.007 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.220-1.614 | .005-.009 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.654-3.500 | .006-.010 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | **Copper and copper alloys** | | .500- .669 | .001-.005 | 985 (820–1260) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | 33.1 | Free cutting alloys (Pb ≥ 1%) | 50–160 | .689-1.000 | .002-.006 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.024-1.181 | .004-.007 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.220-1.614 | .005-.009 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.654-3.500 | .006-.010 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | 33.2 | Brass and leaded alloys (Pb ≤ 1%) | 50–160 | .500- .669 | .001-.005 | 755 (590–870) | -53/1120 | -53/1020 | -53/1120 | -53/1020 |
| | | | | .689-1.000 | .002-.006 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.024-1.181 | .004-.007 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.220-1.614 | .005-.009 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |
| | | | | 1.654-3.500 | .006-.010 | | -53/H13A | -53/H13A | -53/H13A | -53/H13A |

**Insert positioning:** C = Central P = Peripheral

# Trepanning

## Metric values

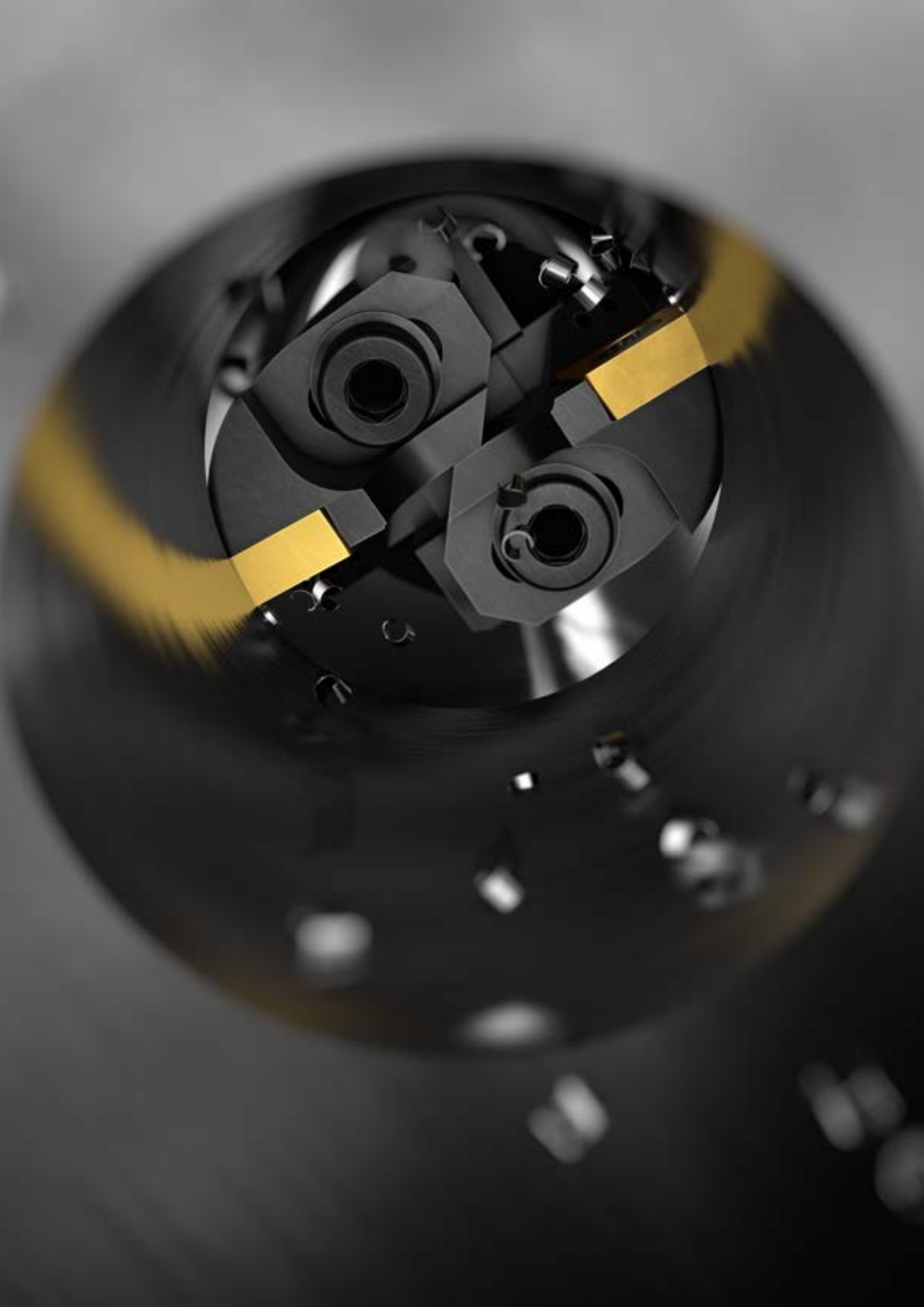
| ISO | CMC No. | Material | Hardness Brinell HB | Drill dia. $D_c$ mm | Feed $f_n$ mm/r | Speed $v_c$ m/min | Geometry / Grade |
|---|---|---|---|---|---|---|---|
| P | | **Unalloyed steel** | | | | | |
| | **01.0** | Non hardened 0.05–0.10% C | 80-170 | | 0.07–0.10 | 250-345 | -58/3040 |
| | **01.1** | 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 and 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 | |
| | | **Gray 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 | | **Aluminum 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%) | | | | | |

# CoroDrill® 880 large diameter drill

### Insert to cartridge correlation

| Diameter range, mm (inch) | Central cartridge Insert | Qty | Peripheral cartridge Insert | Qty |
|---|---|---|---|---|
| 65-69 (2.559 - 2.717) | 880-06...C<br>880-06...P | 1<br>1 | 880-06...P | 2 |
| 70-73 (2.756 - 2.874) | 880-06...C<br>880-06...P | 1<br>1 | 880-06...P | 2 |
| 74 (2.913) | 880-06...C<br>880-06...P | 1<br>1 | 880-07...P | 2 |
| 75-79 (2.953 - 3.110) | 880-07...C<br>880-07...P | 1<br>1 | 880-07...P | 2 |
| 80-84 (3.150 - 3.307) | 880-07...C<br>880-07...P | 1<br>1 | 880-07...P | 2 |

| | | | Included parts | | | |
|---|---|---|---|---|---|---|
| | | | Drill body | | Cartridge | |
| **$D_c$** | **DC"** | **Ordering code** | 3xD | 4xD | Central | Peripheral |
| 65 | 2.559 | 880-D0650xxx-xx | | | | 880-D0650-P |
| 66 | 2.598 | 880-D0660xxx-xx | 880-D065-069L50-3 | 880-D065-069L50-4 | | 880-D0660-P |
| 67 | 2.638 | 880-D0670xxx-xx | 880-D065-069LX50-3 | 880-D065-069LX50-4 | 880-D0650-C | 880-D0670-P |
| 68 | 2.677 | 880-D0680xxx-xx | 880-D065-069V80-3 | 880-D065-069V80-4 | | 880-D0680-P |
| 69 | 2.717 | 880-D0690xxx-xx | | | | 880-D0690-P |
| 70 | 2.756 | 880-D0700xxx-xx | | | | 880-D0700-P |
| 71 | 2.795 | 880-D0710xxx-xx | 880-D070-074L50-3 | 880-D070-074L50-4 | | 880-D0710-P |
| 72 | 2.835 | 880-D0720xxx-xx | 880-D070-074LX50-3 | 880-D070-074LX50-4 | 880-D0700-C | 880-D0720-P |
| 73 | 2.874 | 880-D0730xxx-xx | 880-D070-074V80-3 | 880-D070-074V80-4 | | 880-D0730-P |
| 74 | 2.913 | 880-D0740xxx-xx | | | | 880-D0740-P |
| 75 | 2.953 | 880-D0750xxx-xx | | | | 880-D0750-P |
| 76 | 2.992 | 880-D0760xxx-xx | 880-D075-079L50-3 | 880-D075-079L50-4 | | 880-D0760-P |
| 77 | 3.032 | 880-D0770xxx-xx | 880-D075-079LX50-3 | 880-D075-079LX50-4 | 880-D0750-C | 880-D0770-P |
| 78 | 3.071 | 880-D0780xxx-xx | 880-D075-079V80-3 | 880-D075-079V80-4 | | 880-D0780-P |
| 79 | 3.110 | 880-D0790xxx-xx | | | | 880-D0790-P |
| 80 | 3.150 | 880-D0800xxx-xx | | | | 880-D0800-P |
| 81 | 3.189 | 880-D0810xxx-xx | | | | 880-D0810-P |
| 82 | 3.228 | 880-D0820xxx-xx | 880-D080-084LX63-3<br>880-D080-084V80-3 | 880-D080-084LX63-4<br>880-D080-084V80-4 | 880-D0800-C | 880-D0820-P |
| 83 | 3.268 | 880-D0830xxx-xx | | | | 880-D0830-P |
| 84 | 3.307 | 880-D0840xxx-xx | | | | 880-D0840-P |



# Boring


Rough boring K3

CoroBore® BR10 K4

CoroBore® BR20 K6

CoroBore® BR30 K17

CoroBore® 820 XL K24

Fine boring K35

CoroBore® 824 K36

CoroBore® 825 K46

CoroBore® 826 K47

CoroBore® 825 XL K57

CoroBore® 826 XL K57

Face grooving K70

CoroCut® MB adapter K71

CoroBore® 825 SL K72

SpiroGrooving™ K75

Interpolation turning K78

Adapters K80

CoroBore® cartridges for boring K84

# 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, back boring, 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 based 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 catalog.
- For information regarding start recommendations and insert recommendations for boring operations, see page K97.

## Selection of tooling systems components

**3**

- If needed, find the complete selection of machine interface adapters, 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 for 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 based 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 toolkit code. LF = 14 mm reduces the diameter range of face grooving tool by 8 mm.
- See CoroCut® 1-2 in the Turning Tools catalog for SL head assortment.

## Selection of inserts

**3**

- Choose between CoroCut® 1-2 system inserts. See Turning tools catalog.

# Rough boring

| | Tool concept | Diameter range, mm (inch) | Hole tolerance | Cutting edges | Operation | Insert choice | Machine-side interface | Page |
|---|---|---|---|---|---|---|---|---|
| **CoroBore® BR10** | Conventional | 32-170 (1.260-6.693) | IT9 | 1 | - Single-edge back boring | - CoroTurn® 107 | - Coromant Capto® - Coromant EH | K4-K5 |
| **CoroBore® BR20** | Conventional | 23-150 (.906-5.906) | IT9 | 2 | - Single-edge back boring - Boring - Step boring - Single-edge boring | - CoroTurn® 107 - T-Max® P - CoroBore® 111 | - Coromant Capto® - Coromant EH | K6-K8 |
| | Damped | 23-150 (.906-5.906) | IT9 | 2 | - Boring - Step boring - Single-edge boring | - CoroTurn® 107 - CoroBore® 111 | - Coromant Capto® | K14-K15 |
| **CoroBore® BR30** | Conventional | 35-214 (1.378-8.425) | IT9 | 3 | - Boring - Step boring - Single-edge boring | - CoroTurn® 107 - T-Max® P - CoroBore® 111 | - Coromant Capto® | K17-K21 |
| Cavity boring | Conventional | 85-205 (3.346-8.071) | IT9 | 4,6,8 | - Boring - Step boring | - CoroTurn® 107* - CoroBore® 111 | - Coromant Capto® | K23 |
| **CoroBore® 820 XL** | Conventional | 148-300 (350**) (5.827 - 11.811) (13.780**) 298-1260 (11.732 - 49.606) | IT9 | 2 | - Boring - Step boring - Single-edge boring | - CoroTurn® 107 - T-Max® P - CoroBore® 111 | - Coromant Capto® - 40X with 4 bolt circle | K24-K26 K29-K32 |
| | Lightweight | 148-300 (5.827 - 11.811) | IT9 | 2 | - Boring - Step boring - Single-edge boring | - CoroTurn® 107 - CoroBore® 111 | - 40S with 4 bolt circle | K27 |
| | Damped | 148-300 (5.827 - 11.811) | IT9 | 2 | - Boring - Step boring - Single-edge boring | - CoroTurn® 107 - CoroBore® 111 | - A33 damped adapter | K28 |

*Not included in kit, order components separately

**Order components separately

# CoroBore® BR10

## Single-edge back boring tools

### Application

- Rough boring
- Back boring

### ISO application area:

P M K N S H

### Benefits and features

- Laser-marked scale on adapter increases user-friendliness when setting diameter
- Optional easy assembly as a twin-edge boring tool using BR20 slides
- Coolant nozzles with high-precision capability built into slide for precise coolant direction
- Cutting fluid through the tool for good chip evacuation
- Modularity with Coromant Capto® and Coromant EH

www.sandvik.coromant.com/coroborebr10

### Tools

Couplings:
- Coromant Capto®
- Coromant EH

### Inserts

- Standard CoroTurn® 107 inserts with a wide selection of grades and geometries for all materials.

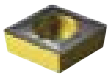
The back boring tool is based on the CoroBore® BR20 adapter together with a unique back boring slide and cover.

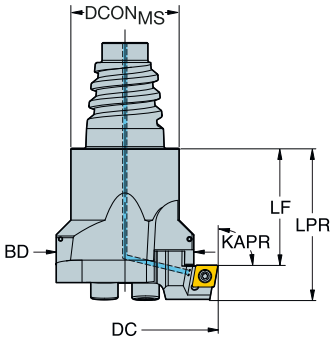
Available as a complete back boring assembly kit or separate back boring slide and cover as additional items.

# CoroBore® BR10 rough boring tool for back boring

## Coromant EH – Internal coolant supply

KAPR 90°





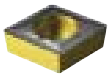

CCMT, CCGT
CCGX, CCET

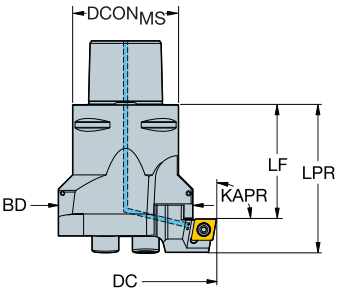
CCMW

| DCN | DCX | ↔ | IC | CZCMS | CNSC | Ordering code | DCONMS | ADJLXRDL | LF | LPR | BD1 | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Dimensions, mm, inch | | | | | | | | |
| 32.00 | 38.00 | 06 | 1/4 | E20 | 1 | BR10-38CC06F-EH20 | 19.30 | 3.00 | 15.00 | 25.00 | 20.00 | 70 | 0.070 | 1 | CCMT 06 02 04 |
| *1.260* | *1.496* | | | | | | *.760* | *.118* | *.591* | *.984* | *.787* | *1015* | | | |
| 37.00 | 45.00 | 06 | 1/4 | E25 | 1 | BR10-45CC06F-EH25 | 24.20 | 4.00 | 14.00 | 24.00 | 24.00 | 70 | 0.110 | 1 | CCMT 06 02 04 |
| *1.457* | *1.772* | | | | | | *.953* | *.157* | *.551* | *.945* | *.945* | *1015* | | | |

## Coromant Capto® - Internal coolant supply

KAPR 90°






CCMT, CCGT
CCGX, CCET

CCMW

| DCN | DCX | ↔ | IC | CZCMS | CNSC | Ordering code | DCONMS | ADJLXRDL | LF | LPR | BD1 | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Dimensions, mm, inch | | | | | | | | |
| 44.00 | 54.00 | 06 | 1/4 | C3 | 3 | BR10-54CC06F-C3 | 32.00 | 5.00 | 35.00 | 45.00 | 30.00 | 70 | 0.560 | 1 | CCMT 06 02 04 |
| *1.732* | *2.126* | | | | | | *1.260* | *.197* | *1.378* | *1.772* | *1.181* | *1015* | | | |
| 53.00 | 65.00 | 06 | 1/4 | C4 | 3 | BR10-65CC06F-C4 | 40.00 | 6.00 | 43.00 | 53.00 | 39.00 | 70 | 0.560 | 1 | CCMT 06 02 04 |
| *2.087* | *2.559* | | | | | | *1.575* | *.236* | *1.693* | *2.087* | *1.535* | *1015* | | | |
| 64.00 | 76.00 | 09 | 3/8 | C4 | 3 | BR10-76CC09F-C4 | 40.00 | 6.00 | 43.00 | 58.00 | 39.00 | 70 | 0.560 | 1 | CCMT 09 T3 08 |
| *2.520* | *2.992* | | | | | | *1.575* | *.236* | *1.693* | *2.283* | *1.535* | *1015* | | | |
| 75.00 | 91.00 | 12 | 1/2 | C5 | 3 | BR10-91CC12F-C5 | 50.00 | 8.00 | 48.00 | 68.00 | 50.00 | 70 | 0.860 | 1 | CCMT 12 04 08 |
| *2.953* | *3.583* | | | | | | *1.969* | *.315* | *1.890* | *2.677* | *1.969* | *1015* | | | |
| 90.00 | 110.00 | 12 | 1/2 | C5 | 3 | BR10-110CC12F-C5 | 50.00 | 10.00 | 50.00 | 70.00 | 63.00 | 70 | 1.230 | 1 | CCMT 12 04 08 |
| *3.543* | *4.331* | | | | | | *1.969* | *.394* | *1.969* | *2.756* | *2.480* | *1015* | | | |
| 109.00 | 136.00 | 12 | 1/2 | C6 | 3 | BR10-136CC12F-C6 | 63.00 | 13.50 | 68.00 | 88.00 | 82.00 | 70 | 2.080 | 1 | CCMT 12 04 08 |
| *4.291* | *5.354* | | | | | | *2.480* | *.531* | *2.677* | *3.465* | *3.228* | *1015* | | | |
| 135.00 | 170.00 | 12 | 1/2 | C6 | 3 | BR10-170CC12F-C6 | 63.00 | 17.50 | 78.00 | 98.00 | 108.00 | 70 | 2.380 | 1 | CCMT 12 04 08 |
| *5.315* | *6.693* | | | | | | *2.480* | *.689* | *3.071* | *3.858* | *4.252* | *1015* | | | |

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

L2

M1

N22

N15

# CoroBore® BR20

## Twin-edge rough boring tools for flexible boring

### Application

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

**ISO application area:**

P M K N S H

### Benefits and features

- Laser-marked scale on adapter increases user-friendliness when setting diameter
- Optional easy assembly as a back boring tool using a unique slide and cover
- Built-in step boring functionality without additional need for an extra shim
- Differential pitch reduces vibration tendencies – tools can be used at longer overhangs and larger depth of cuts
- Dedicated four-edged inserts with grades optimized for rough boring
- Coolant nozzles with high-precision capability built into slide for precise coolant direction.
- Cutting fluid through the tool for good chip evacuation
- Also available as damped boring tool assortment

www.sandvik.coromant.com/coroborebr20

### Tools

Couplings:
- Coromant Capto®
- Coromant EH

### Inserts

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

The differential pitch reduces vibration tendencies—tools can be used at longer overhangs and larger depth of cuts.

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

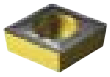
SilentTools®

Problem-solver when working with long overhangs. When using Silent Tools™, you have the opportunity to double the depth of cut, while maintaining productive boring.

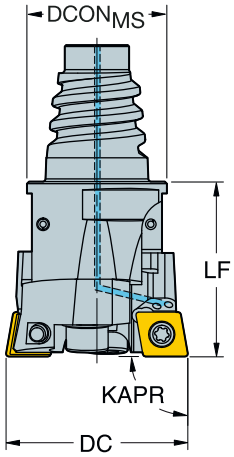
# CoroBore® BR20 twin-edge rough boring tool

**Coromant EH – Internal coolant supply**

KAPR 90°



CCMT, CCGT
CCGX, CCET
CCMW




| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 23.00 | 29.00 | 06 | 1/4 | E20 | 1 | BR20-29CC06F-EH20 | 19.30 | 3.00 | 25.00 | 70 | 0.070 | 2 | CCMT 06 02 04 |
| *.906* | *1.142* | | | | | | *.760* | *.118* | *.984* | *1015* | | | |
| 28.00 | 36.00 | 06 | 1/4 | E25 | 1 | BR20-36CC06F-EH25 | 24.20 | 4.00 | 25.00 | 70 | 0.110 | 2 | CCMT 06 02 04 |
| *1.102* | *1.417* | | | | | | *.953* | *.157* | *.984* | *1015* | | | |

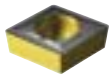
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning catalog

L2 M1 N22 N15 K91

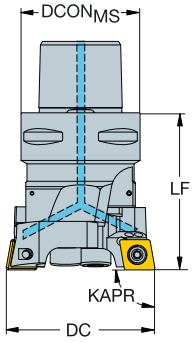
# CoroBore® BR20 twin-edge rough boring tool

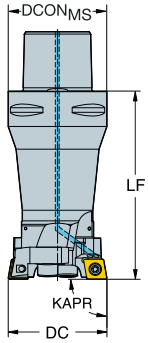
**Coromant Capto® - Internal coolant supply**



CCMT, CCGT
CCGX, CCET
CCMW

| | | |
|---|---|---|
| KAPR | 90° | 90° |
| DSGN | 1 | 2 |




| | | | | | | | | Dimensions, mm, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | DSGN | Ordering code | $DCON_{MS}$ | $ADJLX_{RDL}$ | ULDR | LF | $BD_1$ | BAR PSI | KG | CICT | MIID |
| 23.00 | 29.00 | 06 | 1/4 | C3 | 3 | 2 | BR20-29CC06F-C3 | 32.00 | 3.00 | 2.00 | 76.00 | 20.00 | 70 | 0.260 | 2 | CCMT 06 02 04 |
| *.906* | *1.142* | | | | | | | *1.260* | *.118* | | *2.992* | *.787* | *1015* | | | |
| 28.00 | 36.00 | 06 | 1/4 | C3 | 3 | 2 | BR20-36CC06F-C3 | 32.00 | 4.00 | 2.00 | 83.00 | 24.00 | 70 | 0.360 | 2 | CCMT 06 02 04 |
| *1.102* | *1.417* | | | | | | | *1.260* | *.157* | | *3.268* | *.945* | *1015* | | | |
| 35.00 | 45.00 | 09 | 3/8 | C3 | 3 | 1 | BR20-45CC09F-C3 | 32.00 | 5.00 | | 48.00 | | 70 | 0.270 | 2 | CCMT 09 T3 08 |
| *1.378* | *1.772* | | | | | | | *1.260* | *.197* | | *1.890* | | *1015* | | | |
| 35.00 | 45.00 | 09 | 3/8 | C4 | 3 | 2 | BR20-45CC09F-C4 | 40.00 | 5.00 | 1.50 | 83.00 | 30.00 | 70 | 0.560 | 2 | CCMT 09 T3 08 |
| *1.378* | *1.772* | | | | | | | *1.575* | *.197* | | *3.268* | *1.181* | *1015* | | | |
| 44.00 | 56.00 | 09 | 3/8 | C4 | 3 | 1 | BR20-56CC09F-C4 | 40.00 | 6.00 | | 56.00 | | 70 | 0.480 | 2 | CCMT 09 T3 08 |
| *1.732* | *2.205* | | | | | | | *1.575* | *.236* | | *2.205* | | *1015* | | | |
| 44.00 | 56.00 | 09 | 3/8 | C5 | 3 | 2 | BR20-56CC09F-C5 | 50.00 | 6.00 | 1.50 | 98.00 | 39.00 | 70 | 1.030 | 2 | CCMT 09 T3 08 |
| *1.732* | *2.205* | | | | | | | *1.969* | *.236* | | *3.858* | *1.535* | *1015* | | | |
| 55.00 | 71.00 | 12 | 1/2 | C5 | 3 | 1 | BR20-71CC12F-C5 | 50.00 | 8.00 | | 66.00 | | 70 | 0.860 | 2 | CCMT 12 04 08 |
| *2.165* | *2.795* | | | | | | | *1.969* | *.315* | | *2.598* | | *1015* | | | |
| 55.00 | 71.00 | 12 | 1/2 | C6 | 3 | 2 | BR20-71CC12F-C6 | 63.00 | 8.00 | 1.50 | 120.00 | 50.00 | 70 | 1.940 | 2 | CCMT 12 04 08 |
| *2.165* | *2.795* | | | | | | | *2.480* | *.315* | | *4.724* | *1.969* | *1015* | | | |
| 70.00 | 90.00 | 12 | 1/2 | C5 | 3 | 1 | BR20-90CC12F-C5 | 50.00 | 10.00 | | 70.00 | | 70 | 1.230 | 2 | CCMT 12 04 08 |
| *2.756* | *3.543* | | | | | | | *1.969* | *.394* | | *2.756* | | *1015* | | | |
| 70.00 | 90.00 | 12 | 1/2 | C6 | 3 | 1 | BR20-90CC12F-C6 | 63.00 | 10.00 | | 78.00 | | 70 | 1.580 | 2 | CCMT 12 04 08 |
| *2.756* | *3.543* | | | | | | | *2.480* | *.394* | | *3.071* | | *1015* | | | |
| 89.00 | 116.00 | 12 | 1/2 | C6 | 3 | 1 | BR20-116CC12F-C6 | 63.00 | 13.50 | | 90.00 | | 70 | 2.080 | 2 | CCMT 12 04 08 |
| *3.504* | *4.567* | | | | | | | *2.480* | *.531* | | *3.543* | | *1015* | | | |
| 89.00 | 116.00 | 12 | 1/2 | C8 | 3 | 1 | BR20-116CC12F-C8 | 80.00 | 13.50 | | 94.00 | | 70 | 2.990 | 2 | CCMT 12 04 08 |
| *3.504* | *4.567* | | | | | | | *3.150* | *.531* | | *3.701* | | *1015* | | | |
| 115.00 | 150.00 | 12 | 1/2 | C6 | 3 | 1 | BR20-150CC12F-C6 | 63.00 | 17.50 | | 90.00 | | 70 | 2.380 | 2 | CCMT 12 04 08 |
| *4.528* | *5.906* | | | | | | | *2.480* | *.689* | | *3.543* | | *1015* | | | |
| 115.00 | 150.00 | 12 | 1/2 | C8 | 3 | 1 | BR20-150CC12F-C8 | 80.00 | 17.50 | | 100.00 | | 70 | 3.630 | 2 | CCMT 12 04 08 |
| *4.528* | *5.906* | | | | | | | *3.150* | *.689* | | *3.937* | | *1015* | | | |

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

For inserts, see Turning catalog

For all DSGN 2; LU = DC*ULDR

L2 M1 N22 N15 K91

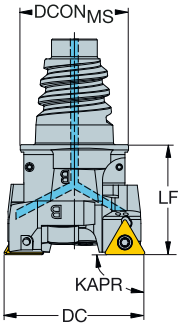


SANDVIK Coromant

# CoroBore® BR20 twin-edge rough boring tool

**Coromant EH – Internal coolant supply**

KAPR 90°



TCMT, TCMX, TCGT, TCGX TCEX

TCMW

| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 28.00 | 36.00 | 09 | 7/32 | E25 | 1 | **BR20-36TC09F-EH25** | 24.20 | 4.00 | 25.00 | 70 | 0.130 | 2 | TCMT 09 02 04 |
| *1.102* | *1.417* | | | | | | *.953* | *.157* | *.984* | *1015* | | | |

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

For inserts, see Turning catalog

L2 M1 N22 N15 K91

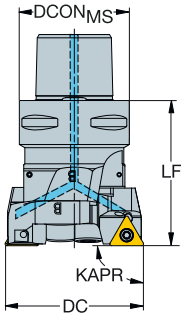
# CoroBore® BR20 twin-edge rough boring tool

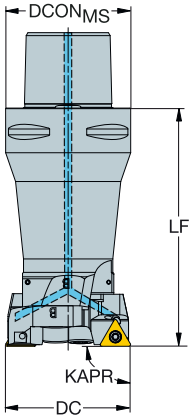
**Coromant Capto® - Internal coolant supply**

| | | |
|---|---|---|
| KAPR | 90° | 90° |
| DSGN | 1 | 2 |

TCMT, TCMX, TCGT, TCGX TCEX

TCMW




| DCN | DCX | ↔ | IC | CZC$_{MS}$ | CNSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | ULDR | LF | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 28.00 | 36.00 | 09 | 7/32 | C3 | 3 | 2 | BR20-36TC09F-C3 | 32.00 | 4.00 | 2.00 | 83.00 | 24.00 | 70 | 0.380 | 2 | TCMT 09 02 04 |
| *1.102* | *1.417* | | | | | | | *1.260* | *.157* | | *3.268* | *.945* | *1015* | | | |
| 35.00 | 45.00 | 11 | 1/4 | C3 | 3 | 1 | BR20-45TC11F-C3 | 32.00 | 5.00 | | 48.00 | | 70 | 0.270 | 2 | TCMT 11 03 04 |
| *1.378* | *1.772* | | | | | | | *1.260* | *.197* | | *1.890* | | *1015* | | | |
| 44.00 | 56.00 | 11 | 1/4 | C4 | 3 | 1 | BR20-56TC11F-C4 | 40.00 | 6.00 | | 56.00 | | 70 | 1.000 | 2 | TCMT 11 03 04 |
| *1.732* | *2.205* | | | | | | | *1.575* | *.236* | | *2.205* | | *1015* | | | |
| 55.00 | 71.00 | 16 | 3/8 | C5 | 3 | 1 | BR20-71TC16F-C5 | 50.00 | 8.00 | | 66.00 | | 70 | 0.860 | 2 | TCMT 16 T3 08 |
| *2.165* | *2.795* | | | | | | | *1.969* | *.315* | | *2.598* | | *1015* | | | |
| 70.00 | 90.00 | 16 | 3/8 | C5 | 3 | 1 | BR20-90TC16F-C5 | 50.00 | 10.00 | | 70.00 | | 70 | 1.250 | 2 | TCMT 16 T3 08 |
| *2.756* | *3.543* | | | | | | | *1.969* | *.394* | | *2.756* | | *1015* | | | |
| 70.00 | 90.00 | 16 | 3/8 | C6 | 3 | 1 | BR20-90TC16F-C6 | 63.00 | 10.00 | | 78.00 | | 70 | 1.600 | 2 | TCMT 16 T3 08 |
| *2.756* | *3.543* | | | | | | | *2.480* | *.394* | | *3.071* | | *1015* | | | |
| 89.00 | 116.00 | 16 | 3/8 | C6 | 3 | 1 | BR20-116TC16F-C6 | 63.00 | 13.50 | | 90.00 | | 70 | 2.100 | 2 | TCMT 16 T3 08 |
| *3.504* | *4.567* | | | | | | | *2.480* | *.531* | | *3.543* | | *1015* | | | |
| 115.00 | 150.00 | 16 | 3/8 | C8 | 3 | 1 | BR20-150TC16F-C8 | 80.00 | 17.50 | | 100.00 | | 70 | 3.650 | 2 | TCMT 16 T3 08 |
| *4.528* | *5.906* | | | | | | | *3.150* | *.689* | | *3.937* | | *1015* | | | |

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

For inserts, see Turning catalog

For all DSGN 2; LU = DC*ULDR

L2 M1 N22 N15 K91



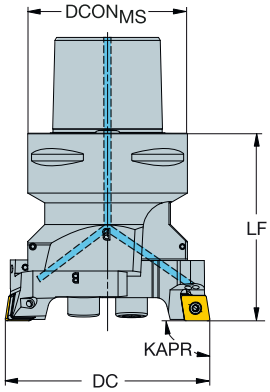
SANDVIK Coromant

# CoroBore® BR20 twin-edge rough boring tool

**Coromant Capto® - Internal coolant supply**

KAPR 90°

CNMU




| DCN | DCX | | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXRDL | LF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 70.00 | 90.00 | 12 | 1/2 | C6 | 3 | BR20-90CN12F-C6 | 63.00 | 10.00 | 78.00 | 70 | 2.200 | 2 | CNMU 12 04 12 |
| *2.756* | *3.543* | | | | | | *2.480* | *.394* | *3.071* | *1015* | | | |
| 89.00 | 116.00 | 12 | 1/2 | C8 | 3 | BR20-116CN12F-C8 | 80.00 | 13.50 | 94.00 | 70 | 2.900 | 2 | CNMU 12 04 12 |
| *3.504* | *4.567* | | | | | | *3.150* | *.531* | *3.701* | *1015* | | | |
| 115.00 | 150.00 | 12 | 1/2 | C8 | 3 | BR20-150CN12F-C8 | 80.00 | 17.50 | 100.00 | 70 | 3.690 | 2 | CNMU 12 04 12 |
| *4.528* | *5.906* | | | | | | *3.150* | *.689* | *3.937* | *1015* | | | |

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

For inserts, see Turning catalog

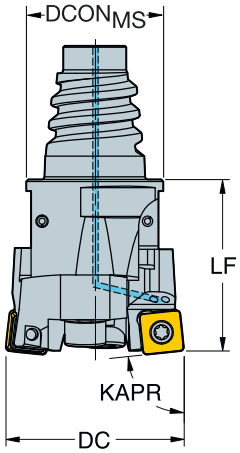
L2 M1 N22 N15 K91

# CoroBore® BR20 twin-edge rough boring tool

**Coromant EH – Internal coolant supply**

SPMT

KAPR 84°




| DCN | DCX | | IC | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | LF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 23.00 | 29.00 | 06 | 06 | E20 | 1 | **BR20-29SP06Y-EH20** | 19.30 | 3.00 | 25.00 | 70 | 0.070 | 2 | SPMT 0606-BM |
| *.906* | *1.142* | | | | | | *.760* | *.118* | *.984* | *1015* | | | |
| 28.00 | 36.00 | 06 | 06 | E25 | 1 | **BR20-36SP06Y-EH25** | 24.20 | 4.00 | 25.00 | 70 | 0.110 | 2 | SPMT 0606-BM |
| *1.102* | *1.417* | | | | | | *.953* | *.157* | *.984* | *1015* | | | |

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

K33 L2 M1 N22 N15 K91



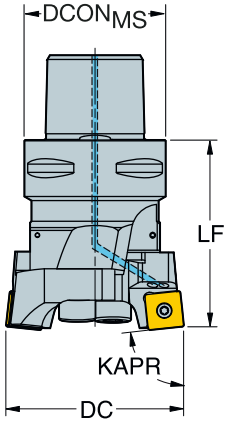
SANDVIK Coromant

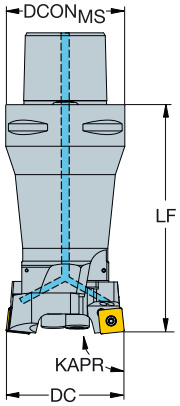
# CoroBore® BR20 twin-edge rough boring tool

**Coromant Capto® - Internal coolant supply**

SPMT

| | | |
|---|---|---|
| KAPR | 84° | 84° |
| DSGN | 1 | 2 |




| | | | | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DCN | DCX | ↔ | ↕IC | $CZC_{MS}$ | CNSC | DSGN | Ordering code | $DCON_{MS}$ | $ADJLX_{RDL}$ | ULDR | LF | $BD_1$ | BAR PSI | KG | CICT | MIID |
| 23.00 | 29.00 | 06 | 06 | C3 | 3 | 2 | BR20-29SP06Y-C3 | 32.00 | 3.00 | 2.00 | 76.00 | 20.00 | 70 | 0.260 | 2 | SPMT 0606-BM |
| *.906* | *1.142* | | | | | | | *1.260* | *.118* | | *2.992* | *.787* | *1015* | | | |
| 28.00 | 36.00 | 06 | 06 | C3 | 3 | 2 | BR20-36SP06Y-C3 | 32.00 | 4.00 | 2.00 | 83.00 | 24.00 | 70 | 0.360 | 2 | SPMT 0606-BM |
| *1.102* | *1.417* | | | | | | | *1.260* | *.157* | | *3.268* | *.945* | *1015* | | | |
| 35.00 | 45.00 | 08 | 08 | C3 | 3 | 1 | BR20-45SP08Y-C3 | 32.00 | 5.00 | | 48.00 | | 70 | 0.270 | 2 | SPMT 0808-BM |
| *1.378* | *1.772* | | | | | | | *1.260* | *.197* | | *1.890* | | *1015* | | | |
| 35.00 | 45.00 | 08 | 08 | C4 | 3 | 2 | BR20-45SP08Y-C4 | 40.00 | 5.00 | 1.50 | 83.00 | 30.00 | 70 | 0.560 | 2 | SPMT 0808-BM |
| *1.378* | *1.772* | | | | | | | *1.575* | *.197* | | *3.268* | *1.181* | *1015* | | | |
| 44.00 | 56.00 | 08 | 08 | C4 | 3 | 1 | BR20-56SP08Y-C4 | 40.00 | 6.00 | | 56.00 | | 70 | 0.480 | 2 | SPMT 0808-BM |
| *1.732* | *2.205* | | | | | | | *1.575* | *.236* | | *2.205* | | *1015* | | | |
| 44.00 | 56.00 | 08 | 08 | C5 | 3 | 2 | BR20-56SP08Y-C5 | 50.00 | 6.00 | 1.50 | 98.00 | 39.00 | 70 | 1.030 | 2 | SPMT 0808-BM |
| *1.732* | *2.205* | | | | | | | *1.969* | *.236* | | *3.858* | *1.535* | *1015* | | | |
| 55.00 | 71.00 | 12 | 12 | C5 | 3 | 1 | BR20-71SP12Y-C5 | 50.00 | 8.00 | | 66.00 | | 70 | 0.860 | 2 | SPMT 1210-BM |
| *2.165* | *2.795* | | | | | | | *1.969* | *.315* | | *2.598* | | *1015* | | | |
| 55.00 | 71.00 | 12 | 12 | C6 | 3 | 2 | BR20-71SP12Y-C6 | 63.00 | 8.00 | 1.50 | 120.00 | 50.00 | 70 | 1.940 | 2 | SPMT 1210-BM |
| *2.165* | *2.795* | | | | | | | *2.480* | *.315* | | *4.724* | *1.969* | *1015* | | | |
| 70.00 | 90.00 | 12 | 12 | C5 | 3 | 1 | BR20-90SP12Y-C5 | 50.00 | 10.00 | | 70.00 | | 70 | 1.230 | 2 | SPMT 1210-BM |
| *2.756* | *3.543* | | | | | | | *1.969* | *.394* | | *2.756* | | *1015* | | | |
| 70.00 | 90.00 | 12 | 12 | C6 | 3 | 1 | BR20-90SP12Y-C6 | 63.00 | 10.00 | | 78.00 | | 70 | 1.580 | 2 | SPMT 1210-BM |
| *2.756* | *3.543* | | | | | | | *2.480* | *.394* | | *3.071* | | *1015* | | | |
| 89.00 | 116.00 | 12 | 12 | C6 | 3 | 1 | BR20-116SP12Y-C6 | 63.00 | 13.50 | | 90.00 | | 70 | 2.080 | 2 | SPMT 1210-BM |
| *3.504* | *4.567* | | | | | | | *2.480* | *.531* | | *3.543* | | *1015* | | | |
| 89.00 | 116.00 | 12 | 12 | C8 | 3 | 1 | BR20-116SP12Y-C8 | 80.00 | 13.50 | | 94.00 | | 70 | 2.990 | 2 | SPMT 1210-BM |
| *3.504* | *4.567* | | | | | | | *3.150* | *.531* | | *3.701* | | *1015* | | | |
| 115.00 | 150.00 | 12 | 12 | C6 | 3 | 1 | BR20-150SP12Y-C6 | 63.00 | 17.50 | | 90.00 | | 70 | 2.380 | 2 | SPMT 1210-BM |
| *4.528* | *5.906* | | | | | | | *2.480* | *.689* | | *3.543* | | *1015* | | | |
| 115.00 | 150.00 | 12 | 12 | C8 | 3 | 1 | BR20-150SP12Y-C8 | 80.00 | 17.50 | | 100.00 | | 70 | 3.630 | 2 | SPMT 1210-BM |
| *4.528* | *5.906* | | | | | | | *3.150* | *.689* | | *3.937* | | *1015* | | | |

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

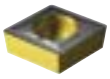
For all DSGN 2; LU = DC*ULDR

K33 L2 M1 N22 N15 K91

# CoroBore® BR20 twin-edge damped rough boring tool

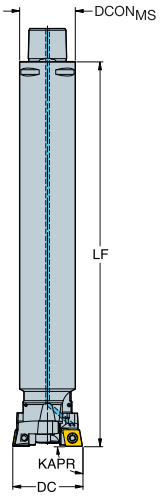
**Coromant Capto® - Internal coolant supply**

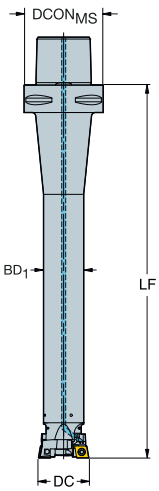
SilentTools®



CCMT, CCGT
CCGX, CCET
CCMW

| KAPR | 90° | 90° |
|---|---|---|
| DSGN | 1 | 2 |




| DCN | DCX | ↔ | ↕IC | CZC$_{MS}$ | CNSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | ULDR | LF | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 23.00 | 29.00 | 06 | 1/4 | C4 | 3 | 2 | BR20D-29CC06F-C4L | 40.00 | 3.00 | 6.00 | 199.00 | 20.00 | 70 | 0.740 | 2 | CCMT 06 02 04 |
| *.906* | *1.142* | | | | | | | *1.575* | *.118* | | *7.835* | *.787* | *1015* | | | |
| 28.00 | 36.00 | 06 | 1/4 | C3 | 3 | 2 | BR20D-36CC06F-C3L | 32.00 | 4.00 | 6.00 | 216.00 | 25.00 | 70 | 1.030 | 2 | CCMT 06 02 04 |
| *1.102* | *1.417* | | | | | | | *1.260* | *.157* | | *8.504* | *.984* | *1015* | | | |
| 35.00 | 45.00 | 09 | 3/8 | C3 | 3 | 1 | BR20D-45CC09F-C3L | 32.00 | 5.00 | | 221.00 | | 70 | 1.540 | 2 | CCMT 09 T3 08 |
| *1.378* | *1.772* | | | | | | | *1.260* | *.197* | | *8.701* | | *1015* | | | |
| 35.00 | 45.00 | 09 | 3/8 | C4 | 3 | 2 | BR20D-45CC09F-C4L | 40.00 | 5.00 | 6.00 | 270.00 | 32.00 | 70 | 1.980 | 2 | CCMT 09 T3 08 |
| *1.378* | *1.772* | | | | | | | *1.575* | *.197* | | *10.630* | *1.260* | *1015* | | | |
| 35.00 | 45.00 | 09 | 3/8 | C6 | 3 | 2 | BR20D-45CC09F-C6L | 63.00 | 5.00 | 6.00 | 297.00 | 32.00 | 70 | 2.620 | 2 | CCMT 09 T3 08 |
| *1.378* | *1.772* | | | | | | | *2.480* | *.197* | | *11.693* | *1.260* | *1015* | | | |
| 44.00 | 56.00 | 09 | 3/8 | C4 | 3 | 1 | BR20D-56CC09F-C4L | 40.00 | 6.00 | | 220.00 | | 70 | 2.380 | 2 | CCMT 09 T3 08 |
| *1.732* | *2.205* | | | | | | | *1.575* | *.236* | | *8.661* | | *1015* | | | |
| 44.00 | 56.00 | 09 | 3/8 | C5 | 3 | 2 | BR20D-56CC09F-C5L | 50.00 | 6.00 | 6.00 | 336.00 | 40.00 | 70 | 3.720 | 2 | CCMT 09 T3 08 |
| *1.732* | *2.205* | | | | | | | *1.969* | *.236* | | *13.228* | *1.575* | *1015* | | | |
| 44.00 | 56.00 | 09 | 3/8 | C6 | 3 | 2 | BR20D-56CC09F-C6L | 63.00 | 6.00 | 6.00 | 363.00 | 40.00 | 70 | 4.350 | 2 | CCMT 09 T3 08 |
| *1.732* | *2.205* | | | | | | | *2.480* | *.236* | | *14.291* | *1.575* | *1015* | | | |
| 55.00 | 71.00 | 12 | 1/2 | C5 | 3 | 1 | BR20D-71CC12F-C5M | 50.00 | 8.00 | | 300.00 | | 70 | 5.080 | 2 | CCMT 12 04 08 |
| *2.165* | *2.795* | | | | | | | *1.969* | *.315* | | *11.811* | | *1015* | | | |
| 55.00 | 71.00 | 12 | 1/2 | C6 | 3 | 2 | BR20D-71CC12F-C6M | 63.00 | 8.00 | 5.60 | 400.00 | 50.00 | 70 | 6.940 | 2 | CCMT 12 04 08 |
| *2.165* | *2.795* | | | | | | | *2.480* | *.315* | | *15.748* | *1.969* | *1015* | | | |
| 70.00 | 90.00 | 12 | 1/2 | C6 | 3 | 1 | BR20D-90CC12F-C6M | 63.00 | 10.00 | | 400.00 | | 70 | 9.910 | 2 | CCMT 12 04 08 |
| *2.756* | *3.543* | | | | | | | *2.480* | *.394* | | *15.748* | | *1015* | | | |
| 70.00 | 90.00 | 12 | 1/2 | C8 | 3 | 2 | BR20D-90CC12F-C8M | 80.00 | 10.00 | 5.60 | 500.00 | 63.00 | 70 | 12.660 | 2 | CCMT 12 04 08 |
| *2.756* | *3.543* | | | | | | | *3.150* | *.394* | | *19.685* | *2.480* | *1015* | | | |
| 89.00 | 116.00 | 12 | 1/2 | C8 | 3 | 1 | BR20D-116CC12F-C8M | 80.00 | 13.50 | | 500.00 | | 70 | 18.490 | 2 | CCMT 12 04 08 |
| *3.504* | *4.567* | | | | | | | *3.150* | *.531* | | *19.685* | | *1015* | | | |
| 89.00 | 116.00 | 12 | 1/2 | C8 | 3 | 1 | BR20D-116CC12F-C8S | 80.00 | 13.50 | | 410.00 | | 70 | 16.140 | 2 | CCMT 12 04 08 |
| *3.504* | *4.567* | | | | | | | *3.150* | *.531* | | *16.142* | | *1015* | | | |
| 115.00 | 150.00 | 12 | 1/2 | C8 | 3 | 1 | BR20D-150CC12F-C8M | 80.00 | 17.50 | | 500.00 | | 70 | 18.620 | 2 | CCMT 12 04 08 |
| *4.528* | *5.906* | | | | | | | *3.150* | *.689* | | *19.685* | | *1015* | | | |

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

L2 M1 N22 N15 K91

# CoroBore® BR20 twin-edge damped rough boring tool

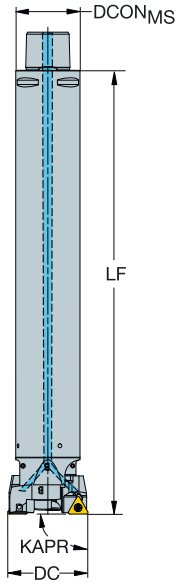
**Coromant Capto® - Internal coolant supply**

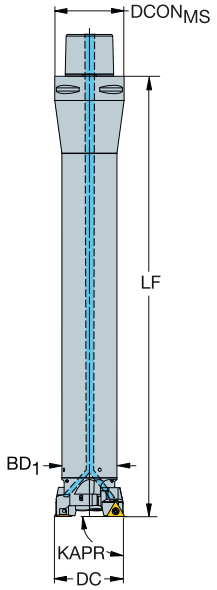
| | | |
|---|---|---|
| KAPR | 90° | 90° |
| DSGN | 1 | 2 |

SilentTools®

TCMT, TCMX, TCGT, TCGX TCEX

TCMW




| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | DSGN | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | ULDR | LF | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 28.00 | 36.00 | 09 | 7/32 | C3 | 3 | 2 | BR20D-36TC09F-C3L | 32.00 | 4.00 | 6.00 | 216.00 | 25.00 | 70 | 1.718 | 2 | TCMT 09 02 04 |
| *1.102* | *1.417* | | | | | | | *1.260* | *.157* | | *8.504* | *.984* | *1015* | | | |
| 35.00 | 45.00 | 11 | 1/4 | C3 | 3 | 1 | BR20D-45TC11F-C3L | 32.00 | 5.00 | | 221.00 | | 70 | 2.330 | 2 | TCMT 11 03 04 |
| *1.378* | *1.772* | | | | | | | *1.260* | *.197* | | *8.701* | | *1015* | | | |
| 35.00 | 45.00 | 11 | 1/4 | C4 | 3 | 2 | BR20D-45TC11F-C4L | 40.00 | 5.00 | 6.00 | 270.00 | 32.00 | 70 | 1.980 | 2 | TCMT 11 03 04 |
| *1.378* | *1.772* | | | | | | | *1.575* | *.197* | | *10.630* | *1.260* | *1015* | | | |
| 44.00 | 56.00 | 11 | 1/4 | C4 | 3 | 1 | BR20D-56TC11F-C4L | 40.00 | 6.00 | | 220.00 | | 70 | 2.400 | 2 | TCMT 11 03 04 |
| *1.732* | *2.205* | | | | | | | *1.575* | *.236* | | *8.661* | | *1015* | | | |
| 44.00 | 56.00 | 11 | 1/4 | C5 | 3 | 2 | BR20D-56TC11F-C5L | 50.00 | 6.00 | 6.00 | 336.00 | 40.00 | 70 | 5.740 | 2 | TCMT 11 03 04 |
| *1.732* | *2.205* | | | | | | | *1.969* | *.236* | | *13.228* | *1.575* | *1015* | | | |
| 55.00 | 71.00 | 16 | 3/8 | C5 | 3 | 1 | BR20D-71TC16F-C5M | 50.00 | 8.00 | | 300.00 | | 70 | 5.080 | 2 | TCMT 16 T3 08 |
| *2.165* | *2.795* | | | | | | | *1.969* | *.315* | | *11.811* | | *1015* | | | |
| 70.00 | 90.00 | 16 | 3/8 | C6 | 3 | 1 | BR20D-90TC16F-C6M | 63.00 | 10.00 | | 400.00 | | 70 | 9.930 | 2 | TCMT 16 T3 08 |
| *2.756* | *3.543* | | | | | | | *2.480* | *.394* | | *15.748* | | *1015* | | | |
| 89.00 | 116.00 | 16 | 3/8 | C8 | 3 | 1 | BR20D-116TC16F-C8M | 80.00 | 13.50 | | 500.00 | | 70 | 22.085 | 2 | TCMT 16 T3 08 |
| *3.504* | *4.567* | | | | | | | *3.150* | *.531* | | *19.685* | | *1015* | | | |
| 89.00 | 116.00 | 16 | 3/8 | C8 | 3 | 1 | BR20D-116TC16F-C8S | 80.00 | 13.50 | | 410.00 | | 70 | 16.160 | 2 | TCMT 16 T3 08 |
| *3.504* | *4.567* | | | | | | | *3.150* | *.531* | | *16.142* | | *1015* | | | |
| 115.00 | 150.00 | 16 | 3/8 | C8 | 3 | 1 | BR20D-150TC16F-C8M | 80.00 | 17.50 | | 500.00 | | 70 | 23.200 | 2 | TCMT 16 T3 08 |
| *4.528* | *5.906* | | | | | | | *3.150* | *.689* | | *19.685* | | *1015* | | | |

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

For inserts, see Turning catalog

For all DSGN 2; LU = DC*ULDR

L2 M1 N22 N15 K91

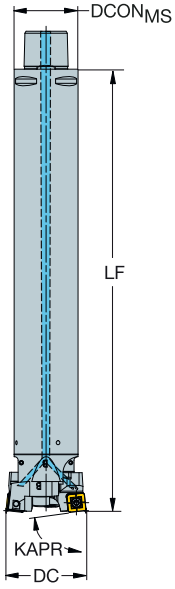
# CoroBore® BR20 twin-edge damped rough boring tool

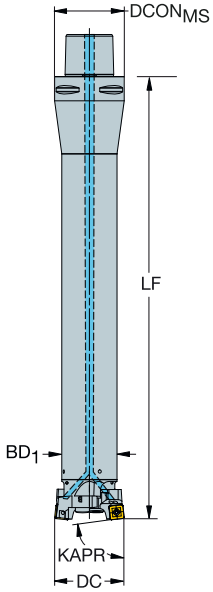
**Coromant Capto® - Internal coolant supply**

SPMT

SilentTools®

| | | |
|---|---|---|
| KAPR | 84° | 84° |
| DSGN | 1 | 2 |




| DCN | DCX | ↔ | ↔IC | CZC$_{MS}$ | CNSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | ULDR | LF | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 23.00 | 29.00 | 06 | 06 | C4 | 3 | 2 | BR20D-29SP06Y-C4L | 40.00 | 3.00 | 6.00 | 199.00 | 20.00 | 70 | 0.740 | 2 | SPMT 0606-BM |
| *.906* | *1.142* | | | | | | | *1.575* | *.118* | | *7.835* | *.787* | *1015* | | | |
| 28.00 | 36.00 | 06 | 06 | C3 | 3 | 2 | BR20D-36SP06Y-C3L | 32.00 | 4.00 | 6.00 | 216.00 | 25.00 | 70 | 1.030 | 2 | SPMT 0606-BM |
| *1.102* | *1.417* | | | | | | | *1.260* | *.157* | | *8.504* | *.984* | *1015* | | | |
| 35.00 | 45.00 | 08 | 08 | C3 | 3 | 1 | BR20D-45SP08Y-C3L | 32.00 | 5.00 | | 221.00 | | 70 | 2.330 | 2 | SPMT 0808-BM |
| *1.378* | *1.772* | | | | | | | *1.260* | *.197* | | *8.701* | | *1015* | | | |
| 35.00 | 45.00 | 08 | 08 | C4 | 3 | 2 | BR20D-45SP08Y-C4L | 40.00 | 5.00 | 6.00 | 270.00 | 32.00 | 70 | 4.500 | 2 | SPMT 0808-BM |
| *1.378* | *1.772* | | | | | | | *1.575* | *.197* | | *10.630* | *1.260* | *1015* | | | |
| 35.00 | 45.00 | 08 | 08 | C6 | 3 | 2 | BR20D-45SP08Y-C6L | 63.00 | 5.00 | 6.00 | 297.00 | 32.00 | 70 | 2.630 | 2 | SPMT 0808-BM |
| *1.378* | *1.772* | | | | | | | *2.480* | *.197* | | *11.693* | *1.260* | *1015* | | | |
| 44.00 | 56.00 | 08 | 08 | C4 | 3 | 1 | BR20D-56SP08Y-C4L | 40.00 | 6.00 | | 220.00 | | 70 | 5.120 | 2 | SPMT 0808-BM |
| *1.732* | *2.205* | | | | | | | *1.575* | *.236* | | *8.661* | | *1015* | | | |
| 44.00 | 56.00 | 08 | 08 | C5 | 3 | 2 | BR20D-56SP08Y-C5L | 50.00 | 6.00 | 6.00 | 336.00 | 40.00 | 70 | 3.720 | 2 | SPMT 0808-BM |
| *1.732* | *2.205* | | | | | | | *1.969* | *.236* | | *13.228* | *1.575* | *1015* | | | |
| 44.00 | 56.00 | 08 | 08 | C6 | 3 | 1 | BR20D-56SP08Y-C6L | 63.00 | 6.00 | 6.00 | 363.00 | 40.00 | 70 | 4.350 | 2 | SPMT 0808-BM |
| *1.732* | *2.205* | | | | | | | *2.480* | *.236* | | *14.291* | *1.575* | *1015* | | | |
| 55.00 | 71.00 | 12 | 12 | C5 | 3 | 1 | BR20D-71SP12Y-C5M | 50.00 | 8.00 | | 300.00 | | 70 | 7.672 | 2 | SPMT 1210-BM |
| *2.165* | *2.795* | | | | | | | *1.969* | *.315* | | *11.811* | | *1015* | | | |
| 55.00 | 71.00 | 12 | 12 | C6 | 3 | 2 | BR20D-71SP12Y-C6M | 63.00 | 8.00 | 5.60 | 400.00 | 50.00 | 70 | 6.940 | 2 | SPMT 1210-BM |
| *2.165* | *2.795* | | | | | | | *2.480* | *.315* | | *15.748* | *1.969* | *1015* | | | |
| 70.00 | 90.00 | 12 | 12 | C6 | 3 | 1 | BR20D-90SP12Y-C6M | 63.00 | 10.00 | | 400.00 | | 70 | 12.000 | 2 | SPMT 1210-BM |
| *2.756* | *3.543* | | | | | | | *2.480* | *.394* | | *15.748* | | *1015* | | | |
| 70.00 | 90.00 | 12 | 12 | C8 | 3 | 2 | BR20D-90SP12Y-C8M | 80.00 | 10.00 | 5.60 | 500.00 | 63.00 | 70 | 16.183 | 2 | SPMT 1210-BM |
| *2.756* | *3.543* | | | | | | | *3.150* | *.394* | | *19.685* | *2.480* | *1015* | | | |
| 89.00 | 116.00 | 12 | 12 | C8 | 3 | 1 | BR20D-116SP12Y-C8M | 80.00 | 13.50 | | 500.00 | | 70 | 22.125 | 2 | SPMT 1210-BM |
| *3.504* | *4.567* | | | | | | | *3.150* | *.531* | | *19.685* | | *1015* | | | |
| 89.00 | 116.00 | 12 | 12 | C8 | 3 | 1 | BR20D-116SP12Y-C8S | 80.00 | 13.50 | | 410.00 | | 70 | 16.140 | 2 | SPMT 1210-BM |
| *3.504* | *4.567* | | | | | | | *3.150* | *.531* | | *16.142* | | *1015* | | | |
| 115.00 | 150.00 | 12 | 12 | C8 | 3 | 1 | BR20D-150SP12Y-C8M | 80.00 | 17.50 | | 500.00 | | 70 | 18.620 | 2 | SPMT 1210-BM |
| *4.528* | *5.906* | | | | | | | *3.150* | *.689* | | *19.685* | | *1015* | | | |

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

For all DSGN 2; LU = DC*ULDR

K33 L2 M1 N22 N15 K91



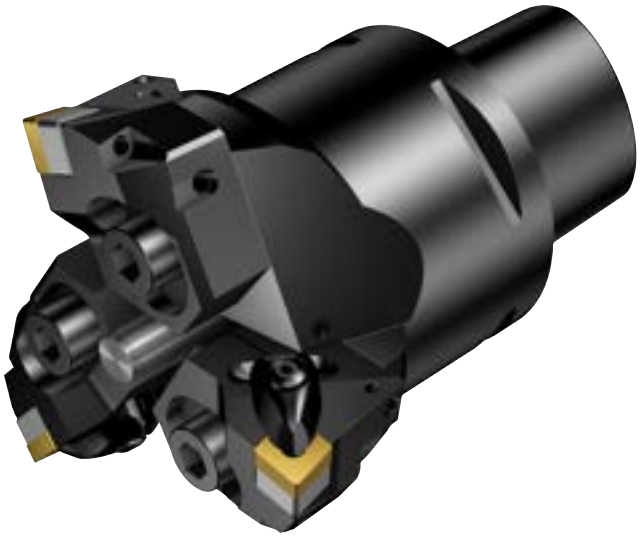
SANDVIK Coromant

# 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 adapter increases user-friendliness when setting diameter.
- Modularity with Coromant Capto® .
- High-pressure coolant through adapter
- Step boring: Additional shims available, order 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.

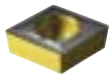
From diameters of 85 to 205 mm (3.346 to 8.071 inch), CoroBore® BR30 is available with up to 8 cutting edges for maximum metal removal rate.

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

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

# CoroBore® BR30 three-edge rough boring tool

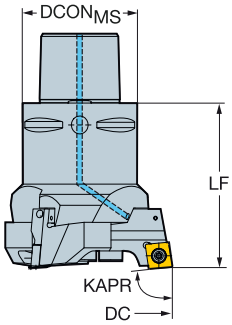
**Coromant Capto® - Internal coolant supply**

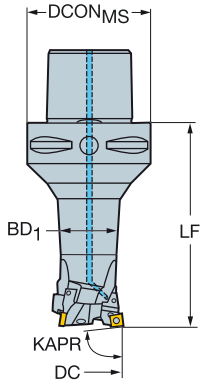


CCMT, CCGT
CCGX, CCET

CCMW

KAPR 90° 90°
DSGN 1 2




| DCN | DCX | ap | IC | CZC$_{MS}$ | CNSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | ULDR | LF | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 35.00 | 40.50 | 06 | 1/4 | C3 | 3 | 1 | BR30-41CC06F-C3 | 32.00 | 2.75 | | 48.00 | | 70 | 0.250 | 3 | CCMT 06 02 04 |
| *1.378* | *1.594* | | | | | | | *1.260* | *.108* | | *1.890* | | *1015* | | | |
| 35.00 | 40.50 | 06 | 1/4 | C4 | 3 | 2 | BR30-41CC06F-C4 | 40.00 | 2.75 | 1.50 | 83.00 | 31.50 | 70 | 0.640 | 3 | CCMT 06 02 04 |
| *1.378* | *1.594* | | | | | | | *1.575* | *.108* | | *3.268* | *1.240* | *1015* | | | |
| 39.50 | 45.00 | 06 | 1/4 | C3 | 3 | 1 | BR30-45CC06F-C3 | 32.00 | 2.75 | | 48.00 | | 70 | 0.280 | 3 | CCMT 06 02 04 |
| *1.555* | *1.772* | | | | | | | *1.260* | *.108* | | *1.890* | | *1015* | | | |
| 39.50 | 45.00 | 06 | 1/4 | C4 | 3 | 2 | BR30-45CC06F-C4 | 40.00 | 2.75 | 1.50 | 83.00 | 31.50 | 70 | 0.670 | 3 | CCMT 06 02 04 |
| *1.555* | *1.772* | | | | | | | *1.575* | *.108* | | *3.268* | *1.240* | *1015* | | | |
| 44.00 | 50.50 | 06 | 1/4 | C4 | 3 | 1 | BR30-51CC06F-C4 | 40.00 | 3.25 | | 56.00 | | 70 | 0.620 | 3 | CCMT 06 02 04 |
| *1.732* | *1.988* | | | | | | | *1.575* | *.128* | | *2.205* | | *1015* | | | |
| 44.00 | 50.50 | 06 | 1/4 | C5 | 3 | 2 | BR30-51CC06F-C5 | 50.00 | 3.25 | 1.50 | 98.00 | 39.60 | 70 | 1.180 | 3 | CCMT 06 02 04 |
| *1.732* | *1.988* | | | | | | | *1.969* | *.128* | | *3.858* | *1.559* | *1015* | | | |
| 49.50 | 56.00 | 06 | 1/4 | C4 | 3 | 1 | BR30-56CC06F-C4 | 40.00 | 3.25 | | 56.00 | | 70 | 0.650 | 3 | CCMT 06 02 04 |
| *1.949* | *2.205* | | | | | | | *1.575* | *.128* | | *2.205* | | *1015* | | | |
| 49.50 | 56.00 | 09 | 3/8 | C4 | 3 | 1 | BR30-56CC09F-C4 | 40.00 | 3.25 | | 58.00 | | 70 | 0.641 | 3 | CCMT 09 T3 08 |
| *1.949* | *2.205* | | | | | | | *1.575* | *.128* | | *2.283* | | *1015* | | | |
| 49.50 | 56.00 | 06 | 1/4 | C5 | 3 | 2 | BR30-56CC06F-C5 | 50.00 | 3.25 | 1.50 | 98.00 | 39.60 | 70 | 1.210 | 3 | CCMT 06 02 04 |
| *1.949* | *2.205* | | | | | | | *1.969* | *.128* | | *3.858* | *1.559* | *1015* | | | |
| 49.50 | 56.00 | 09 | 3/8 | C5 | 3 | 2 | BR30-56CC09F-C5 | 50.00 | 3.25 | 1.50 | 100.00 | 39.60 | 70 | 1.240 | 3 | CCMT 09 T3 08 |
| *1.949* | *2.205* | | | | | | | *1.969* | *.128* | | *3.937* | *1.559* | *1015* | | | |
| 55.00 | 63.00 | 09 | 3/8 | C5 | 3 | 1 | BR30-63CC09F-C5 | 50.00 | 4.00 | | 66.00 | | 70 | 0.890 | 3 | CCMT 09 T3 08 |
| *2.165* | *2.480* | | | | | | | *1.969* | *.157* | | *2.598* | | *1015* | | | |
| 55.00 | 63.00 | 09 | 3/8 | C6 | 3 | 2 | BR30-63CC09F-C6 | 63.00 | 4.00 | 1.50 | 120.00 | 49.50 | 70 | 1.980 | 3 | CCMT 09 T3 08 |
| *2.165* | *2.480* | | | | | | | *2.480* | *.157* | | *4.724* | *1.949* | *1015* | | | |
| 62.00 | 70.00 | 09 | 3/8 | C5 | 3 | 1 | BR30-70CC09F-C5 | 50.00 | 4.00 | | 66.00 | | 70 | 0.920 | 3 | CCMT 09 T3 08 |
| *2.441* | *2.756* | | | | | | | *1.969* | *.157* | | *2.598* | | *1015* | | | |
| 62.00 | 70.00 | 12 | 1/2 | C5 | 3 | 1 | BR30-70CC12F-C5 | 50.00 | 4.00 | | 68.00 | | 70 | 0.980 | 3 | CCMT 12 04 08 |
| *2.441* | *2.756* | | | | | | | *1.969* | *.157* | | *2.677* | | *1015* | | | |
| 62.00 | 70.00 | 09 | 3/8 | C6 | 3 | 2 | BR30-70CC09F-C6 | 63.00 | 4.00 | 1.50 | 120.00 | 49.50 | 70 | 2.312 | 3 | CCMT 09 T3 08 |
| *2.441* | *2.756* | | | | | | | *2.480* | *.157* | | *4.724* | *1.949* | *1015* | | | |
| 62.00 | 70.00 | 12 | 1/2 | C6 | 3 | 2 | BR30-70CC12F-C6 | 63.00 | 4.00 | 1.50 | 122.00 | 49.50 | 70 | 2.070 | 3 | CCMT 12 04 08 |
| *2.441* | *2.756* | | | | | | | *2.480* | *.157* | | *4.803* | *1.949* | *1015* | | | |

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

L2 M1 N22 N15 K92



SANDVIK Coromant

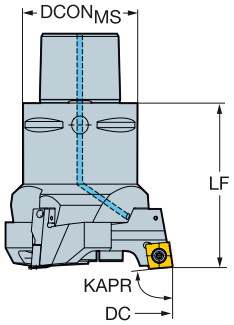
# CoroBore® BR30 three-edge rough boring tool

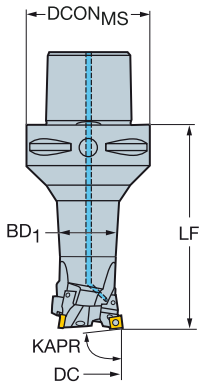
**Coromant Capto® - Internal coolant supply**

CCMT, CCGT
CCGX, CCET

CCMW

KAPR 90° 90°
DSGN 1 2




| DCN | DCX | | IC | CZC$_{MS}$ | CNSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | ULDR | LF | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 69.00 | 78.50 | 12 | 1/2 | C5 | 3 | 1 | BR30-79CC12F-C5 | 50.00 | 4.75 | | 70.00 | | 70 | 1.180 | 3 | CCMT 12 04 08 |
| *2.717* | *3.091* | | | | | | | *1.969* | *.187* | | *2.756* | | *1015* | | | |
| 69.00 | 78.50 | 12 | 1/2 | C6 | 3 | 1 | BR30-79CC12F-C6 | 63.00 | 4.75 | | 78.00 | | 70 | 2.130 | 3 | CCMT 12 04 08 |
| *2.717* | *3.091* | | | | | | | *2.480* | *.187* | | *3.071* | | *1015* | | | |
| 77.50 | 87.00 | 12 | 1/2 | C5 | 3 | 1 | BR30-87CC12F-C5 | 50.00 | 4.75 | | 70.00 | | 70 | 1.210 | 3 | CCMT 12 04 08 |
| *3.051* | *3.425* | | | | | | | *1.969* | *.187* | | *2.756* | | *1015* | | | |
| 77.50 | 87.00 | 12 | 1/2 | C6 | 3 | 1 | BR30-87CC12F-C6 | 63.00 | 4.75 | | 78.00 | | 70 | 1.967 | 3 | CCMT 12 04 08 |
| *3.051* | *3.425* | | | | | | | *2.480* | *.187* | | *3.071* | | *1015* | | | |
| 86.00 | 97.00 | 12 | 1/2 | C6 | 3 | 1 | BR30-97CC12F-C6 | 63.00 | 5.50 | | 90.00 | | 70 | 2.280 | 3 | CCMT 12 04 08 |
| *3.386* | *3.819* | | | | | | | *2.480* | *.217* | | *3.543* | | *1015* | | | |
| 86.00 | 97.00 | 12 | 1/2 | C8 | 3 | 1 | BR30-97CC12F-C8 | 80.00 | 5.50 | | 94.00 | | 70 | 3.300 | 3 | CCMT 12 04 08 |
| *3.386* | *3.819* | | | | | | | *3.150* | *.217* | | *3.701* | | *1015* | | | |
| 96.00 | 107.00 | 12 | 1/2 | C6 | 3 | 1 | BR30-107CC12F-C6 | 63.00 | 5.50 | | 90.00 | | 70 | 2.340 | 3 | CCMT 12 04 08 |
| *3.780* | *4.213* | | | | | | | *2.480* | *.217* | | *3.543* | | *1015* | | | |
| 96.00 | 107.00 | 12 | 1/2 | C8 | 3 | 1 | BR30-107CC12F-C8 | 80.00 | 5.50 | | 94.00 | | 70 | 3.360 | 3 | CCMT 12 04 08 |
| *3.780* | *4.213* | | | | | | | *3.150* | *.217* | | *3.701* | | *1015* | | | |
| 106.00 | 122.00 | 12 | 1/2 | C8 | 3 | 1 | BR30-122CC12F-C8 | 80.00 | 8.00 | | 100.00 | | 70 | 4.100 | 3 | CCMT 12 04 08 |
| *4.173* | *4.803* | | | | | | | *3.150* | *.315* | | *3.937* | | *1015* | | | |
| 121.00 | 137.00 | 12 | 1/2 | C8 | 3 | 1 | BR30-137CC12F-C8 | 80.00 | 8.00 | | 100.00 | | 70 | 4.250 | 3 | CCMT 12 04 08 |
| *4.764* | *5.394* | | | | | | | *3.150* | *.315* | | *3.937* | | *1015* | | | |
| 136.00 | 152.00 | 12 | 1/2 | C8 | 3 | 1 | BR30-152CC12F-C8 | 80.00 | 8.00 | | 100.00 | | 70 | 4.760 | 3 | CCMT 12 04 08 |
| *5.354* | *5.984* | | | | | | | *3.150* | *.315* | | *3.937* | | *1015* | | | |
| 151.00 | 167.00 | 12 | 1/2 | C8 | 3 | 1 | BR30-167CC12F-C8 | 80.00 | 8.00 | | 100.00 | | 70 | 4.880 | 3 | CCMT 12 04 08 |
| *5.945* | *6.575* | | | | | | | *3.150* | *.315* | | *3.937* | | *1015* | | | |
| 166.00 | 191.00 | 12 | 1/2 | C8 | 3 | 1 | BR30-191CC12F-C8 | 80.00 | 12.50 | | 115.00 | | 70 | 6.860 | 3 | CCMT 12 04 08 |
| *6.535* | *7.520* | | | | | | | *3.150* | *.492* | | *4.528* | | *1015* | | | |
| 189.00 | 214.00 | 12 | 1/2 | C8 | 3 | 1 | BR30-214CC12F-C8 | 80.00 | 12.50 | | 115.00 | | 70 | 7.130 | 3 | CCMT 12 04 08 |
| *7.441* | *8.425* | | | | | | | *3.150* | *.492* | | *4.528* | | *1015* | | | |

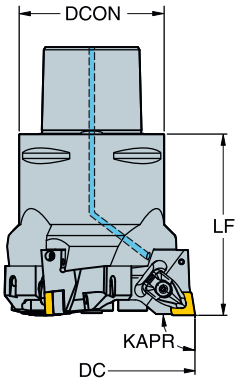
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning catalog
For all DSGN 2; LU = DC*ULDR

L2 M1 N22 N15 K92

# CoroBore® BR30 three-edge rough boring tool

**Coromant Capto® - Internal coolant supply**

KAPR 90°




CNMM
CNMG
CNMA, CNGA

| DCN | DCX | | IC | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | LF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 106.00 | 122.00 | 12 | 1/2 | C8 | 3 | **BR30-122CN12F-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.190 | 3 | CNMG 12 04 08 |
| *4.173* | *4.803* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 121.00 | 137.00 | 12 | 1/2 | C8 | 3 | **BR30-137CN12F-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.340 | 3 | CNMG 12 04 08 |
| *4.764* | *5.394* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 136.00 | 152.00 | 12 | 1/2 | C8 | 3 | **BR30-152CN12F-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.820 | 3 | CNMG 12 04 08 |
| *5.354* | *5.984* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 151.00 | 167.00 | 12 | 1/2 | C8 | 3 | **BR30-167CN12F-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.970 | 3 | CNMG 12 04 08 |
| *5.945* | *6.575* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 166.00 | 191.00 | 16 | 5/8 | C8 | 3 | **BR30-191CN16F-C8** | 80.00 | 12.50 | 119.00 | 70 | 7.430 | 3 | CNMG 16 06 12 |
| *6.535* | *7.520* | | | | | | *3.150* | *.492* | *4.685* | *1015* | | | |
| 189.00 | 214.00 | 16 | 5/8 | C8 | 3 | **BR30-214CN16F-C8** | 80.00 | 12.50 | 119.00 | 70 | 22.400 | 3 | CNMG 16 06 12 |
| *7.441* | *8.425* | | | | | | *3.150* | *.492* | *4.685* | *1015* | | | |

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

For inserts, see Turning catalog

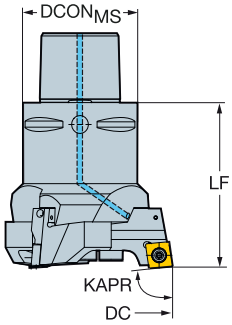
L2 M1 N22 N15 K92

# CoroBore® BR30 three-edge rough boring tool

**Coromant Capto® - Internal coolant supply**

KAPR 84°

SPMT




| DCN | DCX | ↔ | ↕ IC | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | LF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 35.00 | 40.50 | 06 | 06 | C3 | 3 | BR30-41SP06Y-C3 | 32.00 | 2.75 | 48.00 | 70 | 0.250 | 3 | SPMT 0606-BM |
| *1.378* | *1.594* | | | | | | *1.260* | *.108* | *1.890* | *1015* | | | |
| 39.50 | 45.00 | 06 | 06 | C3 | 3 | BR30-45SP06Y-C3 | 32.00 | 2.75 | 48.00 | 70 | 0.280 | 3 | SPMT 0606-BM |
| *1.555* | *1.772* | | | | | | *1.260* | *.108* | *1.890* | *1015* | | | |
| 44.00 | 50.50 | 06 | 06 | C4 | 3 | BR30-51SP06Y-C4 | 40.00 | 3.25 | 56.00 | 70 | 0.620 | 3 | SPMT 0606-BM |
| *1.732* | *1.988* | | | | | | *1.575* | *.128* | *2.205* | *1015* | | | |
| 49.50 | 56.00 | 08 | 08 | C4 | 3 | BR30-56SP08Y-C4 | 40.00 | 3.25 | 58.00 | 70 | 0.640 | 3 | SPMT 0808-BM |
| *1.949* | *2.205* | | | | | | *1.575* | *.128* | *2.283* | *1015* | | | |
| 55.00 | 63.00 | 08 | 08 | C5 | 3 | BR30-63SP08Y-C5 | 50.00 | 4.00 | 66.00 | 70 | 0.890 | 3 | SPMT 0808-BM |
| *2.165* | *2.480* | | | | | | *1.969* | *.157* | *2.598* | *1015* | | | |
| 62.00 | 70.00 | 12 | 12 | C5 | 3 | BR30-70SP12Y-C5 | 50.00 | 4.00 | 68.00 | 70 | 0.980 | 3 | SPMT 1210-BM |
| *2.441* | *2.756* | | | | | | *1.969* | *.157* | *2.677* | *1015* | | | |
| 69.00 | 78.50 | 12 | 12 | C6 | 3 | BR30-79SP12Y-C6 | 63.00 | 4.75 | 78.00 | 70 | 1.922 | 3 | SPMT 1210-BM |
| *2.717* | *3.091* | | | | | | *2.480* | *.187* | *3.071* | *1015* | | | |
| 77.50 | 87.00 | 12 | 12 | C6 | 3 | BR30-87SP12Y-C6 | 63.00 | 4.75 | 78.00 | 70 | 2.190 | 3 | SPMT 1210-BM |
| *3.051* | *3.425* | | | | | | *2.480* | *.187* | *3.071* | *1015* | | | |
| 86.00 | 97.00 | 12 | 12 | C8 | 3 | BR30-97SP12Y-C8 | 80.00 | 5.50 | 94.00 | 70 | 3.300 | 3 | SPMT 1210-BM |
| *3.386* | *3.819* | | | | | | *3.150* | *.217* | *3.701* | *1015* | | | |
| 96.00 | 107.00 | 12 | 12 | C8 | 3 | BR30-107SP12Y-C8 | 80.00 | 5.50 | 94.00 | 70 | 3.360 | 3 | SPMT 1210-BM |
| *3.780* | *4.213* | | | | | | *3.150* | *.217* | *3.701* | *1015* | | | |
| 106.00 | 122.00 | 12 | 12 | C8 | 3 | BR30-122SP12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.100 | 3 | SPMT 1210-BM |
| *4.173* | *4.803* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 121.00 | 137.00 | 12 | 12 | C8 | 3 | BR30-137SP12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.250 | 3 | SPMT 1210-BM |
| *4.764* | *5.394* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 136.00 | 152.00 | 12 | 12 | C8 | 3 | BR30-152SP12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.760 | 3 | SPMT 1210-BM |
| *5.354* | *5.984* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 151.00 | 167.00 | 12 | 12 | C8 | 3 | BR30-167SP12Y-C8 | 80.00 | 8.00 | 100.00 | 70 | 4.880 | 3 | SPMT 1210-BM |
| *5.945* | *6.575* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 166.00 | 191.00 | 12 | 12 | C8 | 3 | BR30-191SP12Y-C8 | 80.00 | 12.50 | 115.00 | 70 | 6.860 | 3 | SPMT 1210-BM |
| *6.535* | *7.520* | | | | | | *3.150* | *.492* | *4.528* | *1015* | | | |
| 189.00 | 214.00 | 12 | 12 | C8 | 3 | BR30-214SP12Y-C8 | 80.00 | 12.50 | 115.00 | 70 | 7.130 | 3 | SPMT 1210-BM |
| *7.441* | *8.425* | | | | | | *3.150* | *.492* | *4.528* | *1015* | | | |

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

K33

L2

M1

N22

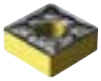
N15

K92

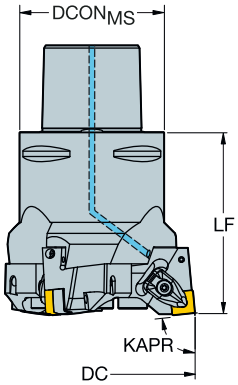
# CoroBore® BR30 three-edge rough boring tool

**Coromant Capto® - Internal coolant supply**

KAPR 84°



SNMM
SNMG
SNMA, SNGA




| DCN | DCX | ⟷ | ⟷C | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXRDL | LF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 106.00 | 122.00 | 12 | 1/2 | C8 | 3 | **BR30-122SN12Y-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.190 | 3 | SNMG 12 04 08 |
| *4.173* | *4.803* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 121.00 | 137.00 | 12 | 1/2 | C8 | 3 | **BR30-137SN12Y-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.340 | 3 | SNMG 12 04 08 |
| *4.764* | *5.394* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 136.00 | 152.00 | 12 | 1/2 | C8 | 3 | **BR30-152SN12Y-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.820 | 3 | SNMG 12 04 08 |
| *5.354* | *5.984* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 151.00 | 167.00 | 12 | 1/2 | C8 | 3 | **BR30-167SN12Y-C8** | 80.00 | 8.00 | 100.00 | 70 | 4.970 | 3 | SNMG 12 04 08 |
| *5.945* | *6.575* | | | | | | *3.150* | *.315* | *3.937* | *1015* | | | |
| 166.00 | 191.00 | 15 | 5/8 | C8 | 3 | **BR30-191SN15Y-C8** | 80.00 | 12.50 | 119.00 | 70 | 7.480 | 3 | SNMG 15 06 12 |
| *6.535* | *7.520* | | | | | | *3.150* | *.492* | *4.685* | *1015* | | | |
| 189.00 | 214.00 | 15 | 5/8 | C8 | 3 | **BR30-214SN15Y-C8** | 80.00 | 12.50 | 119.00 | 70 | 7.790 | 3 | SNMG 15 06 12 |
| *7.441* | *8.425* | | | | | | *3.150* | *.492* | *4.685* | *1015* | | | |

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

L2 M1 N22 N15 K92

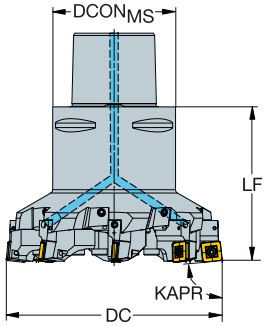
# CoroBore® BR30 multi-edge rough boring tool

**Coromant Capto® - Internal coolant supply**

**Dedicated for cavity boring operations**

KAPR 84°

SPMT




| DCN | DCX | ↔ | IC | CZCMS | CNSC | Ordering code | DCONMS | ADJLXRDL | LF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Dimensions, mm, inch | | | | | | |
| 85.00 | 94.50 | 12 | 12 | C6 | 3 | BR30-095-4-SP12Y-C6 | 63.00 | 4.75 | 80.00 | 70 | 2.050 | 4 | SPMT 1210-BM |
| *3.346* | *3.720* | | | | | | *2.480* | *.187* | *3.150* | *1015* | | | |
| 93.50 | 103.00 | 12 | 12 | C6 | 3 | BR30-103-4-SP12Y-C6 | 63.00 | 4.75 | 80.00 | 70 | 2.130 | 4 | SPMT 1210-BM |
| *3.681* | *4.055* | | | | | | *2.480* | *.187* | *3.150* | *1015* | | | |
| 102.00 | 111.50 | 12 | 12 | C8 | 3 | BR30-112-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.110 | 6 | SPMT 1210-BM |
| *4.016* | *4.390* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 110.50 | 120.00 | 12 | 12 | C8 | 3 | BR30-120-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.230 | 6 | SPMT 1210-BM |
| *4.350* | *4.724* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 119.00 | 128.50 | 12 | 12 | C8 | 3 | BR30-129-8-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.510 | 8 | SPMT 1210-BM |
| *4.685* | *5.059* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 127.50 | 137.00 | 12 | 12 | C8 | 3 | BR30-137-8-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.670 | 8 | SPMT 1210-BM |
| *5.020* | *5.394* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 136.00 | 145.50 | 12 | 12 | C8 | 3 | BR30-146-8-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 4.900 | 8 | SPMT 1210-BM |
| *5.354* | *5.728* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 144.50 | 154.00 | 12 | 12 | C8 | 3 | BR30-154-8-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 6.300 | 8 | SPMT 1210-BM |
| *5.689* | *6.063* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 153.00 | 162.50 | 12 | 12 | C8 | 3 | BR30-163-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 5.150 | 6 | SPMT 1210-BM |
| *6.024* | *6.398* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 161.50 | 171.00 | 12 | 12 | C8 | 3 | BR30-171-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 5.270 | 6 | SPMT 1210-BM |
| *6.358* | *6.732* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 170.00 | 179.50 | 12 | 12 | C8 | 3 | BR30-180-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 5.730 | 6 | SPMT 1210-BM |
| *6.693* | *7.067* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 178.50 | 188.00 | 12 | 12 | C8 | 3 | BR30-188-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 5.850 | 6 | SPMT 1210-BM |
| *7.028* | *7.402* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 187.00 | 196.50 | 12 | 12 | C8 | 3 | BR30-197-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 6.470 | 6 | SPMT 1210-BM |
| *7.362* | *7.736* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |
| 195.50 | 205.00 | 12 | 12 | C8 | 3 | BR30-205-6-SP12Y-C8 | 80.00 | 4.75 | 100.00 | 70 | 6.590 | 6 | SPMT 1210-BM |
| *7.697* | *8.071* | | | | | | *3.150* | *.187* | *3.937* | *1015* | | | |

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

K33

L2

M1

N22

N15

K92

# CoroBore® 820 XL

## Rough boring tool for large diameters

### Application

- Rough boring
- Multi-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 in large-diameter rough boring
- Axially and radially 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 adjustable in axial direction for step boring.

Use same bridge / bridge extension for roughing, finishing, and face grooving from diameter 148 mm (5.827 inch) (counterweight needed for finishing).

Bore large diameter without increasing tool weight.

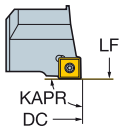
Dedicated CoroBore® 111 rough boring inserts. Excellent chip breaking and increased lifetime.

# CoroBore® 820 XL rough boring tool

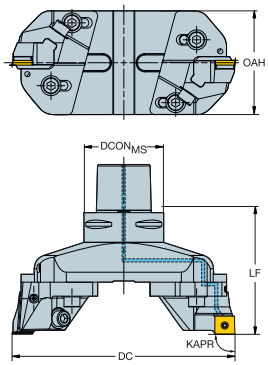
**Coromant Capto® - Internal coolant supply**

SPMT

KAPR




90°

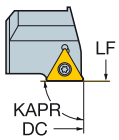



| DCN | DCX | ↔ | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 200.00 | 18 | 18 | C8 | 3 | 820-200SP18-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 6.900 | 2 | SPMT 1810-BM |
| *5.827* | *7.874* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 148.00 | 200.00 | 18 | 18 | C10 | 3 | 820-200SP18-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 9.900 | 2 | SPMT 1810-BM |
| *5.827* | *7.874* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 18 | 18 | C8 | 3 | 820-250SP18-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.700 | 2 | SPMT 1810-BM |
| *7.795* | *9.843* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 18 | 18 | C10 | 3 | 820-250SP18-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 11.308 | 2 | SPMT 1810-BM |
| *7.795* | *9.843* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 18 | 18 | C8 | 3 | 820-300SP18-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 10.620 | 2 | SPMT 1810-BM |
| *9.764* | *11.811* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 18 | 18 | C10 | 3 | 820-300SP18-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 12.640 | 2 | SPMT 1810-BM |
| *9.764* | *11.811* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |

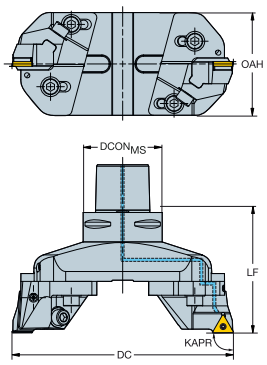
TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR




90°




| DCN | DCX | ↔ | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 200.00 | 22 | 1/2 | C8 | 3 | 820-200TC22-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.390 | 2 | TCMT 22 04 08 |
| *5.827* | *7.874* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 148.00 | 200.00 | 22 | 1/2 | C10 | 3 | 820-200TC22-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 10.170 | 2 | TCMT 22 04 08 |
| *5.827* | *7.874* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 22 | 1/2 | C8 | 3 | 820-250TC22-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.800 | 2 | TCMT 22 04 08 |
| *7.795* | *9.843* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 22 | 1/2 | C10 | 3 | 820-250TC22-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 11.400 | 2 | TCMT 22 04 08 |
| *7.795* | *9.843* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 22 | 1/2 | C8 | 3 | 820-300TC22-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 10.600 | 2 | TCMT 22 04 08 |
| *9.764* | *11.811* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 22 | 1/2 | C10 | 3 | 820-300TC22-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 12.660 | 2 | TCMT 22 04 08 |
| *9.764* | *11.811* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |

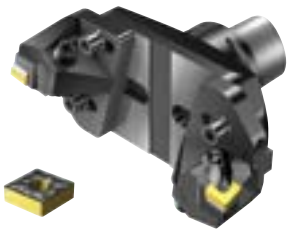
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning catalog

K33 M1 L2 N22 N15 K93

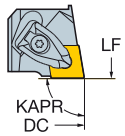
# CoroBore® 820 XL rough boring tool

**Coromant Capto® - Internal coolant supply**

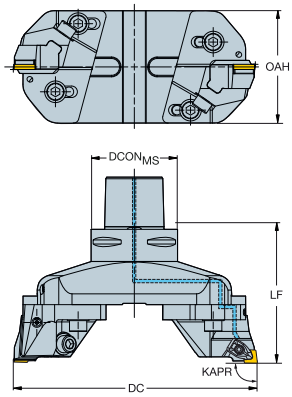


CNMM
CNMG
CNMA, CNGA

KAPR




90°

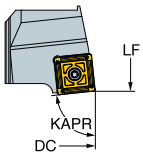



| DCN | DCX | ⟷ | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 200.00 | 19 | 3/4 | C8 | 3 | 820-200CN19-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.240 | 2 | CNMG 19 06 12 |
| *5.827* | *7.874* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 148.00 | 200.00 | 19 | 3/4 | C10 | 3 | 820-200CN19-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 10.100 | 2 | CNMG 19 06 12 |
| *5.827* | *7.874* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 19 | 3/4 | C8 | 3 | 820-250CN19-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 9.620 | 2 | CNMG 19 06 12 |
| *7.795* | *9.843* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 19 | 3/4 | C10 | 3 | 820-250CN19-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 11.520 | 2 | CNMG 19 06 12 |
| *7.795* | *9.843* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 19 | 3/4 | C8 | 3 | 820-300CN19-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 10.000 | 2 | CNMG 19 06 12 |
| *9.764* | *11.811* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 19 | 3/4 | C10 | 3 | 820-300CN19-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 12.685 | 2 | CNMG 19 06 12 |
| *9.764* | *11.811* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |

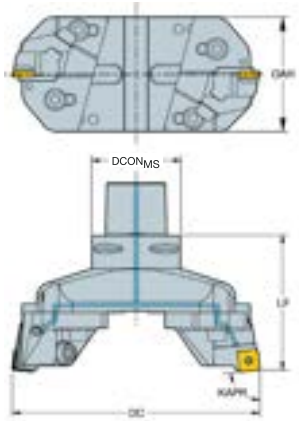
For inserts, see Turning catalog

SPMT

KAPR




84°




| DCN | DCX | ⟷ | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 200.00 | 18 | 18 | C8 | 3 | 820-200SP18Y-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 7.030 | 2 | SPMT 1810-BM |
| *5.827* | *7.874* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 148.00 | 200.00 | 18 | 18 | C10 | 3 | 820-200SP18Y-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 8.940 | 2 | SPMT 1810-BM |
| *5.827* | *7.874* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 18 | 18 | C8 | 3 | 820-250SP18Y-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 8.260 | 2 | SPMT 1810-BM |
| *7.795* | *9.843* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 18 | 18 | C10 | 3 | 820-250SP18Y-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 10.190 | 2 | SPMT 1810-BM |
| *7.795* | *9.843* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 18 | 18 | C8 | 3 | 820-300SP18Y-C8 | 80.00 | 1.50 | 26.00 | 122.00 | 104.00 | 70 | 9.460 | 2 | SPMT 1810-BM |
| *9.764* | *11.811* | | | | | | *3.150* | *.059* | *1.024* | *4.803* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 18 | 18 | C10 | 3 | 820-300SP18Y-C10 | 100.00 | 1.50 | 26.00 | 128.00 | 104.00 | 70 | 11.510 | 2 | SPMT 1810-BM |
| *9.764* | *11.811* | | | | | | *3.937* | *.059* | *1.024* | *5.039* | *4.094* | *1015* | | | |

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

K33 L2 M1 N22 N15 K93

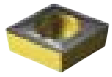


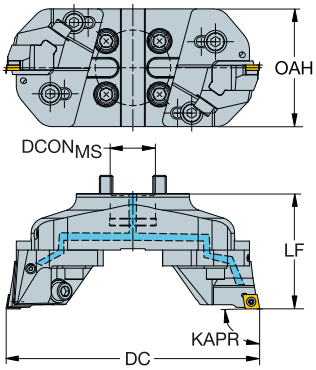
SANDVIK Coromant

# CoroBore® 820 XL lightweight rough boring tool

**Arbor - Internal coolant supply**

KAPR 90°





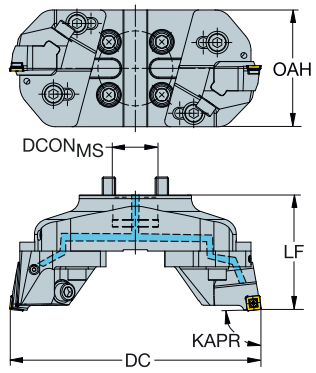

CCMT, CCGT
CCGX, CCET

CCMW

| DCN | DCX | ↔ | ↕ | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ISO | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 200.00 | 12 | 1/2 | 40S | 1 | **820L-200CC12F** | 40.00 | C | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 3.860 | 2 | CCMT 12 04 08 |
| *5.827* | *7.874* | | | | | | *1.575* | | *.059* | *1.024* | *4.016* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 12 | 1/2 | 40S | 1 | **820L-250CC12F** | 40.00 | C | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 4.390 | 2 | CCMT 12 04 08 |
| *7.795* | *9.843* | | | | | | *1.575* | | *.059* | *1.024* | *4.016* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 12 | 1/2 | 40S | 1 | **820L-300CC12F** | 40.00 | C | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 4.870 | 2 | CCMT 12 04 08 |
| *9.764* | *11.811* | | | | | | *1.575* | | *.059* | *1.024* | *4.016* | *4.094* | *1015* | | | |

For inserts, see Turning catalog

KAPR 84°




SPMT

| DCN | DCX | ↔ | ↕ | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ISO | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 200.00 | 12 | 12 | 40S | 1 | **820L-200SP12Y** | 40.00 | C | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 3.860 | 2 | SPMT 1210-BM |
| *5.827* | *7.874* | | | | | | *1.575* | | *.059* | *1.024* | *4.016* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 12 | 12 | 40S | 1 | **820L-250SP12Y** | 40.00 | C | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 4.390 | 2 | SPMT 1210-BM |
| *7.795* | *9.843* | | | | | | *1.575* | | *.059* | *1.024* | *4.016* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 12 | 12 | 40S | 1 | **820L-300SP12Y** | 40.00 | C | 1.50 | 26.00 | 102.00 | 104.00 | 70 | 4.870 | 2 | SPMT 1210-BM |
| *9.764* | *11.811* | | | | | | *1.575* | | *.059* | *1.024* | *4.016* | *4.094* | *1015* | | | |

Use with 40S facemill holders, e.g C8-391.05-40 060M. To be ordered separately.

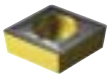
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com

K33 L2 N22 N15 K93

# CoroBore® 820 XL rough boring tool

**Arbor - Internal coolant supply**

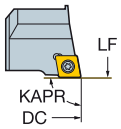
**Dedicated for Silent Tools™ boring**



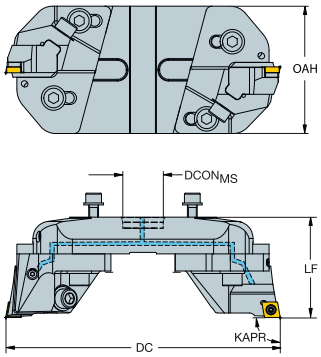
CCMT, CCGT
CCGX, CCET

CCMW

KAPR



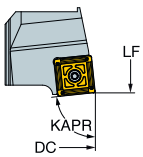

90°



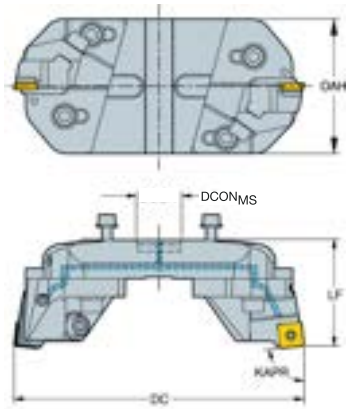

| DCN | DCX | ↔ | ↕IC | $CZC_{MS}$ | CNSC | Ordering code | $DCON_{MS}$ | $ADJLX_{AXL}$ | $ADJLX_{RDL}$ | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Dimensions, mm, inch | | | | | | | | |
| 148.00 | 200.00 | 12 | 1/2 | 33 | 1 | **820D-200CC12** | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 3.350 | 2 | CCMT 12 04 08 |
| *5.827* | *7.874* | | | | | | *1.299* | *.059* | *1.024* | *3.228* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 12 | 1/2 | 33 | 1 | **820D-250CC12** | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 3.670 | 2 | CCMT 12 04 08 |
| *7.795* | *9.843* | | | | | | *1.299* | *.059* | *1.024* | *3.228* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 12 | 1/2 | 33 | 1 | **820D-300CC12** | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 4.030 | 2 | CCMT 12 04 08 |
| *9.764* | *11.811* | | | | | | *1.299* | *.059* | *1.024* | *3.228* | *4.094* | *1015* | | | |

For inserts, see Turning catalog

KAPR




84°



SPMT

| DCN | DCX | ↔ | ↕IC | $CZC_{MS}$ | CNSC | Ordering code | $DCON_{MS}$ | $ADJLX_{AXL}$ | $ADJLX_{RDL}$ | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | | Dimensions, mm, inch | | | | | | | | |
| 148.00 | 200.00 | 12 | 12 | 33 | 1 | **820D-200SP12Y** | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 3.350 | 2 | SPMT 1210-BM |
| *5.827* | *7.874* | | | | | | *1.299* | *.059* | *1.024* | *3.228* | *4.094* | *1015* | | | |
| 198.00 | 250.00 | 12 | 12 | 33 | 1 | **820D-250SP12Y** | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 3.670 | 2 | SPMT 1210-BM |
| *7.795* | *9.843* | | | | | | *1.299* | *.059* | *1.024* | *3.228* | *4.094* | *1015* | | | |
| 248.00 | 300.00 | 12 | 12 | 33 | 1 | **820D-300SP12Y** | 33.00 | 1.50 | 26.00 | 82.00 | 104.00 | 70 | 4.030 | 2 | SPMT 1210-BM |
| *9.764* | *11.811* | | | | | | *1.299* | *.059* | *1.024* | *3.228* | *4.094* | *1015* | | | |

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

These lightweight assemblies are dedicated for use with damped boring adapters. Damped adapters are bought separately; see page K83.

K33 L2 N22 N15 K93



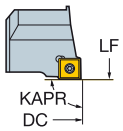
SANDVIK Coromant

# CoroBore® 820 XL rough boring tool

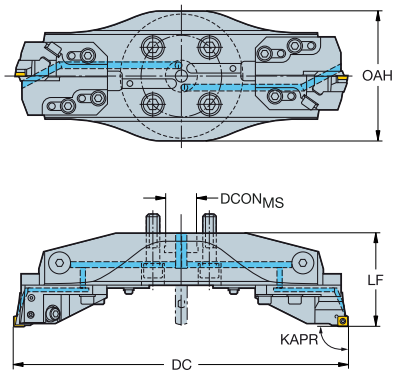
**Arbor - Internal coolant supply**

SPMT

KAPR

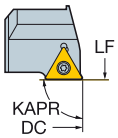



90°

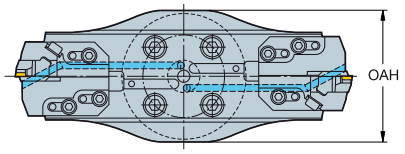



| DCN | DCX | ↔ | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{AXL}$ | $ADJLX_{RDL}$ | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 298.00 | 380.00 | 18 | 18 | 40X | 1 | **820-380SP18** | 40.00 | 1.50 | 41.00 | 114.00 | 164.00 | 70 | 10.000 | 2 | SPMT 1810-BM |
| *11.732* | *14.961* | | | | | | *1.575* | *.059* | *1.614* | *4.488* | *6.457* | *1015* | | | |
| 378.00 | 460.00 | 18 | 18 | 40X | 1 | **820-460SP18** | 40.00 | 1.50 | 41.00 | 119.00 | 164.00 | 70 | 13.131 | 2 | SPMT 1810-BM |
| *14.882* | *18.110* | | | | | | *1.575* | *.059* | *1.614* | *4.685* | *6.457* | *1015* | | | |
| 458.00 | 540.00 | 18 | 18 | 40X | 1 | **820-540SP18** | 40.00 | 1.50 | 41.00 | 124.00 | 164.00 | 70 | 16.741 | 2 | SPMT 1810-BM |
| *18.032* | *21.260* | | | | | | *1.575* | *.059* | *1.614* | *4.882* | *6.457* | *1015* | | | |

KAPR

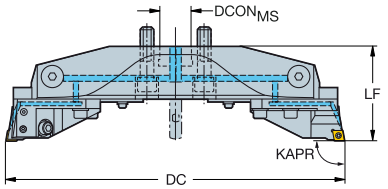



90°



TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW




| DCN | DCX | ↔ | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{AXL}$ | $ADJLX_{RDL}$ | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 298.00 | 380.00 | 22 | 1/2 | 40X | 1 | **820-380TC22** | 40.00 | 1.50 | 41.00 | 114.00 | 164.00 | 70 | 10.980 | 2 | TCMT 22 04 08 |
| *11.732* | *14.961* | | | | | | *1.575* | *.059* | *1.614* | *4.488* | *6.457* | *1015* | | | |
| 378.00 | 460.00 | 22 | 1/2 | 40X | 1 | **820-460TC22** | 40.00 | 1.50 | 41.00 | 119.00 | 164.00 | 70 | 12.720 | 2 | TCMT 22 04 08 |
| *14.882* | *18.110* | | | | | | *1.575* | *.059* | *1.614* | *4.685* | *6.457* | *1015* | | | |
| 458.00 | 540.00 | 22 | 1/2 | 40X | 1 | **820-540TC22** | 40.00 | 1.50 | 41.00 | 124.00 | 164.00 | 70 | 16.580 | 2 | TCMT 22 04 08 |
| *18.032* | *21.260* | | | | | | *1.575* | *.059* | *1.614* | *4.882* | *6.457* | *1015* | | | |

Use with 40X CoroBore® XL holders only. To be ordered separately. See page K80.

In the case of a direct flange to the machine spindle, use a centering plug. See page K82

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

For inserts, see Turning catalog

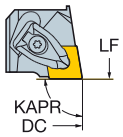
K33 L2 N22 N15 K93

# CoroBore® 820 XL rough boring tool

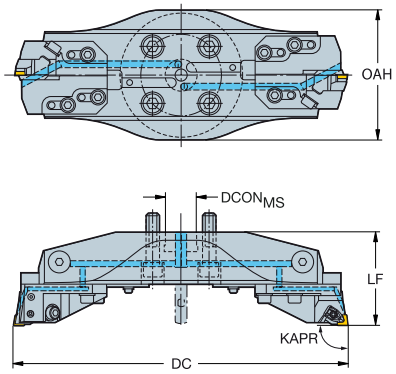
**Arbor - Internal coolant supply**

CNMM
CNMG
CNMA, CNGA

KAPR



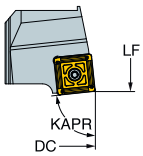

90°



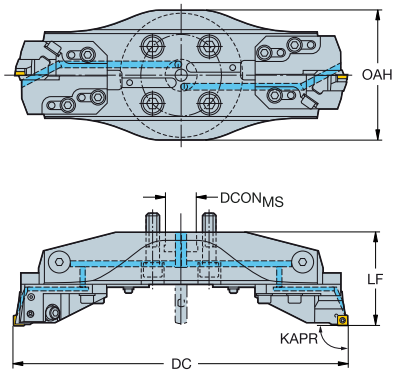

| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{AXL}$ | $ADJLX_{RDL}$ | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 298.00 | 380.00 | 19 | 3/4 | 40X | 1 | **820-380CN19** | 40.00 | 1.50 | 41.00 | 114.00 | 164.00 | 70 | 10.815 | 2 | CNMG 19 06 12 |
| *11.732* | *14.961* | | | | | | *1.575* | *.059* | *1.614* | *4.488* | *6.457* | *1015* | | | |
| 378.00 | 460.00 | 19 | 3/4 | 40X | 1 | **820-460CN19** | 40.00 | 1.50 | 41.00 | 119.00 | 164.00 | 70 | 12.685 | 2 | CNMG 19 06 12 |
| *14.882* | *18.110* | | | | | | *1.575* | *.059* | *1.614* | *4.685* | *6.457* | *1015* | | | |
| 458.00 | 540.00 | 19 | 3/4 | 40X | 1 | **820-540CN19** | 40.00 | 1.50 | 41.00 | 124.00 | 164.00 | 70 | 16.780 | 2 | CNMG 19 06 12 |
| *18.032* | *21.260* | | | | | | *1.575* | *.059* | *1.614* | *4.882* | *6.457* | *1015* | | | |

For inserts, see Turning catalog

KAPR




84°



SPMT

| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{AXL}$ | $ADJLX_{RDL}$ | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 298.00 | 380.00 | 18 | 18 | 40X | 1 | **820-380SP18Y** | 40.00 | 1.50 | 41.00 | 114.00 | 164.00 | 70 | 9.050 | 2 | SPMT 1810-BM |
| *11.732* | *14.961* | | | | | | *1.575* | *.059* | *1.614* | *4.488* | *6.457* | *1015* | | | |
| 378.00 | 460.00 | 18 | 18 | 40X | 1 | **820-460SP18Y** | 40.00 | 1.50 | 41.00 | 119.00 | 164.00 | 70 | 10.810 | 2 | SPMT 1810-BM |
| *14.882* | *18.110* | | | | | | *1.575* | *.059* | *1.614* | *4.685* | *6.457* | *1015* | | | |
| 458.00 | 540.00 | 18 | 18 | 40X | 1 | **820-540SP18Y** | 40.00 | 1.50 | 41.00 | 124.00 | 164.00 | 70 | 12.740 | 2 | SPMT 1810-BM |
| *18.032* | *21.260* | | | | | | *1.575* | *.059* | *1.614* | *4.882* | *6.457* | *1015* | | | |

Use with 40X CoroBore® XL holders only. To be ordered separately. See page K80.
In the case of a direct flange to the machine spindle, use a centering plug. See page K82

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

K33 L2 N22 N15 K93



SANDVIK Coromant

# CoroBore® 820 XL rough boring tool

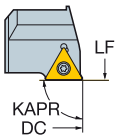
**Arbor - Internal coolant supply**

**With bridge extension**

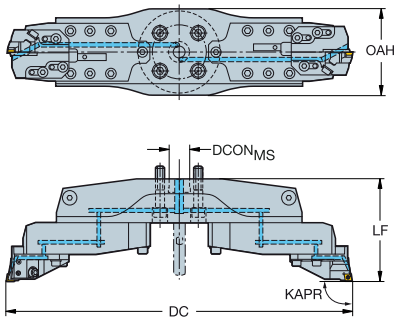
TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR




90°

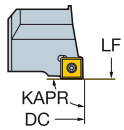



| DCN | DCX | ◁▷ | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 538.00 | 780.00 | 22 | 1/2 | 40X | 1 | **820-780TC22** | 40.00 | 1.50 | 121.00 | 198.00 | 164.00 | 70 | 28.000 | 2 | TCMT 22 04 08 |
| *21.181* | *30.709* | | | | | | *1.575* | *.059* | *4.764* | *7.795* | *6.457* | *1015* | | | |
| 778.00 | 1020.00 | 22 | 1/2 | 40X | 1 | **820-1020TC22** | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 48.000 | 2 | TCMT 22 04 08 |
| *30.630* | *40.158* | | | | | | *1.575* | *.059* | *4.764* | *8.583* | *6.457* | *1015* | | | |
| 1018.00 | 1260.00 | 22 | 1/2 | 40X | 1 | **820-1260TC22** | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.730 | 2 | TCMT 22 04 08 |
| *40.079* | *49.606* | | | | | | *1.575* | *.059* | *4.764* | *8.583* | *6.457* | *1015* | | | |

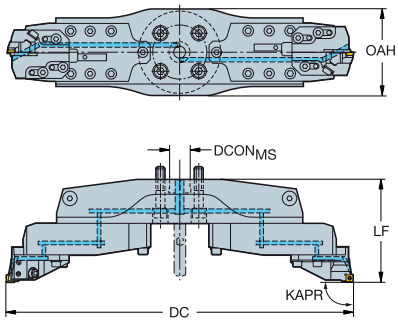
For inserts, see Turning catalog

SPMT

KAPR




90°




| DCN | DCX | ◁▷ | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 538.00 | 780.00 | 18 | 18 | 40X | 1 | **820-780SP18** | 40.00 | 1.50 | 121.00 | 198.00 | 164.00 | 70 | 39.000 | 2 | SPMT 1810-BM |
| *21.181* | *30.709* | | | | | | *1.575* | *.059* | *4.764* | *7.795* | *6.457* | *1015* | | | |
| 778.00 | 1020.00 | 18 | 18 | 40X | 1 | **820-1020SP18** | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 36.380 | 2 | SPMT 1810-BM |
| *30.630* | *40.158* | | | | | | *1.575* | *.059* | *4.764* | *8.583* | *6.457* | *1015* | | | |
| 1018.00 | 1260.00 | 18 | 18 | 40X | 1 | **820-1260SP18** | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.810 | 2 | SPMT 1810-BM |
| *40.079* | *49.606* | | | | | | *1.575* | *.059* | *4.764* | *8.583* | *6.457* | *1015* | | | |

Use with 40X CoroBore® XL holders only. To be ordered separately. See page K80.
In the case of a direct flange to the machine spindle, use a centering plug. See page K82

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

K33 L2 N22 N15 K93

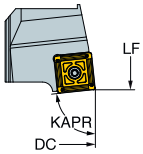
# CoroBore® 820 XL rough boring tool

**Arbor - Internal coolant supply**

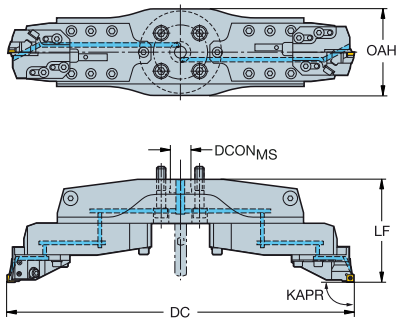
**With bridge extension**

SPMT

KAPR

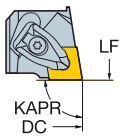



84°

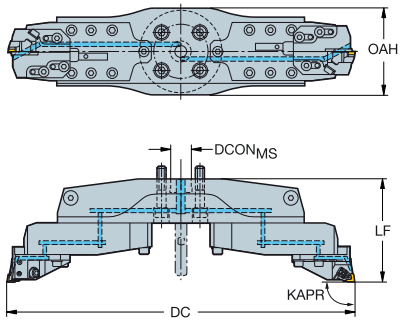



| DCN | DCX | ⟷ | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 538.00 | 780.00 | 18 | 18 | 40X | 1 | **820-780SP18Y** | 40.00 | 1.50 | 121.00 | 198.00 | 164.00 | 70 | 25.190 | 2 | SPMT 1810-BM |
| *21.181* | *30.709* | | | | | | *1.575* | *.059* | *4.764* | *7.795* | *6.457* | *1015* | | | |
| 778.00 | 1020.00 | 18 | 18 | 40X | 1 | **820-1020SP18Y** | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 36.380 | 2 | SPMT 1810-BM |
| *30.630* | *40.158* | | | | | | *1.575* | *.059* | *4.764* | *8.583* | *6.457* | *1015* | | | |
| 1018.00 | 1260.00 | 18 | 18 | 40X | 1 | **820-1260SP18Y** | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.810 | 2 | SPMT 1810-BM |
| *40.079* | *49.606* | | | | | | *1.575* | *.059* | *4.764* | *8.583* | *6.457* | *1015* | | | |

KAPR




90°



CNMM
CNMG
CNMA, CNGA

| DCN | DCX | ⟷ | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXAXL | ADJLXRDL | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 538.00 | 780.00 | 19 | 3/4 | 40X | 1 | **820-780CN19** | 40.00 | 1.50 | 121.00 | 198.00 | 164.00 | 70 | 34.000 | 2 | CNMG 19 06 12 |
| *21.181* | *30.709* | | | | | | *1.575* | *.059* | *4.764* | *7.795* | *6.457* | *1015* | | | |
| 778.00 | 1020.00 | 19 | 3/4 | 40X | 1 | **820-1020CN19** | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.000 | 2 | CNMG 19 06 12 |
| *30.630* | *40.158* | | | | | | *1.575* | *.059* | *4.764* | *8.583* | *6.457* | *1015* | | | |
| 1018.00 | 1260.00 | 19 | 3/4 | 40X | 1 | **820-1260CN19** | 40.00 | 1.50 | 121.00 | 218.00 | 164.00 | 70 | 43.830 | 2 | CNMG 19 06 12 |
| *40.079* | *49.606* | | | | | | *1.575* | *.059* | *4.764* | *8.583* | *6.457* | *1015* | | | |

Use with 40X CoroBore® XL holders only. To be ordered separately. See page K80.

In the case of a direct flange to the machine spindle, use a centering plug. See page K82

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

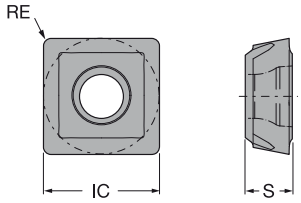
K33 L2 N22 N15 K93



SANDVIK Coromant

# CoroBore® 111 inserts for rough boring

**S-style insert (Square)**

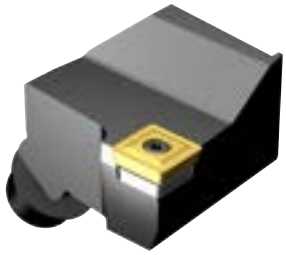



| | | | IC | S | RE | ISO CODE | P 4325 | M 2025 | K 3210 | S 1145 |
|---|---|---|---|---|---|---|---|---|---|---|
| Medium | BM | 06 | 6.0 | 2.60 | 0.60 | SPMT0606-BM | | ☆ | | ☆ |
| | | | .236 | .102 | .024 | | | | | |
| | | 08 | 8.9 | 3.00 | 0.80 | SPMT0808-BM | | ☆ | | ☆ |
| | | | .350 | .118 | .031 | | | | | |
| | | 12 | 12.65 | 4.00 | 1.00 | SPMT1210-BM | | ☆ | | ☆ |
| | | | .498 | .157 | .039 | | | | | |
| | | 18 | 18.6 | 5.50 | 1.00 | SPMT1810-BM | | ☆ | | ☆ |
| | | | .732 | .217 | .039 | | | | | |
| Roughing | BR | 06 | 6.0 | 2.60 | 0.60 | SPMT0606-BR | ☆ | | ☆ | |
| | | | .236 | .102 | .024 | | | | | |
| | | 08 | 8.9 | 3.00 | 0.80 | SPMT0808-BR | ☆ | | ☆ | |
| | | | .350 | .118 | .031 | | | | | |
| | | 12 | 12.65 | 4.00 | 1.20 | SPMT1212-BR | ☆ | | ☆ | |
| | | | .498 | .157 | .047 | | | | | |
| | | 18 | 18.6 | 5.50 | 1.20 | SPMT1812-BR | ☆ | | ☆ | |
| | | | .732 | .217 | .047 | | | | | |

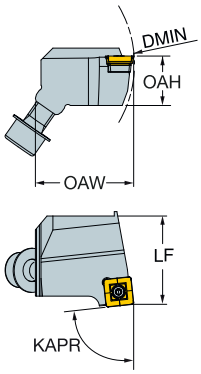
K97 N22

# Cartridge for CoroBore® XL

KAPR 84°

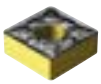


SPMT

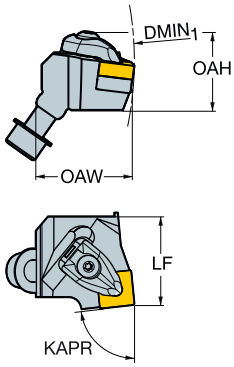



| DMIN1 | | CZCMS | Ordering code | Dimensions, mm, inch LF | HF | WF | OAH | OAL | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.0 | 12 | S12 | S12-R820XLR40SSYP12 | 40.00 | 22.40 | 42.00 | 30.16 | 43.30 | 0.250 | 1 | SPMT 1210-BM |
| *5.827* | | | | *1.575* | *.882* | *1.654* | *1.187* | *1.705* | | | |

KAPR 84°



SNMM
SNMG
SNMA, SNGA




| DMIN1 | | CZCMS | Ordering code | Dimensions, mm, inch 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 |
| *5.827* | | | | *1.575* | *1.646* | *.787* | *1.654* | *1.563* | *1.724* | | | |

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

K33 N22 N15

# Fine boring

| | Tool concept | Diameter range, mm (inch) | Hole tolerance | Cutting edge | Operation | Insert choice | Machine-side interface | Page |
|---|---|---|---|---|---|---|---|---|
| **CoroBore® 824** | Conventional | 1-20 (.039-.787) | IT6 | - Solid carbide bars<br>- Indexable carbide bars | - Single edge boring | - CoroTurn® 107<br>- CoroTurn® XS | - Coromant Capto®<br>- Coromant EH | K36-K38 |
| **391.37A/B** | Conventional | 3-36 (.118-1.417) | IT6 | - Solid carbide bars<br>- Indexable carbide bars<br>- Indexable steel bars | - Single edge boring | - CoroTurn® 107<br>- Solid bars with ground geometry | - Coromant Capto®<br>- HSK | K39-K45 |
| **CoroBore® 826 HP** | Conventional | 35-154 | IT6 | - Indexable cartridges | - Single edge boring | - CoroTurn® 107 | - Coromant Capto® | K51-K54 |
| **CoroBore® 825** | Conventional | 19-167 (.748-6.575) | IT6 | - Indexable cartridges | - Single edge boring<br>- Back boring | - CoroTurn® 107 | - Coromant Capto®<br>- Cylindrical shank<br>- Coromant EH | K46-K54 |
| | Lightweight | 69-167 (2.717-6.575) | IT6 | - Indexable cartridges | - Single edge boring<br>- Back boring | - CoroTurn® 107 | - Coromant Capto® | K55 |
| | Damped | 19-167 (.748-6.575) | IT6 | - Indexable cartridges | - Single edge boring<br>- Back boring | - CoroTurn® 107 | - Coromant Capto® | K56 |
| **CoroBore® 825 XL/ CoroBore® 826 XL** | Conventional | 148-315 (5.827-12.402)<br>298-1275 (11.732-50.197) | IT6 | - Indexable cartridges | - Single edge boring Back boring External boring | - CoroTurn® 107 | - Coromant Capto®<br>- 40X with 4 bolt circle | K57-K59<br>K66-K69 |
| | Lightweight | 148-315 (5.827-12.402) | IT6 | - Indexable cartridges | - Single edge boring<br>- Back boring<br>- External boring | - CoroTurn® 107 | - Coromant Capto®<br>- 40S with 4 bolt circle | K60-K63 |
| | Damped | 148-315 (5.827-12.402) | IT6 | - Indexable cartridges | - Single edge boring<br>- Back boring<br>- External boring | - CoroTurn® 107 | - A33 damped adapter | K64-K65 |

# 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 (.039-.787 inch)
- 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 (.039 inch)
- Solid carbide boring bars with standard CoroTurn® 107 indexable inserts available from diameter 6 mm (.236 inch)
- 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 | inch |
| 4 | 28000 | 1 | .039 |
| 6 | 20000 | 1 | .039 |
| 8 | 14000 | 1 | .039 |
| 10 | 10000 | 1.5 | .059 |

- CoroTurn® XS for small-diameter holes. For assortment, see Turning catalog.

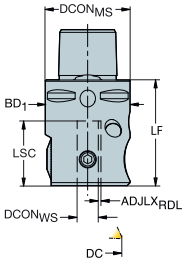
Adjusts diameter 0.002 mm (.000079 inch) with a nonius scale. A 360° turn change diameter by 0.5 mm (.020 inch).

# Coromant Capto® to CoroTurn® XS adapter

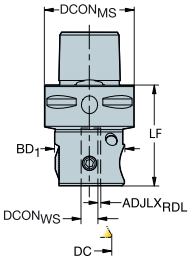
**CoroBore® 824 XS**

**Internal coolant supply**

DSGN 1




2

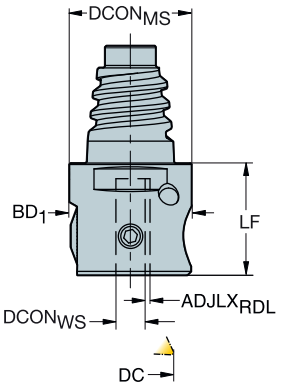



| | | | | | | | Dimensions, mm, inch | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DCN | DCX | $CZC_{MS}$ | $CZC_{WS}$ | CNSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | $ADJLX_{RDL}$ | LF | $BD_1$ | BAR PSI | KG |
| 1.00 | 6.00 | C3 | 4 | 3 | 2 | C3-R824XS04-021 | 32.00 | 4.00 | 1.00 | 36.00 | 25.00 | 20 | 0.213 |
| *.039* | *.236* | | | | | | *1.260* | *.157* | *.039* | *1.417* | *.984* | *290* | |
| 6.00 | 10.00 | C3 | 6 | 3 | 2 | C3-R824XS06-016 | 32.00 | 6.00 | 1.00 | 36.00 | 25.00 | 20 | 0.210 |
| *.236* | *.394* | | | | | | *1.260* | *.236* | *.039* | *1.417* | *.984* | *290* | |
| 10.00 | 14.00 | C3 | 8 | 3 | 1 | C3-R824XS08-015 | 32.00 | 8.00 | 1.00 | 40.00 | 32.00 | 20 | 0.269 |
| *.394* | *.551* | | | | | | *1.260* | *.315* | *.039* | *1.575* | *1.260* | *290* | |
| 14.00 | 20.00 | C4 | 10 | 3 | 1 | C4-R824XS10-017 | 40.00 | 10.00 | 1.50 | 42.00 | 40.00 | 20 | 0.451 |
| *.551* | *.787* | | | | | | *1.575* | *.394* | *.059* | *1.654* | *1.575* | *290* | |

# Coromant EH to CoroTurn® XS adapter

**CoroBore® 824 XS**

**Internal coolant supply**




| | | | | | | Dimensions, mm, inch | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| DCN | DCX | $CZC_{MS}$ | $CZC_{WS}$ | CNSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | $ADJLX_{RDL}$ | LF | $BD_1$ | BAR PSI | KG |
| 1.00 | 6.00 | E25 | 4 | 1 | EH25-R824XS04-008 | 24.20 | 4.00 | 1.00 | 23.00 | 25.00 | 20 | 0.174 |
| *.039* | *.236* | | | | | *.953* | *.157* | *.039* | *.906* | *.984* | *290* | |
| 6.00 | 10.00 | E25 | 6 | 1 | EH25-R824XS06-003 | 24.20 | 6.00 | 1.00 | 23.00 | 25.00 | 20 | 0.172 |
| *.236* | *.394* | | | | | *.953* | *.236* | *.039* | *.906* | *.984* | *290* | |
| 10.00 | 14.00 | E25 | 8 | 1 | EH25-R824XS08-013 | 24.20 | 8.00 | 1.00 | 38.00 | 32.00 | 20 | 0.285 |
| *.394* | *.551* | | | | | *.953* | *.315* | *.039* | *1.496* | *1.260* | *290* | |
| 14.00 | 20.00 | E25 | 10 | 1 | EH25-R824XS10-013 | 24.20 | 10.00 | 1.50 | 38.00 | 40.00 | 20 | 0.368 |
| *.551* | *.787* | | | | | *.953* | *.394* | *.059* | *1.496* | *1.575* | *290* | |

**Note:**

To be used with CoroTurn® XS boring bar for boring

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

L2 N22 N15

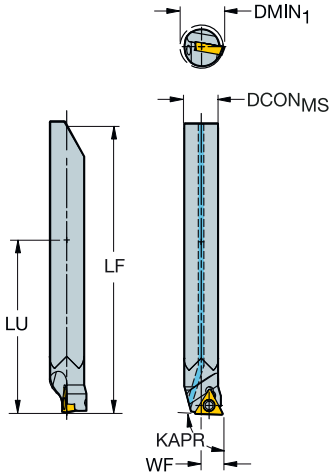
# CoroTurn® XS boring bar for boring

**CXS connection - Internal coolant supply**
**Indexable solid carbide bar**

KAPR 92°

TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW




| DMIN1 | | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | LU | LF | WF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 6.0 | 05 | 1/8 | 6 | 1 | CXS-06-06 030TC05 | 6.00 | 30.00 | 49.90 | 3.00 | 20 | 0.028 | 1 | TCEX 05 01 00L-F |
| *.236* | | | | | | *.236* | *1.181* | *1.965* | *.118* | *290* | | | |
| 8.0 | 05 | 1/8 | 6 | 1 | CXS-06-08 030TC05 | 6.00 | 30.00 | 49.90 | 4.00 | 20 | 0.031 | 1 | TCEX 05 01 00L-F |
| *.315* | | | | | | *.236* | *1.181* | *1.965* | *.157* | *290* | | | |
| 10.0 | 06 | 5/32 | 8 | 1 | CXS-08-10 040TC06 | 8.00 | 40.00 | 64.04 | 5.00 | 20 | 0.050 | 1 | TCMT 06 T1 02 |
| *.394* | | | | | | *.315* | *1.575* | *2.521* | *.197* | *290* | | | |
| 12.0 | 06 | 5/32 | 8 | 1 | CXS-08-12 040TC06 | 8.00 | 40.00 | 64.04 | 6.00 | 20 | 0.050 | 1 | TCMT 06 T1 02 |
| *.472* | | | | | | *.315* | *1.575* | *2.521* | *.236* | *290* | | | |
| 14.0 | 09 | 7/32 | 10 | 1 | CXS-10-14 050TC09 | 10.00 | 50.00 | 73.17 | 7.00 | 20 | 0.104 | 1 | TCMT 09 02 02 |
| *.551* | | | | | | *.394* | *1.969* | *2.881* | *.276* | *290* | | | |
| 17.0 | 09 | 7/32 | 10 | 1 | CXS-10-17 050TC09 | 10.00 | 50.00 | 73.17 | 8.50 | 20 | 0.106 | 1 | TCMT 09 02 02 |
| *.669* | | | | | | *.394* | *1.969* | *2.881* | *.335* | *290* | | | |

Recommended adapters: CoroBore 824XS

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

K37

N22

N15



SANDVIK Coromant

# 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 for length/diameter ratio
- Flexible solutions for a broad diameter range, 3–36 mm (.118–1.417 inch)
- Excellent for small o-ring grooves
- 391.37B high-speed fine boring head with rotation speed of 20,000 rev/min
- Choose between conventional (.37A) and high-speed (.37B) fine boring heads:
- Internal coolant supply
- Diameter adjustment: 0.002 mm (.000079 inch)

### Tools

Couplings:
- Coromant Capto®
- Coromant EH

### Inserts

Standard inserts with dedicated grades and geometries for all materials
- CoroTurn® XS
- CoroTurn® 107
- CoroCut® MB - 09FA

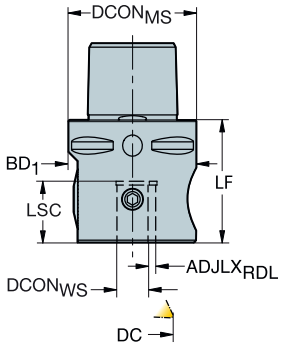
### 391.37A/B Fine boring head

| $DCON_{WS}$ | Max rotation speed: RPMX | Diameter range ADJRG mm | inch |
|---|---|---|---|
| 12 | 7000 | 3 | .118 |
| 16 | 5000 | 3 | .118 |
| 20 | 3500 | 5 | .118 |

Adjusts diameter 0.002 mm (.000079 inch) with a nonius scale. A 360° turn change diameter by 0.5 mm (.020 inch).

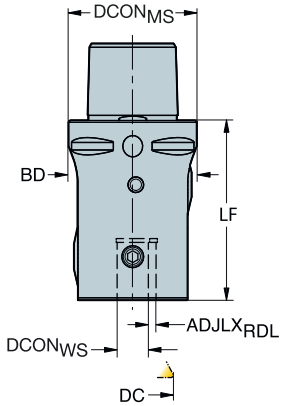
# Coromant Capto® to fine boring head adapter

**Internal coolant supply**




## 391.37A adapter

| DCN | DCX | CZC$_{MS}$ | CZC$_{WS}$ | CNSC | Ordering code | DCON$_{MS}$ | DCON$_{WS}$ | ADJLX$_{RDL}$ | LF | BD$_1$ | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | Dimensions, mm, inch | | | | | | |
| 3.00 | 26.00 | C4 | 12 | 3 | C4-391.37A-12 055B | 40.00 | 12.00 | 3.00 | 55.00 | 50.00 | 20 | 0.714 |
| *.118* | *1.024* | | | | | *1.575* | *.472* | *.118* | *2.165* | *1.969* | *290* | |
| 3.00 | 26.00 | C5 | 12 | 3 | C5-391.37A-12 048B | 50.00 | 12.00 | 3.00 | 48.00 | 48.00 | 20 | 0.799 |
| *.118* | *1.024* | | | | | *1.969* | *.472* | *.118* | *1.890* | *1.890* | *290* | |
| 3.00 | 32.00 | C5 | 16 | 3 | C5-391.37A-16 070A | 50.00 | 16.00 | 3.00 | 70.00 | 63.00 | 20 | 1.450 |
| *.118* | *1.260* | | | | | *1.969* | *.630* | *.118* | *2.756* | *2.480* | *290* | |
| 3.00 | 32.00 | C6 | 16 | 3 | C6-391.37A-16 075A | 63.00 | 16.00 | 3.00 | 75.00 | 63.00 | 20 | 1.896 |
| *.118* | *1.260* | | | | | *2.480* | *.630* | *.118* | *2.953* | *2.480* | *290* | |
| 17.00 | 36.00 | C5 | 20 | 3 | C5-391.37A-20 085A | 50.00 | 20.00 | 5.00 | 85.00 | 80.00 | 20 | 1.616 |
| *.669* | *1.417* | | | | | *1.969* | *.787* | *.197* | *3.346* | *3.150* | *290* | |
| 17.00 | 36.00 | C6 | 20 | 3 | C6-391.37A-20 085A | 63.00 | 20.00 | 5.00 | 85.00 | 80.00 | 20 | 2.886 |
| *.669* | *1.417* | | | | | *2.480* | *.787* | *.197* | *3.346* | *3.150* | *290* | |




## 391.37B head with adjustable counterweight

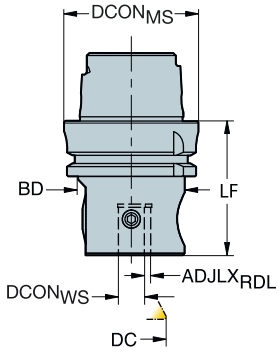
| DCN | DCX | CZC$_{MS}$ | CZC$_{WS}$ | CNSC | Ordering code | DCON$_{MS}$ | DCON$_{WS}$ | ADJLX$_{RDL}$ | LF | BD$_1$ | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | Dimensions, mm, inch | | | | | | |
| 3.00 | 26.00 | C5 | 12 | 3 | C5-391.37B-12 070B | 50.00 | 12.00 | 3.00 | 70.00 | 50.00 | 20 | 1.090 |
| *.118* | *1.024* | | | | | *1.969* | *.472* | *.118* | *2.756* | *1.969* | *290* | |

To be used with R429U/R429.90 boring bars
For spare parts, visit www.sandvik.coromant.com

L2 M37 N22 N15

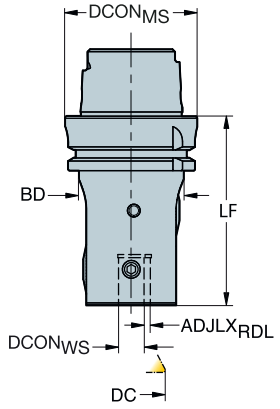
# HSK to fine boring head adapter

**Internal coolant supply**




## 391.37A adapter

| DCN | DCX | $CZC_{MS}$ | $CZC_{WS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON | $DCON_{WS}$ | ISO | $ADJLX_{RDL}$ | LF | $BD_1$ | BAR PSI | 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 |
| *.118* | *1.024* | | | | | *2.480* | *.472* | | *.118* | *2.480* | *1.969* | *290* | |
| 3.00 | 26.00 | 100 | 12 | 1 | 392.41037A-10012076B | 100.00 | 12.00 | A | 3.00 | 76.00 | 50.00 | 20 | 2.700 |
| *.118* | *1.024* | | | | | *3.937* | *.472* | | *.118* | *2.992* | *1.969* | *290* | |
| 3.00 | 32.00 | 63 | 16 | 1 | 392.41037A-6316085A | 63.00 | 16.00 | A | 3.00 | 85.00 | 63.00 | 20 | 1.770 |
| *.118* | *1.260* | | | | | *2.480* | *.630* | | *.118* | *3.346* | *2.480* | *290* | |
| 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 |
| *.669* | *1.417* | | | | | *2.480* | *.787* | | *.197* | *3.937* | *3.150* | *290* | |




## 391.37B head with adjustable counterweight

| DCN | DCX | $CZC_{MS}$ | $CZC_{WS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $DCON_{WS}$ | ISO | $ADJLX_{RDL}$ | LF | $BD_1$ | BAR PSI | 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 |
| *.118* | *1.024* | | | | | *2.480* | *.472* | | *.118* | *3.543* | *1.969* | *290* | |

To be used with R429U/R429.90 boring bars

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

L2 M37 N22 N15

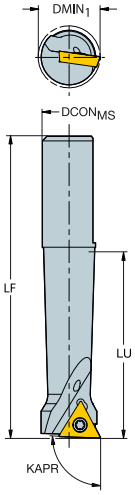
# Boring bar with indexable insert for fine boring heads

**Cylindrical shank - Internal coolant supply**
**Steel bar**

TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR 92°




| DMIN1 | | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | LU | LF | WF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 8.0 | 06 | 5/32 | 12 | 1 | R429U-A12-08028TC06 | 12.00 | 28.00 | 54.00 | 4.00 | 20 | 0.036 | 1 | TCMT 06 T1 02 |
| .315 | | | | | | .472 | 1.102 | 2.126 | .157 | 290 | | | |
| 8.0 | 06 | 5/32 | 12 | 1 | R429U-A12-08040TC06 | 12.00 | 40.00 | 66.00 | 4.00 | 20 | 0.040 | 1 | TCMT 06 T1 02 |
| .315 | | | | | | .472 | 1.575 | 2.598 | .157 | 290 | | | |
| 11.0 | 06 | 5/32 | 12 | 1 | R429U-A12-11039TC06 | 12.00 | 39.00 | 65.00 | 5.50 | 20 | 0.048 | 1 | TCMT 06 T1 02 |
| .433 | | | | | | .472 | 1.535 | 2.559 | .217 | 290 | | | |
| 11.0 | 06 | 5/32 | 12 | 1 | R429U-A12-11055TC06 | 12.00 | 55.00 | 81.00 | 5.50 | 20 | 0.053 | 1 | TCMT 06 T1 02 |
| .433 | | | | | | .472 | 2.165 | 3.189 | .217 | 290 | | | |
| 14.0 | 09 | 7/32 | 12 | 1 | R429U-A12-14042TC09 | 12.00 | 42.00 | 68.00 | 7.00 | 20 | 0.060 | 1 | TCMT 09 02 02 |
| .551 | | | | | | .472 | 1.654 | 2.677 | .276 | 290 | | | |
| 14.0 | 09 | 7/32 | 12 | 1 | R429U-A12-14060TC09 | 12.00 | 60.00 | 86.00 | 7.00 | 20 | 0.070 | 1 | TCMT 09 02 02 |
| .551 | | | | | | .472 | 2.362 | 3.386 | .276 | 290 | | | |
| 17.0 | 09 | 7/32 | 12 | 1 | R429U-A12-17042TC09 | 12.00 | 42.00 | 68.00 | 8.50 | 20 | 0.060 | 1 | TCMT 09 02 02 |
| .669 | | | | | | .472 | 1.654 | 2.677 | .335 | 290 | | | |
| 17.0 | 09 | 7/32 | 12 | 1 | R429U-A12-17060TC09 | 12.00 | 60.00 | 86.00 | 8.50 | 20 | 0.071 | 1 | TCMT 09 02 02 |
| .669 | | | | | | .472 | 2.362 | 3.386 | .335 | 290 | | | |
| 20.0 | 09 | 7/32 | 12 | 1 | R429U-A12-20042TC09 | 12.00 | 42.00 | 68.00 | 10.00 | 20 | 0.063 | 1 | TCMT 09 02 02 |
| .787 | | | | | | .472 | 1.654 | 2.677 | .394 | 290 | | | |
| 20.0 | 09 | 7/32 | 12 | 1 | R429U-A12-20060TC09 | 12.00 | 60.00 | 86.00 | 10.00 | 20 | 0.072 | 1 | TCMT 09 02 02 |
| .787 | | | | | | .472 | 2.362 | 3.386 | .394 | 290 | | | |
| 8.0 | 06 | 5/32 | 16 | 1 | R429U-A16-08028 TC06A | 16.00 | 28.00 | 89.00 | 4.00 | 20 | 0.114 | 1 | TCMT 06 T1 02 |
| .315 | | | | | | .630 | 1.102 | 3.504 | .157 | 290 | | | |
| 8.0 | 06 | 5/32 | 16 | 1 | R429U-A16-08040TC06 | 16.00 | 40.00 | 101.00 | 4.00 | 20 | 0.103 | 1 | TCMT 06 T1 02 |
| .315 | | | | | | .630 | 1.575 | 3.976 | .157 | 290 | | | |
| 11.0 | 06 | 5/32 | 16 | 1 | R429U-A16-11039 TC06A | 16.00 | 39.00 | 100.00 | 5.50 | 20 | 0.124 | 1 | TCMT 06 T1 02 |
| .433 | | | | | | .630 | 1.535 | 3.937 | .217 | 290 | | | |
| 11.0 | 06 | 5/32 | 16 | 1 | R429U-A16-11055TC06 | 16.00 | 55.00 | 116.00 | 5.50 | 20 | 0.120 | 1 | TCMT 06 T1 02 |
| .433 | | | | | | .630 | 2.165 | 4.567 | .217 | 290 | | | |
| 14.0 | 09 | 7/32 | 16 | 1 | R429U-A16-14049 TC09A | 16.00 | 49.00 | 110.00 | 1.50 | 20 | 0.148 | 1 | TCMT 09 02 02 |
| .551 | | | | | | .630 | 1.929 | 4.331 | .059 | 290 | | | |
| 14.0 | 09 | 7/32 | 16 | 1 | R429U-A16-14070TC09 | 16.00 | 70.00 | 131.00 | 7.00 | 20 | 0.156 | 1 | TCMT 09 02 02 |
| .551 | | | | | | .630 | 2.756 | 5.157 | .276 | 290 | | | |
| 17.0 | 09 | 7/32 | 16 | 1 | R429U-A16-17056 TC09A | 16.00 | 56.00 | 117.00 | 8.50 | 20 | 0.165 | 1 | TCMT 09 02 02 |
| .669 | | | | | | .630 | 2.205 | 4.606 | .335 | 290 | | | |
| 17.0 | 09 | 7/32 | 16 | 1 | R429U-A16-17080TC09 | 16.00 | 80.00 | 141.00 | 8.50 | 20 | 0.193 | 1 | TCMT 09 02 02 |
| .669 | | | | | | .630 | 3.150 | 5.551 | .335 | 290 | | | |

Recommended adapters:
A12: 391.37A/B
A16, A20: 391.37A
For spare parts, visit www.sandvik.coromant.com
For inserts, see Turning catalog

K40

M37

N22

N15

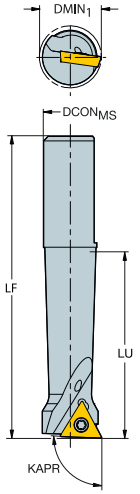
# Boring bar with indexable insert for fine boring heads

**Cylindrical shank - Internal coolant supply**
**Steel bar**

TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR 92°



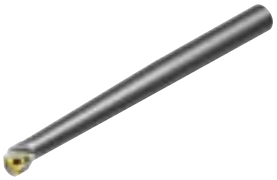

| DMIN1 | | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | LU | LF | WF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20.0 | 09 | 7/32 | 16 | 1 | R429U-A16-20056 TC09A | 16.00 | 56.00 | 117.00 | 10.00 | 20 | 7.400 | 1 | TCMT 09 02 02 |
| *.787* | | | | | | *.630* | *2.205* | *4.606* | *.394* | *290* | | | |
| 20.0 | 09 | 7/32 | 16 | 1 | R429U-A16-20080TC09 | 16.00 | 80.00 | 141.00 | 10.00 | 20 | 0.195 | 1 | TCMT 09 02 02 |
| *.787* | | | | | | *.630* | *3.150* | *5.551* | *.394* | *290* | | | |
| 23.0 | 09 | 7/32 | 16 | 1 | R429U-A16-23056 TC09A | 16.00 | 56.00 | 117.00 | 11.50 | 20 | 0.160 | 1 | TCMT 09 02 02 |
| *.906* | | | | | | *.630* | *2.205* | *4.606* | *.453* | *290* | | | |
| 23.0 | 09 | 7/32 | 16 | 1 | R429U-A16-23080TC09 | 16.00 | 80.00 | 141.00 | 11.50 | 20 | 0.192 | 1 | TCMT 09 02 02 |
| *.906* | | | | | | *.630* | *3.150* | *5.551* | *.453* | *290* | | | |
| 26.0 | 09 | 7/32 | 16 | 1 | R429U-A16-26056 TC09A | 16.00 | 56.00 | 117.00 | 13.00 | 20 | 0.160 | 1 | TCMT 09 02 02 |
| *1.024* | | | | | | *.630* | *2.205* | *4.606* | *.512* | *290* | | | |
| 26.0 | 09 | 7/32 | 16 | 1 | R429U-A16-26080TC09 | 16.00 | 80.00 | 141.00 | 13.00 | 20 | 0.194 | 1 | TCMT 09 02 02 |
| *1.024* | | | | | | *.630* | *3.150* | *5.551* | *.512* | *290* | | | |
| 17.0 | 09 | 7/32 | 20 | 1 | R429U-A20-17060 TC09A | 20.00 | 60.00 | 134.00 | 8.50 | 20 | 0.260 | 1 | TCMT 09 02 02 |
| *.669* | | | | | | *.787* | *2.362* | *5.276* | *.335* | *290* | | | |
| 20.0 | 09 | 7/32 | 20 | 1 | R429U-A20-20070 TC09A | 20.00 | 70.00 | 144.00 | 10.00 | 20 | 0.270 | 1 | TCMT 09 02 02 |
| *.787* | | | | | | *.787* | *2.756* | *5.669* | *.394* | *290* | | | |
| 23.0 | 09 | 7/32 | 20 | 1 | R429U-A20-23070 TC09A | 20.00 | 70.00 | 144.00 | 11.50 | 20 | 0.290 | 1 | TCMT 09 02 02 |
| *.906* | | | | | | *.787* | *2.756* | *5.669* | *.453* | *290* | | | |
| 26.0 | 09 | 7/32 | 20 | 1 | R429U-A20-26070 TC09A | 20.00 | 70.00 | 144.00 | 13.00 | 20 | 0.290 | 1 | TCMT 09 02 02 |
| *1.024* | | | | | | *.787* | *2.756* | *5.669* | *.512* | *290* | | | |

Recommended adapters:
A12: 391.37A/B
A16, A20: 391.37A
For spare parts, visit www.sandvik.coromant.com
For inserts, see Turning catalog

K40 M37 N22 N15

# Boring bar with indexable insert for fine boring heads

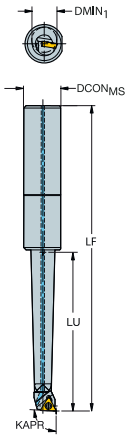
**Cylindrical shank - Internal coolant supply**
**Carbide bar with brazed steel head**



TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR 92°




| DMIN1 | | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | LU | LF | WF | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 8.0 | 06 | 5/32 | 16 | 1 | R429U-E16-08048TC06 | 16.00 | 48.00 | 109.00 | 4.00 | 20 | 0.130 | 1 | TCMT 06 T1 02 |
| *.315* | | | | | | *.630* | *1.890* | *4.291* | *.157* | *290* | | | |
| 11.0 | 06 | 5/32 | 16 | 1 | R429U-E16-11066TC06 | 16.00 | 66.00 | 127.00 | 5.50 | 20 | 0.170 | 1 | TCMT 06 T1 02 |
| *.433* | | | | | | *.630* | *2.598* | *5.000* | *.217* | *290* | | | |
| 14.0 | 09 | 7/32 | 16 | 1 | R429U-E16-14084TC09 | 16.00 | 84.00 | 145.00 | 7.00 | 20 | 0.275 | 1 | TCMT 09 02 02 |
| *.551* | | | | | | *.630* | *3.307* | *5.709* | *.276* | *290* | | | |
| 17.0 | 09 | 7/32 | 16 | 1 | R429U-E16-17096TC09 | 16.00 | 96.00 | 157.00 | 8.50 | 20 | 0.391 | 1 | TCMT 09 02 02 |
| *.669* | | | | | | *.630* | *3.780* | *6.181* | *.335* | *290* | | | |
| 20.0 | 09 | 7/32 | 16 | 1 | R429U-E16-20096TC09 | 16.00 | 96.00 | 157.00 | 10.00 | 20 | 0.394 | 1 | TCMT 09 02 02 |
| *.787* | | | | | | *.630* | *3.780* | *6.181* | *.394* | *290* | | | |
| 23.0 | 09 | 7/32 | 16 | 1 | R429U-E16-23096TC09 | 16.00 | 96.00 | 157.00 | 11.50 | 20 | 0.395 | 1 | TCMT 09 02 02 |
| *.906* | | | | | | *.630* | *3.780* | *6.181* | *.453* | *290* | | | |
| 26.0 | 09 | 7/32 | 16 | 1 | R429U-E16-26096TC09 | 16.00 | 96.00 | 157.00 | 13.00 | 20 | 0.395 | 1 | TCMT 09 02 02 |
| *1.024* | | | | | | *.630* | *3.780* | *6.181* | *.512* | *290* | | | |

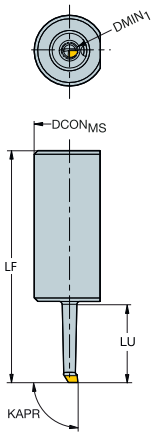
For inserts, see Turning catalog

Recommended adapters:
A12: A391.37A/B
A16: A391.37A

K40 N22 N15

# Solid boring bar for fine boring head

KAPR 90°




| DMIN$_1$ | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | LU | LF | WF | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|
| 3.0 | 16 | 1 | R429U-E16-0301501A | 16.00 | 15.00 | 76.00 | 1.50 | 70 | 0.102 |
| *.118* | | | | *.630* | *.591* | *2.992* | *.059* | *1015* | |
| 5.0 | 16 | 1 | R429U-E16-0502502A | 16.00 | 25.00 | 86.00 | 2.50 | 70 | 0.100 |
| *.197* | | | | *.630* | *.984* | *3.386* | *.098* | *1015* | |

| DMIN$_1$ | CZC$_{MS}$ | CNSC | Ordering code | P H10F | M H10F | K H10F | N H10F | S H10F | Dimensions, mm, inch DCON$_{MS}$ | LU | LF | WF | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 3.0 | 12 | 1 | R429.90-03-013-01-CB | ★ | ★ | ★ | ★ | ★ | 12.00 | 13.50 | 40.00 | 1.50 | 70 | 0.039 |
| *.118* | | | | | | | | | *.472* | *.531* | *1.575* | *.059* | *1015* | |
| 5.0 | 12 | 1 | R429.90-05-021-02-CB | ★ | ★ | ★ | ★ | ★ | 12.00 | 21.00 | 48.00 | 2.50 | 70 | 0.042 |
| *.197* | | | | | | | | | *.472* | *.827* | *1.890* | *.098* | *1015* | |

Recommended adapters:
A12: A391.37A/B
A16: A391.37A

L2 M37 N22 N15

# 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 0.002 mm (.00008 inch) 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 (.000079 inch) with a nonius scale. A 360° turn change diameter by 0.5 mm (.020 inch).

With a Silent Tools™ damper built closer to the cutting edge and a fine boring head in aluminum with reduced length, higher performance and increased productivity can be achieved.

Also available as lightweight tools. Bore large diameters with increased stability without increasing the tool weight.

# CoroBore® 826

## Fine boring tool for high precision boring

### Application

- High-precision fine boring

### ISO application area

P M K N S H

### Benefits and features

- High-precision coolant directed at the cutting edge for excellent chip control up to 70 bars
- Coolant through the tool and cartridge
- Stepwise click function for easy tool setting
- Reliable system with rigid interfaces between head and cartridge for stable and vibration-free boring
- Close hole tolerances up to IT6
- CoroBore® 826 high precision adjusts the cutting edge to the diameter in increments of 2 micrometers

www.sandvik.coromant.com/corobore826

### Tools

Couplings:
- Coromant Capto®

### Inserts

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

Each click adjusts the diameter by 0.002 mm (.000079 inch). A 360° turn changes the diameter by 0.1 mm (.004 inch). Total diameter change on fine boring head 1.3 mm (.051 inch).

High precision coolant nozzle for precise coolant flow to cutting edge

Extend diameter range with cartridge kits! See page K90

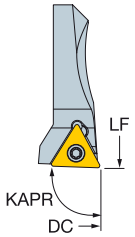
# CoroBore® 825 fine boring tool

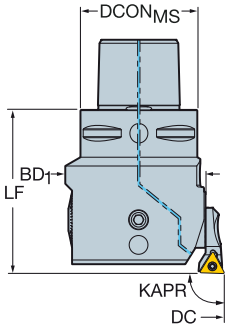
**Coromant Capto® - Internal coolant supply**

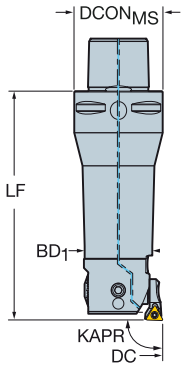
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR 92° 92°
DSGN 1 2




| DCN | DCX | ⟷ | IC | $CZC_{MS}$ | CNSC | DSGN | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | ULDR | LF | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 19.00 | 23.00 | 06 | 5/32 | C3 | 3 | 2 | 825-23TC06-C3 | 32.00 | 2.00 | 3.00 | 89.00 | 18.00 | 70 | 0.430 | 1 | TCMT 06 T1 02 |
| *.748* | *.906* | | | | | | | *1.260* | *.079* | | *3.504* | *.709* | *1015* | | | |
| 23.00 | 29.00 | 06 | 5/32 | C3 | 3 | 2 | 825-29TC06-C3 | 32.00 | 3.00 | 2.00 | 76.00 | 20.00 | 70 | 0.414 | 1 | TCMT 06 T1 02 |
| *.906* | *1.142* | | | | | | | *1.260* | *.118* | | *2.992* | *.787* | *1015* | | | |
| 23.00 | 29.00 | 06 | 5/32 | C4 | 3 | 2 | 825-29TC06-C4 | 40.00 | 3.00 | 2.00 | 85.00 | 20.00 | 70 | 0.897 | 1 | TCMT 06 T1 02 |
| *.906* | *1.142* | | | | | | | *1.575* | *.118* | | *3.346* | *.787* | *1015* | | | |
| 28.00 | 36.00 | 06 | 5/32 | C3 | 3 | 2 | 825-36TC06-C3 | 32.00 | 4.00 | 2.00 | 83.00 | 25.00 | 70 | 0.692 | 1 | TCMT 06 T1 02 |
| *1.102* | *1.417* | | | | | | | *1.260* | *.157* | | *3.268* | *.984* | *1015* | | | |
| 28.00 | 36.00 | 06 | 5/32 | C4 | 3 | 2 | 825-36TC06-C4 | 40.00 | 4.00 | 2.00 | 95.00 | 25.00 | 70 | 0.992 | 1 | TCMT 06 T1 02 |
| *1.102* | *1.417* | | | | | | | *1.575* | *.157* | | *3.740* | *.984* | *1015* | | | |
| 35.00 | 45.00 | 09 | 7/32 | C3 | 3 | 1 | 825-45TC09-C3 | 32.00 | 5.00 | | 48.00 | 32.00 | 70 | 0.641 | 1 | TCMT 09 02 04 |
| *1.378* | *1.772* | | | | | | | *1.260* | *.197* | | *1.890* | *1.260* | *1015* | | | |
| 35.00 | 45.00 | 09 | 7/32 | C4 | 3 | 2 | 825-45TC09-C4 | 40.00 | 5.00 | 1.50 | 83.00 | 32.00 | 70 | 1.007 | 1 | TCMT 09 02 04 |
| *1.378* | *1.772* | | | | | | | *1.575* | *.197* | | *3.268* | *1.260* | *1015* | | | |
| 44.00 | 56.00 | 09 | 7/32 | C4 | 3 | 1 | 825-56TC09-C4 | 40.00 | 6.00 | | 56.00 | 40.00 | 70 | 0.874 | 1 | TCMT 09 02 04 |
| *1.732* | *2.205* | | | | | | | *1.575* | *.236* | | *2.205* | *1.575* | *1015* | | | |
| 44.00 | 56.00 | 09 | 7/32 | C5 | 3 | 2 | 825-56TC09-C5 | 50.00 | 6.00 | 1.50 | 98.00 | 40.00 | 70 | 1.600 | 1 | TCMT 09 02 04 |
| *1.732* | *2.205* | | | | | | | *1.969* | *.236* | | *3.858* | *1.575* | *1015* | | | |
| 55.00 | 70.00 | 11 | 1/4 | C5 | 3 | 1 | 825-70TC11-C5 | 50.00 | 7.50 | | 66.00 | 50.00 | 70 | 1.430 | 1 | TCMT 11 03 04 |
| *2.165* | *2.756* | | | | | | | *1.969* | *.295* | | *2.598* | *1.969* | *1015* | | | |
| 55.00 | 70.00 | 11 | 1/4 | C6 | 3 | 2 | 825-70TC11-C6 | 63.00 | 7.50 | 1.50 | 120.00 | 50.00 | 70 | 2.620 | 1 | TCMT 11 03 04 |
| *2.165* | *2.756* | | | | | | | *2.480* | *.295* | | *4.724* | *1.969* | *1015* | | | |
| 69.00 | 87.00 | 11 | 1/4 | C5 | 3 | 1 | 825-87TC11-C5 | 50.00 | 9.00 | | 70.00 | 63.00 | 70 | 1.930 | 1 | TCMT 11 03 04 |
| *2.717* | *3.425* | | | | | | | *1.969* | *.354* | | *2.756* | *2.480* | *1015* | | | |
| 69.00 | 87.00 | 11 | 1/4 | C6 | 3 | 1 | 825-87TC11-C6 | 63.00 | 9.00 | | 78.00 | 63.00 | 70 | 2.360 | 1 | TCMT 11 03 04 |
| *2.717* | *3.425* | | | | | | | *2.480* | *.354* | | *3.071* | *2.480* | *1015* | | | |
| 86.00 | 107.00 | 11 | 1/4 | C5 | 3 | 1 | 825-107TC11-C5 | 50.00 | 10.50 | | 76.00 | 80.00 | 70 | 2.240 | 1 | TCMT 11 03 04 |
| *3.386* | *4.213* | | | | | | | *1.969* | *.413* | | *2.992* | *3.150* | *1015* | | | |
| 86.00 | 107.00 | 11 | 1/4 | C6 | 3 | 1 | 825-107TC11-C6 | 63.00 | 10.50 | | 90.00 | 80.00 | 70 | 3.180 | 1 | TCMT 11 03 04 |
| *3.386* | *4.213* | | | | | | | *2.480* | *.413* | | *3.543* | *3.150* | *1015* | | | |
| 106.00 | 137.00 | 11 | 1/4 | C6 | 3 | 1 | 825-137TC11-C6 | 63.00 | 15.50 | | 90.00 | 100.00 | 70 | 3.792 | 1 | TCMT 11 03 04 |
| *4.173* | *5.394* | | | | | | | *2.480* | *.610* | | *3.543* | *3.937* | *1015* | | | |
| 106.00 | 137.00 | 11 | 1/4 | C8 | 3 | 1 | 825-137TC11-C8 | 80.00 | 15.50 | | 100.00 | 100.00 | 70 | 5.045 | 1 | TCMT 11 03 04 |
| *4.173* | *5.394* | | | | | | | *3.150* | *.610* | | *3.937* | *3.937* | *1015* | | | |
| 136.00 | 167.00 | 11 | 1/4 | C6 | 3 | 1 | 825-167TC11-C6 | 63.00 | 15.50 | | 90.00 | 130.00 | 70 | 4.430 | 1 | TCMT 11 03 04 |
| *5.354* | *6.575* | | | | | | | *2.480* | *.610* | | *3.543* | *5.118* | *1015* | | | |
| 136.00 | 167.00 | 11 | 1/4 | C8 | 3 | 1 | 825-167TC11-C8 | 80.00 | 15.50 | | 100.00 | 130.00 | 70 | 5.570 | 1 | TCMT 11 03 04 |
| *5.354* | *6.575* | | | | | | | *3.150* | *.610* | | *3.937* | *5.118* | *1015* | | | |

Diameters are valid when frontboring.
For more information about backboring, see page K98
For more information about the use of slide extensions, see page K98
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning catalog
For all DSGN 2; LU = DC*ULDR

L2 N22 N15 K94

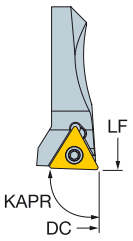


SANDVIK Coromant

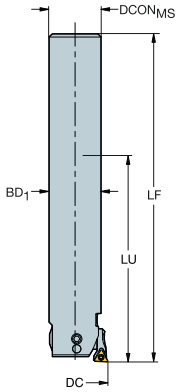
# CoroBore® 825 fine boring tool

**Cylindrical shank - Internal coolant supply**

KAPR




92°




TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

| DCN | DCX | | IC | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | LU | LF | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 19.00 | 23.00 | 06 | 5/32 | 18 | 1 | **825-23TC06-A18** | 18.00 | 2.00 | 77.00 | 128.00 | 18.00 | 70 | 0.640 | 1 | TCMT 06 T1 02 |
| *.748* | *.906* | | | | | | *.709* | *.079* | *3.032* | *5.039* | *.709* | *1015* | | | |
| 23.00 | 29.00 | 06 | 5/32 | 20 | 1 | **825-29TC06-A20** | 20.00 | 3.00 | 81.00 | 132.00 | 20.00 | 70 | 0.606 | 1 | TCMT 06 T1 02 |
| *.906* | *1.142* | | | | | | *.787* | *.118* | *3.189* | *5.197* | *.787* | *1015* | | | |
| 28.00 | 36.00 | 06 | 5/32 | 25 | 1 | **825-36TC06-A25** | 25.00 | 4.00 | 101.00 | 158.00 | 25.00 | 70 | 0.951 | 1 | TCMT 06 T1 02 |
| *1.102* | *1.417* | | | | | | *.984* | *.157* | *3.976* | *6.220* | *.984* | *1015* | | | |

Diameters are valid when frontboring.

For more information about backboring, see page K98

For more information about the use of slide extensions, see page K98

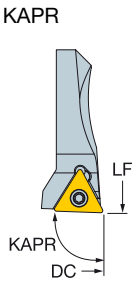
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com

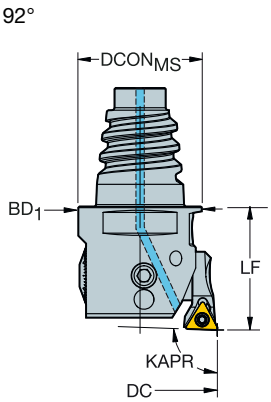
For inserts, see Turning catalog

L2 N22 N15 K94

# CoroBore® 825 fine boring tool

**Coromant EH coupling - Internal coolant supply**




TCMT, TCMX, TCGT, TCGX TCEX

TCMW

| DCN | DCX | | IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXRDL | LF | BD1 | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 19.00 | 23.00 | 06 | 5/32 | E16 | 1 | 825-23TC06-EH16 | 15.50 | 2.00 | 25.00 | 18.00 | 70 | 0.500 | 1 | TCMT 06 T1 02 |
| *.748* | *.906* | | | | | | *.610* | *.079* | *.984* | *.709* | *1015* | | | |
| 23.00 | 29.00 | 06 | 5/32 | E20 | 1 | 825-29TC06-EH20 | 19.30 | 3.00 | 25.00 | 20.00 | 70 | 0.600 | 1 | TCMT 06 T1 02 |
| *.906* | *1.142* | | | | | | *.760* | *.118* | *.984* | *.787* | *1015* | | | |
| 28.00 | 36.00 | 06 | 5/32 | E25 | 1 | 825-36TC06-EH25 | 24.20 | 4.00 | 25.00 | 25.00 | 70 | 0.687 | 1 | TCMT 06 T1 02 |
| *1.102* | *1.417* | | | | | | *.953* | *.157* | *.984* | *.984* | *1015* | | | |

Diameters are valid when frontboring.

For more information about backboring, see page K98

For more information about the use of slide extensions, see page K98

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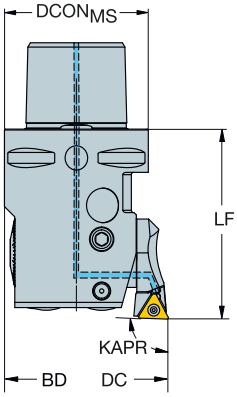
L2 N22 N15 K94

# CoroBore® 826 fine boring tool

**Coromant Capto® - Precision coolant supply**

KAPR 92°




TCMT, TCMX, TCGT, TCGX TCEX

TCMW

| DCN | DCX | ↔ | ↔IC | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXRDL | LF | BD1 | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 35.45 | 36.55 | 09 | 7/32 | C3 | 3 | 826-36TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.566 | 1 | TCMT 09 02 04 |
| *1.396* | *1.439* | | | | | | *1.260* | *.022* | *1.890* | *1.260* | *1015* | | | |
| 36.45 | 37.55 | 09 | 7/32 | C3 | 3 | 826-37TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.565 | 1 | TCMT 09 02 04 |
| *1.435* | *1.478* | | | | | | *1.260* | *.022* | *1.890* | *1.260* | *1015* | | | |
| 37.45 | 38.55 | 09 | 7/32 | C3 | 3 | 826-38TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.631 | 1 | TCMT 09 02 04 |
| *1.474* | *1.518* | | | | | | *1.260* | *.022* | *1.890* | *1.260* | *1015* | | | |
| 38.45 | 39.55 | 09 | 7/32 | C3 | 3 | 826-39TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.640 | 1 | TCMT 09 02 04 |
| *1.514* | *1.557* | | | | | | *1.260* | *.022* | *1.890* | *1.260* | *1015* | | | |
| 39.45 | 40.55 | 09 | 7/32 | C3 | 3 | 826-40TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.647 | 1 | TCMT 09 02 04 |
| *1.553* | *1.596* | | | | | | *1.260* | *.022* | *1.890* | *1.260* | *1015* | | | |
| 40.45 | 41.55 | 09 | 7/32 | C3 | 3 | 826-41TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.290 | 1 | TCMT 09 02 04 |
| *1.593* | *1.636* | | | | | | *1.260* | *.022* | *1.890* | *1.260* | *1015* | | | |
| 41.45 | 42.55 | 09 | 7/32 | C3 | 3 | 826-42TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.290 | 1 | TCMT 09 02 04 |
| *1.632* | *1.675* | | | | | | *1.260* | *.022* | *1.890* | *1.260* | *1015* | | | |
| 42.45 | 43.55 | 09 | 7/32 | C3 | 3 | 826-43TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.290 | 1 | TCMT 09 02 04 |
| *1.671* | *1.715* | | | | | | *1.260* | *.022* | *1.890* | *1.260* | *1015* | | | |
| 43.45 | 44.55 | 09 | 7/32 | C3 | 3 | 826-44TC09-C3HP | 32.00 | 0.55 | 48.00 | 32.00 | 70 | 0.290 | 1 | TCMT 09 02 04 |
| *1.711* | *1.754* | | | | | | *1.260* | *.022* | *1.890* | *1.260* | *1015* | | | |
| 44.45 | 45.55 | 09 | 7/32 | C4 | 3 | 826-45TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.591 | 1 | TCMT 09 02 04 |
| *1.750* | *1.793* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 45.45 | 46.55 | 09 | 7/32 | C4 | 3 | 826-46TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| *1.789* | *1.833* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 46.45 | 47.55 | 09 | 7/32 | C4 | 3 | 826-47TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 1.104 | 1 | TCMT 09 02 04 |
| *1.829* | *1.872* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 47.45 | 48.55 | 09 | 7/32 | C4 | 3 | 826-48TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| *1.868* | *1.911* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 48.45 | 49.55 | 09 | 7/32 | C4 | 3 | 826-49TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| *1.907* | *1.951* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 49.45 | 50.55 | 09 | 7/32 | C4 | 3 | 826-50TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.918 | 1 | TCMT 09 02 04 |
| *1.947* | *1.990* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 50.45 | 51.55 | 09 | 7/32 | C4 | 3 | 826-51TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| *1.986* | *2.030* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 51.45 | 52.55 | 09 | 7/32 | C4 | 3 | 826-52TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.940 | 1 | TCMT 09 02 04 |
| *2.026* | *2.069* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 52.45 | 53.55 | 09 | 7/32 | C4 | 3 | 826-53TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| *2.065* | *2.108* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 53.45 | 54.55 | 09 | 7/32 | C4 | 3 | 826-54TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| *2.104* | *2.148* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 54.45 | 55.55 | 09 | 7/32 | C4 | 3 | 826-55TC09-C4HP | 40.00 | 0.55 | 56.00 | 40.00 | 70 | 0.570 | 1 | TCMT 09 02 04 |
| *2.144* | *2.187* | | | | | | *1.575* | *.022* | *2.205* | *1.575* | *1015* | | | |
| 55.35 | 56.65 | 11 | 1/4 | C5 | 3 | 826-56TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.397 | 1 | TCMT 11 03 04 |
| *2.179* | *2.230* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 56.35 | 57.65 | 11 | 1/4 | C5 | 3 | 826-57TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.455 | 1 | TCMT 11 03 04 |
| *2.219* | *2.270* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |

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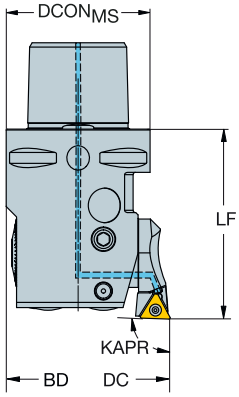
L2 N22 N15 K94

# CoroBore® 826 fine boring tool

**Coromant Capto® - Precision coolant supply**

KAPR 92°




TCMT, TCMX, TCGT, TCGX TCEX

TCMW

| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 57.35 | 58.65 | 11 | 1/4 | C5 | 3 | 826-58TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.414 | 1 | TCMT 11 03 04 |
| *2.258* | *2.309* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 58.35 | 59.65 | 11 | 1/4 | C5 | 3 | 826-59TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| *2.297* | *2.348* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 59.35 | 60.65 | 11 | 1/4 | C5 | 3 | 826-60TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.466 | 1 | TCMT 11 03 04 |
| *2.337* | *2.388* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 60.35 | 61.65 | 11 | 1/4 | C5 | 3 | 826-61TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| *2.376* | *2.427* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 61.35 | 62.65 | 11 | 1/4 | C5 | 3 | 826-62TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| *2.415* | *2.467* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 62.35 | 63.65 | 11 | 1/4 | C5 | 3 | 826-63TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.426 | 1 | TCMT 11 03 04 |
| *2.455* | *2.506* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 63.35 | 64.65 | 11 | 1/4 | C5 | 3 | 826-64TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.503 | 1 | TCMT 11 03 04 |
| *2.494* | *2.545* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 64.35 | 65.65 | 11 | 1/4 | C5 | 3 | 826-65TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.520 | 1 | TCMT 11 03 04 |
| *2.533* | *2.585* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 65.35 | 66.65 | 11 | 1/4 | C5 | 3 | 826-66TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| *2.573* | *2.624* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 66.35 | 67.65 | 11 | 1/4 | C5 | 3 | 826-67TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| *2.612* | *2.663* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 67.35 | 68.65 | 11 | 1/4 | C5 | 3 | 826-68TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| *2.652* | *2.703* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 68.35 | 69.65 | 11 | 1/4 | C5 | 3 | 826-69TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| *2.691* | *2.742* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 69.35 | 70.65 | 11 | 1/4 | C5 | 3 | 826-70TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.455 | 1 | TCMT 11 03 04 |
| *2.730* | *2.782* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 70.35 | 71.65 | 11 | 1/4 | C5 | 3 | 826-71TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| *2.770* | *2.821* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 71.35 | 72.65 | 11 | 1/4 | C5 | 3 | 826-72TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.070 | 1 | TCMT 11 03 04 |
| *2.809* | *2.860* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 72.35 | 73.65 | 11 | 1/4 | C5 | 3 | 826-73TC11-C5HP | 50.00 | 0.65 | 66.00 | 50.00 | 70 | 1.557 | 1 | TCMT 11 03 04 |
| *2.848* | *2.900* | | | | | | *1.969* | *.026* | *2.598* | *1.969* | *1015* | | | |
| 73.35 | 74.65 | 11 | 1/4 | C6 | 3 | 826-74TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *2.888* | *2.939* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 74.35 | 75.65 | 11 | 1/4 | C6 | 3 | 826-75TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *2.927* | *2.978* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 75.35 | 76.65 | 11 | 1/4 | C6 | 3 | 826-76TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 2.400 | 1 | TCMT 11 03 04 |
| *2.967* | *3.018* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 76.35 | 77.65 | 11 | 1/4 | C6 | 3 | 826-77TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.006* | *3.057* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 77.35 | 78.65 | 11 | 1/4 | C6 | 3 | 826-78TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.045* | *3.096* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 78.35 | 79.65 | 11 | 1/4 | C6 | 3 | 826-79TC11-C6HP | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.085* | *3.136* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |

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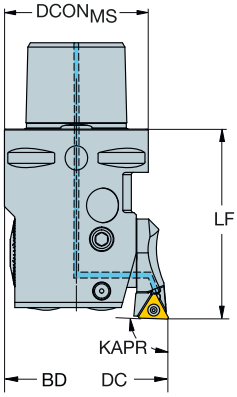
L2 N22 N15 K94

# CoroBore® 826 fine boring tool

**Coromant Capto® - Precision coolant supply**

KAPR 92°




TCMT, TCMX, TCGT, TCGX TCEX

TCMW

| DCN | DCX | ⟷ | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 79.35 | 80.65 | 11 | 1/4 | C6 | 3 | **826-80TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.124* | *3.175* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 80.35 | 81.65 | 11 | 1/4 | C6 | 3 | **826-81TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.163* | *3.215* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 81.35 | 82.65 | 11 | 1/4 | C6 | 3 | **826-82TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.203* | *3.254* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 82.35 | 83.65 | 11 | 1/4 | C6 | 3 | **826-83TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.242* | *3.293* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 83.35 | 84.65 | 11 | 1/4 | C6 | 3 | **826-84TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.282* | *3.333* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 84.35 | 85.65 | 11 | 1/4 | C6 | 3 | **826-85TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.321* | *3.372* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 85.35 | 86.65 | 11 | 1/4 | C6 | 3 | **826-86TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.360* | *3.411* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 86.35 | 87.65 | 11 | 1/4 | C6 | 3 | **826-87TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.400* | *3.451* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 87.35 | 88.65 | 11 | 1/4 | C6 | 3 | **826-88TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.439* | *3.490* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 88.35 | 89.65 | 11 | 1/4 | C6 | 3 | **826-89TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.478* | *3.530* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 89.35 | 90.65 | 11 | 1/4 | C6 | 3 | **826-90TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.518* | *3.569* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |
| 90.35 | 91.65 | 11 | 1/4 | C6 | 3 | **826-91TC11-C6HP** | 63.00 | 0.65 | 78.00 | 63.00 | 70 | 1.940 | 1 | TCMT 11 03 04 |
| *3.557* | *3.608* | | | | | | *2.480* | *.026* | *3.071* | *2.480* | *1015* | | | |

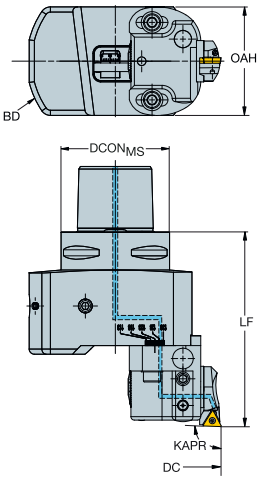
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning catalog

L2 N22 N15 K94

# CoroBore® 826 fine boring tool

**Coromant Capto® - Internal coolant supply**

KAPR 92°




TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

| DCN | DCX | ⟷ | IC | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | LF | OAH | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 91.35 | 112.65 | 11 | 1/4 | C6 | 3 | **826-112TC11-C6HP** | 63.00 | 10.65 | 113.00 | 63.00 | 85.00 | 70 | 3.215 | 1 | TCMT 11 03 04 |
| *3.596* | *4.435* | | | | | | *2.480* | *.419* | *4.449* | *2.480* | *3.346* | *1015* | | | |
| 112.35 | 133.65 | 11 | 1/4 | C6 | 3 | **826-133TC11-C6HP** | 63.00 | 10.65 | 113.00 | 63.00 | 105.00 | 70 | 3.645 | 1 | TCMT 11 03 04 |
| *4.423* | *5.262* | | | | | | *2.480* | *.419* | *4.449* | *2.480* | *4.134* | *1015* | | | |
| 133.35 | 154.65 | 11 | 1/4 | C6 | 3 | **826-154TC11-C6HP** | 63.00 | 10.65 | 113.00 | 63.00 | 125.00 | 70 | 3.940 | 1 | TCMT 11 03 04 |
| *5.250* | *6.089* | | | | | | *2.480* | *.419* | *4.449* | *2.480* | *4.921* | *1015* | | | |

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

L2 N22 N15 K94

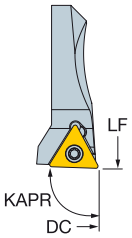
# CoroBore® 825 lightweight fine boring tool

**Coromant Capto® - Internal coolant supply**

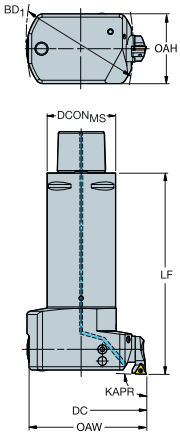
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 69.00 | 87.00 | 11 | 1/4 | C5 | 3 | **825L-87TC11-C5** | 50.00 | 9.00 | 150.00 | 51.00 | 63.00 | 70 | 2.150 | 1 | TCMT 11 03 04 |
| *2.717* | *3.425* | | | | | | *1.969* | *.354* | *5.906* | *2.008* | *2.480* | *1015* | | | |
| 86.00 | 107.00 | 11 | 1/4 | C5 | 3 | **825L-107TC11-C5** | 50.00 | 10.50 | 156.00 | 51.00 | 80.00 | 70 | 2.230 | 1 | TCMT 11 03 04 |
| *3.386* | *4.213* | | | | | | *1.969* | *.413* | *6.142* | *2.008* | *3.150* | *1015* | | | |
| 106.00 | 137.00 | 11 | 1/4 | C6 | 3 | **825L-137TC11-C6** | 63.00 | 15.50 | 190.00 | 64.00 | 100.00 | 70 | 3.970 | 1 | TCMT 11 03 04 |
| *4.173* | *5.394* | | | | | | *2.480* | *.610* | *7.480* | *2.520* | *3.937* | *1015* | | | |
| 106.00 | 137.00 | 11 | 1/4 | C8 | 3 | **825L-137TC11-C8** | 80.00 | 15.50 | 200.00 | 80.00 | 100.00 | 70 | 4.885 | 1 | TCMT 11 03 04 |
| *4.173* | *5.394* | | | | | | *3.150* | *.610* | *7.874* | *3.150* | *3.937* | *1015* | | | |
| 136.00 | 167.00 | 11 | 1/4 | C8 | 3 | **825L-167TC11-C8** | 80.00 | 15.50 | 200.00 | 80.00 | 130.00 | 70 | 5.160 | 1 | TCMT 11 03 04 |
| *5.354* | *6.575* | | | | | | *3.150* | *.610* | *7.874* | *3.150* | *5.118* | *1015* | | | |

Diameters are valid when frontboring.

For more information about backboring, see page K98
For more information about the use of slide extensions, see page K98

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

L2 N22 N15 K94

# CoroBore® 825 damped fine boring tool

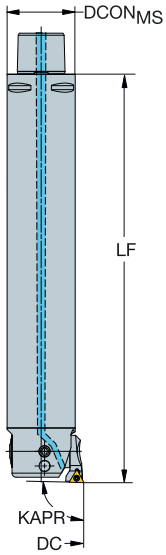
**Coromant Capto® - Internal coolant supply**

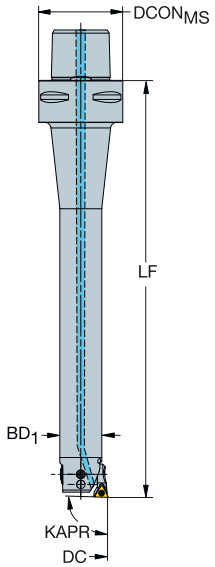
SilentTools®

TCMT, TCMX, TCGT, TCGX TCEX

TCMW

| | | |
|---|---|---|
| KAPR | 92° | 92° |
| DSGN | 1 | 2 |




| DCN | DCX | ↔ | IC | $CZC_{MS}$ | CNSC | DSGN | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | ULDR | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 19.00 | 23.00 | 06 | 5/32 | C4 | 3 | 2 | 825D-23TC06U-C4L | 40.00 | 2.00 | 6.00 | 163.00 | | 18.00 | 70 | 0.568 | 1 | TCMT 06 T1 02 |
| *.748* | *.906* | | | | | | | *1.575* | *.079* | | *6.417* | | *.709* | *1015* | | | |
| 23.00 | 29.00 | 06 | 5/32 | C4 | 3 | 2 | 825D-29TC06U-C4L | 40.00 | 3.00 | 6.00 | 199.00 | | 20.00 | 70 | 0.728 | 1 | TCMT 06 T1 02 |
| *.906* | *1.142* | | | | | | | *1.575* | *.118* | | *7.835* | | *.787* | *1015* | | | |
| 28.00 | 36.00 | 06 | 5/32 | C3 | 3 | 2 | 825D-36TC06U-C3L | 32.00 | 4.00 | 6.00 | 216.00 | | 25.00 | 70 | 0.968 | 1 | TCMT 06 T1 02 |
| *1.102* | *1.417* | | | | | | | *1.260* | *.157* | | *8.504* | | *.984* | *1015* | | | |
| 35.00 | 45.00 | 09 | 7/32 | C3 | 3 | 1 | 825D-45TC09U-C3L | 32.00 | 5.00 | | 221.00 | | 32.00 | 70 | 1.484 | 1 | TCMT 09 02 04 |
| *1.378* | *1.772* | | | | | | | *1.260* | *.197* | | *8.701* | | *1.260* | *1015* | | | |
| 35.00 | 45.00 | 09 | 7/32 | C4 | 3 | 2 | 825D-45TC09U-C4L | 40.00 | 5.00 | 6.00 | 270.00 | | 32.00 | 70 | 1.924 | 1 | TCMT 09 02 04 |
| *1.378* | *1.772* | | | | | | | *1.575* | *.197* | | *10.630* | | *1.260* | *1015* | | | |
| 35.00 | 45.00 | 09 | 7/32 | C6 | 3 | 2 | 825D-45TC09U-C6L | 63.00 | 5.00 | 6.00 | 297.00 | | 32.00 | 70 | 2.574 | 1 | TCMT 09 02 04 |
| *1.378* | *1.772* | | | | | | | *2.480* | *.197* | | *11.693* | | *1.260* | *1015* | | | |
| 44.00 | 56.00 | 09 | 7/32 | C4 | 3 | 1 | 825D-56TC09U-C4L | 40.00 | 6.00 | | 220.00 | | 40.00 | 70 | 2.124 | 1 | TCMT 09 02 04 |
| *1.732* | *2.205* | | | | | | | *1.575* | *.236* | | *8.661* | | *1.575* | *1015* | | | |
| 44.00 | 56.00 | 09 | 7/32 | C5 | 3 | 2 | 825D-56TC09U-C5L | 50.00 | 6.00 | 6.00 | 336.00 | | 40.00 | 70 | 3.744 | 1 | TCMT 09 02 04 |
| *1.732* | *2.205* | | | | | | | *1.969* | *.236* | | *13.228* | | *1.575* | *1015* | | | |
| 44.00 | 56.00 | 09 | 7/32 | C6 | 3 | 2 | 825D-56TC09U-C6L | 63.00 | 6.00 | 6.00 | 401.00 | | 40.00 | 70 | 4.384 | 1 | TCMT 09 02 04 |
| *1.732* | *2.205* | | | | | | | *2.480* | *.236* | | *15.787* | | *1.575* | *1015* | | | |
| 55.00 | 70.00 | 11 | 1/4 | C5 | 3 | 1 | 825D-70TC11U-C5M | 50.00 | 7.50 | | 300.00 | | 50.00 | 70 | 4.940 | 1 | TCMT 11 03 04 |
| *2.165* | *2.756* | | | | | | | *1.969* | *.295* | | *11.811* | | *1.969* | *1015* | | | |
| 55.00 | 70.00 | 11 | 1/4 | C6 | 3 | 2 | 825D-70TC11U-C6M | 63.00 | 7.50 | 5.60 | 400.00 | | 50.00 | 70 | 6.789 | 1 | TCMT 11 03 04 |
| *2.165* | *2.756* | | | | | | | *2.480* | *.295* | | *15.748* | | *1.969* | *1015* | | | |
| 69.00 | 87.00 | 11 | 1/4 | C6 | 3 | 1 | 825D-87TC11U-C6M | 63.00 | 9.00 | | 400.00 | | 63.00 | 70 | 9.659 | 1 | TCMT 11 03 04 |
| *2.717* | *3.425* | | | | | | | *2.480* | *.354* | | *15.748* | | *2.480* | *1015* | | | |
| 69.00 | 87.00 | 11 | 1/4 | C8 | 3 | 2 | 825D-87TC11U-C8S | 80.00 | 9.00 | 5.60 | 500.00 | | 63.00 | 70 | 12.869 | 1 | TCMT 11 03 04 |
| *2.717* | *3.425* | | | | | | | *3.150* | *.354* | | *19.685* | | *2.480* | *1015* | | | |
| 86.00 | 107.00 | 11 | 1/4 | C6 | 3 | 1 | 825D-107TC11U-C6M | 63.00 | 10.50 | | 400.00 | 64.00 | 80.00 | 70 | 9.729 | 1 | TCMT 11 03 04 |
| *3.386* | *4.213* | | | | | | | *2.480* | *.413* | | *15.748* | *2.520* | *3.150* | *1015* | | | |
| 86.00 | 107.00 | 11 | 1/4 | C8 | 3 | 1 | 825D-107TC11U-C8M | 80.00 | 10.50 | | 500.00 | | 80.00 | 70 | 18.089 | 1 | TCMT 11 03 04 |
| *3.386* | *4.213* | | | | | | | *3.150* | *.413* | | *19.685* | | *3.150* | *1015* | | | |
| 86.00 | 107.00 | 11 | 1/4 | C8 | 3 | 1 | 825D-107TC11U-C8S | 80.00 | 10.50 | | 410.00 | | 80.00 | 70 | 15.669 | 1 | TCMT 11 03 04 |
| *3.386* | *4.213* | | | | | | | *3.150* | *.413* | | *16.142* | | *3.150* | *1015* | | | |
| 106.00 | 137.00 | 11 | 1/4 | C6 | 3 | 1 | 825D-137TC11U-C6M | 63.00 | 15.50 | | 400.00 | 64.00 | 100.00 | 70 | 9.809 | 1 | TCMT 11 03 04 |
| *4.173* | *5.394* | | | | | | | *2.480* | *.610* | | *15.748* | *2.520* | *3.937* | *1015* | | | |
| 106.00 | 137.00 | 11 | 1/4 | C8 | 3 | 1 | 825D-137TC11U-C8M | 80.00 | 15.50 | | 500.00 | 81.00 | 100.00 | 70 | 18.199 | 1 | TCMT 11 03 04 |
| *4.173* | *5.394* | | | | | | | *3.150* | *.610* | | *19.685* | *3.189* | *3.937* | *1015* | | | |
| 106.00 | 137.00 | 11 | 1/4 | C8 | 3 | 1 | 825D-137TC11U-C8S | 80.00 | 15.50 | | 400.00 | 81.00 | 100.00 | 70 | 15.759 | 1 | TCMT 11 03 04 |
| *4.173* | *5.394* | | | | | | | *3.150* | *.610* | | *15.748* | *3.189* | *3.937* | *1015* | | | |
| 136.00 | 167.00 | 11 | 1/4 | C8 | 3 | 1 | 825D-167TC11U-C8S | 80.00 | 15.50 | | 500.00 | 81.00 | 130.00 | 70 | 18.359 | 1 | TCMT 11 03 04 |
| *5.354* | *6.575* | | | | | | | *3.150* | *.610* | | *19.685* | *3.189* | *5.118* | *1015* | | | |

Diameters are valid when frontboring.

For more information about backboring, see page K98

For more information about the use of slide extensions, see page K95

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

For inserts, see Turning catalog

For all DSGN 2; LU = DC*ULDR

L2 N22 N15 K94

# 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 (11.732–50.197 inch) is made of high-strength aluminum, 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 applications (rough boring, fine boring, face grooving, spiro-grooving and interpolation turning)

www.sandvik.coromant.com/corobore825

SilentTools®

### Tools

Couplings:
- Coromant Capto®
- Arbor

### Inserts

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

### Diameter adjustment:

825 - Adjusts diameter 0.002 mm (.000079 inch) with a nonius scale. A 360° turn changes the diameter by 0.5 mm (.020 inch).

826 - Each click adjusts the diameter by 0.002 mm (.000079 inch). A 360° turn changes the diameter by 0.1 mm (.0039 inch). Total diameter change on fine boring head 1.3 mm (.051 inch).

High precision coolant nozzle for precise coolant flow to cutting edge

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

Use the same bridge/bridge extension for roughing and finishing from diameters of 150 mm (5.906 inch) (counterweight needed for finishing).

Use slide extensions for radial adjustment and back boring

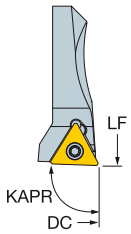
# CoroBore® 825 XL fine boring tool

**Coromant Capto® - Internal coolant supply**

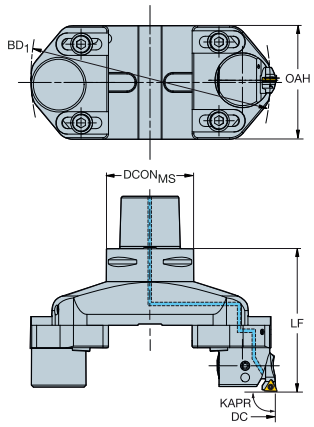
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| DCN | DCX | | IC | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | LF | OAH | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 215.00 | 11 | 1/4 | C6 | 3 | **825-215TC11-C6** | 63.00 | 33.50 | 118.00 | 104.00 | 145.00 | 70 | 4.534 | 1 | TCMT 11 03 04 |
| *5.827* | *8.465* | | | | | | *2.480* | *1.319* | *4.646* | *4.094* | *5.709* | *1015* | | | |
| 148.00 | 215.00 | 11 | 1/4 | C8 | 3 | **825-215TC11-C8** | 80.00 | 33.50 | 130.00 | 104.00 | 145.00 | 70 | 7.500 | 1 | TCMT 11 03 04 |
| *5.827* | *8.465* | | | | | | *3.150* | *1.319* | *5.118* | *4.094* | *5.709* | *1015* | | | |
| 148.00 | 215.00 | 11 | 1/4 | C10 | 3 | **825-215TC11-C10** | 100.00 | 33.50 | 136.00 | 104.00 | 145.00 | 70 | 9.460 | 1 | TCMT 11 03 04 |
| *5.827* | *8.465* | | | | | | *3.937* | *1.319* | *5.354* | *4.094* | *5.709* | *1015* | | | |
| 198.00 | 265.00 | 11 | 1/4 | C6 | 3 | **825-265TC11-C6** | 63.00 | 33.50 | 118.00 | 104.00 | 195.00 | 70 | 4.750 | 1 | TCMT 11 03 04 |
| *7.795* | *10.433* | | | | | | *2.480* | *1.319* | *4.646* | *4.094* | *7.677* | *1015* | | | |
| 198.00 | 265.00 | 11 | 1/4 | C8 | 3 | **825-265TC11-C8** | 80.00 | 33.50 | 130.00 | 104.00 | 195.00 | 70 | 9.100 | 1 | TCMT 11 03 04 |
| *7.795* | *10.433* | | | | | | *3.150* | *1.319* | *5.118* | *4.094* | *7.677* | *1015* | | | |
| 198.00 | 265.00 | 11 | 1/4 | C10 | 3 | **825-265TC11-C10** | 100.00 | 33.50 | 136.00 | 104.00 | 195.00 | 70 | 10.850 | 1 | TCMT 11 03 04 |
| *7.795* | *10.433* | | | | | | *3.937* | *1.319* | *5.354* | *4.094* | *7.677* | *1015* | | | |
| 248.00 | 315.00 | 11 | 1/4 | C6 | 3 | **825-315TC11-C6** | 63.00 | 33.50 | 118.00 | 104.00 | 245.00 | 70 | 5.400 | 1 | TCMT 11 03 04 |
| *9.764* | *12.402* | | | | | | *2.480* | *1.319* | *4.646* | *4.094* | *9.646* | *1015* | | | |
| 248.00 | 315.00 | 11 | 1/4 | C8 | 3 | **825-315TC11-C8** | 80.00 | 33.50 | 130.00 | 104.00 | 245.00 | 70 | 10.350 | 1 | TCMT 11 03 04 |
| *9.764* | *12.402* | | | | | | *3.150* | *1.319* | *5.118* | *4.094* | *9.646* | *1015* | | | |
| 248.00 | 315.00 | 11 | 1/4 | C10 | 3 | **825-315TC11-C10** | 100.00 | 33.50 | 136.00 | 104.00 | 245.00 | 70 | 12.570 | 1 | TCMT 11 03 04 |
| *9.764* | *12.402* | | | | | | *3.937* | *1.319* | *5.354* | *4.094* | *9.646* | *1015* | | | |

Diameters are valid when frontboring.

For more information about external boring, see page K100
For more information about backboring, see page K98
For more information about the use of slide extensions, see page K98

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

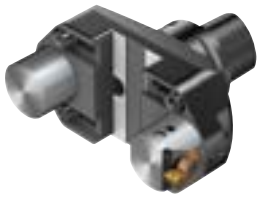
L2 N22 N15 K96



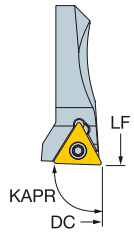
SANDVIK Coromant

# CoroBore® 826 XL fine boring tool

**Coromant Capto® - Internal coolant supply**



KAPR
STDNO

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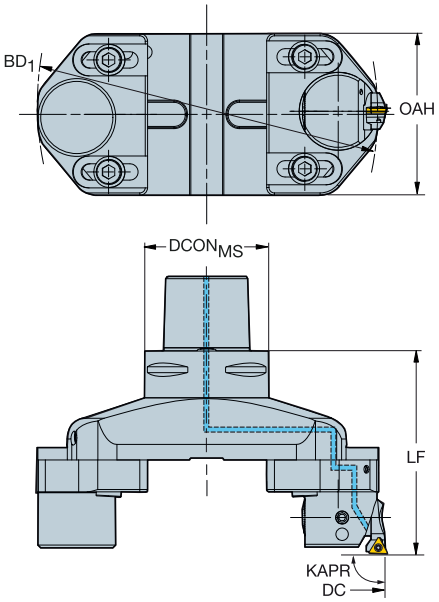
ISO26623-1



TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | 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 |
| 6.077 | 8.175 | | | | | | 2.480 | 1.049 | 4.921 | 4.094 | 5.709 | 1015 | | | |
| 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 |
| 6.077 | 8.175 | | | | | | 3.150 | 1.049 | 5.394 | 4.094 | 5.709 | 1015 | | | |
| 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 |
| 8.045 | 10.144 | | | | | | 2.480 | 1.049 | 4.921 | 4.094 | 7.677 | 1015 | | | |
| 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 |
| 8.045 | 10.144 | | | | | | 3.150 | 1.049 | 5.394 | 4.094 | 7.677 | 1015 | | | |
| 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 |
| 10.014 | 12.112 | | | | | | 2.480 | 1.049 | 4.921 | 4.094 | 9.646 | 1015 | | | |
| 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 |
| 10.014 | 12.112 | | | | | | 3.150 | 1.049 | 5.394 | 4.094 | 9.646 | 1015 | | | |

Diameters are valid when frontboring.
Backboring is not recommended with CoroBore® 826
For more information about the use of slide extensions, see page K98
For more information about external boring, see page K100
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning catalog

L2 N22 N15 K96

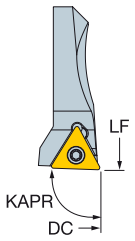
# CoroBore® 825 XL lightweight fine boring tool

**Arbor - Internal coolant supply**

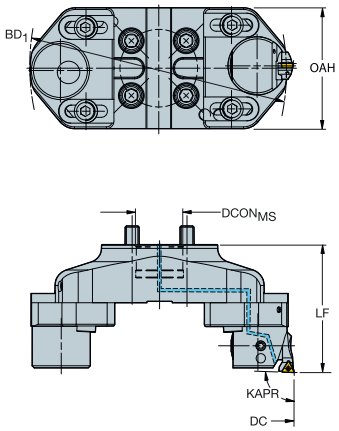
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | ISO | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 215.00 | 11 | 1/4 | 40S | 1 | **825L-215TC11** | 40.00 | C | 33.50 | 110.00 | 104.00 | 145.00 | 70 | 4.450 | 1 | TCMT 11 03 04 |
| *5.827* | *8.465* | | | | | | *1.575* | | *1.319* | *4.331* | *4.094* | *5.709* | *1015* | | | |
| 198.00 | 265.00 | 11 | 1/4 | 40S | 1 | **825L-265TC11** | 40.00 | C | 33.50 | 110.00 | 104.00 | 195.00 | 70 | 4.920 | 1 | TCMT 11 03 04 |
| *7.795* | *10.433* | | | | | | *1.575* | | *1.319* | *4.331* | *4.094* | *7.677* | *1015* | | | |
| 248.00 | 315.00 | 11 | 1/4 | 40S | 1 | **825L-315TC11** | 40.00 | C | 33.50 | 110.00 | 104.00 | 245.00 | 70 | 5.370 | 1 | TCMT 11 03 04 |
| *9.764* | *12.402* | | | | | | *1.575* | | *1.319* | *4.331* | *4.094* | *9.646* | *1015* | | | |

Use with 40S facemill holders, e.g C8-391.05-40 060M. To be ordered separately.
Diameters are valid when frontboring.
For more information about backboring, see page K98
For more information about the use of slide extensions, see page K98
For more information about external boring, see page K100
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning catalog

L2 N22 N15 K96

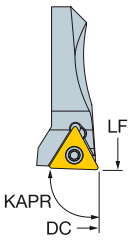
# CoroBore® 826 XL lightweight fine boring tool

**Arbor - Internal coolant supply**

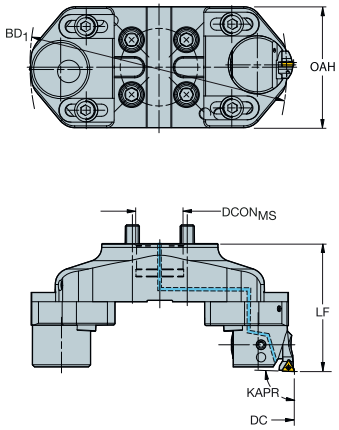
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | ISO | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 154.35 | 207.65 | 11 | 1/4 | 40S | 1 | **826L-207TC11HP** | 40.00 | C | 26.65 | 117.00 | 104.00 | 145.00 | 70 | 3.310 | 1 | TCMT 11 03 04 |
| *6.077* | *8.175* | | | | | | *1.575* | | *1.049* | *4.606* | *4.094* | *5.709* | *1015* | | | |
| 204.35 | 257.65 | 11 | 1/4 | 40S | 1 | **826L-257TC11HP** | 40.00 | C | 26.65 | 117.00 | 104.00 | 195.00 | 70 | 3.650 | 1 | TCMT 11 03 04 |
| *8.045* | *10.144* | | | | | | *1.575* | | *1.049* | *4.606* | *4.094* | *7.677* | *1015* | | | |
| 254.35 | 307.65 | 11 | 1/4 | 40S | 1 | **826L-307TC11HP** | 40.00 | C | 26.65 | 117.00 | 104.00 | 245.00 | 70 | 4.320 | 1 | TCMT 11 03 04 |
| *10.014* | *12.112* | | | | | | *1.575* | | *1.049* | *4.606* | *4.094* | *9.646* | *1015* | | | |

Use with 40S facemill holders, e.g C8-391.05-40 060M. To be ordered separately.
Backboring is not recommended with CoroBore® 826
For more information about external boring, see page K100
For more information about the use of slide extensions, see page K98
Diameters are valid when frontboring.

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

L2 N22 N15 K96

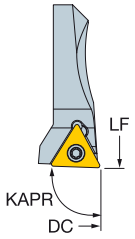
# CoroBore® 825 XL lightweight fine boring tool

**Coromant Capto® - Internal coolant supply**

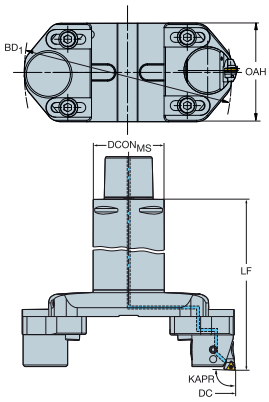
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| DCN | DCX | | IC | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | LF | OAH | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 215.00 | 11 | 1/4 | C8 | 3 | **825L-215TC11-C8** | 80.00 | 33.50 | 230.00 | 104.00 | 145.00 | 70 | 7.640 | 1 | TCMT 11 03 04 |
| *5.827* | *8.465* | | | | | | *3.150* | *1.319* | *9.055* | *4.094* | *5.709* | *1015* | | | |
| 198.00 | 265.00 | 11 | 1/4 | C8 | 3 | **825L-265TC11-C8** | 80.00 | 33.50 | 230.00 | 104.00 | 195.00 | 70 | 8.320 | 1 | TCMT 11 03 04 |
| *7.795* | *10.433* | | | | | | *3.150* | *1.319* | *9.055* | *4.094* | *7.677* | *1015* | | | |
| 248.00 | 315.00 | 11 | 1/4 | C8 | 3 | **825L-315TC11-C8** | 80.00 | 33.50 | 230.00 | 104.00 | 245.00 | 70 | 8.680 | 1 | TCMT 11 03 04 |
| *9.764* | *12.402* | | | | | | *3.150* | *1.319* | *9.055* | *4.094* | *9.646* | *1015* | | | |

Diameters are valid when frontboring.

For more information about external boring, see page K100
For more information about backboring, see page K98
For more information about the use of slide extensions, see page K98

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

For inserts, see Turning catalog

L2 N22 N15 K96

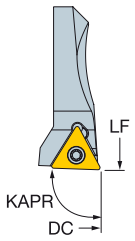
# CoroBore® 826 XL lightweight fine boring tool

**Coromant Capto® - Internal coolant supply**

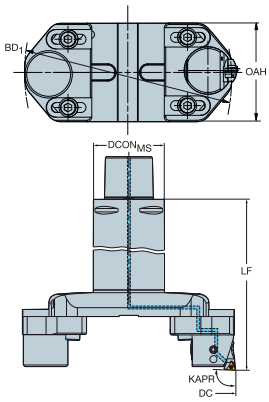
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| DCN | DCX | ↔ | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 154.35 | 207.65 | 11 | 1/4 | C8 | 3 | **826L-207TC11-C8HP** | 80.00 | 26.65 | 237.00 | 104.00 | 145.00 | 70 | 6.300 | 1 | TCMT 11 03 04 |
| *6.077* | *8.175* | | | | | | *3.150* | *1.049* | *9.331* | *4.094* | *5.709* | *1015* | | | |
| 204.35 | 257.65 | 11 | 1/4 | C8 | 3 | **826L-257TC11-C8HP** | 80.00 | 26.65 | 237.00 | 104.00 | 195.00 | 70 | 6.660 | 1 | TCMT 11 03 04 |
| *8.045* | *10.144* | | | | | | *3.150* | *1.049* | *9.331* | *4.094* | *7.677* | *1015* | | | |
| 254.35 | 307.65 | 11 | 1/4 | C8 | 3 | **826L-307TC11-C8HP** | 80.00 | 26.65 | 237.00 | 104.00 | 245.00 | 70 | 7.030 | 1 | TCMT 11 03 04 |
| *10.014* | *12.112* | | | | | | *3.150* | *1.049* | *9.331* | *4.094* | *9.646* | *1015* | | | |

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K100
For more information about the use of slide extensions, see page K98

Diameters are valid when frontboring.

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

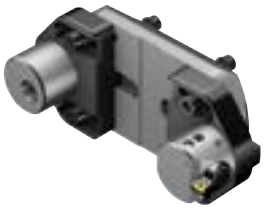
For inserts, see Turning catalog

L2 N22 N15 K96

# CoroBore® 825 XL fine boring tool

**Arbor - Internal coolant supply**

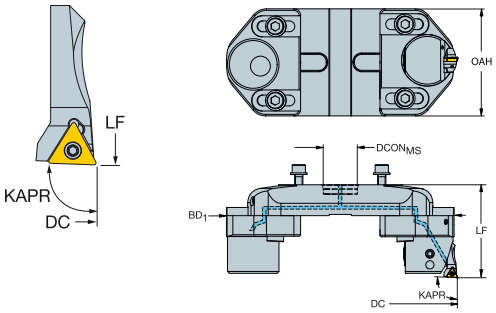
**Dedicated for Silent Tools™ boring**



TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR 92°




| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 148.00 | 215.00 | 11 | 1/4 | 33 | 1 | **825D-215TC11** | 33.00 | 33.50 | 90.00 | 104.00 | 145.00 | 70 | 2.620 | 1 | TCMT 11 03 04 |
| *5.827* | *8.465* | | | | | | *1.299* | *1.319* | *3.543* | *4.094* | *5.709* | *1015* | | | |
| 198.00 | 265.00 | 11 | 1/4 | 33 | 1 | **825D-265TC11** | 33.00 | 33.50 | 90.00 | 104.00 | 195.00 | 70 | 2.940 | 1 | TCMT 11 03 04 |
| *7.795* | *10.433* | | | | | | *1.299* | *1.319* | *3.543* | *4.094* | *7.677* | *1015* | | | |
| 248.00 | 315.00 | 11 | 1/4 | 33 | 1 | **825D-315TC11** | 33.00 | 33.50 | 90.00 | 104.00 | 245.00 | 70 | 4.190 | 1 | TCMT 11 03 04 |
| *9.764* | *12.402* | | | | | | *1.299* | *1.319* | *3.543* | *4.094* | *9.646* | *1015* | | | |

Diameters are valid when frontboring.

For more information about external boring, see page K100

For more information about backboring, see page K98

For more information about the use of slide extensions, see page K98

These lightweight assemblies are dedicated for use with damped boring adapters. Damped adapters are bought separately; see page K82.

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

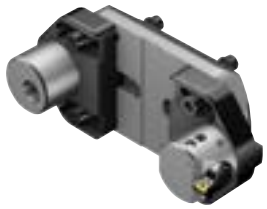
For inserts, see Turning catalog

L2 N22 N15 K96

# CoroBore® 826 XL fine boring tool

**Arbor - Internal coolant supply**

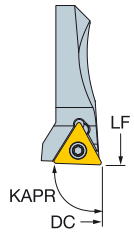
**Dedicated for Silent Tools™ boring**



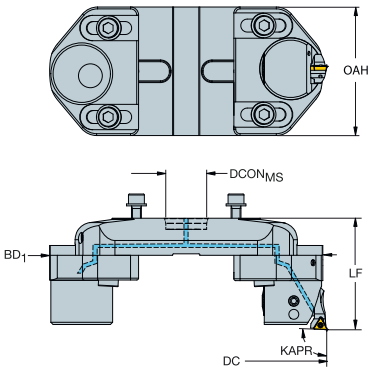
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| DCN | DCX | ↔ | ↔IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 154.35 | 207.65 | 11 | 1/4 | 33 | 1 | **826D-207TC11HP** | 33.00 | 26.65 | 97.00 | 104.00 | 145.00 | 70 | 2.770 | 1 | TCMT 11 03 04 |
| *6.077* | *8.175* | | | | | | *1.299* | *1.049* | *3.819* | *4.094* | *5.709* | *1015* | | | |
| 204.35 | 257.65 | 11 | 1/4 | 33 | 1 | **826D-257TC11HP** | 33.00 | 26.65 | 97.00 | 104.00 | 195.00 | 70 | 3.110 | 1 | TCMT 11 03 04 |
| *8.045* | *10.144* | | | | | | *1.299* | *1.049* | *3.819* | *4.094* | *7.677* | *1015* | | | |
| 254.35 | 307.65 | 11 | 1/4 | 33 | 1 | **826D-307TC11HP** | 33.00 | 26.65 | 97.00 | 104.00 | 245.00 | 70 | 3.470 | 1 | TCMT 11 03 04 |
| *10.014* | *12.112* | | | | | | *1.299* | *1.049* | *3.819* | *4.094* | *9.646* | *1015* | | | |

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K100

For more information about the use of slide extensions, see page K98

These lightweight assemblies are dedicated for use with damped boring adapters. Damped adapters are bought separately; see page K82.

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

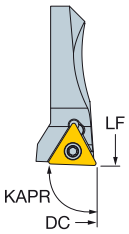
For inserts, see Turning catalog

L2 N22 N15 K96

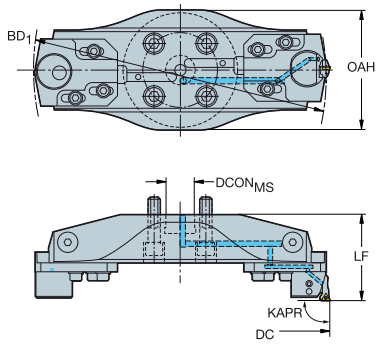
# CoroBore® 825 XL fine boring tool

**Arbor - Internal coolant supply**

KAPR




92°




TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

| DCN | DCX | ⟷ | IC | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | LF | OAH | BD$_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 298.00 | 395.00 | 11 | 1/4 | 40X | 1 | **825-395TC11** | 40.00 | 48.50 | 114.00 | 164.00 | 295.00 | 70 | 10.385 | 1 | TCMT 11 03 04 |
| *11.732* | *15.551* | | | | | | *1.575* | *1.909* | *4.488* | *6.457* | *11.614* | *1015* | | | |
| 378.00 | 475.00 | 11 | 1/4 | 40X | 1 | **825-475TC11** | 40.00 | 48.50 | 119.00 | 164.00 | 375.00 | 70 | 12.280 | 1 | TCMT 11 03 04 |
| *14.882* | *18.701* | | | | | | *1.575* | *1.909* | *4.685* | *6.457* | *14.764* | *1015* | | | |
| 458.00 | 555.00 | 11 | 1/4 | 40X | 1 | **825-555TC11** | 40.00 | 48.50 | 124.00 | 164.00 | 455.00 | 70 | 16.400 | 1 | TCMT 11 03 04 |
| *18.032* | *21.850* | | | | | | *1.575* | *1.909* | *4.882* | *6.457* | *17.913* | *1015* | | | |

Diameters are valid when frontboring.

For more information about external boring, see page K100
For more information about backboring, see page K98
For more information about the use of slide extensions, see page K98

Use with 40X CoroBore® XL holders only. To be ordered separately. See page K80.

In the case of a direct flange to the machine spindle, use a centering plug. See page K82

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

For inserts, see Turning catalog

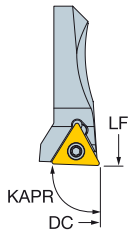
L2 N22 N15 K96

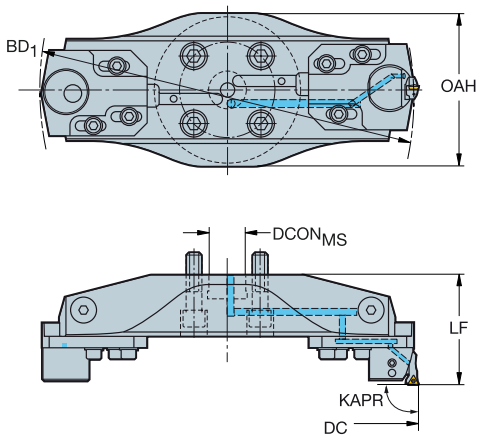
# CoroBore® 826 XL fine boring tool

**Arbor - Internal coolant supply**

TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW




| DCN | DCX | ↔ | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 304.35 | 387.65 | 11 | 1/4 | 40X | 1 | **826-387TC11HP** | 40.00 | 41.65 | 121.00 | 164.00 | 295.00 | 70 | 8.870 | 1 | TCMT 11 03 04 |
| 11.982 | 15.262 | | | | | | 1.575 | 1.640 | 4.764 | 6.457 | 11.614 | 1015 | | | |
| 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 |
| 15.132 | 18.411 | | | | | | 1.575 | 1.640 | 4.961 | 6.457 | 14.764 | 1015 | | | |
| 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 |
| 18.282 | 21.561 | | | | | | 1.575 | 1.640 | 5.157 | 6.457 | 17.913 | 1015 | | | |

Diameters are valid when frontboring.
Backboring is not recommended with CoroBore® 826
For more information about external boring, see page K100
For more information about the use of slide extensions, see page K98
Use with 40X CoroBore® XL holders only. To be ordered separately. See page K80.
In the case of a direct flange to the machine spindle, use a centering plug. See page K82

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

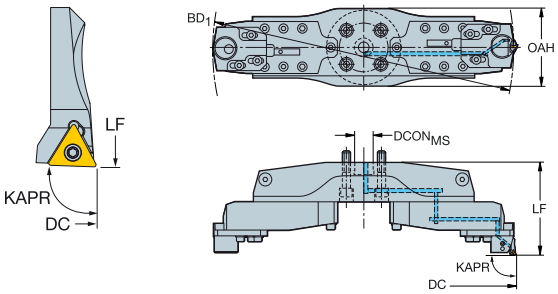
K80 N22 N15 K96

# CoroBore® 825 XL fine boring tool

**Arbor - Internal coolant supply**

**With bridge extension**

KAPR 92°



TCMT, TCMX, TCGT, TCGX TCEX

TCMW

| DCN | DCX | | IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 538.00 | 795.00 | 11 | 1/4 | 40X | 1 | **825-795TC11** | 40.00 | 128.50 | 198.00 | 164.00 | 535.00 | 70 | 25.640 | 1 | TCMT 11 03 04 |
| *21.181* | *31.299* | | | | | | *1.575* | *5.059* | *7.795* | *6.457* | *21.063* | *1015* | | | |
| 778.00 | 1035.00 | 11 | 1/4 | 40X | 1 | **825-1035TC11** | 40.00 | 128.50 | 218.00 | 164.00 | 775.00 | 70 | 36.830 | 1 | TCMT 11 03 04 |
| *30.630* | *40.748* | | | | | | *1.575* | *5.059* | *8.583* | *6.457* | *30.512* | *1015* | | | |
| 1018.00 | 1275.00 | 11 | 1/4 | 40X | 1 | **825-1275TC11** | 40.00 | 128.50 | 218.00 | 164.00 | 1015.00 | 70 | 44.260 | 1 | TCMT 11 03 04 |
| *40.079* | *50.197* | | | | | | *1.575* | *5.059* | *8.583* | *6.457* | *39.961* | *1015* | | | |

Diameters are valid when frontboring.

For more information about external boring, see page K100
For more information about backboring, see page K98
For more information about the use of slide extensions, see page K98

Use with 40X CoroBore® XL holders only. To be ordered separately. See page K80.

In the case of a direct flange to the machine spindle, use a centering plug. See page K82

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

For inserts, see Turning catalog

L2 N22 N15 K96

# CoroBore® 826 XL fine boring tool

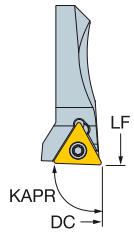
**Arbor - Internal coolant supply**

**With bridge extension**

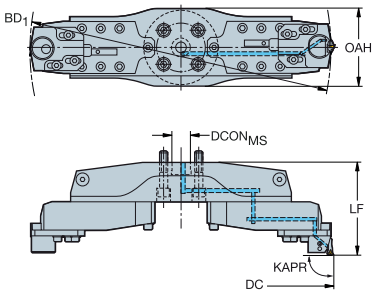
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR




92°




| DCN | DCX | ⟷ | ⟷IC | $CZC_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $ADJLX_{RDL}$ | LF | OAH | $BD_1$ | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 544.35 | 787.65 | 11 | 1/4 | 40X | 1 | **826-787TC11HP** | 40.00 | 121.65 | 205.00 | 164.00 | 535.00 | 70 | 24.430 | 1 | TCMT 11 03 04 |
| *21.431* | *31.010* | | | | | | *1.575* | *4.789* | *8.071* | *6.457* | *21.063* | *1015* | | | |
| 784.35 | 1027.65 | 11 | 1/4 | 40X | 1 | **826-1027TC11HP** | 40.00 | 121.65 | 225.00 | 164.00 | 775.00 | 70 | 35.060 | 1 | TCMT 11 03 04 |
| *30.880* | *40.459* | | | | | | *1.575* | *4.789* | *8.858* | *6.457* | *30.512* | *1015* | | | |
| 1024.35 | 1267.65 | 11 | 1/4 | 40X | 1 | **826-1267TC11HP** | 40.00 | 121.65 | 225.00 | 164.00 | 1015.00 | 70 | 44.110 | 1 | TCMT 11 03 04 |
| *40.329* | *49.908* | | | | | | *1.575* | *4.789* | *8.858* | *6.457* | *39.961* | *1015* | | | |

Diameters are valid when frontboring.

Backboring is not recommended with CoroBore® 826

For more information about external boring, see page K100

For more information about the use of slide extensions, see page K98

Use with 40X CoroBore® XL holders only. To be ordered separately. See page K80.

In the case of a direct flange to the machine spindle, use a centering plug. See page K82

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

For inserts, see Turning catalog

L2

N22

N15

K96

# Face grooving

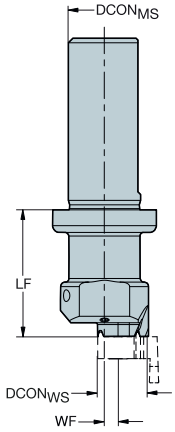
| | Diameter range, mm (inch) | Hole tolerance | Cutting edges | Operation | Insert choice | Coupling type | Page |
|---|---|---|---|---|---|---|---|
| **CoroCut® MB** | 14-50 (.551-1.969) | IT7 | 1 | - Face grooving | - CoroCut® MB | - Coromant Capto® | K71 |
| **CoroBore® 825 SL** | 47-150 (1.850-5.906) | IT7 | 1 | - Face grooving | - CoroCut® | - Coromant Capto® | K72 |
| **CoroBore® 825 SL XL** | 148-1275 (5.827-50.197) | IT7 | 1 | - Face grooving | - CoroCut® | - Coromant Capto®<br>- 40X with 4 bolt circle | K73-K74 |
| **SpiroGrooving™** | 30-289 (1.181-11.378) | | 1 (internal and external) | - SpiroGrooving™ | - CoroTurn® 107 | - Coromant Capto® | K75-K77 |

# Cylindrical shank to CoroCut® MB adapter

**For face grooving**

**Internal coolant supply**

MB...FA




| | | | | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | WF | BAR PSI | KG |
| 16 | 09 | 1 | R429U-A16-14032MB09 | 16.00 | 9.00 | 32.00 | -2.00 | 20 | 0.115 |
| | | | | *.630* | *.354* | *1.260* | *-.079* | *290* | |
| 16 | 09 | 1 | R429U-A16-19030MB09 | 16.00 | 9.00 | 30.00 | 0.50 | 20 | 0.114 |
| | | | | *.630* | *.354* | *1.181* | *.020* | *290* | |
| 16 | 09 | 1 | R429U-A16-24028MB09 | 16.00 | 9.00 | 28.00 | 3.00 | 20 | 0.120 |
| | | | | *.630* | *.354* | *1.102* | *.118* | *290* | |
| 16 | 09 | 1 | R429U-A16-29026MB09 | 16.00 | 9.00 | 26.00 | 5.50 | 20 | 0.120 |
| | | | | *.630* | *.354* | *1.024* | *.217* | *290* | |
| 16 | 09 | 1 | R429U-A16-34024MB09 | 16.00 | 9.00 | 24.00 | 8.00 | 20 | 0.129 |
| | | | | *.630* | *.354* | *.945* | *.315* | *290* | |
| 16 | 09 | 1 | R429U-A16-39022MB09 | 16.00 | 9.00 | 22.00 | 10.50 | 20 | 0.145 |
| | | | | *.630* | *.354* | *.866* | *.413* | *290* | |
| 16 | 09 | 1 | R429U-A16-44020MB09 | 16.00 | 9.00 | 20.00 | 13.00 | 20 | 0.153 |
| | | | | *.630* | *.354* | *.787* | *.512* | *290* | |

For CoroCut® MB cutting tools, see Turning Tools catalog

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

Recommended adapters:

A16: 391.37A

L2

N22

N15

# CoroBore® 825 SL

## Face grooving

### Application

- Face grooving
- Axial grooving

### ISO application area

P M K N S H

### Benefits and features

- Increased productivity compared to milling
- Excellent chip control thanks to internal coolant at the cutting edge
- Builds on our large assortment of standard CoroTurn® SL heads and CoroCut® system 1-2 inserts. ( Type left hand, A-curve )
- Radial, fine-adjustable, face grooving heads for pre-setting
- Rigid design with dedicated tools for small and large diameter face grooving
- Internal coolant

### Tools

Couplings:
- Coromant Capto®
- Arbor

### Inserts

- CoroCut® 1-2 system inserts
- Dedicated grades and geometries for all materials

* CoroTurn® SL head and inserts are ordered separately.

825 - Adjusts diameter 0.002 mm (.000079 inch) with a nonius scale. A 360° turn changes the diameter by 0.5 mm (.020 inch).

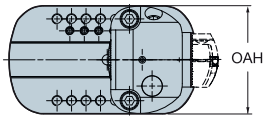
Radially fine adjustable face grooving heads for pre-setting with same interface as CoroBore 825 fine boring head

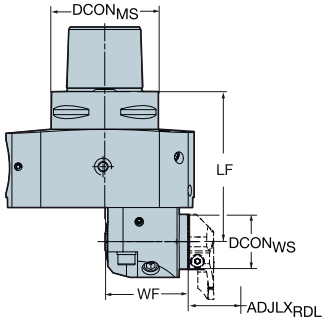
First choice geometries: -CM or -TF depending on chosen nose radius. Recommended starting value for feed: 0.15 mm/rev (.006 inch/rev)

If grooves with greater width tolerance are required, chose -GF geometry. Recommended starting value for feed: 0.10 mm/rev (.004 inch/rev)

# Coromant Capto® to CoroTurn® SL adjustable adapter

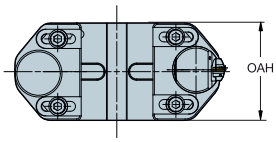
**Coromant Capto® - Internal coolant supply**

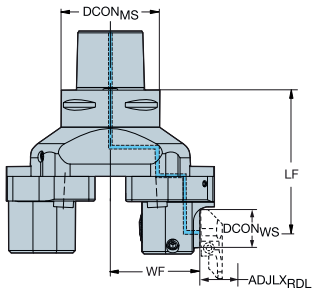



## CoroBore® 825 fine adjustment

| | | | | Dimensions, mm, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | $ADJLX_{RDL}$ | LF | LPR | WF | OAH | OAW | BAR PSI | 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 |
| | | | | *2.480* | *1.260* | *2.028* | *3.465* | *4.291* | *.217* | *2.496* | *4.173* | *290* | |
| 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 |
| | | | | *3.150* | *1.260* | *2.028* | *3.780* | *4.606* | *.217* | *3.165* | *4.173* | *290* | |




## CoroBore® 825 XL

| | | | | Dimensions, mm, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | $ADJLX_{RDL}$ | LF | LPR | WF | OAH | OAW | BAR PSI | 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 |
| | | | | *3.150* | *1.260* | *1.319* | *4.409* | *5.236* | *2.205* | *4.094* | *5.118* | *290* | |
| 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 |
| | | | | *3.150* | *1.260* | *1.319* | *4.409* | *5.236* | *3.189* | *4.094* | *7.087* | *290* | |
| 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 |
| | | | | *3.150* | *1.260* | *1.319* | *4.409* | *5.236* | *4.173* | *4.094* | *9.055* | *290* | |

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

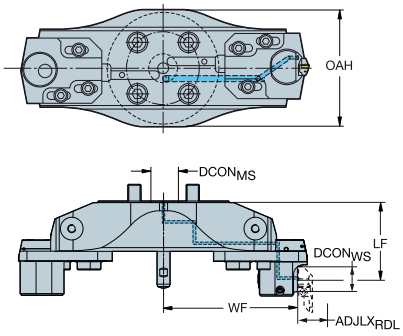
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com

L2 N22 N15

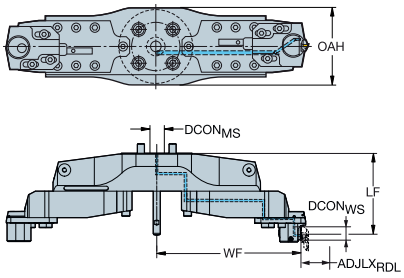
# Arbor to CoroTurn® SL adjustable adapter

**Arbor - Internal coolant supply**

STDNO ISO 6462




| CZCMS | CZCWS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | DCONWS | ADJLXRDL | LF | LPR | WF | OAH | OAW | BAR PSI | 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 |
| | | | | *1.575* | *1.260* | *1.909* | *3.780* | *4.606* | *5.157* | *6.457* | *13.150* | *290* | |
| 40X | 32 | 1 | **825-475SL32** | 40.00 | 32.00 | 48.50 | 101.00 | 122.00 | 171.00 | 164.00 | 414.00 | 20 | 12.830 |
| | | | | *1.575* | *1.260* | *1.909* | *3.976* | *4.803* | *6.732* | *6.457* | *16.299* | *290* | |
| 40X | 32 | 1 | **825-555SL32** | 40.00 | 32.00 | 48.50 | 106.00 | 127.00 | 211.00 | 104.00 | 494.00 | 20 | 12.670 |
| | | | | *1.575* | *1.260* | *1.909* | *4.173* | *5.000* | *8.307* | *4.094* | *19.449* | *290* | |




**With bridge extension**

| CZCMS | CZCWS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | DCONWS | ADJLXRDL | LF | LPR | WF | OAH | OAW | BAR PSI | 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 |
| | | | | *1.575* | *1.260* | *5.059* | *7.874* | *8.701* | *14.606* | *6.457* | *32.992* | *290* | |
| 40X | 32 | 1 | **825-1275SL32** | 40.00 | 32.00 | 128.50 | 200.00 | 221.00 | 491.00 | 164.00 | 1078.00 | 20 | 43.740 |
| | | | | *1.575* | *1.260* | *5.059* | *7.874* | *8.701* | *19.331* | *6.457* | *42.441* | *290* | |
| 40X | 32 | 1 | **825-795SL32** | 40.00 | 32.00 | 128.50 | 180.00 | 201.00 | 251.00 | 164.00 | 598.00 | 20 | 25.120 |
| | | | | *1.575* | *1.260* | *5.059* | *7.087* | *7.913* | *9.882* | *6.457* | *23.543* | *290* | |

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

Use with 40X CoroBore® XL holders only. To be ordered separately. See page K80.
In the case of a direct flange to the machine spindle, use a centering plug. See page K82
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com

L2 N22 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 for programming 'mid-tolerance' sizes for depth & diameter.
- Transfer the generated NC-code to the machine controller

### 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 thanks 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

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 sizes 30–75 mm (1.181–2.953 inch)
- CoroTurn® 107 inserts (VBMT) for sizes 48–289 mm (1.890–11.378 inch)

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 behavior, 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.

**Do you have questions about programming?**

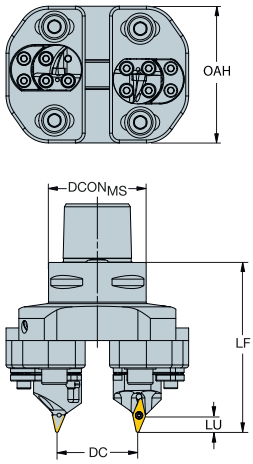
With the SpiroGrooving™ NC-code generator, you can get your NC code in a few quick steps.
NC-code generator – Input groove geometry and cutting parameters to receive an NC-code

# 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, inch DCON$_{MS}$ | ADJLX$_{RDL}$ | LU | LF | OAH | BAR PSI | NM | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.00 | 75.60 | 11 | 1/4 | C5 | 1 | **820-75VC11X-C5** | 50.00 | 22.80 | 9.00 | 87.00 | 70.00 | 80 | 3.0 | 2.655 | 1 | VBMT 11 03 04 |
| *1.181* | *2.976* | | | | | | *1.969* | *.898* | *.354* | *3.425* | *2.756* | *1160* | | | | |

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

L2 N22 N15



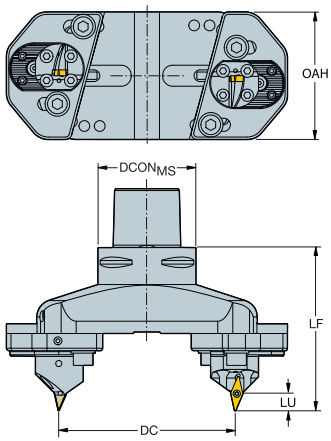
SANDVIK Coromant

# CoroBore® XL adjustable tool for SpiroGrooving™

**Coromant Capto® - Internal coolant supply**

KAPR 67°

VBMT




## Radially and axially adjustable

| DCN | DCX | | | CZCMS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | ADJLXRDL | LU | LF | OAH | BAR PSI | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 48.00 | 139.60 | 16 | 3/8 | C6 | 1 | **820-139VB16X-C6** | 63.00 | 45.80 | 15.00 | 121.00 | 104.00 | 80 | 5.060 | 1 | VBMT 16 04 08 |
| *1.890* | *5.496* | | | | | | *2.480* | *1.803* | *.591* | *4.764* | *4.094* | *1160* | | | |
| 48.00 | 139.60 | 16 | 3/8 | C8 | 1 | **820-139VB16X-C8** | 80.00 | 45.80 | 15.00 | 133.00 | 104.00 | 80 | 6.390 | 1 | VBMT 16 04 08 |
| *1.890* | *5.496* | | | | | | *3.150* | *1.803* | *.591* | *5.236* | *4.094* | *1160* | | | |
| 98.00 | 189.60 | 16 | 3/8 | C6 | 1 | **820-189VB16X-C6** | 63.00 | 45.80 | 15.00 | 121.00 | 104.00 | 80 | 6.210 | 1 | VBMT 16 04 08 |
| *3.858* | *7.465* | | | | | | *2.480* | *1.803* | *.591* | *4.764* | *4.094* | *1160* | | | |
| 98.00 | 189.60 | 16 | 3/8 | C8 | 1 | **820-189VB16X-C8** | 80.00 | 45.80 | 15.00 | 133.00 | 104.00 | 80 | 7.620 | 1 | VBMT 16 04 08 |
| *3.858* | *7.465* | | | | | | *3.150* | *1.803* | *.591* | *5.236* | *4.094* | *1160* | | | |
| 148.00 | 239.60 | 16 | 3/8 | C8 | 1 | **820-239VB16X-C8** | 80.00 | 45.80 | 15.00 | 133.00 | 104.00 | 80 | 8.820 | 1 | VBMT 16 04 08 |
| *5.827* | *9.433* | | | | | | *3.150* | *1.803* | *.591* | *5.236* | *4.094* | *1160* | | | |
| 198.00 | 289.60 | 16 | 3/8 | C8 | 1 | **820-289VB16X-C8** | 80.00 | 45.80 | 15.00 | 133.00 | 104.00 | 80 | 9.860 | 1 | VBMT 16 04 08 |
| *7.795* | *11.402* | | | | | | *3.150* | *1.803* | *.591* | *5.236* | *4.094* | *1160* | | | |

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

For inserts, see Turning Tools catalog

L2 N22 N15

# Interpolation turning

## Turning the unturnable

### Application

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

### ISO application area

P M K N S H

### Benefits and features

- Flexible solution, making it possible to use machining centers with modular tool setups instead of dedicated boring machines with U- or W-axis facing heads
- The component can be machined completely without being moved – especially beneficial for large, non-symmetrical components
- Reduced tool investment cost
- Built on CoroBore® XL – rigid and reliable system for maximum stability when building assemblies for different applications (rough boring, fine boring, face grooving, spiro-grooving and interpolation turning)

### Tools

- Coromant Capto®

### Inserts

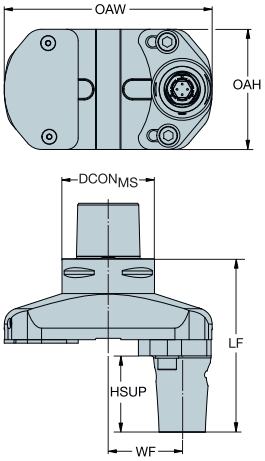
- CoroTurn® 107

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

# Coromant Capto® adjustable adapter with quick change

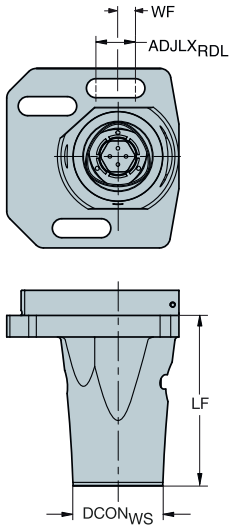
**For Interpolation Turning**

**Internal coolant supply**




| CZCMS | CZCWS | CNSC | Ordering code | Dimensions, mm, inch DCONMS | DCONWS | ADJLXRDL | LF | WF | OAH | OAW | BAR PSI | 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 |
| | | | | *3.150* | *1.575* | *1.024* | *5.906* | *2.008* | *4.094* | *7.087* | *1015* | |
| C8 | C4 | 3 | 820-150C4-QC-C8 | 80.00 | 40.00 | 51.00 | 150.00 | 51.00 | 104.00 | 230.00 | 70 | 9.430 |
| | | | | *3.150* | *1.575* | *2.008* | *5.906* | *2.008* | *4.094* | *9.055* | *1015* | |
| C8 | C4 | 3 | 820-50C4-QC-C8 | 80.00 | 40.00 | 13.50 | 150.00 | 38.50 | 104.00 | 130.00 | 70 | 5.860 |
| | | | | *3.150* | *1.575* | *.531* | *5.906* | *1.516* | *4.094* | *5.118* | *1015* | |

# Slide for CoroBore® XL




| CZCMS | CZCWS | CNSC | Ordering code | Dimensions, mm, inch DCONWS | ADJLXRDL | LF | WF | OAH | OAW | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|
| S24R | C5 | 4 | S24-R820XLC5QC-095 | 50.00 | 22.00 | 95.00 | 9.75 | 100.00 | 96.00 | 70 | 2.350 |
| | | | | 1.969 | .866 | 3.740 | .384 | 3.937 | 3.780 | 1015 | |

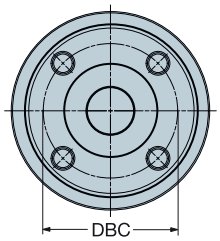
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com

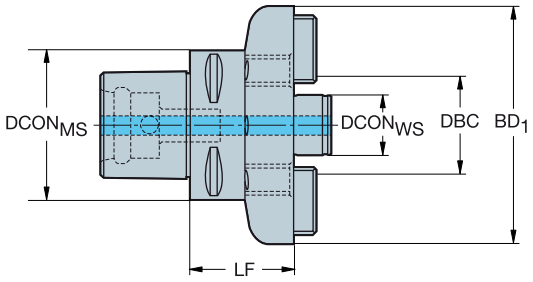
For cutting heads and inserts, see Turning tools catalog

L2 N22 N15

# Coromant Capto® to CoroBore® XL adapter

**Internal coolant supply**

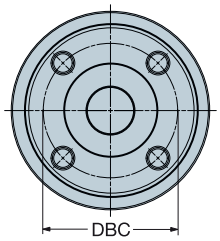


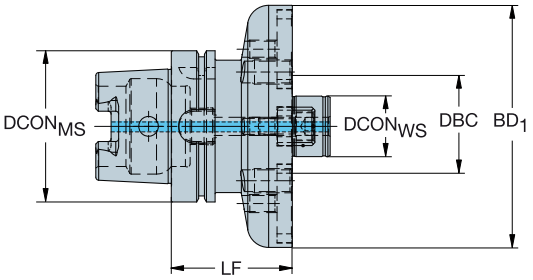




| | | | | | Dimensions, mm, inch | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | DBC | LF | $BD_1$ | BAR PSI | KG |
| C8 | 40X | 1 | 1 | C8-391.XL-40 065 | 80.0 | 40.0 | 101.6 | 65.0 | 160.0 | 80 | 7.09 |
| | | | | | *3.150* | *1.575* | *4.000* | *2.559* | *6.299* | *1160* | |
| C10 | 40X | 1 | 1 | C10-391.XL-40 070 | 100.0 | 40.0 | 101.6 | 70.0 | 160.0 | 80 | 8.67 |
| | | | | | *3.937* | *1.575* | *4.000* | *2.756* | *6.299* | *1160* | |

# HSK to CoroBore® XL adapter

**Internal coolant supply**



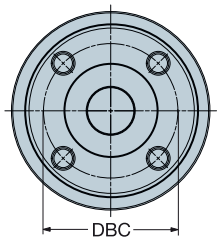

| | | | | | | Dimensions, mm, inch | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | DBC | LF | $BD_1$ | BAR PSI | KG |
| 100.0 | 40X | 1 | 1 | 1 | 392.410XL-10040 080 | 100.0 | 40.0 | 101.6 | 80.0 | 160.0 | 80 | 8.16 |
| | | | | | | *3.937* | *1.575* | *4.000* | *3.150* | *6.299* | *1160* | |

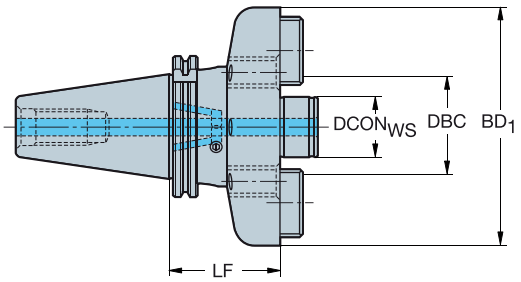
All CoroBore XL solid holders have ground backside of flange and threads for the option to mount a shim to increase stability if needed. Shim needs to be ordered separately and ground to fit the specific machine and holder, see accessories page M11.

N22 N15

# CAT-V to CoroBore® XL adapter

**Internal coolant supply**



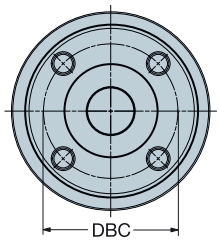



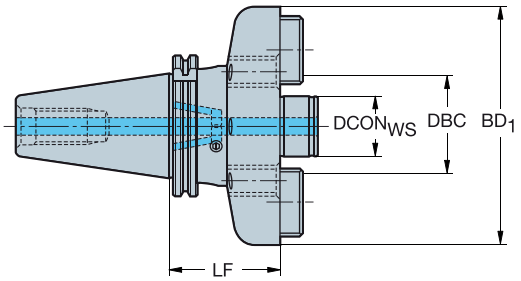

**CAT V-Flange**

| | | | | | | Dimensions, mm, inch | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | DBC | $DCON_{WS}$ | LF | $LB_1$ | $BD_1$ | BAR PSI | KG |
| 50 | 40X | 7 | 1 | 1 | A392.645XL-5040 075 | 101.6 | 40.0 | 75.0 | 75.0 | 160.0 | 20 | 3.38 |
| | | | | | | *4.000* | *1.575* | *2.953* | *2.953* | *6.299* | *290* | |

# ISO 7388-1 to CoroBore® XL adapter

**Internal coolant supply**




**ISO7388.1 / MAS-BT 403**

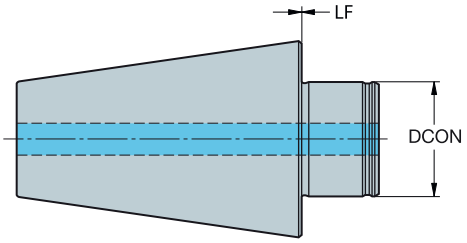
| | | | | | | Dimensions, mm, inch | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | DBC | $DCON_{WS}$ | LF | $LB_1$ | $BD_1$ | BAR PSI | KG |
| 50 | 40X | 7 | 1 | 1 | 392.644XL-5040 075 | 101.6 | 40.0 | 75.0 | 75.0 | 160.0 | 80 | 8.46 |
| | | | | | | *4.000* | *1.575* | *2.953* | *2.953* | *6.299* | *1160* | |
| | 40X | 7 | 1 | 1 | 392.646XL-5040 080 | 101.6 | 40.0 | 80.0 | 80.0 | 160.0 | 80 | 8.46 |
| | | | | | | *4.000* | *1.575* | *3.150* | *3.150* | *6.299* | *1160* | |

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 M11.

N22 N15

# Centering plug

**Internal coolant supply**




## ISO7388.1 / MAS-BT 403

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch LF | BAR PSI | KG |
|---|---|---|---|---|---|---|---|
| 50.0 | 40 plug | 1 | 1 | 392.647XL-5040 | 0.0 | 80 | 2.00 |
| | | | | | *.000* | *1160* | |

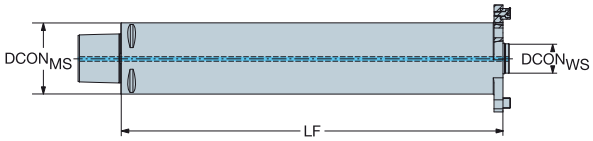
## CAT V-Flange

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch LF | BAR PSI | KG |
|---|---|---|---|---|---|---|---|
| 50 | 40 plug | 1 | 1 | A392.647XL-5040 | 0.0 | 20 | 8.17 |
| | | | | | *.000* | *290* | |

L2 N22 N15

# Coromant Capto® to CoroBore® XL damped tool body

**Internal coolant supply**




SilentTools®

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | BD$_1$ | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|
| C8 | 33 | 3 | C8-R822XLA33-F410 | 80.00 | 33.00 | 410.00 | 80.00 | 70 | 17.800 |
| | | | | 3.150 | 1.299 | 16.142 | 3.150 | 1015 | |
| C10 | 33 | 3 | C10-R822XLA33-F560 | 100.00 | 33.00 | 560.00 | 80.00 | 70 | 26.400 |
| | | | | 3.937 | 1.299 | 22.047 | 3.150 | 1015 | |

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

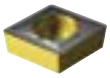
See page K28 for the boring tool kit used with this adapter

L2 N22 N15

# Indexable boring cartridge

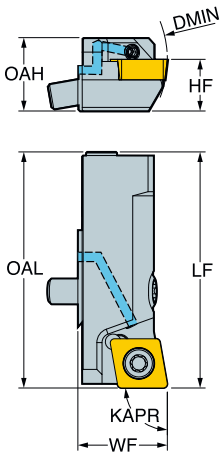
**Axial and radial adjustment**

KAPR 90°



CCMT, CCGT
CCGX, CCET

CCMW

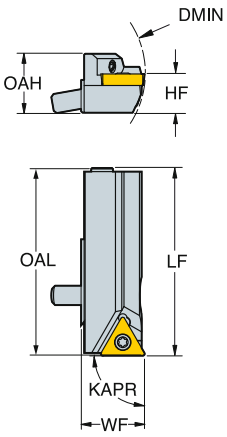



| DMIN1 | | CZCMS | CNSC | Ordering code | Dimensions, mm, inch ADJLXAXL | ADJLXRDL | LF | HF | WF | OAH | OAL | BAR | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 25.0 | 06 | 08CB | 2 | SCFCR08CBX06 | 0.50 | 0.20 | 40.00 | 8.00 | 13.50 | 12.20 | 40.00 | 70 | 0.050 | 1 | CCMT 06 02 04 |
| .984 | | | | | .020 | .008 | 1.575 | .315 | .531 | .480 | 1.575 | 1015 | | | |
| 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 |
| 1.575 | | | | | .020 | .008 | 1.772 | .394 | .650 | .559 | 1.772 | 1015 | | | |
| 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 |
| 1.969 | | | | | .020 | .008 | 1.969 | .472 | .748 | .638 | 1.969 | 1015 | | | |

KAPR 90°

TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW




| DMIN1 | | CZCMS | CNSC | Ordering code | Dimensions, mm, inch 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 |
| .984 | | | | | .020 | .008 | 1.575 | .315 | .531 | .480 | 1.575 | 1015 | | | |
| 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 |
| 1.575 | | | | | .020 | .008 | 1.772 | .394 | .650 | .559 | 1.772 | 1015 | | | |
| 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 |
| 1.969 | | | | | .020 | .008 | 1.969 | .472 | .748 | .638 | 1.969 | 1015 | | | |

For inserts, see Turning catalog

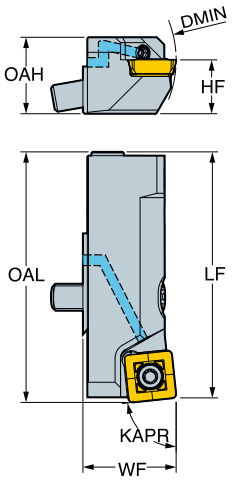
N22 N15

# Indexable boring cartridge

**Axial and radial adjustment**

KAPR 84°

SPMT




| DMIN1 | | CZCMS | CNSC | Ordering code | Dimensions, mm, inch ADJLXAXL | ADJLXRDL | 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 |
| .984 | | | | | .020 | .008 | 1.575 | .315 | .531 | .480 | 1.598 | 1015 | | | |
| 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 |
| 1.575 | | | | | .020 | .008 | 1.772 | .394 | .650 | .559 | 1.803 | 1015 | | | |
| 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 |
| 1.969 | | | | | .020 | .008 | 1.969 | .472 | .748 | .638 | 2.016 | 1015 | | | |

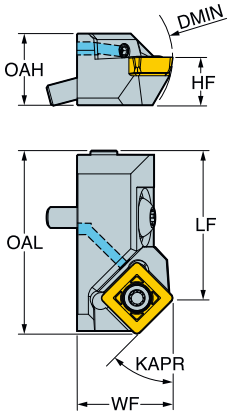
K33 N22 N15

# Indexable boring cartridge

**Axial adjustment**

KAPR 45°

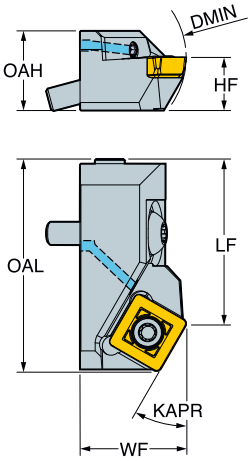
SPMT




| DMIN1 | | CZCMS | CNSC | Ordering code | Dimensions, mm, inch 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 |
| .787 | | | | | .020 | .827 | .236 | .433 | .402 | .976 | 1015 | | | |
| 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 |
| .984 | | | | | .020 | .984 | .315 | .630 | .480 | 1.209 | 1015 | | | |
| 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 |
| 1.575 | | | | | .020 | 1.260 | .394 | .827 | .551 | 1.583 | 1015 | | | |

KAPR 30°

SPMT



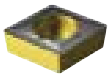

| DMIN1 | | CZCMS | CNSC | Ordering code | Dimensions, mm, inch ADJLXAXL | LF | HF | WF | OAH | OAL | BAR | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20.0 | 06 | 06CC | 2 | SSTPR06CCX06 | 0.50 | 21.00 | 6.00 | 11.00 | 10.20 | 25.60 | 70 | 0.020 | 1 | SPMT 0606-BM |
| .787 | | | | | .020 | .827 | .236 | .433 | .402 | 1.008 | 1015 | | | |
| 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 |
| .984 | | | | | .020 | .984 | .315 | .630 | .480 | 1.256 | 1015 | | | |
| 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 |
| 1.575 | | | | | .020 | 1.260 | .394 | .827 | .559 | 1.654 | 1015 | | | |

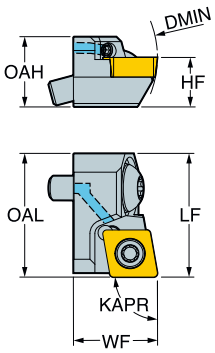
K33 N22 N15

# Indexable boring cartridge

**No adjustment**

KAPR 90°



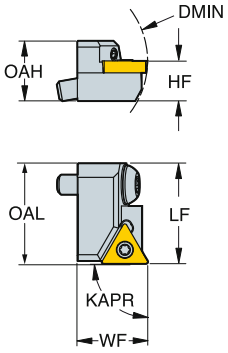



CCMT, CCGT
CCGX, CCET

CCMW

| DMIN$_1$ | | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch 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 |
| .787 | | | | | .630 | .236 | .433 | .402 | .630 | 1015 | | | |
| 25.0 | 06 | 08CD | 2 | **SCFCR08CDX06** | 20.00 | 8.00 | 14.00 | 12.00 | 20.00 | 70 | 0.030 | 1 | CCMT 06 02 04 |
| .984 | | | | | .787 | .315 | .551 | .472 | .787 | 1015 | | | |
| 40.0 | 09 | 10CD | 2 | **SCFCR10CDX09** | 25.00 | 10.00 | 17.00 | 14.20 | 25.00 | 70 | 0.050 | 1 | CCMT 09 T3 08 |
| 1.575 | | | | | .984 | .394 | .669 | .559 | .984 | 1015 | | | |
| 50.0 | 12 | 12CD | 2 | **SCFCR12CDX12** | 30.00 | 12.00 | 20.00 | 16.20 | 30.00 | 70 | 0.070 | 1 | CCMT 12 04 08 |
| 1.969 | | | | | 1.181 | .472 | .787 | .638 | 1.181 | 1015 | | | |

KAPR 90°




TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

| DMIN$_1$ | | CZC$_{MS}$ | CNSC | Ordering code | Dimensions, mm, inch 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 |
| .787 | | | | | .630 | .236 | .433 | .402 | .630 | 1015 | | | |
| 25.0 | 09 | 08CD | 2 | **STFCR08CDX09** | 20.00 | 8.00 | 14.00 | 12.20 | 20.00 | 70 | 0.030 | 1 | TCMT 09 02 04 |
| .984 | | | | | .787 | .315 | .551 | .480 | .787 | 1015 | | | |
| 40.0 | 11 | 10CD | 2 | **STFCR10CDX11** | 25.00 | 10.00 | 17.00 | 14.20 | 25.00 | 70 | 0.050 | 1 | TCMT 11 03 04 |
| 1.575 | | | | | .984 | .394 | .669 | .559 | .984 | 1015 | | | |
| 50.0 | 16 | 12CD | 2 | **STFCR12CDX16** | 30.00 | 12.00 | 20.00 | 16.20 | 30.00 | 70 | 0.070 | 1 | TCMT 16 T3 08 |
| 1.969 | | | | | 1.181 | .472 | .787 | .638 | 1.181 | 1015 | | | |

For inserts, see Turning catalog

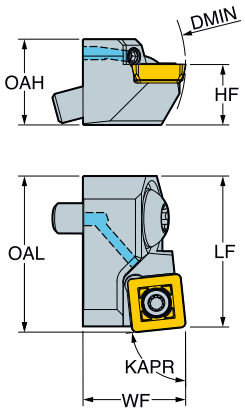
N22 N15

# Indexable boring cartridge

**No adjustment**

KAPR 84°

SPMT

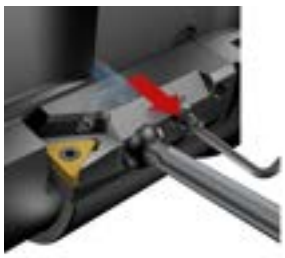



| DMIN1 | | CZCMS | CNSC | Ordering code | Dimensions, mm, inch LF | HF | WF | OAH | OAL | BAR | KG | CICT | MIID |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 20.0 | 06 | 06CD | 2 | SSYPR06CDX06 | 16.00 | 6.00 | 11.00 | 10.20 | 16.60 | 70 | 0.020 | 1 | SPMT 0606-BM |
| .787 | | | | | .630 | .236 | .433 | .402 | .654 | 1015 | | | |
| 25.0 | 08 | 08CD | 2 | SSYPR08CDX08 | 20.00 | 8.00 | 14.00 | 12.20 | 20.80 | 70 | 0.030 | 1 | SPMT 0808-BM |
| .984 | | | | | .787 | .315 | .551 | .480 | .819 | 1015 | | | |
| 40.0 | 08 | 10CD | 2 | SSYPR10CDX08 | 25.00 | 10.00 | 17.00 | 14.00 | 25.80 | 70 | 0.050 | 1 | SPMT 0808-BM |
| 1.575 | | | | | .984 | .394 | .669 | .551 | 1.016 | 1015 | | | |
| 50.0 | 12 | 12CD | 2 | SSYPR12CDX12 | 30.00 | 12.00 | 20.00 | 16.20 | 31.20 | 70 | 0.070 | 1 | SPMT 1210-BM |
| 1.969 | | | | | 1.181 | .472 | .787 | .638 | 1.228 | 1015 | | | |

K33 N22 N15

# CoroBore®

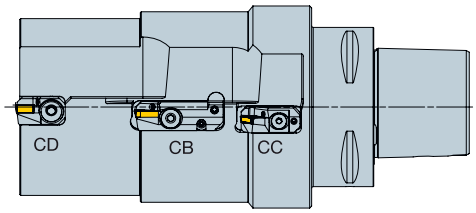
## Built-in cartridges - CB, CC and CD



CB - Boring axial and radial adjustment

CC - Chamfer axial adjustment

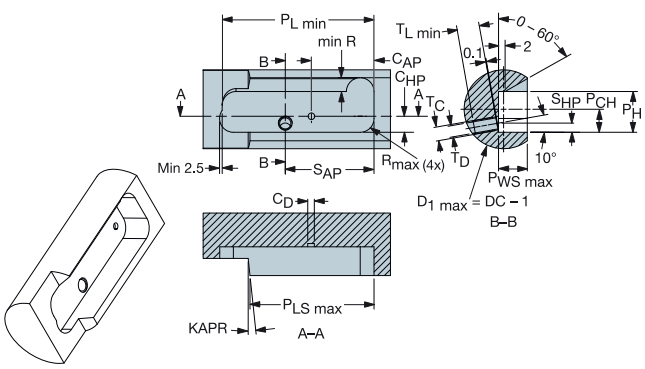
CD - Fixed, no adjustment



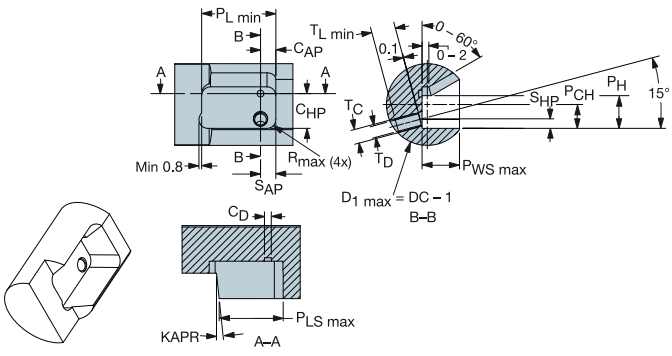

| Size/type | Clamping set | Clamping torque Nm | Clamping torque In-lbs | Key size |
|---|---|---|---|---|
| 06CB | 5519 201-01 | 4.8 | 42.5 | 15IP |
| 10CB | 5519 201-02 | 9.0 | 79.7 | 20IP |
| 12CB | 5519 201-03 | 16.0 | 141.6 | 25IP |
| 06CC | 5519 202-01 | 3.2 | 28.3 | 10IP |
| 08CC | 5519 202-02 | 4.8 | 42.5 | 15IP |
| 10CC | 5519 202-04 | 16.0 | 141.6 | 25IP |
| 06CD | 5519 202-01 | 3.2 | 28.3 | 10IP |
| 08CD | 5519 202-02 | 4.8 | 42.5 | 15IP |
| 10CD | 5519 202-03 | 16.0 | 141.6 | 25IP |
| 12CD | 5519 202-04 | 16.0 | 141.6 | 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

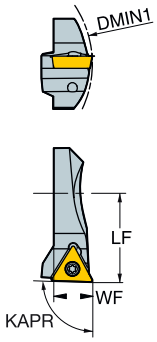



### Type CC and CD



# CoroBore® 826 HP

**Cartridge set**




| | Ordering code | Included cartridges | WF mm | WF inch |
|---|---|---|---|---|
| Size B set | 826B-4-TC09U | R826B-AF17STUC09HP | 7.0 | .276 |
| | | R826B-BF17STUC09HP | 7.5 | .295 |
| | | R826B-CF17STUC09HP | 8.0 | .315 |
| | | R826B-DF17STUC09HP | 8.5 | .335 |
| Size C set | 826C-6-TC11U | R826C-AF23STUC11HP | 10.0 | .394 |
| | | R826C-BF23STUC11HP | 10.5 | .413 |
| | | R826C-CF23STUC11HP | 11.0 | .433 |
| | | R826C-DF23STUC11HP | 11.5 | .453 |
| | | R826C-EF23STUC11HP | 12.0 | .472 |
| | | R826C-FF23STUC11HP | 12.5 | .492 |

# 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:

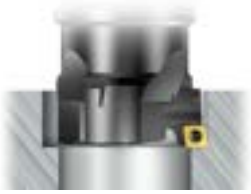
BR20: 1200 m/min (3937 ft/min)
BR20 Damped: 900 m/min (2953 ft/min)

# CoroBore® BR30

## Operations

1

2



3

1. Multi-edge boring
   - Increased feed rate is applicable.

2. Multi-edge step boring
   - High cutting depth is applicable.
   - Shim set is required, order separately. LF-dimension when using shim set increases 1–2 mm (.039–.079 inch).
   - 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**

| Adapter size | Shim set | Thickness mm | inch | Cover |
|---|---|---|---|---|
| A | R820A-AS00B | 0.5+1 | .020+.039 | R820A-AC10B |
| B | R820B-AS00B | 0.5+1 | .020+.039 | R820B-AC11B |
| C | R820C-AS00B | 0.5+1 | .020+.039 | R820C-AC15B |
| D | R820D-AS00B | 0.5+1 | .020+.039 | R820D-AC17A |
| E | R820E-AS00B | 0.8+1.6 | .031+.063 | R820E-AC20A |
| F | R820F-AS00B | 0.8+1.6 | .031+.063 | R820F-AC22A |
| G | R820G-AS00B | 0.8+1.6 | .031+.063 | R820G-AC22A |
| H | R820H-AS00B | 1+2 | .039+.079 | R820H-BC24A |

**Maximum cutting speed, Vc max: Conventional: Vc 1200 m/min (3937 ft/min)**

## Insert choice

| | | | |
|---|---|---|---|
| Entering angle | 90° | 84° | 90° 84° |
| Lead angle | 0° | 6° | 0° 6° |

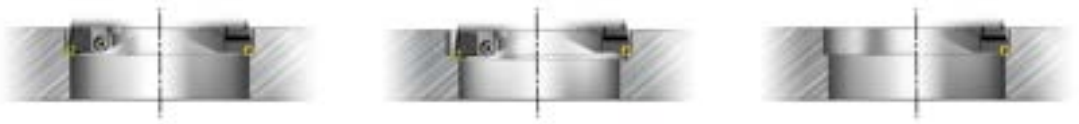
**CoroTurn® 107 screw clamping**
For applications that require lower cutting forces

**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 (.059 inch).
   - 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 (5.906-50.197 inch)**

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 (3937 ft/min), Light weight: 600 m/min (1969 ft/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 high-precision coolant for improved chip breaking

- Feel the microns! Each diameter increment of 0.002 mm (.000079 inch) can be felt with a click

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

Maximum cutting speed, $V_c$ max**:** $V_c$ 1200 m/min (3937 ft/min)

## Insert choice

**CoroTurn® 107 inserts**

| | |
|---|---|
| Entering angle | 92° |
| Lead angle | -2° |

CoroTurn® 107:
TC.. 1103

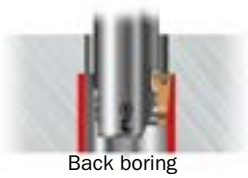


SANDVIK Coromant

# CoroBore® 825

## Operations

Boring



Back boring

**Conventional:**

The geometrical restriction (LU) is only valid when the 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 possible to rotate the assembly in the chuck (using a CoroChuck 930, shrink fit, collet chuck) to find the single edge cutting position.

### Backboring with CoroBore® 825 (Conventional)

1. Remove grub screw from coolant duct A and screw it into coolant duct B.
2. Lock A (if used) + B + C with correct torque.
3. Change spindle direction to counterclockwise (M04).

1.

2.

| Diameter mm *inch* | Slide extension | Thickness mm *inch* | Diameter extension mm *inch* |
|---|---|---|---|
| 19-36 *.748-1.417* | 825A-030A | 3 *.118* | +6 *+.236* |
| 35-56 *1.378-2.205* | 825B-036A | 3.6 *.142* | +7.2 *+.283* |
| 55-1275 *2.165-50.197* | 825C-048A | 4.8 *.189* | +9.6 *+.378* |

### Backboring for CoroBore® 825D (Damped)

| Diameter range, forward boring mm *inch* | Diameter range, back boring mm *inch* | Back boring cartridge kit (1pcs cartridge, 1pcs slide extension) | Back boring cartridge | Slide extension |
|---|---|---|---|---|
| 19-36 *.748-1.417* | 31-48 *1.220-1.890* | 825A-TC06U-BW | L825A-AF11STUC06T1 | 825A-030A |
| 35-56 *1.378-2.205* | 48-69 *1.890-2.717* | 825B-TC06U-BW | L825B-AF15STUC06T1 | 825B-036A |
| 55-167 *2.165-6.575* | 69-181 *2.717-7.126* | 825C-TC09U-BW | L825C-AF20STUC0902 | 825C-048A |

Maximum cutting speed, $V_c$ max**: Conventional:** $V_c$ 1200 m/min (3937 ft/min), **Light weight:** Vc 600 m/min (1969 ft/min) **Damped:** $V_c$ 900 m/min (2953 ft/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 counterclockwise (M04).

**1.**

**2.**

| Diameter<br>mm<br>*inch* | Slide extension (A) | Thickness<br>mm<br>*inch* | Diameter extension<br>mm<br>*inch* |
|---|---|---|---|
| 55-1275<br>*2.165-50.197* | 825C-048A | +4.8<br>*+.189* | +9.6<br>*+.378* |

**Maximum cutting speed, $V_c$ max:**

**Conventional:$V_c$ 1200 m/min (3937 ft/min), Lightweight: Vc 600 m/min (1968 ft/min), Damped:$V_c$ 600 m/min (1968 ft/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))



SANDVIK Coromant

# 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 (656 ft/min) for rough boring, to ensure proper chip evacuation and to secure a stable process.

| CoroBore® 111 | | Feed rate ($f_n$), mm/r, inch/r | | | Cutting depth ($a_p$), mm, inch | | | Cutting speed $v_c$ m/min (ft/min) | | |
|---|---|---|---|---|---|---|---|---|---|---|
| Grade | Ordering code | Min | Max | Rec | Min | Max | Rec | Min | Max | Rec |
| 4325 | SPMT0606-BR | 0.10 (.004) | 0.25 (.010) | 0.20 (.008) | 0.6 (.024) | 4.5 (.177) | 2.0 (.079) | 365 (1197) | 460 (1509) | 395 (1295) |
| | SPMT0808-BR | 0.15 (.006) | 0.35 (.014) | 0.20 (.008) | 0.8 (.031) | 6.5 (.256) | 2.5 (.098) | 325 (1066) | 425 (1394) | 395 (1295) |
| | SPMT1212-BR | 0.15 (.006) | 0.40 (.016) | 0.25 (.010) | 1.2 (.047) | 9.0 (.254) | 3.0 (.118) | 305 (1000) | 425 (1394) | 365 (1197) |
| | SPMT1812-BR | 0.20 (.008) | 0.40 (.016) | 0.30 (.012) | 1.2 (.0.47) | 12.0 (.472) | 3.8 (.150) | 305 (1000) | 395 (1295) | 345 (1135) |
| 2025 | SPMT0606-BM | 0.10 (.004) | 0.15 (.006) | 0.10 (.004) | 0.6 (.024) | 4.5 (.177) | 1.8 (.071) | 260 (853) | 265 (869) | 265 (869) |
| | SPMT0808-BM | 0.10 (.004) | 0.25 (.010) | 0.20 (.008) | 0.8 (.031) | 6.5 (.256) | 2.2 (.087) | 225 (738) | 265 (869) | 240 (787) |
| | SPMT1210-BM | 0.10 (.004) | 0.30 (.012) | 0.20 (.008) | 1.0 (.039) | 9.0 (.354) | 2.5 (.098) | 205 (672) | 265 (869) | 240 (787) |
| | SPMT1810-BM | 0.20 (.008) | 0.30 (.012) | 0.25 (.010) | 1.0 (.039) | 12.0 (.472) | 3.0 (.118) | 205 (672) | 240 (787) | 225 (738) |
| 3210 | SPMT0606-BR | 0.15 (.006) | 0.30 (.012) | 0.25 (.010) | 0.6 (.024) | 4.5 (.177) | 2.0 (.079) | 285 (935) | 330 (1082) | 300 (984) |
| | SPMT0808-BR | 0.20 (.008) | 0.50 (.020) | 0.30 (.012) | 0.8 (.031) | 6.5 (.256) | 2.5 (.098) | 235 (770) | 315 (1033) | 285 (935) |
| | SPMT1212-BR | 0.20 (.008) | 0.50 (.020) | 0.30 (.012) | 1.2 (.047) | 9.0 (.354) | 3.0 (.118) | 235 (770) | 315 (1033) | 285 (935) |
| | SPMT1812-BR | 0.25 (.010) | 0.50 (.020) | 0.30 (.012) | 1.2 (.047) | 12.0 (.472) | 3.8 (.150) | 235 (770) | 300 (984) | 285 (935) |
| 1145 | SPMT0606-BM | 0.10 (.004) | 0.15 (.006) | 0.10 (.004) | 0.6 (.024) | 4.5 (.177) | 1.8 (.071) | 15 (49) | 20 (65) | 20 (65) |
| | SPMT0808-BM | 0.10 (.004) | 0.15 (.006) | 0.10 (.004) | 0.8 (.031) | 6.5 (.256) | 2.2 (.087) | 15 (49) | 20 (65) | 20 (65) |
| | SPMT1210-BM | 0.10 (.004) | 0.20 (.008) | 0.15 (.006) | 1.0 (.039) | 9.0 (.354) | 2.5 (.098) | 10 (32) | 20 (65) | 15 (49) |
| | SPMT1810-BM | 0.10 (.004) | 0.20 (.008) | 0.15 (.006) | 1.0 (.039) | 12.0 (.472) | 3.0 (.118) | 10 (32) | 20 (65) | 15 (49) |

### Fine boring

- Maximum recommended starting value for cutting speed is 240 m/min (787 ft/min) for fine boring, to ensure proper chip evacuation and to secure a stable process.
- The recommended starting value for cutting speed for a fine boring head 391.37A with steel or carbide bars with inserts is 90-120 m/min (295-394 ft/min, use lower values for long steel bars). Recommended starting value for ground carbide bars is 60 m/min (197 ft/min).

- See matrix below for selection of geometry and grade depending on your fine boring application.
- Maximum recommended depth of cut for fine boring is 0.5 mm (0.020 inch). If the tool is adjusted to the minimum possible diameter, chip evacuation will be more critical and a reduction of cutting depth might be necessary.
- Maximum feed in fine boring is limited by desired surface finish. The possibility to influence chip form is therefore limited. By using a wiper insert, surface finish can be retained at higher feeds. However, the wiper inserts exert more radial pressure, increasing the risk of an unstable process.

These are general starting recommendations. For more detailed information, visit CoroPlus® ToolGuide at 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

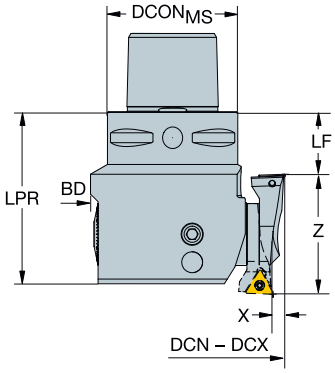
First choice is the CoroCut 2 system insert.
Use -TF geometry for low feed, -CM geometry for medium feed, and -RM geometry for radial bottom face grooving.
The -TF and -CM geometries have positive geometries that eliminate the risk of built-up-edge. The -TF geometry gives good chip control and generates high surface finish due to the Wiper design. The -GF enables larger widths to be selected.
Depending on chosen nose radius:

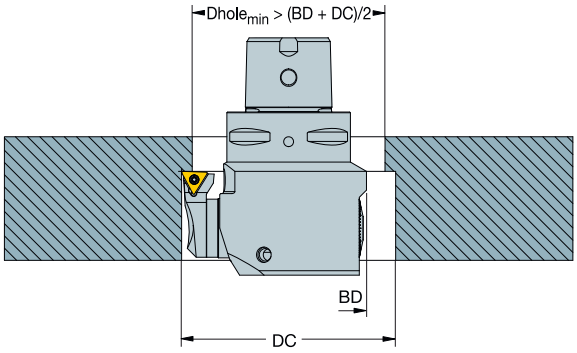
- Choose -CM for a smaller nose radius (0.2)
- Choose -TF for a larger nose radius (>0.3)
- Recommended start feed: 0.15 mm/rev (0.006 inch/rev)
- If grooves with tighter tolerance are required, choose -GF
- Recommended start feed: 0.10 mm/rev (0.004 inch/rev)

To improve chip control:

- increase feed rate
- increase cutting speed

# Backboring with CoroBore® 825 (Conventional)




| Cartridge size | Z mm | Z inch | X mm | X inch |
|---|---|---|---|---|
| A | 22 | .866 | 3.0 | .118 |
| B | 34 | 1.339 | 3.6 | .142 |
| C | 46 | 1.811 | 4.8 | .189 |

### Backboring for CoroBore® 825

In case of backboring, LF will be reduced by twice LF of cartridge. That means:
- LF – 22 mm (.866 inch) for Size A (e.g. R825A-AF**11**STUC06T1A)
- LF – 34 mm (1.417 inch) for Size B (e.g. R825B-AF**17**STUC0902A)
- LF – 46 mm (1.811 inch) for Size C (e.g. R825C-AF**23**STUC1103A)
- Attention, change rotation direction –> left-handed!

DC will be increased by twice WF of slide extension. That means:
- 2 x 3.0 (.118) = 6.0 mm (.236 inch) for Size A (825A-**030**A)
- 2 x 3.6 (.141) = 7.2 mm (.282 inch) for Size B (825B-**036**A)
- 2 x 4.8 (.189) = 9.6 mm (.378 inch) for Size C (825C-**048**A)
- Calculation of minimum possible hole diameter: $Dhole_{min}$ = (BD+DC)/2+1

### Backboring for CoroBore® 825XL

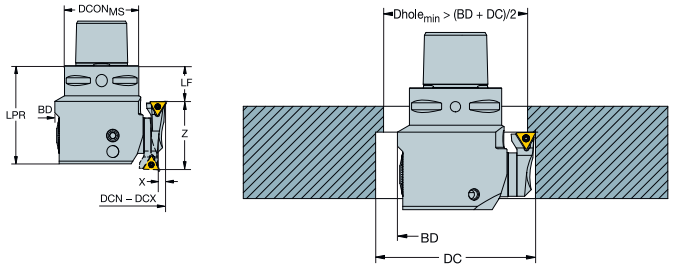
In case of backboring, LF will be reduced by twice LF of cartridge. That means:
- LF – 46 mm (1.811 inch) for Size C (e.g. R825C-AF**23**STUC1103A)
- Attention, change rotation direction –> left-handed!

DC will be increased by twice WF of slide extension. That means:
- 2 x 4.8 (.189) = 9.6 mm (.378 inch) 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 (5.827 inch)+15 mm (.591 inch)+9.6 mm (.378 inch) = **172.6 mm (6.795 inch)**
- **DCX (backboring)**= (DCX(forward))+(2x slide extension) = 215 mm (8.465 inch)+9.6 mm (.378 inch) = **224.6 mm (8.843 inch)**

# Backboring for CoroBore® 825D (Damped)




| | Cartridge | | | | | | | | Slide extension | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Size | LF Forward | | WF Forward | | LF Backward | | WF Backward | | WF | | X | | Z | |
| | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch | mm | inch |
| A | 11 | .433 | 5 | .197 | 11 | .433 | 8.0 | .315 | 3.0 | .118 | 6.0 | .236 | 22 | .866 |
| B | 17 | .669 | 7 | .276 | 15 | .591 | 9.9 | .390 | 3.6 | .142 | 6.5 | .256 | 32 | 1.260 |

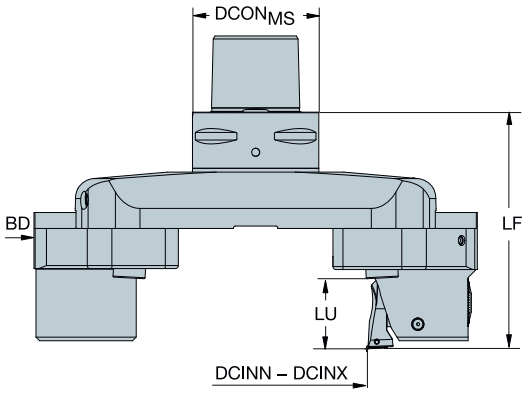
### Back boring for CoroBore® 825D

In case of back boring, LF will be reduced by the LF forward + LF backward. That means:
- LF – 22 mm (.866 inch) for Size A
- LF – 32 mm (1.260 inch) for Size B
- LF – 43 mm (1.693 inch) for Size C
- Attention: rotation direction will remain right-handed!

DC will be increased by twice the WF of the 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 (.118 - .197 + .315) = .472 inch for Size A*
- DC + 2 x (3.6 - 7.0 + 9.9) = 13.0 mm for Size B
  *DC + 2 x (.142 - .276 + .390) = .512 inch for Size B*
- DC + 2 x (4.8 - 10.0 + 12.2) = 14.0 mm for Size C
  *DC + 2 x (.189 - .394 + .480) = .551 inch for Size C*
- Calculation of minimum possible hole diameter: $Dhole_{min}$ = (BD+DC)/2+1

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

# External boring




### External 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 (5.827 inch)-110 mm (4.331 inch)-15 mm (.591 inch) = **23 mm (.906 inch)**
- **DCX (external)** = DCX(forward)-(2x DMIN A34-R825)-(2x A34-R825 stroke) = 215 mm (8.465 inch)-110 mm (4.331 inch)-15 mm (.591 inch) = **90 mm (3.543 inch)**
- Attention, change rotation direction –> left-handed!

The usable length for external boring at diameters of 23 mm (.906 inch) to 190 mm (7.480 inch) (Forward boring: 148 mm (5.827 inch) to 315 mm (12.402 inch)) is 34 mm (1.339 inch).
The usable length for external boring at diameters of 173 mm (6.811 inch) to 1150 mm (45.276 inch) (Forward boring: 298 mm (11.732 inch) to 1275 mm (50.197 inch)) is 28 mm (1.102 inch).

### 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 (5.827 inch)-110 mm (4.331 inch) = **38 mm (1.496 inch)**
- **DCX (external)** = DCX(forward)-(2xDMIN A34-R825) = 200 mm (7.874 inch)-110 mm (4.331 inch) = **90 mm (3.543 inch)**
- Attention, change rotation direction –> left-handed!

The usable length for external boring at diameters of 38 mm (1.496 inch) to 190 mm (7.480 inch) (Forward boring: 148 mm (5.827 inch) to 300 mm (11.811 inch)) is 34 mm (1.339 inch).
The usable length for external boring at diameters of 188 mm (7.402 inch) to 1150 mm (45.276 inch) (Forward boring: 298 mm (11.732 inch) to 1260 mm (49.606 inch)) is 28 mm (1.102 inch).

# Tightening torque

## Coromant Capto®

| Coromant Capto® size | NM | FT/LBS |
|---|---|---|
| C3 | 40-50 | 30-37 |
| C4 | 50-60 | 37-44 |
| C5 | 90-100 | 67-74 |
| C6-C8 | 160-180 | 118-133 |
| C10 | 380 | 283 |

## Coromant EH coupling

| Size | NM | FT/LBS |
|---|---|---|
| 16 | 30 | 22 |
| 20 | 50 | 37 |
| 25 | 65 | 48 |

## Insert screw

| Insert | NM | FT/LBS |
|---|---|---|
| TC05 / TC06 / TP06 | 0.6 | 0.4 |
| TC09 / TP09 / SP06 | 0.8 | 0.6 |
| TC1103 / TP1103 / CC06 | 0.9 | 0.7 |
| SP08 | 1.7 | 1.25 |
| SP12 | 2 | 1.5 |
| CC09 / CC12 / SC09 / SC12 / TC16 / TC22 / SP18 | 3 | 2.2 |
| CN12 / SN12 | 3.9 | 2.9 |
| CN16 / SN15 / RC16 | 6.4 | 4.7 |

## CoroBore® BR10

| | | | | | Tightening torque for slide | | |
|---|---|---|---|---|---|---|---|
| Size | DCN | DCN" | DCX | DCX" | NM | FT/LBS | Screw size |
| A | 32 | 1.260 | 38 | 1.496 | 4.8 | 3.5 | M4 |
| B | 37 | 1.457 | 45 | 1.772 | 4.8 | 3.5 | M4 |
| C | 44 | 1.732 | 54 | 2.126 | 9 | 6.6 | M5 |
| D | 53 | 2.087 | 65 | 2.559 | 16 | 11.8 | M6 |
| DX | 64 | 2.520 | 76 | 2.992 | 16 | 11.8 | M6 |
| E | 75 | 2.953 | 91 | 3.583 | 38 | 28 | M8 |
| F | 90 | 3.543 | 110 | 4.331 | 75 | 55 | M10 |
| G | 109 | 4.291 | 136 | 5.354 | 75 | 55 | M10 |
| H | 135 | 5.315 | 170 | 6.693 | 75 | 55 | M10 |

## CoroBore® BR20

| | | | | | Tightening torque for slide | | |
|---|---|---|---|---|---|---|---|
| Size | DCN | DCN" | DCX | DCX" | NM | FT/LBS | Screw size |
| A | 23 | .906 | 29 | 1.142 | 4.8 | 3.5 | M4 |
| B | 28 | 1.102 | 36 | 1.417 | 4.8 | 3.5 | M4 |
| C | 35 | 1.378 | 45 | 1.772 | 9 | 6.6 | M5 |
| D | 44 | 1.732 | 56 | 2.205 | 16 | 11.8 | M6 |
| E | 55 | 2.165 | 71 | 2.795 | 38 | 28 | M8 |
| F | 70 | 2.756 | 90 | 3.543 | 75 | 55 | M10 |
| G | 89 | 3.504 | 116 | 4.567 | 75 | 55 | M10 |
| H | 115 | 4.528 | 150 | 5.906 | 75 | 55 | M10 |

## CoroBore® BR30

| | | | | | Tightening torque for slide | | |
|---|---|---|---|---|---|---|---|
| Size | DCN | DCN" | DCX | DCX" | NM | FT/LBS | Screw size |
| A | 35 | 1.378 | 45 | 1.772 | 4.8 | 3.5 | M4 |
| B | 44 | 1.732 | 56 | 2.205 | 9 | 6.6 | M5 |
| C | 55 | 2.165 | 70 | 2.756 | 16 | 11.8 | M6 |
| D | 69 | 2.717 | 87 | 3.425 | 16 | 11.8 | M6 |
| E | 86 | 3.386 | 107 | 4.213 | 38 | 28 | M8 |
| F | 106 | 4.173 | 137 | 5.394 | 75 | 55 | M10 |
| G | 136 | 5.354 | 167 | 6.575 | 75 | 55 | M10 |
| H | 166 | 6.535 | 214 | 8.425 | 75; 120 | 55; 88.5 | M10; M12 |

# Tightening torque

## CoroBore® 820 XL / 820L XL

| Diameter range, mm (inch)<br>148-300 (5.512-11.811) | NM | FT/LBS | Screw size |
|---|---|---|---|
| Bridge | 100 | 74 | M12 |
| Slide | 60 | 44 | M10 |
| Cartridge | 60 | 44 | M10 |

## CoroBore® 820 XL

| Diameter range, mm (inch)<br>298-1260 (11.732-49.606) | NM | FT/LBS | Screw size |
|---|---|---|---|
| Bridge | 200 | 148 | M16 |
| Bridge extension | 100 | 74 | M12 |
| Slide | 60 | 44 | M10 |
| Cartridge | 60 | 44 | M10 |

## CoroBore® 825 XL / 826 XL / 825D XL / 826D XL / 825L XL / 826L XL

| Diameter range, mm (inch)<br>825: 148-315 (5.866-12.402)<br>826: 148-300 (5.866-11.810) | NM | FT/LBS | Screw size |
|---|---|---|---|
| Bridge | 100 | 74 | M12 |
| Slide | 60 | 44 | M10 |
| Counterweight | 60 | 44 | M10 |
| Fine boring head | 14 | 10 | M6 |
| Locking screw CB825 | 6 | 4.4 | M8 |
| Locking screw CB826HP | 8 | 5.9 | M8 |
| Cartridge screw | 6 | 4.4 | M8 |

## CoroBore® 825 XL / 826 XL

| Diameter range, mm (inch)<br>825: 298-1275 (11.732-50.197)<br>826: 298-1260 (11.732-49.606) | NM | FT/LBS | Screw size |
|---|---|---|---|
| Bridge | 200 | 148 | M16 |
| Bridge extension | 100 | 74 | M12 |
| Slide | 60 | 44 | M10 |
| Counterweight | 60 | 44 | M10 |
| Fine boring head | 14 | 10 | M6 |
| Locking screw CB825 | 6 | 4.4 | M8 |
| Locking screw CB826HP | 8 | 6 | M8 |
| Cartridge screw | 6 | 4.4 | M8 |

## CoroBore® 825, 825D and 826HP

| Diameter range, mm (inch) | NM | FT/LBS | Screw size |
|---|---|---|---|
| **Cartridge screw** | | | |
| R825A... | 1.2 | 0.9 | M3.5 |
| R825B..., R826B... | 3.0 | 2.2 | M5 |
| R825C..., R826C... | 6.0 | 4.4 | M8 |
| | | | |
| **Locking screw** | | | |
| ...R825A-xA18/...R825A-xAA | 0.9 | 0.7 | M4 |
| ...R825A-xAB | 1.2 | 0.9 | M5 |
| ...R825B...;...R826B | 3.0 ; 4.0 | 2.2 ; 2.9 | M6 |
| ...R825C...;...R826C | 6.0 ; 8.0 | 4.4 ; 5.9 | M8 |

## CoroBore® 824 XS

Diameter range, mm (inch)
1-20 (0.039-0.787)
Locking screw / Boring bar (Insert) screw

| Size | NM | FT/LBS | Screw size |
|---|---|---|---|
| XS04 | 1.2 | 0.9 | M5 |
| XS06 | 1.2 | 0.9 | M5 |
| XS08 | 3 | 2.2 | M6 |
| XS10 | 3 | 2.2 | M6 |

## CoroBore® 825 SL

| Diameter range, mm (inch)<br>47-150 (1.850-5.905) | NM | FT/LBS | Screw size |
|---|---|---|---|
| Face grooving head (S20) | 14 | 10 | M6 |
| Locking screw | 8 | 6 | M10 |
| Counterweight | 8 | 6 | M10 |
| Blade | 9 | 6.6 | M5 |

## CoroBore® 825 SL XL

| Diameter range, mm (inch)<br>150-1275 (5.905-50.197) | NM | FT/LBS | Screw size |
|---|---|---|---|
| Face grooving head (A34) | 14 | 10 | M6 |
| Locking screw | 12 | 6 | M10 |
| Blade | 9 | 6.6 | M5 |

Other components, see CoroBore® 825XL

## Fine boring head, 391.37A / 391.37B / Boring bars

| Diameter<br>mm (inch) | NM | FT/LBS | Screw size |
|---|---|---|---|
| **Screw for boring bar:** | | | |
| 12 (.472) | 10 | 7 | M8 |
| 16 (.630) | 10 | 7 | M8 |
| 20 (.787) | 18 | 13 | M10 |
| | | | |
| **Locking screw:** | | | |
| 12 (.472) | 8 | 6 | M8 |
| 16 (.630) | 8 | 6 | M8 |
| 20 (.787) | 12 | 9 | M10 |

# Rotating tool adapters


## Adapters

Coromant Capto® L4-L42
HSK L43-L62
BIG-PLUS ISO L63-L70
BIG-PLUS MAS-BT L71-L80
Big Plus Cat V L81-L90
ISO 7388-1 L91-L104
MAS-BT L105-L119
CAT-V L120-L134
DIN 2080 L135-L137
DIN 2079 L138-L139
Cylindrical shank L140-L151
Weldon shank L152-L155
Bridgeport L156-L157
Coromant EH L158
ER L160-L163
NMTB L164-L165
Coolant inducer L166

## Damped adapters L167

Coromant Capto® L168-L171
HSK L172

## Adapters

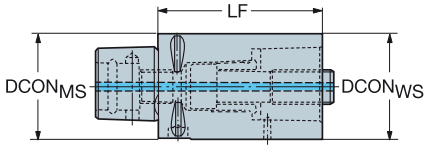
| | | Machine side | | | | | | |
|---|---|---|---|---|---|---|---|---|
| | | **Coromant Capto®** | **HSK** | **BIG-PLUS® ISO** | **BIG-PLUS® MAS-BT** | **BIG-PLUS® CAT-V** | **ISO 7388-1** | **MAS-BT** |
| **Workpiece side** | **Coromant Capto®** | -Extension<br>-Extension with quick change<br>-Reduction<br><br>L4-L8<br><br>Coolant inducer L166 | -Adapter<br>-Quick change<br><br>L44-L47 | -Adapter<br>-Quick change<br><br>L64 | -Adapter<br>-Quick change<br><br>L72-L73 | -Adapter<br>-Quick change<br><br>L82-L83 | -Adapter<br>-Quick change<br><br>L92-L93 | -Adapter<br>-Quick change<br>-Turning<br><br>L106-L108 |
| | **Coromant EH** | –Adapter<br><br>L9-L13 | –Adapter<br><br>L48 | | –Adapter<br><br>L74 | | –Adapter<br><br>L94 | –Adapter<br><br>L109-L110 |
| | **Arbor** | -Adapter<br>-With driving screws<br>-Side and face mill<br><br>L14-L24 | -Adapter<br>-With driving screws<br><br>L49-L51 | –Adapter<br><br>L65 | –Adapter<br><br>L75 | –Adapter<br><br>L84 | -Adapter<br>-With driving screws<br>-Side and face mill<br><br>L95-L96 | -Adapter<br>-With driving screws<br>-Side and face mill<br><br>L111-L113 |
| | **VL** | –Adapter<br><br>L21 | –Adapter<br><br>L51 | –Adapter<br><br>L66 | –Adapter<br><br>L76 | –Adapter<br><br>L85 | –Adapter<br><br>L97 | –Adapter<br><br>L113 |
| | **Weldon** | –Adapter<br><br>L22-L24 | –Adapter<br><br>L52-L53 | | | | –Adapter<br><br>L98 | –Adapter<br><br>L114 |
| | **MDI** | –Adapter<br><br>L25 | –Adapter<br><br>L54 | | | | | |
| | **ISO 9766** | –Adapter<br><br>L26<br><br>Coolant inducer L166 | –Adapter<br><br>L55 | | | | -Adapter<br>-Adjustable adapter<br><br>L99 | -Adapter<br>-Adjustable adapter<br><br>L115 |
| | **Weldon/ ISO 9766** | –Adapter<br><br>L27 | | –Adapter<br><br>L66 | –Adapter<br><br>L76 | –Adapter<br><br>L85 | | |
| | **CoroMill® 327** | –Adapter<br><br>L28 | | | | | | |
| | **CoroChuck™ 930** | –Adapter<br><br>L29-L34 | –Adapter<br><br>L56-L59 | –Adapter<br><br>L67-L68 | –Adapter<br><br>L77-L78 | –Adapter<br><br>L86-L87 | –Adapter<br><br>L100-L117 | –Adapter<br><br>L116-L117 |
| | **Shrink fit chuck** | –Adapter<br><br>L35-L38 | –Adapter<br><br>L60 | | | | | |
| | **ER** | -Collet chuck<br>-Drill chuck<br><br>L39-L41 | -Collet chuck<br><br>L61 | -Collet chuck<br><br>L69 | -Collet chuck<br><br>L79 | –Adapter<br><br>L89 | -Collet chuck<br><br>L103 | -Collet chuck<br><br>L118 |
| | **CoroChuck™ 970** | –Adapter<br><br>L42 | –Adapter<br><br>L62 | –Adapter<br><br>L70 | –Adapter<br><br>L80 | –Adapter<br><br>L90 | –Adapter<br><br>L104 | –Adapter<br><br>L119 |

## Damped adapters

| | | Machine side | |
|---|---|---|---|
| | | **Coromant Capto®** | **HSK** |
| **Workpiece side** | **Coromant EH** | –Adapter<br><br>L168 | |
| | **Arbor** | -Adapter<br>-With driving screws<br><br>L169-L171 | –Adapter<br><br>L172 |

| CAT-V | DIN 2080 | DIN 2079 | Cylindrical shank | Weldon shank | Bridgeport | Coromant EH | ER | NMTB |
|---|---|---|---|---|---|---|---|---|
| -Adapter<br>-Quick change<br><br>L121-L122 | –Adapter<br><br>L136 | -Adapter<br>-Quick change<br><br>L139 | | | | | | –Adapter<br><br>L165 |
| –Adapter<br><br>L123 | | | –Adapter<br><br>L141-L148 | | | | –Adapter<br><br>L161-L162 | |
| -Adapter<br>-With driving screws<br>-Side and face mill<br><br>L124-L125 | | | -With driving screws<br><br>L149 | | –Adapter<br><br>L157 | | | |
| –Adapter<br><br>L126 | | | | | | | | |
| –Adapter<br><br>L126-L129 | | | | | | | | |
| | | | | | | | | |
| -Adapter<br>-Adjustable adapter<br><br>L128-L129 | | | | | | | | |
| | | | | | | | | |
| | | | | –Adapter<br><br>L153-L154 | | –Adapter<br><br>L159 | –Adapter<br><br>L163 | |
| –Adapter<br><br>L130-L132 | | | | | | | | |
| | | | | | | | | |
| -Collet chuck<br><br>L133 | | | -Collet chuck<br><br>L150 | | | –Adapter<br><br>L159 | | |
| –Adapter<br><br>L134 | | | –Adapter<br><br>L151 | –Adapter<br><br>L155 | | –Adapter<br><br>L159 | | |

# Coromant Capto® extension adapter




| CZCMS | CZCWS | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCONMS | DCONWS | LF | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|
| C3 | C3 | 3 | 1 | C3-391.01-32 060A | 32.0 | 32.0 | 60.0 | 80 | 45.0 | 0.36 |
| | | | | | *1.260* | *1.260* | *2.362* | *1160* | | |
| | C3 | 3 | 1 | C3-391.01-32 080A | 32.0 | 32.0 | 80.0 | 80 | 45.0 | 0.47 |
| | | | | | *1.260* | *1.260* | *3.150* | *1160* | | |
| | C3 | 3 | 1 | C3-391.01-32 095 | 32.0 | 32.0 | 95.0 | 80 | 45.0 | 0.56 |
| | | | | | *1.260* | *1.260* | *3.740* | *1160* | | |
| C4 | C4 | 3 | 1 | C4-391.01-40 060A | 40.0 | 40.0 | 60.0 | 80 | 55.0 | 0.57 |
| | | | | | *1.575* | *1.575* | *2.362* | *1160* | | |
| | C4 | 3 | 1 | C4-391.01-40 080A | 40.0 | 40.0 | 80.0 | 80 | 55.0 | 0.70 |
| | | | | | *1.575* | *1.575* | *3.150* | *1160* | | |
| | C4 | 3 | 1 | C4-391.01-40 120 | 40.0 | 40.0 | 120.0 | 80 | 55.0 | 1.11 |
| | | | | | *1.575* | *1.575* | *4.724* | *1160* | | |
| C5 | C5 | 3 | 1 | C5-391.01-50 080A | 50.0 | 50.0 | 80.0 | 80 | 95.0 | 1.15 |
| | | | | | *1.969* | *1.969* | *3.150* | *1160* | | |
| | C5 | 3 | 1 | C5-391.01-50 100A | 50.0 | 50.0 | 100.0 | 80 | 95.0 | 1.38 |
| | | | | | *1.969* | *1.969* | *3.937* | *1160* | | |
| | C5 | 3 | 1 | C5-391.01-50 150 | 50.0 | 50.0 | 150.0 | 80 | 95.0 | 2.17 |
| | | | | | *1.969* | *1.969* | *5.906* | *1160* | | |
| C6 | C6 | 3 | 1 | C6-391.01-63 100A | 63.0 | 63.0 | 100.0 | 80 | 170.0 | 2.26 |
| | | | | | *2.480* | *2.480* | *3.937* | *1160* | | |
| | C6 | 3 | 1 | C6-391.01-63 140A | 63.0 | 63.0 | 140.0 | 80 | 170.0 | 3.17 |
| | | | | | *2.480* | *2.480* | *5.512* | *1160* | | |
| | C6 | 3 | 1 | C6-391.01-63 185 | 63.0 | 63.0 | 185.0 | 80 | 170.0 | 4.19 |
| | | | | | *2.480* | *2.480* | *7.283* | *1160* | | |
| C8 | C8 | 3 | 1 | C8-391.01-80 100A | 80.0 | 80.0 | 100.0 | 80 | 170.0 | 3.70 |
| | | | | | *3.150* | *3.150* | *3.937* | *1160* | | |
| | C8 | 3 | 1 | C8-391.01-80 125A | 80.0 | 80.0 | 125.0 | 80 | 170.0 | 4.64 |
| | | | | | *3.150* | *3.150* | *4.921* | *1160* | | |
| | C8 | 3 | 1 | C8-391.01-80 200 | 80.0 | 80.0 | 200.0 | 80 | 170.0 | 7.47 |
| | | | | | *3.150* | *3.150* | *7.874* | *1160* | | |
| C10 | C10 | 3 | 1 | C10-391.01-100 140 | 100.0 | 100.0 | 140.0 | 80 | 380.0 | 7.93 |
| | | | | | *3.937* | *3.937* | *5.512* | *1160* | | |
| | C10 | 3 | 1 | C10-391.01-100 200 | 100.0 | 100.0 | 200.0 | 80 | 380.0 | 11.49 |
| | | | | | *3.937* | *3.937* | *7.874* | *1160* | | |

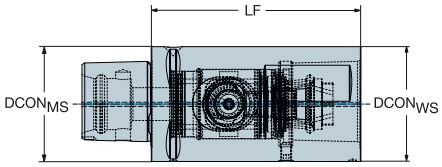
## Short design, for segment clamping only

| CZCMS | CZCWS | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCONMS | DCONWS | LF | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|
| C3 | C3 | 3 | 1 | C3-391.01-32 035 | 32.0 | 32.0 | 35.0 | 80 | 45.0 | 0.22 |
| | | | | | *1.260* | *1.260* | *1.378* | *1160* | | |
| C4 | C4 | 3 | 1 | C4-391.01-40 040 | 40.0 | 40.0 | 40.0 | 80 | 55.0 | 0.40 |
| | | | | | *1.575* | *1.575* | *1.575* | *1160* | | |
| C5 | C5 | 3 | 1 | C5-391.01-50 050 | 50.0 | 50.0 | 50.0 | 80 | 95.0 | 0.73 |
| | | | | | *1.969* | *1.969* | *1.969* | *1160* | | |
| C6 | C6 | 3 | 1 | C6-391.01-63 060 | 63.0 | 63.0 | 60.0 | 80 | 170.0 | 1.36 |
| | | | | | *2.480* | *2.480* | *2.362* | *1160* | | |
| C8 | C8 | 3 | 1 | C8-391.01-80 065 | 80.0 | 80.0 | 65.0 | 80 | 170.0 | 2.41 |
| | | | | | *3.150* | *3.150* | *2.559* | *1160* | | |

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

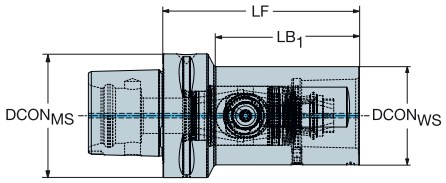
M1 N22 N6 N15

## Coromant Capto® extension adapter with quick change




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|
| C4 | C4 | 3 | 1 | C4-QC-C4-085 | 40.0 | 40.0 | 85.0 | 150 | 50.0 | 0.75 | 39000 |
| | | | | | *1.575* | *1.575* | *3.346* | *2175* | | | |
| C5 | C5 | 3 | 1 | C5-QC-C5-100 | 50.0 | 50.0 | 100.0 | 150 | 70.0 | 1.39 | 28000 |
| | | | | | *1.969* | *1.969* | *3.937* | *2175* | | | |
| C6 | C6 | 3 | 1 | C6-QC-C6-115 | 63.0 | 63.0 | 115.0 | 150 | 90.0 | 2.53 | 20000 |
| | | | | | *2.480* | *2.480* | *4.528* | *2175* | | | |
| C8 | C8 | 3 | 1 | C8-QC-C8-145 | 80.0 | 80.0 | 145.0 | 150 | 130.0 | 5.16 | 14000 |
| | | | | | *3.150* | *3.150* | *5.709* | *2175* | | | |

## Coromant Capto® reduction adapter with Quick change




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C5 | C4 | 3 | 1 | C5-QC-C4-085 | 50.0 | 40.0 | 85.0 | 60.5 | 150 | 50.0 | 0.95 | 28000 |
| | | | | | *1.969* | *1.575* | *3.346* | *2.382* | *2175* | | | |
| C6 | C5 | 3 | 1 | C6-QC-C5-100 | 63.0 | 50.0 | 100.0 | 73.0 | 150 | 70.0 | 1.75 | 20000 |
| | | | | | *2.480* | *1.969* | *3.937* | *2.874* | *2175* | | | |
| C8 | C6 | 3 | 1 | C8-QC-C6-120 | 80.0 | 63.0 | 120.0 | 84.5 | 150 | 90.0 | 3.48 | 14000 |
| | | | | | *3.150* | *2.480* | *4.724* | *3.327* | *2175* | | | |
| C10 | C8 | 3 | 1 | C10-QC-C8-150 | 100.0 | 80.0 | 150.0 | 108.0 | 150 | 130.0 | 6.83 | 10000 |
| | | | | | *3.937* | *3.150* | *5.906* | *4.252* | *2175* | | | |

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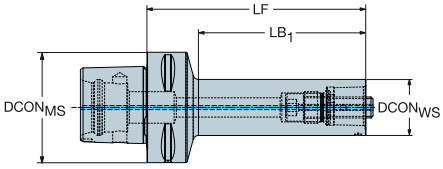
M1 N22 N6 N15

# Coromant Capto® reduction adapter

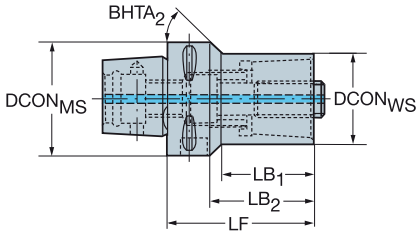



| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|
| C4 | C3 | 3 | 1 | C4-391.02-32 055A | 40.0 | 32.0 | 55.0 | 31.0 | 80 | 45.0 | 0.49 |
| | | | | | *1.575* | *1.260* | *2.165* | *1.220* | *1160* | | |
| | C3 | 3 | 1 | C4-391.02-32 120 | 40.0 | 32.0 | 120.0 | 95.7 | 80 | 45.0 | 0.81 |
| | | | | | *1.575* | *1.260* | *4.724* | *3.768* | *1160* | | |
| C5 | C3 | 3 | 1 | C5-391.02-32 060A | 50.0 | 32.0 | 60.0 | 34.8 | 80 | 45.0 | 0.68 |
| | | | | | *1.969* | *1.260* | *2.362* | *1.370* | *1160* | | |
| | C3 | 3 | 1 | C5-391.02-32 120 | 50.0 | 32.0 | 120.0 | 94.4 | 80 | 45.0 | 0.99 |
| | | | | | *1.969* | *1.260* | *4.724* | *3.717* | *1160* | | |
| | C4 | 3 | 1 | C5-391.02-40 065A | 50.0 | 40.0 | 65.0 | 40.0 | 80 | 55.0 | 0.80 |
| | | | | | *1.969* | *1.575* | *2.559* | *1.575* | *1160* | | |
| | C4 | 3 | 1 | C5-391.02-40 140 | 50.0 | 40.0 | 140.0 | 115.5 | 80 | 55.0 | 1.46 |
| | | | | | *1.969* | *1.575* | *5.512* | *4.547* | *1160* | | |
| C6 | C3 | 3 | 1 | C6-391.02-32 070A | 63.0 | 32.0 | 70.0 | 39.0 | 80 | 45.0 | 1.12 |
| | | | | | *2.480* | *1.260* | *2.756* | *1.535* | *1160* | | |
| | C3 | 3 | 1 | C6-391.02-32 125 | 63.0 | 32.0 | 125.0 | 95.6 | 80 | 45.0 | 1.43 |
| | | | | | *2.480* | *1.260* | *4.921* | *3.764* | *1160* | | |
| | C4 | 3 | 1 | C6-391.02-40 080A | 63.0 | 40.0 | 80.0 | 51.4 | 80 | 55.0 | 1.32 |
| | | | | | *2.480* | *1.575* | *3.150* | *2.024* | *1160* | | |
| | C4 | 3 | 1 | C6-391.02-40 145 | 63.0 | 40.0 | 145.0 | 116.7 | 80 | 55.0 | 1.86 |
| | | | | | *2.480* | *1.575* | *5.709* | *4.594* | *1160* | | |
| | C5 | 3 | 1 | C6-391.02-50 080A | 63.0 | 50.0 | 80.0 | 51.5 | 80 | 95.0 | 1.53 |
| | | | | | *2.480* | *1.969* | *3.150* | *2.028* | *1160* | | |
| | C5 | 3 | 1 | C6-391.02-50 175 | 63.0 | 50.0 | 175.0 | 148.1 | 80 | 95.0 | 2.79 |
| | | | | | *2.480* | *1.969* | *6.890* | *5.831* | *1160* | | |
| C8 | C3 | 3 | 1 | C8-391.02-32 060B | 80.0 | 32.0 | 60.0 | 20.7 | 80 | 45.0 | 2.07 |
| | | | | | *3.150* | *1.260* | *2.362* | *.815* | *1160* | | |
| | C3 | 3 | 1 | C8-391.02-32 135 | 80.0 | 32.0 | 135.0 | 95.7 | 80 | 45.0 | 2.53 |
| | | | | | *3.150* | *1.260* | *5.315* | *3.768* | *1160* | | |
| | C4 | 3 | 1 | C8-391.02-40 070B | 80.0 | 40.0 | 70.0 | 31.4 | 80 | 55.0 | 2.20 |
| | | | | | *3.150* | *1.575* | *2.756* | *1.236* | *1160* | | |
| | C4 | 3 | 1 | C8-391.02-40 155 | 80.0 | 40.0 | 155.0 | 116.4 | 80 | 55.0 | 2.97 |
| | | | | | *3.150* | *1.575* | *6.102* | *4.583* | *1160* | | |
| | C5 | 3 | 1 | C8-391.02-50 080B | 80.0 | 50.0 | 80.0 | 42.8 | 80 | 95.0 | 2.43 |
| | | | | | *3.150* | *1.969* | *3.150* | *1.685* | *1160* | | |
| | C5 | 3 | 1 | C8-391.02-50 185 | 80.0 | 50.0 | 185.0 | 147.8 | 80 | 95.0 | 3.88 |
| | | | | | *3.150* | *1.969* | *7.283* | *5.819* | *1160* | | |
| | C6 | 3 | 1 | C8-391.02-63 080B | 80.0 | 63.0 | 80.0 | 44.5 | 80 | 170.0 | 2.65 |
| | | | | | *3.150* | *2.480* | *3.150* | *1.752* | *1160* | | |
| | C6 | 3 | 1 | C8-391.02-63 200 | 80.0 | 63.0 | 200.0 | 164.5 | 80 | 170.0 | 5.37 |
| | | | | | *3.150* | *2.480* | *7.874* | *6.476* | *1160* | | |
| C10 | C6 | 3 | 1 | C10-391.02-63 200 | 100.0 | 63.0 | 200.0 | 155.8 | 80 | 170.0 | 6.92 |
| | | | | | *3.937* | *2.480* | *7.874* | *6.134* | *1160* | | |
| | C8 | 3 | 1 | C10-391.02-80 200 | 100.0 | 80.0 | 200.0 | 158.1 | 80 | 170.0 | 8.92 |
| | | | | | *3.937* | *3.150* | *7.874* | *6.224* | *1160* | | |

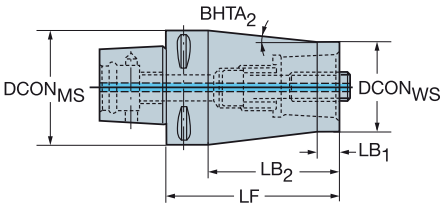
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15

# Coromant Capto® reduction adapter




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | BHTA$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C8 | C6 | 3 | 1 | C8-391.02-63 120A | 80.0 | 63.0 | 120.0 | 12.0 | 90.0 | 6° | 80 | 170.0 | 4.10 |
| | | | | | *3.150* | *2.480* | *4.724* | *.472* | *3.543* | | *1160* | | |
| C10 | C3 | 3 | 1 | C10-391.02-32 085 | 100.0 | 32.0 | 85.0 | 29.4 | 49.0 | 60° | 80 | 45.0 | 4.15 |
| | | | | | *3.937* | *1.260* | *3.346* | *1.157* | *1.929* | | *1160* | | |
| | C4 | 3 | 1 | C10-391.02-40 090 | 100.0 | 40.0 | 90.0 | 36.7 | 54.0 | 60° | 80 | 55.0 | 4.25 |
| | | | | | *3.937* | *1.575* | *3.543* | *1.445* | *2.126* | | *1160* | | |
| | C5 | 3 | 1 | C10-391.02-50 095 | 100.0 | 50.0 | 95.0 | 44.6 | 59.0 | 60° | 80 | 95.0 | 4.42 |
| | | | | | *3.937* | *1.969* | *3.740* | *1.756* | *2.323* | | *1160* | | |
| | C6 | 3 | 1 | C10-391.02-63 095 | 100.0 | 63.0 | 95.0 | 48.3 | 59.0 | 60° | 80 | 170.0 | 4.68 |
| | | | | | *3.937* | *2.480* | *3.740* | *1.902* | *2.323* | | *1160* | | |
| | C8 | 3 | 1 | C10-391.02-80 100 | 100.0 | 80.0 | 100.0 | 58.2 | 64.0 | 60° | 80 | 170.0 | 5.25 |
| | | | | | *3.937* | *3.150* | *3.937* | *2.291* | *2.520* | | *1160* | | |




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | BHTA$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C4 | C3 | 3 | 1 | C4-391.02-32 070A | 40.0 | 32.0 | 70.0 | 12.0 | 50.0 | 6° | 80 | 45.0 | 0.59 |
| | | | | | *1.575* | *1.260* | *2.756* | *.472* | *1.969* | | *1160* | | |
| C5 | C3 | 3 | 1 | C5-391.02-32 150 | 50.0 | 32.0 | 150.0 | 5.0 | 128.2 | 8° | 80 | 45.0 | 1.65 |
| | | | | | *1.969* | *1.260* | *5.906* | *.197* | *5.047* | | *1160* | | |
| | C4 | 3 | 1 | C5-391.02-40 085A | 50.0 | 40.0 | 85.0 | 12.0 | 65.0 | 5° | 80 | 45.0 | 1.10 |
| | | | | | *1.969* | *1.575* | *3.346* | *.472* | *2.559* | | *1160* | | |
| C6 | C3 | 3 | 1 | C6-391.02-32 185 | 63.0 | 32.0 | 185.0 | 5.0 | 162.2 | 11° | 80 | 45.0 | 2.99 |
| | | | | | *2.480* | *1.260* | *7.283* | *.197* | *6.386* | | *1160* | | |
| | C4 | 3 | 1 | C6-391.02-40 185 | 63.0 | 40.0 | 185.0 | 5.0 | 162.2 | 8° | 80 | 55.0 | 3.23 |
| | | | | | *2.480* | *1.575* | *7.283* | *.197* | *6.386* | | *1160* | | |
| | C5 | 3 | 1 | C6-391.02-50 110A | 63.0 | 50.0 | 110.0 | 12.0 | 88.0 | 5° | 80 | 95.0 | 2.23 |
| | | | | | *2.480* | *1.969* | *4.331* | *.472* | *3.465* | | *1160* | | |
| C8 | C4 | 3 | 1 | C8-391.02-40 200 | 80.0 | 40.0 | 200.0 | 5.0 | 169.2 | 13° | 80 | 55.0 | 5.42 |
| | | | | | *3.150* | *1.575* | *7.874* | *.197* | *6.661* | | *1160* | | |
| | C5 | 3 | 1 | C8-391.02-50 200 | 80.0 | 50.0 | 200.0 | 5.0 | 169.2 | 10° | 80 | 95.0 | 5.84 |
| | | | | | *3.150* | *1.969* | *7.874* | *.197* | *6.661* | | *1160* | | |

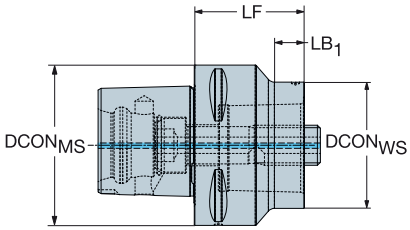
For spare parts, visit www.sandvik.coromant.com

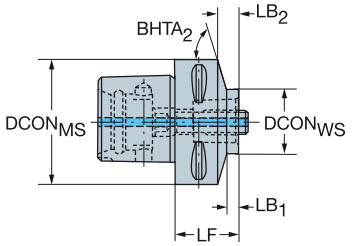
M1 N22 N6 N15

# Coromant Capto® reduction adapter

**Short design, for segment clamping only**

DSGN 2 7



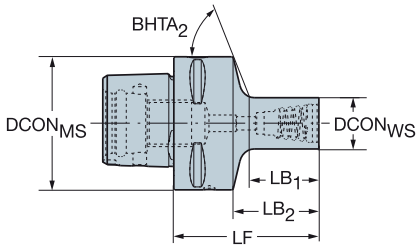

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_2$ | BD$_3$ | BHTA$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C5 | C3 | 3 | 1 | 2 | **C5-391.02-32 033A** | 50.0 | 32.0 | 33.0 | 5.0 | 33.0 | | 50.0 | | 0° | 80 | 45.0 | 0.54 |
| | | | | | | *1.969* | *1.260* | *1.299* | *.197* | *1.299* | | *1.969* | | | *1160* | | |
| | C4 | 3 | 1 | 2 | **C5-391.02-40 040A** | 50.0 | 40.0 | 40.0 | 15.0 | 40.0 | | 50.0 | | 0° | 80 | 55.0 | 0.59 |
| | | | | | | *1.969* | *1.575* | *1.575* | *.591* | *1.575* | | *1.969* | | | *1160* | | |
| C6 | C3 | 3 | 1 | 2 | **C6-391.02-32 032** | 63.0 | 32.0 | 32.0 | 6.0 | 32.0 | | 63.0 | | 0° | 80 | 45.0 | 0.91 |
| | | | | | | *2.480* | *1.260* | *1.260* | *.236* | *1.260* | | *2.480* | | | *1160* | | |
| | C4 | 3 | 1 | 2 | **C6-391.02-40 040** | 63.0 | 40.0 | 40.0 | 11.0 | 40.0 | | 63.0 | | 0° | 80 | 55.0 | 0.98 |
| | | | | | | *2.480* | *1.575* | *1.575* | *.433* | *1.575* | | *2.480* | | | *1160* | | |
| | C5 | 3 | 1 | 2 | **C6-391.02-50 050A** | 63.0 | 50.0 | 50.0 | 20.0 | 50.0 | | 63.0 | | 0° | 80 | 95.0 | 1.11 |
| | | | | | | *2.480* | *1.969* | *1.969* | *.787* | *1.969* | | *2.480* | | | *1160* | | |
| C8 | C5 | 3 | 1 | 2 | **C8-391.02-50 045A** | 80.0 | 50.0 | 45.0 | 5.0 | 45.0 | | 80.0 | | 0° | 80 | 95.0 | 2.00 |
| | | | | | | *3.150* | *1.969* | *1.772* | *.197* | *1.772* | | *3.150* | | | *1160* | | |
| | C6 | 3 | 1 | 2 | **C8-391.02-63 055A** | 80.0 | 63.0 | 55.0 | 15.0 | 55.0 | | 80.0 | | 0° | 80 | 170.0 | 2.15 |
| | | | | | | *3.150* | *2.480* | *2.165* | *.591* | *2.165* | | *3.150* | | | *1160* | | |
| 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 | 170.0 | 3.70 |
| | | | | | | *3.937* | *2.480* | *2.165* | *.551* | *.748* | *2.165* | *2.480* | *3.937* | | *1160* | | |
| | 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 | 170.0 | 3.92 |
| | | | | | | *3.937* | *3.150* | *2.559* | *1.000* | *1.142* | *2.559* | *3.150* | *3.937* | | *1160* | | |

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

M1 N22 N6 N15

# Coromant Capto® to Coromant EH adapter

**Short design**




**Metric version**

| | | | | | Dimensions, mm, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $BHTA_2$ | BAR PSI | NM | KG | RPMX |
| C3 | E10 | 3 | 1 | **C3-391.EH-10 035** | 32.0 | 9.6 | 35.0 | 13.2 | 20.0 | 58° | 150 | 12.0 | 0.19 | 40000 |
| | | | | | *1.260* | *.378* | *1.378* | *.520* | *.787* | | *2175* | | | |
| | E12 | 3 | 1 | **C3-391.EH-12 038** | 32.0 | 11.6 | 38.0 | 16.4 | 23.0 | 57° | 150 | 15.0 | 0.21 | 40000 |
| | | | | | *1.260* | *.457* | *1.496* | *.646* | *.906* | | *2175* | | | |
| | E16 | 3 | 1 | **C3-391.EH-16 043** | 32.0 | 15.4 | 43.0 | 21.9 | 28.0 | 53° | 150 | 30.0 | 0.26 | 40000 |
| | | | | | *1.260* | *.606* | *1.693* | *.862* | *1.102* | | *2175* | | | |
| C4 | E10 | 3 | 1 | **C4-391.EH-10 041** | 40.0 | 9.6 | 41.0 | 13.1 | 21.0 | 62° | 150 | 12.0 | 0.35 | 39000 |
| | | | | | *1.575* | *.378* | *1.614* | *.516* | *.827* | | *2175* | | | |
| | E12 | 3 | 1 | **C4-391.EH-12 044** | 40.0 | 11.6 | 44.0 | 16.4 | 24.0 | 61° | 150 | 15.0 | 0.36 | 39000 |
| | | | | | *1.575* | *.457* | *1.732* | *.646* | *.945* | | *2175* | | | |
| | E16 | 3 | 1 | **C4-391.EH-16 049** | 40.0 | 15.4 | 49.0 | 21.9 | 29.0 | 59° | 150 | 30.0 | 0.42 | 39000 |
| | | | | | *1.575* | *.606* | *1.929* | *.862* | *1.142* | | *2175* | | | |
| | E20 | 3 | 1 | **C4-391.EH-20 046** | 40.0 | 19.2 | 46.0 | 19.4 | 26.0 | 57° | 150 | 50.0 | 0.43 | 39000 |
| | | | | | *1.575* | *.756* | *1.811* | *.764* | *1.024* | | *2175* | | | |
| | E25 | 3 | 1 | **C4-391.EH-25 051** | 40.0 | 24.1 | 51.0 | 25.0 | 31.0 | 53° | 150 | 65.0 | 0.50 | 39000 |
| | | | | | *1.575* | *.949* | *2.008* | *.984* | *1.220* | | *2175* | | | |
| C5 | E10 | 3 | 1 | **C5-391.EH-10 042** | 50.0 | 9.6 | 42.0 | 12.8 | 22.0 | 65° | 150 | 12.0 | 0.56 | 28000 |
| | | | | | *1.969* | *.378* | *1.654* | *.504* | *.866* | | *2175* | | | |
| | E12 | 3 | 1 | **C5-391.EH-12 045** | 50.0 | 11.6 | 45.0 | 16.0 | 25.0 | 64° | 150 | 15.0 | 0.57 | 28000 |
| | | | | | *1.969* | *.457* | *1.772* | *.630* | *.984* | | *2175* | | | |
| | E16 | 3 | 1 | **C5-391.EH-16 050** | 50.0 | 15.4 | 50.0 | 21.5 | 30.0 | 63° | 150 | 30.0 | 0.63 | 28000 |
| | | | | | *1.969* | *.606* | *1.969* | *.846* | *1.181* | | *2175* | | | |
| | E20 | 3 | 1 | **C5-391.EH-20 047** | 50.0 | 19.2 | 47.0 | 19.0 | 27.0 | 62° | 150 | 50.0 | 0.64 | 28000 |
| | | | | | *1.969* | *.756* | *1.850* | *.748* | *1.063* | | *2175* | | | |
| | E25 | 3 | 1 | **C5-391.EH-25 052** | 50.0 | 24.1 | 52.0 | 24.7 | 32.0 | 60° | 150 | 65.0 | 0.70 | 28000 |
| | | | | | *1.969* | *.949* | *2.047* | *.972* | *1.260* | | *2175* | | | |
| C6 | E10 | 3 | 1 | **C6-391.EH-10 046** | 63.0 | 9.6 | 46.0 | 13.0 | 24.0 | 67° | 150 | 12.0 | 0.94 | 20000 |
| | | | | | *2.480* | *.378* | *1.811* | *.512* | *.945* | | *2175* | | | |
| | E12 | 3 | 1 | **C6-391.EH-12 049** | 63.0 | 11.6 | 49.0 | 16.3 | 27.0 | 67° | 150 | 15.0 | 0.95 | 20000 |
| | | | | | *2.480* | *.457* | *1.929* | *.642* | *1.063* | | *2175* | | | |
| | E16 | 3 | 1 | **C6-391.EH-16 054** | 63.0 | 15.4 | 54.0 | 21.8 | 32.0 | 66° | 150 | 30.0 | 1.01 | 20000 |
| | | | | | *2.480* | *.606* | *2.126* | *.858* | *1.260* | | *2175* | | | |
| | E20 | 3 | 1 | **C6-391.EH-20 051** | 63.0 | 19.2 | 51.0 | 19.3 | 29.0 | 66° | 150 | 50.0 | 1.02 | 20000 |
| | | | | | *2.480* | *.756* | *2.008* | *.760* | *1.142* | | *2175* | | | |
| | E25 | 3 | 1 | **C6-391.EH-25 056** | 63.0 | 24.1 | 56.0 | 25.0 | 34.0 | 65° | 150 | 65.0 | 1.08 | 20000 |
| | | | | | *2.480* | *.949* | *2.205* | *.984* | *1.339* | | *2175* | | | |

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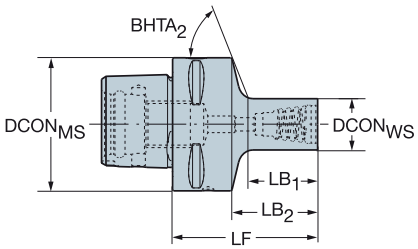
M1 N22 N6 N15 N3

# Coromant Capto® to Coromant EH adapter

**Short design**




**Inch version**

| | | | | | Dimensions, mm, inch | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BHTA_2$ | | | | RPMX |
| C3 | E10 | 3 | 1 | **C3-A391.EH-10 034** | 32.0 | 9.2 | 34.0 | 12.1 | 19.0 | 34.0 | 59° | 150 | 12.0 | 0.18 | 40000 |
| | | | | | *1.260* | *.360* | *1.339* | *.476* | *.748* | *1.339* | | *2175* | | | |
| C4 | E10 | 3 | 1 | **C4-A391.EH-10 040** | 40.0 | 9.2 | 40.0 | 12.0 | 20.0 | 40.0 | 63° | 150 | 12.0 | 0.35 | 39000 |
| | | | | | *1.575* | *.360* | *1.575* | *.472* | *.787* | *1.575* | | *2175* | | | |
| | E12 | 3 | 1 | **C4-A391.EH-12 045** | 40.0 | 12.2 | 45.0 | 17.4 | 25.0 | 45.0 | 62° | 150 | 15.0 | 0.37 | 39000 |
| | | | | | *1.575* | *.480* | *1.772* | *.685* | *.984* | *1.772* | | *2175* | | | |
| | E16 | 3 | 1 | **C4-A391.EH-16 049** | 40.0 | 15.4 | 49.0 | 21.9 | 29.0 | 49.0 | 60° | 150 | 30.0 | 0.42 | 39000 |
| | | | | | *1.575* | *.606* | *1.929* | *.862* | *1.142* | *1.929* | | *2175* | | | |
| | E20 | 3 | 1 | **C4-A391.EH-20 044** | 40.0 | 18.4 | 44.0 | 17.3 | 24.0 | 44.0 | 58° | 150 | 50.0 | 0.42 | 39000 |
| | | | | | *1.575* | *.724* | *1.732* | *.681* | *.945* | *1.732* | | *2175* | | | |
| C5 | E10 | 3 | 1 | **C5-A391.EH-10 041** | 50.0 | 9.2 | 41.0 | 11.7 | 21.0 | 60.0 | 65° | 150 | 12.0 | 0.55 | 28000 |
| | | | | | *1.969* | *.360* | *1.614* | *.461* | *.827* | *2.362* | | *2175* | | | |
| | E20 | 3 | 1 | **C5-A391.EH-20 045** | 50.0 | 18.4 | 45.0 | 16.9 | 25.0 | 45.0 | 63° | 150 | 50.0 | 0.63 | 28000 |
| | | | | | *1.969* | *.724* | *1.772* | *.665* | *.984* | *1.772* | | *2175* | | | |
| | E25 | 3 | 1 | **C5-A391.EH-25 053** | 50.0 | 24.4 | 53.0 | 25.7 | 33.0 | 53.0 | 60° | 150 | 65.0 | 0.70 | 28000 |
| | | | | | *1.969* | *.961* | *2.087* | *1.012* | *1.299* | *2.087* | | *2175* | | | |
| C6 | E10 | 3 | 1 | **C6-A391.EH-10 045** | 63.0 | 9.2 | 45.0 | 11.9 | 23.0 | 45.0 | 68° | 150 | 12.0 | 0.93 | 20000 |
| | | | | | *2.480* | *.360* | *1.772* | *.470* | *.906* | *1.772* | | *2175* | | | |
| | E12 | 3 | 1 | **C6-A391.EH-12 050** | 63.0 | 12.2 | 50.0 | 17.4 | 28.0 | 50.0 | 68° | 150 | 15.0 | 0.96 | 20000 |
| | | | | | *2.480* | *.480* | *1.969* | *.685* | *1.102* | *1.969* | | *2175* | | | |
| | E16 | 3 | 1 | **C6-A391.EH-16 054** | 63.0 | 15.4 | 54.0 | 21.8 | 32.0 | 54.0 | 67° | 150 | 30.0 | 1.01 | 20000 |
| | | | | | *2.480* | *.606* | *2.126* | *.858* | *1.260* | *2.126* | | *2175* | | | |
| | E20 | 3 | 1 | **C6-A391.EH-20 049** | 63.0 | 18.4 | 49.0 | 17.2 | 27.0 | 49.0 | 66° | 150 | 50.0 | 1.01 | 20000 |
| | | | | | *2.480* | *.724* | *1.929* | *.677* | *1.063* | *1.929* | | *2175* | | | |
| | E25 | 3 | 1 | **C6-A391.EH-25 057** | 63.0 | 24.4 | 57.0 | 26.0 | 35.0 | 57.0 | 65° | 150 | 65.0 | 1.08 | 20000 |
| | | | | | *2.480* | *.961* | *2.244* | *1.024* | *1.378* | *2.244* | | *2175* | | | |

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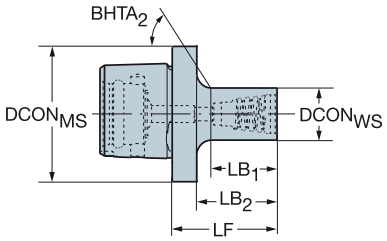
M1 N22 N6 N15 N3



SANDVIK Coromant

# Coromant Capto® to Coromant EH adapter

**Short design, for segment clamping only**




## Metric version

| | | | | | Dimensions, mm, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $BHTA_2$ | BAR PSI | NM | KG | RPMX |
| C3 | E10 | 3 | 1 | **C3-391.EH-10 026** | 32.0 | 9.6 | 26.0 | 13.0 | 18.0 | 45° | 150 | 12.0 | 0.15 | 40000 |
| | | | | | *1.260* | *.378* | *1.024* | *.512* | *.709* | | *2175* | | | |
| | E12 | 3 | 1 | **C3-391.EH-12 029** | 32.0 | 11.6 | 29.0 | 16.0 | 21.0 | 45° | 150 | 15.0 | 0.17 | 40000 |
| | | | | | *1.260* | *.457* | *1.142* | *.630* | *.827* | | *2175* | | | |
| | E16 | 3 | 1 | **C3-391.EH-16 027** | 32.0 | 15.4 | 27.0 | 14.0 | 19.0 | 45° | 150 | 30.0 | 0.24 | 55000 |
| | | | | | *1.260* | *.606* | *1.063* | *.551* | *.748* | | *2175* | | | |
| | E20 | 3 | 1 | **C3-391.EH-20 031** | 32.0 | 19.2 | 31.0 | 18.0 | 23.0 | 45° | 150 | 50.0 | 0.27 | 55000 |
| | | | | | *1.260* | *.756* | *1.220* | *.709* | *.906* | | *2175* | | | |
| C4 | E10 | 3 | 1 | **C4-391.EH-10 026** | 40.0 | 9.6 | 26.0 | 13.0 | 18.0 | 45° | 150 | 12.0 | 0.24 | 39000 |
| | | | | | *1.575* | *.378* | *1.024* | *.512* | *.709* | | *2175* | | | |
| | E12 | 3 | 1 | **C4-391.EH-12 029** | 40.0 | 11.6 | 29.0 | 16.0 | 21.0 | 45° | 150 | 15.0 | 0.26 | 39000 |
| | | | | | *1.575* | *.457* | *1.142* | *.630* | *.827* | | *2175* | | | |
| | E16 | 3 | 1 | **C4-391.EH-16 035** | 40.0 | 15.4 | 35.0 | 22.0 | 27.0 | 45° | 150 | 30.0 | 0.31 | 39000 |
| | | | | | *1.575* | *.606* | *1.378* | *.866* | *1.063* | | *2175* | | | |
| | E20 | 3 | 1 | **C4-391.EH-20 031** | 40.0 | 19.2 | 31.0 | 18.0 | 23.0 | 45° | 150 | 50.0 | 0.34 | 39000 |
| | | | | | *1.575* | *.756* | *1.220* | *.709* | *.906* | | *2175* | | | |
| | E25 | 3 | 1 | **C4-391.EH-25 038** | 40.0 | 24.1 | 38.0 | 25.0 | 30.0 | 45° | 150 | 65.0 | 0.28 | 39000 |
| | | | | | *1.575* | *.949* | *1.496* | *.984* | *1.181* | | *2175* | | | |
| C5 | E10 | 3 | 1 | **C5-391.EH-10 026** | 50.0 | 9.6 | 26.0 | 13.0 | 18.0 | 45° | 150 | 12.0 | 0.38 | 28000 |
| | | | | | *1.969* | *.378* | *1.024* | *.512* | *.709* | | *2175* | | | |
| | E12 | 3 | 1 | **C5-391.EH-12 029** | 50.0 | 11.6 | 29.0 | 16.0 | 21.0 | 45° | 150 | 15.0 | 0.40 | 28000 |
| | | | | | *1.969* | *.457* | *1.142* | *.630* | *.827* | | *2175* | | | |
| | E16 | 3 | 1 | **C5-391.EH-16 035** | 50.0 | 15.4 | 35.0 | 22.0 | 27.0 | 45° | 150 | 30.0 | 0.45 | 28000 |
| | | | | | *1.969* | *.606* | *1.378* | *.866* | *1.063* | | *2175* | | | |
| | E20 | 3 | 1 | **C5-391.EH-20 031** | 50.0 | 19.2 | 31.0 | 18.0 | 23.0 | 45° | 150 | 50.0 | 0.47 | 28000 |
| | | | | | *1.969* | *.756* | *1.220* | *.709* | *.906* | | *2175* | | | |
| | E25 | 3 | 1 | **C5-391.EH-25 038** | 50.0 | 24.1 | 38.0 | 25.0 | 30.0 | 45° | 150 | 65.0 | 0.53 | 28000 |
| | | | | | *1.969* | *.949* | *1.496* | *.984* | *1.181* | | *2175* | | | |

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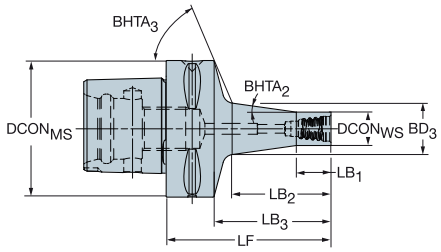
M1 N22 N6 N15 N3

# Coromant Capto® to Coromant EH adapter

**Long design**




**Metric version**

| | | | | | Dimensions, mm, inch | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_3$ | $BD_4$ | $BHTA_2$ | $BHTA_3$ | BAR PSI | 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 | 32.0 | 8° | 57° | 150 | 12.0 | 0.20 | 40000 |
| | | | | | *1.260* | *.378* | *1.929* | *.394* | *1.122* | *1.339* | *.583* | *1.260* | | | *2175* | | | |
| | E12 | 3 | 1 | C3-391.EH-12 054 | 32.0 | 11.6 | 54.0 | 12.0 | 33.9 | 39.0 | 17.8 | 32.0 | 8° | 54° | 150 | 15.0 | 0.25 | 40000 |
| | | | | | *1.260* | *.457* | *2.126* | *.472* | *1.335* | *1.535* | *.701* | *1.260* | | | *2175* | | | |
| | E16 | 3 | 1 | C3-391.EH-16 065 | 32.0 | 15.4 | 65.0 | 16.0 | 45.7 | 50.0 | 23.8 | 32.0 | 8° | 44° | 150 | 30.0 | 0.32 | 40000 |
| | | | | | *1.260* | *.606* | *2.559* | *.630* | *1.799* | *1.969* | *.937* | *1.260* | | | *2175* | | | |
| C4 | E10 | 3 | 1 | C4-391.EH-10 055 | 40.0 | 9.6 | 55.0 | 10.0 | 28.5 | 32.6 | 22.1 | 40.0 | 8° | 62° | 150 | 12.0 | 0.37 | 39000 |
| | | | | | *1.575* | *.378* | *2.165* | *.394* | *1.122* | *1.283* | *.870* | *1.575* | | | *2175* | | | |
| | E12 | 3 | 1 | C4-391.EH-12 060 | 40.0 | 11.6 | 60.0 | 12.0 | 33.9 | 40.0 | 17.7 | 40.0 | 8° | 61° | 150 | 15.0 | 0.39 | 39000 |
| | | | | | *1.575* | *.457* | *2.362* | *.472* | *1.335* | *1.575* | *.697* | *1.575* | | | *2175* | | | |
| | E16 | 3 | 1 | C4-391.EH-16 071 | 40.0 | 15.4 | 71.0 | 16.0 | 45.7 | 51.0 | 23.7 | 40.0 | 8° | 56° | 150 | 30.0 | 0.48 | 39000 |
| | | | | | *1.575* | *.606* | *2.795* | *.630* | *1.799* | *2.008* | *.933* | *1.575* | | | *2175* | | | |
| | E20 | 3 | 1 | C4-391.EH-20 084 | 40.0 | 19.2 | 84.0 | 20.0 | 59.6 | 64.0 | 30.3 | 40.0 | 8° | 47° | 150 | 50.0 | 0.59 | 39000 |
| | | | | | *1.575* | *.756* | *3.307* | *.787* | *2.346* | *2.520* | *1.193* | *1.575* | | | *2175* | | | |
| | E25 | 3 | 1 | C4-391.EH-25 074 | 40.0 | 24.1 | 74.0 | 25.0 | 49.6 | 54.0 | 31.0 | 40.0 | 8° | 45° | 150 | 65.0 | 0.61 | 39000 |
| | | | | | *1.575* | *.949* | *2.913* | *.984* | *1.953* | *2.126* | *1.220* | *1.575* | | | *2175* | | | |
| C5 | E10 | 3 | 1 | C5-391.EH-10 056 | 50.0 | 9.6 | 56.0 | 10.0 | 28.1 | 36.0 | 14.7 | 50.0 | 8° | 65° | 150 | 12.0 | 0.57 | 28000 |
| | | | | | *1.969* | *.378* | *2.205* | *.394* | *1.106* | *1.417* | *.579* | *1.969* | | | *2175* | | | |
| | E12 | 3 | 1 | C5-391.EH-12 061 | 50.0 | 11.6 | 61.0 | 12.0 | 33.5 | 41.0 | 17.6 | 50.0 | 8° | 65° | 150 | 15.0 | 0.60 | 28000 |
| | | | | | *1.969* | *.457* | *2.402* | *.472* | *1.319* | *1.614* | *.693* | *1.969* | | | *2175* | | | |
| | E16 | 3 | 1 | C5-391.EH-16 072 | 50.0 | 15.4 | 72.0 | 16.0 | 45.3 | 52.0 | 23.6 | 50.0 | 8° | 63° | 150 | 30.0 | 0.69 | 28000 |
| | | | | | *1.969* | *.606* | *2.835* | *.630* | *1.783* | *2.047* | *.929* | *1.969* | | | *2175* | | | |
| | E20 | 3 | 1 | C5-391.EH-20 085 | 50.0 | 19.2 | 85.0 | 20.0 | 59.2 | 65.0 | 30.2 | 50.0 | 8° | 59° | 150 | 50.0 | 0.79 | 28000 |
| | | | | | *1.969* | *.756* | *3.346* | *.787* | *2.331* | *2.559* | *1.189* | *1.969* | | | *2175* | | | |
| | E25 | 3 | 1 | C5-391.EH-25 100 | 50.0 | 24.1 | 100.0 | 25.0 | 75.3 | 80.0 | 38.2 | 50.0 | 8° | 51° | 150 | 65.0 | 1.01 | 28000 |
| | | | | | *1.969* | *.949* | *3.937* | *.984* | *2.965* | *3.150* | *1.504* | *1.969* | | | *2175* | | | |
| C6 | E10 | 3 | 1 | C6-391.EH-10 060 | 63.0 | 9.6 | 60.0 | 10.0 | 28.4 | 38.0 | 14.8 | 63.0 | 8° | 68° | 150 | 12.0 | 0.95 | 20000 |
| | | | | | *2.480* | *.378* | *2.362* | *.394* | *1.118* | *1.496* | *.583* | *2.480* | | | *2175* | | | |
| | E12 | 3 | 1 | C6-391.EH-12 065 | 63.0 | 11.6 | 65.0 | 12.0 | 33.8 | 43.0 | 17.7 | 63.0 | 8° | 67° | 150 | 15.0 | 0.97 | 20000 |
| | | | | | *2.480* | *.457* | *2.559* | *.472* | *1.331* | *1.693* | *.697* | *2.480* | | | *2175* | | | |
| | E16 | 3 | 1 | C6-391.EH-16 076 | 63.0 | 15.4 | 76.0 | 16.0 | 45.6 | 54.0 | 23.7 | 63.0 | 8° | 66° | 150 | 30.0 | 1.07 | 20000 |
| | | | | | *2.480* | *.606* | *2.992* | *.630* | *1.795* | *2.126* | *.933* | *2.480* | | | *2175* | | | |
| | E20 | 3 | 1 | C6-391.EH-20 088 | 63.0 | 19.2 | 88.0 | 20.0 | 58.4 | 66.0 | 30.0 | 63.0 | 8° | 65° | 150 | 50.0 | 1.16 | 20000 |
| | | | | | *2.480* | *.756* | *3.465* | *.787* | *2.299* | *2.598* | *1.181* | *2.480* | | | *2175* | | | |
| | E25 | 3 | 1 | C6-391.EH-25 103 | 63.0 | 24.1 | 103.0 | 25.0 | 74.5 | 81.0 | 38.0 | 63.0 | 8° | 62° | 150 | 65.0 | 1.37 | 20000 |
| | | | | | *2.480* | *.949* | *4.055* | *.984* | *2.933* | *3.189* | *1.496* | *2.480* | | | *2175* | | | |
| C8 | E20 | 3 | 1 | C8-391.EH-20 100 | 80.0 | 19.2 | 100.0 | 20.0 | 60.2 | 70.0 | 30.5 | 80.0 | 8° | 68° | 150 | 50.0 | 2.25 | 14000 |
| | | | | | *3.150* | *.756* | *3.937* | *.787* | *2.370* | *2.756* | *1.201* | *3.150* | | | *2175* | | | |
| | E25 | 3 | 1 | C8-391.EH-25 114 | 80.0 | 24.1 | 114.0 | 25.0 | 75.3 | 84.0 | 38.2 | 80.0 | 8° | 68° | 150 | 65.0 | 2.45 | 14000 |
| | | | | | *3.150* | *.949* | *4.488* | *.984* | *2.965* | *3.307* | *1.504* | *3.150* | | | *2175* | | | |

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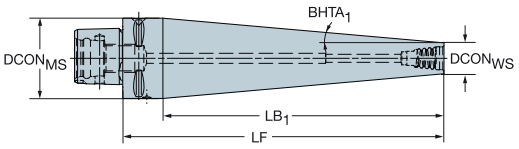
M1 N22 N6 N15 N3



SANDVIK Coromant

# Coromant Capto® to Coromant EH adapter

**Long conical design**




## Metric version

| | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| C3 | E10 | 3 | 1 | **C3-391.EH-10 143** | 32.0 | 9.6 | 143.0 | 128.0 | 5° | 150 | 12.0 | 0.55 | 40000 |
| | | | | | *1.260* | *.378* | *5.630* | *5.039* | | *2175* | | | |
| | E12 | 3 | 1 | **C3-391.EH-12 132** | 32.0 | 11.6 | 132.0 | 117.0 | 5° | 150 | 15.0 | 0.56 | 40000 |
| | | | | | *1.260* | *.457* | *5.197* | *4.606* | | *2175* | | | |
| | E16 | 3 | 1 | **C3-391.EH-16 110** | 32.0 | 15.4 | 110.0 | 95.0 | 5° | 150 | 30.0 | 0.57 | 40000 |
| | | | | | *1.260* | *.606* | *4.331* | *3.740* | | *2175* | | | |
| C4 | E10 | 3 | 1 | **C4-391.EH-10 128** | 40.0 | 9.6 | 128.0 | 108.0 | 8° | 150 | 12.0 | 0.78 | 39000 |
| | | | | | *1.575* | *.378* | *5.039* | *4.252* | | *2175* | | | |
| | E12 | 3 | 1 | **C4-391.EH-12 121** | 40.0 | 11.6 | 121.0 | 101.0 | 8° | 150 | 15.0 | 0.78 | 39000 |
| | | | | | *1.575* | *.457* | *4.764* | *3.976* | | *2175* | | | |
| | E16 | 3 | 1 | **C4-391.EH-16 160** | 40.0 | 15.4 | 160.0 | 140.0 | 5° | 150 | 30.0 | 1.06 | 39000 |
| | | | | | *1.575* | *.606* | *6.299* | *5.512* | | *2175* | | | |
| | E20 | 3 | 1 | **C4-391.EH-20 139** | 40.0 | 19.2 | 139.0 | 119.0 | 5° | 150 | 50.0 | 1.03 | 39000 |
| | | | | | *1.575* | *.756* | *5.472* | *4.685* | | *2175* | | | |
| C5 | E16 | 3 | 1 | **C5-391.EH-16 143** | 50.0 | 15.4 | 143.0 | 123.0 | 8° | 150 | 30.0 | 1.43 | 28000 |
| | | | | | *1.969* | *.606* | *5.630* | *4.843* | | *2175* | | | |
| | E20 | 3 | 1 | **C5-391.EH-20 130** | 50.0 | 19.2 | 130.0 | 110.0 | 8° | 150 | 50.0 | 1.40 | 28000 |
| | | | | | *1.969* | *.756* | *5.118* | *4.331* | | *2175* | | | |

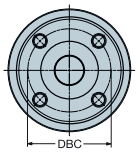
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15 N3

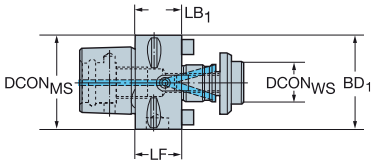
# Coromant Capto® to arbor adapter

**Coolant through arbor**

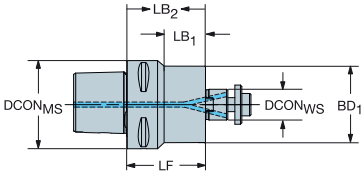
DSGN




1




2




**Metric pilot**

| | | | | | | Dimensions, mm, inch | | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | DBC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | | | | RPMX |
| C3 | 16 | 3 | 4 | 1 | C3-391.05C-16 030 | 32.0 | 16.0 | | 30.0 | 30.0 | | 32.0 | | 80 | 22.0 | 0.25 | 20000 |
| | | | | | | *1.260* | *.630* | | *1.181* | *1.181* | | *1.260* | | *1160* | | | |
| 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 | 22.0 | 0.38 | 20000 |
| | | | | | | *1.575* | *.630* | | *1.260* | *.394* | *1.260* | *1.260* | *1.575* | *1160* | | | |
| | 16 | 3 | 4 | 2 | C4-391.05C-16 055 | 40.0 | 16.0 | | 55.0 | 33.0 | 55.0 | 32.0 | 40.0 | 80 | 22.0 | 0.40 | 20000 |
| | | | | | | *1.575* | *.630* | | *2.165* | *1.299* | *2.165* | *1.260* | *1.575* | *1160* | | | |
| | 22 | 3 | 4 | 1 | C4-391.05C-22 025 | 40.0 | 22.0 | | 25.0 | 25.0 | | 40.0 | | 80 | 45.0 | 0.40 | 16000 |
| | | | | | | *1.575* | *.866* | | *.984* | *.984* | | *1.575* | | *1160* | | | |
| | 22 | 3 | 4 | 1 | C4-391.05C-22 055 | 40.0 | 22.0 | | 55.0 | 55.0 | | 40.0 | | 80 | 45.0 | 0.60 | 16000 |
| | | | | | | *1.575* | *.866* | | *2.165* | *2.165* | | *1.575* | | *1160* | | | |
| 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 | 22.0 | 0.60 | 20000 |
| | | | | | | *1.969* | *.630* | | *1.378* | *.394* | *1.378* | *1.260* | *1.969* | *1160* | | | |
| | 16 | 3 | 4 | 2 | C5-391.05C-16 070 | 50.0 | 16.0 | | 70.0 | 44.8 | 70.0 | 32.0 | 50.0 | 80 | 22.0 | 0.70 | 20000 |
| | | | | | | *1.969* | *.630* | | *2.756* | *1.764* | *2.756* | *1.260* | *1.969* | *1160* | | | |
| | 22 | 3 | 4 | 1 | C5-391.05C-22 025M | 50.0 | 22.0 | | 25.0 | 25.0 | | 50.0 | | 80 | 45.0 | 0.62 | 16000 |
| | | | | | | *1.969* | *.866* | | *.984* | *.984* | | *1.969* | | *1160* | | | |
| | 22 | 3 | 4 | 2 | C5-391.05C-22 070 | 50.0 | 22.0 | | 70.0 | 47.0 | 70.0 | 40.0 | 50.0 | 80 | 45.0 | 0.90 | 16000 |
| | | | | | | *1.969* | *.866* | | *2.756* | *1.850* | *2.756* | *1.575* | *1.969* | *1160* | | | |
| | 27 | 3 | 4 | 1 | C5-391.05C-27 025M | 50.0 | 27.0 | | 25.0 | 25.0 | | 56.0 | | 80 | 80.0 | 0.68 | 17000 |
| | | | | | | *1.969* | *1.063* | | *.984* | *.984* | | *2.205* | | *1160* | | | |
| | 32 | 3 | 4 | 1 | C5-391.05C-32 040 | 50.0 | 32.0 | | 40.0 | 40.0 | | 63.0 | | 80 | 180.0 | 1.14 | 16000 |
| | | | | | | *1.969* | *1.260* | | *1.575* | *1.575* | | *2.480* | | *1160* | | | |
| 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 | 22.0 | 1.00 | 20000 |
| | | | | | | *2.480* | *.630* | | *1.575* | *.394* | *1.575* | *1.260* | *2.480* | *1160* | | | |
| | 22 | 3 | 4 | 1 | C6-391.05C-22 025M | 63.0 | 22.0 | | 25.0 | 25.0 | | 63.0 | | 80 | 45.0 | 0.96 | 16000 |
| | | | | | | *2.480* | *.866* | | *.984* | *.984* | | *2.480* | | *1160* | | | |
| | 22 | 3 | 4 | 2 | C6-391.05C-22 080 | 63.0 | 22.0 | | 80.0 | 40.0 | 80.0 | 40.0 | 63.0 | 80 | 45.0 | 1.40 | 16000 |
| | | | | | | *2.480* | *.866* | | *3.150* | *1.575* | *3.150* | *1.575* | *2.480* | *1160* | | | |
| | 27 | 3 | 4 | 1 | C6-391.05C-27 025M | 63.0 | 27.0 | | 25.0 | 25.0 | | 63.0 | | 80 | 80.0 | 1.01 | 17000 |
| | | | | | | *2.480* | *1.063* | | *.984* | *.984* | | *2.480* | | *1160* | | | |
| | 27 | 3 | 4 | 2 | C6-391.05C-27 080 | 63.0 | 27.0 | | 80.0 | 55.0 | 80.0 | 50.0 | 63.0 | 80 | 80.0 | 1.60 | 17000 |
| | | | | | | *2.480* | *1.063* | | *3.150* | *2.165* | *3.150* | *1.969* | *2.480* | *1160* | | | |
| | 32 | 3 | 4 | 1 | C6-391.05C-32 025M | 63.0 | 32.0 | | 25.0 | 25.0 | | 65.0 | | 80 | 180.0 | 1.09 | 16000 |
| | | | | | | *2.480* | *1.260* | | *.984* | *.984* | | *2.559* | | *1160* | | | |
| | 40S | 3 | 4 | 1 | C6-391.05C-40 050M | 63.0 | 40.0 | 66.7 | 50.0 | 50.0 | | 87.0 | | 80 | 300.0 | 2.40 | 17000 |
| | | | | | | *2.480* | *1.575* | *2.626* | *1.969* | *1.969* | | *3.425* | | *1160* | | | |
| 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 | 22.0 | 2.10 | 14000 |
| | | | | | | *3.150* | *.630* | | *1.969* | *.394* | *1.969* | *1.260* | *3.150* | *1160* | | | |
| | 22 | 3 | 4 | 1 | C8-391.05C-22 030M | 80.0 | 22.0 | | 30.0 | 30.0 | | 80.0 | | 80 | 45.0 | 1.86 | 14000 |
| | | | | | | *3.150* | *.866* | | *1.181* | *1.181* | | *3.150* | | *1160* | | | |
| | 22 | 3 | 4 | 2 | C8-391.05C-22 090 | 80.0 | 22.0 | | 90.0 | 45.0 | 90.0 | 40.0 | 80.0 | 80 | 45.0 | 2.40 | 14000 |
| | | | | | | *3.150* | *.866* | | *3.543* | *1.772* | *3.543* | *1.575* | *3.150* | *1160* | | | |
| | 27 | 3 | 4 | 1 | C8-391.05C-27 030M | 80.0 | 27.0 | | 30.0 | 30.0 | | 80.0 | | 80 | 80.0 | 1.91 | 14000 |
| | | | | | | *3.150* | *1.063* | | *1.181* | *1.181* | | *3.150* | | *1160* | | | |
| | 27 | 3 | 4 | 2 | C8-391.05C-27 090 | 80.0 | 27.0 | | 90.0 | 50.0 | 90.0 | 50.0 | 80.0 | 80 | 80.0 | 2.70 | 14000 |
| | | | | | | *3.150* | *1.063* | | *3.543* | *1.969* | *3.543* | *1.969* | *3.150* | *1160* | | | |
| | 32 | 3 | 4 | 1 | C8-391.05C-32 030M | 80.0 | 32.0 | | 30.0 | 30.0 | | 80.0 | | 80 | 180.0 | 2.02 | 14000 |
| | | | | | | *3.150* | *1.260* | | *1.181* | *1.181* | | *3.150* | | *1160* | | | |
| | 40S | 3 | 4 | 1 | C8-391.05C-40 060M | 80.0 | 40.0 | 66.7 | 60.0 | 60.0 | | 87.0 | | 80 | 300.0 | 3.47 | 14000 |
| | | | | | | *3.150* | *1.575* | *2.626* | *2.362* | *2.362* | | *3.425* | | *1160* | | | |
| 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 | 80.0 | 4.52 | |
| | | | | | | *3.937* | *1.063* | | *2.953* | *1.142* | *2.953* | *2.362* | *3.937* | *1160* | | | |
| | 32 | 3 | 4 | 2 | C10-391.05C-32 075 | 100.0 | 32.0 | | 75.0 | 33.0 | 75.0 | 78.0 | 100.0 | 80 | 180.0 | 5.04 | 10000 |
| | | | | | | *3.937* | *1.260* | | *2.953* | *1.299* | *2.953* | *3.071* | *3.937* | *1160* | | | |
| | 40S | 3 | 4 | 1 | C10-391.05C-40 040M | 100.0 | 40.0 | 66.7 | 40.0 | 40.0 | | 100.0 | | 80 | 300.0 | 3.95 | 10000 |
| | | | | | | *3.937* | *1.575* | *2.626* | *1.575* | *1.575* | | *3.937* | | *1160* | | | |

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

M1

N22

N15

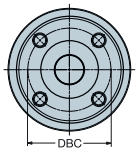


SANDVIK Coromant

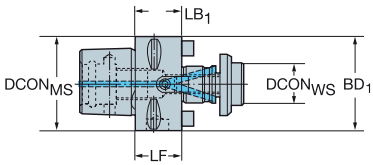
# Coromant Capto® to arbor adapter

**Coolant through arbor**

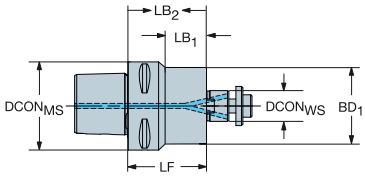
DSGN




1




2




## Inch pilot

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $DCON_{WS}$ | DBC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C3 | 3/4 | 3 | 4 | 1 | C3-A391.05C-19 030 | 32.0 | 19.1 | | 30.0 | 30.0 | | 40.0 | | 80 | 25.0 | 0.35 | 18500 |
| | | | | | | *1.260* | *.750* | | *1.181* | *1.181* | | *1.575* | | *1160* | | | |
| C4 | 3/4 | 3 | 4 | 1 | C4-A391.05C-19 025M | 40.0 | 19.1 | | 25.0 | 25.0 | | 40.0 | | 80 | 25.0 | 0.39 | 18500 |
| | | | | | | *1.575* | *.750* | | *.984* | *.984* | | *1.575* | | *1160* | | | |
| | 3/4 | 3 | 4 | 1 | C4-A391.05C-19 055 | 40.0 | 19.1 | | 55.0 | 55.0 | | 40.0 | | 80 | 25.0 | 0.60 | 18500 |
| | | | | | | *1.575* | *.750* | | *2.165* | *2.165* | | *1.575* | | *1160* | | | |
| | 1 | 3 | 4 | 1 | C4-A391.05C-25 035 | 40.0 | 25.4 | | 35.0 | 35.0 | | 50.0 | | 80 | 65.0 | 0.67 | 17000 |
| | | | | | | *1.575* | *1.000* | | *1.378* | *1.378* | | *1.969* | | *1160* | | | |
| C5 | 3/4 | 3 | 4 | 1 | C5-A391.05C-19 025M | 50.0 | 19.1 | | 25.0 | 25.0 | | 50.0 | | 80 | 25.0 | 0.56 | 16500 |
| | | | | | | *1.969* | *.750* | | *.984* | *.984* | | *1.969* | | *1160* | | | |
| | 3/4 | 3 | 4 | 1 | C5-A391.05C-19 070 | 50.0 | 19.1 | | 70.0 | 48.0 | 70.0 | 43.0 | 50.0 | 80 | 25.0 | 0.90 | 16500 |
| | | | | | | *1.969* | *.750* | | *2.756* | *1.890* | *2.756* | *1.693* | *1.969* | *1160* | | | |
| | 1 | 3 | 4 | 1 | C5-A391.05C-25 025M | 50.0 | 25.4 | | 25.0 | 25.0 | | 54.0 | | 80 | 65.0 | 0.72 | 17000 |
| | | | | | | *1.969* | *1.000* | | *.984* | *.984* | | *2.126* | | *1160* | | | |
| | 1 | 3 | 4 | 1 | C5-A391.05C-25 070 | 50.0 | 25.4 | | 70.0 | 70.0 | | 50.0 | | 80 | 65.0 | 1.10 | 17000 |
| | | | | | | *1.969* | *1.000* | | *2.756* | *2.756* | | *1.969* | | *1160* | | | |
| | 1 1/4 | 3 | 4 | 1 | C5-A391.05C-31 040 | 50.0 | 31.8 | | 40.0 | 40.0 | | 63.0 | | 80 | 120.0 | 1.16 | 14000 |
| | | | | | | *1.969* | *1.250* | | *1.575* | *1.575* | | *2.480* | | *1160* | | | |
| | 1 1/2 | 3 | 4 | 1 | C5-A391.05C-38 045M | 50.0 | 38.1 | 66.7 | 45.0 | 45.0 | | 87.0 | | 80 | 220.0 | 2.06 | 17000 |
| | | | | | | *1.969* | *1.500* | *2.626* | *1.772* | *1.772* | | *3.425* | | *1160* | | | |
| C6 | 3/4 | 3 | 4 | 1 | C6-A391.05C-19 030M | 63.0 | 19.1 | | 30.0 | 30.0 | | 63.0 | | 80 | 25.0 | 1.06 | 16500 |
| | | | | | | *2.480* | *.750* | | *1.181* | *1.181* | | *2.480* | | *1160* | | | |
| | 3/4 | 3 | 4 | 2 | C6-A391.05C-19 080 | 63.0 | 19.1 | | 80.0 | 40.0 | 80.0 | 43.0 | 63.0 | 80 | 25.0 | 1.50 | 16500 |
| | | | | | | *2.480* | *.750* | | *3.150* | *1.575* | *3.150* | *1.693* | *2.480* | *1160* | | | |
| | 1 | 3 | 4 | 1 | C6-A391.05C-25 030M | 63.0 | 25.4 | | 30.0 | 30.0 | | 63.0 | | 80 | 65.0 | 1.17 | 17000 |
| | | | | | | *2.480* | *1.000* | | *1.181* | *1.181* | | *2.480* | | *1160* | | | |
| | 1 | 3 | 4 | 2 | C6-A391.05C-25 080 | 63.0 | 25.4 | | 80.0 | 55.0 | 80.0 | 50.0 | 63.0 | 80 | 65.0 | 1.60 | 17000 |
| | | | | | | *2.480* | *1.000* | | *3.150* | *2.165* | *3.150* | *1.969* | *2.480* | *1160* | | | |
| | 1 1/4 | 3 | 4 | 1 | C6-A391.05C-31 030M | 63.0 | 31.8 | | 30.0 | 30.0 | | 65.0 | | 80 | 120.0 | 1.22 | 14000 |
| | | | | | | *2.480* | *1.250* | | *1.181* | *1.181* | | *2.559* | | *1160* | | | |
| | 1 1/2 | 3 | 4 | 1 | C6-A391.05C-38 050M | 63.0 | 38.1 | 66.7 | 50.0 | 50.0 | | 87.0 | | 80 | 220.0 | 2.52 | 17000 |
| | | | | | | *2.480* | *1.500* | *2.626* | *1.969* | *1.969* | | *3.425* | | *1160* | | | |
| C8 | 3/4 | 3 | 4 | 1 | C8-A391.05C-19 030M | 80.0 | 19.1 | | 30.0 | 30.0 | | 80.0 | | 80 | 25.0 | 1.87 | 14000 |
| | | | | | | *3.150* | *.750* | | *1.181* | *1.181* | | *3.150* | | *1160* | | | |
| | 3/4 | 3 | 4 | 2 | C8-A391.05C-19 090 | 80.0 | 19.1 | | 90.0 | 45.0 | 90.0 | 43.0 | 80.0 | 80 | 25.0 | 2.50 | 14000 |
| | | | | | | *3.150* | *.750* | | *3.543* | *1.772* | *3.543* | *1.693* | *3.150* | *1160* | | | |
| | 1 | 3 | 4 | 1 | C8-A391.05C-25 030M | 80.0 | 25.4 | | 30.0 | 30.0 | | 80.0 | | 80 | 65.0 | 1.98 | 14000 |
| | | | | | | *3.150* | *1.000* | | *1.181* | *1.181* | | *3.150* | | *1160* | | | |
| | 1 | 3 | 4 | 2 | C8-A391.05C-25 090 | 80.0 | 25.4 | | 90.0 | 50.0 | 90.0 | 50.0 | 80.0 | 80 | 65.0 | 2.60 | 14000 |
| | | | | | | *3.150* | *1.000* | | *3.543* | *1.969* | *3.543* | *1.969* | *3.150* | *1160* | | | |
| | 1 1/4 | 3 | 4 | 1 | C8-A391.05C-31 030M | 80.0 | 31.8 | | 30.0 | 30.0 | | 80.0 | | 80 | 120.0 | 2.03 | 14000 |
| | | | | | | *3.150* | *1.250* | | *1.181* | *1.181* | | *3.150* | | *1160* | | | |
| | 1 1/2 | 3 | 4 | 1 | C8-A391.05C-38 060M | 80.0 | 38.1 | 66.7 | 60.0 | 60.0 | | 87.0 | | 80 | 220.0 | 3.58 | 14000 |
| | | | | | | *3.150* | *1.500* | *2.626* | *2.362* | *2.362* | | *3.425* | | *1160* | | | |
| C10 | 1 | 3 | 4 | 2 | C10-A391.05C-25 075 | 100.0 | 25.4 | | 75.0 | 28.0 | 75.0 | 50.0 | 100.0 | 80 | 65.0 | 4.36 | 10000 |
| | | | | | | *3.937* | *1.000* | | *2.953* | *1.102* | *2.953* | *1.969* | *3.937* | *1160* | | | |
| | 1 1/2 | 3 | 4 | 1 | C10-A391.05C-38 040M | 100.0 | 38.1 | 66.7 | 40.0 | 40.0 | | 100.0 | | 80 | 220.0 | 4.05 | 10000 |
| | | | | | | *3.937* | *1.500* | *2.626* | *1.575* | *1.575* | | *3.937* | | *1160* | | | |

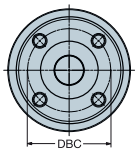
For spare parts, visit www.sandvik.coromant.com

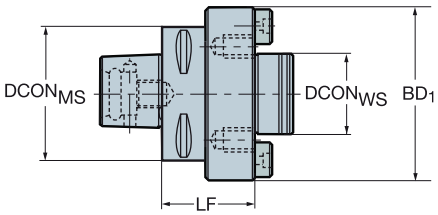
M1

N22

N15

# Coromant Capto® to arbor adapter




## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LF | BD$_1$ | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|
| C8 | 60 | C8-391.05-60 060 | 80.0 | 60.0 | 101.6 | 60.0 | 130.0 | 180.0 | 6.03 | 14000 |
| | | | *3.150* | *2.362* | *4.000* | *2.362* | *5.118* | | | |
| C10 | 60 | C10-391.05-60 075 | 100.0 | 60.0 | 101.6 | 75.0 | 130.0 | 180.0 | 8.50 | 10000 |
| | | | *3.937* | *2.362* | *4.000* | *2.953* | *5.118* | | | |

## Inch pilot

| CZC$_{MS}$ | CZC$_{WS}$ | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LF | BD$_1$ | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|
| C8 | 2 | C8-A391.05-50 060 | 80.0 | 50.8 | 101.6 | 60.0 | 130.0 | 120.0 | 5.44 | 14000 |
| | | | *3.150* | *2.000* | *4.000* | *2.362* | *5.118* | | | |
| | 2 1/2 | C8-A391.05-63 060 | 80.0 | 63.5 | 101.6 | 60.0 | 130.0 | 120.0 | 5.64 | 12000 |
| | | | *3.150* | *2.500* | *4.000* | *2.362* | *5.118* | | | |

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

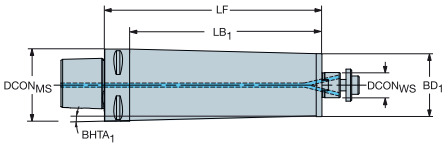
M1 N22

# Coromant Capto® to arbor adapter

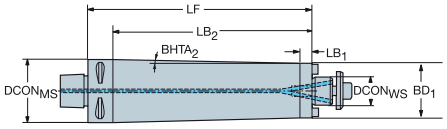
**Coolant through arbor**

**Long conical design**

DSGN 3




DSGN 7




## Metric pilot

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | $BHTA_2$ | BAR PSI | 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 | 22.0 | 0.99 | 18000 |
| | | | | | | *1.575* | *.630* | *4.724* | *.866* | *3.937* | *4.724* | *1.260* | *1.260* | *1.575* | | | *1160* | | | |
| 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 | 45.0 | 2.04 | 16000 |
| | | | | | | *1.969* | *.866* | *5.906* | *.472* | *5.118* | *5.906* | *1.575* | *1.575* | *1.969* | | | *1160* | | | |
| 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 | 45.0 | 2.82 | 16000 |
| | | | | | | *2.480* | *.866* | *4.724* | *3.858* | *4.724* | | *2.165* | *2.480* | | | | *1160* | | | |
| | 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 | 45.0 | 4.25 | 14000 |
| | | | | | | *2.480* | *.866* | *7.480* | *6.614* | *7.480* | | *2.165* | *2.480* | | | | *1160* | | | |
| 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 | 80.0 | 5.62 | 12000 |
| | | | | | | *3.150* | *1.063* | *5.906* | *4.724* | *5.906* | | *2.559* | *3.150* | | | | *1160* | | | |
| | 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 | 80.0 | 8.42 | 10000 |
| | | | | | | *3.150* | *1.063* | *9.449* | *8.268* | *9.449* | | *2.559* | *3.150* | | | | *1160* | | | |

## Inch pilot

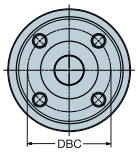
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BHTA_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C5 | 3/4 | 3 | 4 | 7 | **C5-A391.05C-19 150** | 50.0 | 19.1 | 150.0 | 15.0 | 130.0 | 43.0 | 1° | 80 | 25.0 | 2.15 | 16000 |
| | | | | | | *1.969* | *.750* | *5.906* | *.591* | *5.118* | *1.693* | | *1160* | | | |
| C6 | 3/4 | 3 | 4 | 7 | **C6-A391.05C-19 120** | 63.0 | 19.1 | 120.0 | 5.0 | 98.0 | 52.0 | 3° | 80 | 25.0 | 2.72 | 16500 |
| | | | | | | *2.480* | *.750* | *4.724* | *.197* | *3.858* | *2.047* | | *1160* | | | |
| | 3/4 | 3 | 4 | 7 | **C6-A391.05C-19 190** | 63.0 | 19.1 | 190.0 | 5.0 | 168.0 | 52.0 | 1° | 80 | 25.0 | 4.09 | 15000 |
| | | | | | | *2.480* | *.750* | *7.480* | *.197* | *6.614* | *2.047* | | *1160* | | | |

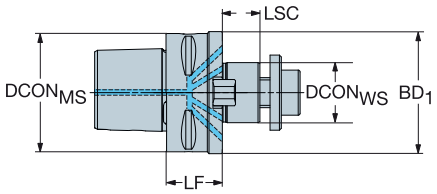
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

# Coromant Capto® to arbor adapter

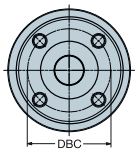
**For CoroMill® QD driving collars**

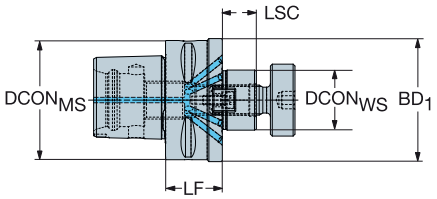



## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LSC | LF | BD$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C6 | 32 | 3 | 3 | **C6-391.07C-32 030** | 63.0 | 32.0 | | 20 | 25.0 | 65.0 | 80 | 180.0 | 1.23 | 12000 |
| | | | | | *2.480* | *1.260* | | *.787* | *.984* | *2.559* | *1160* | | | |
| C8 | 40S | 3 | 3 | **C8-391.07C-40 060** | 80.0 | 40.0 | 66.7 | 23 | 60.0 | 87.0 | 80 | 300.0 | 3.48 | 10000 |
| | | | | | *3.150* | *1.575* | *2.626* | *.906* | *2.362* | *3.425* | *1160* | | | |




## Inch pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LSC | LF | BD$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C6 | 1 1/4 | 3 | 3 | **C6-A391.07C-31 030** | 63.0 | 31.8 | | 18 | 30.0 | 65.0 | 80 | 120.0 | 1.24 | 12000 |
| | | | | | *2.480* | *1.250* | | *.709* | *1.181* | *2.559* | *1160* | | | |
| C8 | 1 1/2 | 3 | 3 | **C8-A391.07C-38 060** | 80.0 | 38.1 | 66.7 | 23 | 60.0 | 87.0 | 80 | 220.0 | 3.60 | 10000 |
| | | | | | *3.150* | *1.500* | *2.626* | *.906* | *2.362* | *3.425* | *1160* | | | |

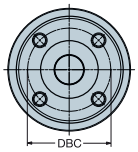
Coolant supply for CoroMill® QD with driving collars. For driving collars, see page M38.
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

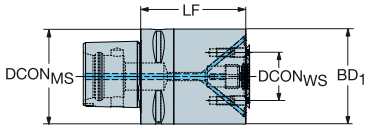
# Coromant Capto® to arbor with driving screws adapter

**For CoroMill® QD with internal coolant supply**

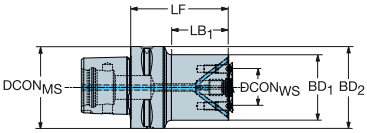
DSGN




1




2




## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C3 | X10 | 3 | 3 | 1 | **C3-X10-032-040** | 32.0 | 10.0 | 22.0 | 2 | 40.0 | 40.0 | | 32.0 | | 80 | 6.4 | 0.28 | 12000 |
| | | | | | | *1.260* | *.394* | *.866* | *.094* | *1.575* | *1.575* | | *1.260* | | *1160* | | | |
| C4 | X10 | 3 | 3 | 2 | **C4-X10-032-050** | 40.0 | 10.0 | 22.0 | 2 | 50.0 | 25.5 | 50.0 | 32.0 | 40.0 | 80 | 6.4 | 0.46 | 12000 |
| | | | | | | *1.575* | *.394* | *.866* | *.094* | *1.969* | *1.004* | *1.969* | *1.260* | *1.575* | *1160* | | | |
| | X22 | 3 | 3 | 1 | **C4-X22-040-050** | 40.0 | 22.0 | 32.0 | 2 | 50.0 | 50.0 | | 40.0 | | 80 | 3.9 | 0.56 | 11000 |
| | | | | | | *1.575* | *.866* | *1.260* | *.094* | *1.969* | *1.969* | | *1.575* | | *1160* | | | |
| C5 | X22 | 3 | 3 | 2 | **C5-X22-040-060** | 50.0 | 22.0 | 32.0 | 2 | 60.0 | 35.0 | 60.0 | 40.0 | 50.0 | 80 | 3.9 | 0.85 | 11000 |
| | | | | | | *1.969* | *.866* | *1.260* | *.094* | *2.362* | *1.378* | *2.362* | *1.575* | *1.969* | *1160* | | | |
| | X32 | 3 | 3 | 1 | **C5-X32-063-070** | 50.0 | 32.0 | 45.0 | 2 | 70.0 | 70.0 | | 63.0 | | 80 | 6.4 | 1.64 | 10000 |
| | | | | | | *1.969* | *1.260* | *1.772* | *.094* | *2.756* | *2.756* | | *2.480* | | *1160* | | | |
| C6 | X32 | 3 | 3 | 1 | **C6-X32-063-070** | 63.0 | 32.0 | 45.0 | 2 | 70.0 | 70.0 | | 63.0 | | 80 | 6.4 | 1.93 | 10000 |
| | | | | | | *2.480* | *1.260* | *1.772* | *.094* | *2.756* | *2.756* | | *2.480* | | *1160* | | | |
| | X40 | 3 | 3 | 1 | **C6-X40-080-090** | 63.0 | 40.0 | 63.0 | 2 | 90.0 | 90.0 | | 80.0 | | 80 | 70.0 | 3.46 | 8000 |
| | | | | | | *2.480* | *1.575* | *2.480* | *.094* | *3.543* | *3.543* | | *3.150* | | *1160* | | | |
| C8 | X40 | 3 | 3 | 1 | **C8-X40-080-095** | 80.0 | 40.0 | 63.0 | 2 | 95.0 | 95.0 | | 80.0 | | 80 | 70.0 | 4.34 | 8000 |
| | | | | | | *3.150* | *1.575* | *2.480* | *.094* | *3.740* | *3.740* | | *3.150* | | *1160* | | | |

## Inch pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LSC | LF | BD$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C4 | Y25 | 3 | 3 | 1 | **C4-Y25-050-060** | 40.0 | 25.4 | 36.0 | 2 | 60.0 | 50.0 | 80 | 3.9 | 0.94 | 11000 |
| | | | | | | *1.575* | *1.000* | *1.417* | *.094* | *2.362* | *1.969* | *1160* | | | |
| C5 | Y25 | 3 | 3 | 1 | **C5-Y25-050-060** | 50.0 | 25.4 | 36.0 | 2 | 60.0 | 50.0 | 80 | 3.9 | 1.06 | 11000 |
| | | | | | | *1.969* | *1.000* | *1.417* | *.094* | *2.362* | *1.969* | *1160* | | | |
| | Y31 | 3 | 3 | 1 | **C5-Y31-063-070** | 50.0 | 31.8 | 45.0 | 2 | 70.0 | 63.0 | 80 | 6.4 | 1.63 | 10000 |
| | | | | | | *1.969* | *1.250* | *1.772* | *.094* | *2.756* | *2.480* | *1160* | | | |
| C6 | Y31 | 3 | 3 | 1 | **C6-Y31-063-070** | 63.0 | 31.8 | 45.0 | 2 | 70.0 | 63.0 | 80 | 6.4 | 1.92 | 10000 |
| | | | | | | *2.480* | *1.250* | *1.772* | *.094* | *2.756* | *2.480* | *1160* | | | |
| | Y38 | 3 | 3 | 1 | **C6-Y38-080-090** | 63.0 | 38.1 | 63.0 | 2 | 90.0 | 80.0 | 80 | 70.0 | 3.43 | 8000 |
| | | | | | | *2.480* | *1.500* | *2.480* | *.094* | *3.543* | *3.150* | *1160* | | | |
| C8 | Y38 | 3 | 3 | 1 | **C8-Y38-080-095** | 80.0 | 38.1 | 63.0 | 2 | 95.0 | 80.0 | 80 | 70.0 | 4.32 | 8000 |
| | | | | | | *3.150* | *1.500* | *2.480* | *.094* | *3.740* | *3.150* | *1160* | | | |

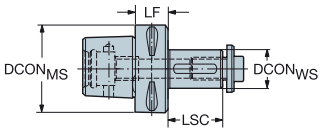
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

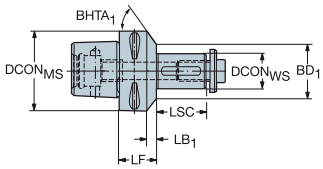
# Coromant Capto® to side and face-mill arbor adapter

DSGN

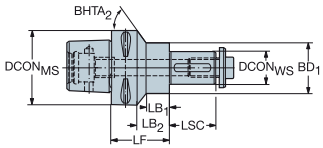
1




3




7




**Metric pilot**

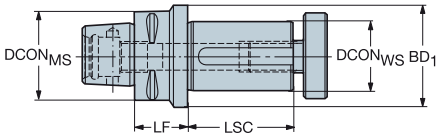
| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | $BHTA_2$ | BAR PSI | 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 | 22.0 | 0.22 | 8000 |
| | | | | | | *1.260* | *.630* | *1.181* | *.787* | *.197* | *.787* | | *1.102* | *1.260* | | | | *1160* | | | |
| 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 | 22.0 | 0.37 | 8000 |
| | | | | | | *1.575* | *.630* | *1.181* | *.984* | *.197* | *.984* | | *1.102* | *1.575* | | | | *1160* | | | |
| | 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 | 45.0 | 0.46 | 8000 |
| | | | | | | *1.575* | *.866* | *1.575* | *.984* | *.197* | *.984* | | *1.417* | *1.575* | | | | *1160* | | | |
| | 27 | 3 | 1 | 1 | C4-391.10-27 025 | 40.0 | 27.0 | 60 | 25.0 | 25.0 | | | 40.0 | | | | | 80 | 80.0 | 0.62 | 7000 |
| | | | | | | *1.575* | *1.063* | *2.362* | *.984* | *.984* | | | *1.575* | | | | | *1160* | | | |
| 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 | 45.0 | 0.72 | 8000 |
| | | | | | | *1.969* | *.866* | *1.575* | *.984* | *.201* | *.984* | | *1.417* | *1.969* | | | | *1160* | | | |
| | 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 | 80.0 | 0.83 | 7000 |
| | | | | | | *1.969* | *1.063* | *2.362* | *.984* | *.197* | *.984* | | *1.693* | *1.969* | | | | *1160* | | | |
| | 32 | 3 | 1 | 1 | C5-391.10-32 025 | 50.0 | 32.0 | 60 | 25.0 | 25.0 | | | 50.0 | | | | | 80 | 180.0 | 0.96 | 6000 |
| | | | | | | *1.969* | *1.260* | *2.362* | *.984* | *.984* | | | *1.969* | | | | | *1160* | | | |
| 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 | 22.0 | 0.97 | 10000 |
| | | | | | | *2.480* | *.630* | *1.181* | *1.181* | *.307* | *1.181* | | *1.102* | *2.480* | | | | *1160* | | | |
| | 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 | 45.0 | 1.10 | 8000 |
| | | | | | | *2.480* | *.866* | *1.575* | *1.181* | *.311* | *1.181* | | *1.417* | *2.480* | | | | *1160* | | | |
| | 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 | 80.0 | 1.25 | 7000 |
| | | | | | | *2.480* | *1.063* | *2.362* | *1.181* | *.307* | *1.181* | | *1.693* | *2.480* | | | | *1160* | | | |
| | 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 | 180.0 | 1.30 | 6000 |
| | | | | | | *2.480* | *1.260* | *2.362* | *.984* | *.118* | *.984* | | *1.890* | *2.480* | | | | *1160* | | | |
| | 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 | 300.0 | 1.57 | 5000 |
| | | | | | | *2.480* | *1.575* | *2.362* | *.984* | *.118* | *.984* | | *2.205* | *2.480* | | | | *1160* | | | |
| 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 | 45.0 | 2.26 | 8000 |
| | | | | | | *3.150* | *.866* | *1.575* | *1.575* | *.402* | *1.575* | | *1.417* | *3.150* | | | | *1160* | | | |
| | 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 | 80.0 | 2.00 | 7000 |
| | | | | | | *3.150* | *1.063* | *2.362* | *1.181* | *.307* | *1.181* | | *1.693* | *3.150* | | | | *1160* | | | |
| | 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 | 180.0 | 2.12 | 6000 |
| | | | | | | *3.150* | *1.260* | *2.362* | *1.181* | *.299* | *1.181* | | *1.890* | *3.150* | | | | *1160* | | | |
| | 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 | 300.0 | 2.38 | 5000 |
| | | | | | | *3.150* | *1.575* | *2.362* | *1.181* | *.311* | *1.181* | | *2.205* | *3.150* | | | | *1160* | | | |
| | 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 | 120.0 | 2.90 | 4500 |
| | | | | | | *3.150* | *1.969* | *2.362* | *1.181* | *.118* | *1.181* | | *2.756* | *3.150* | | | | *1160* | | | |
| | 60 | 3 | 1 | 1 | C8-391.10-60 030 | 80.0 | 60.0 | 60 | 30.0 | 30.0 | | | 80.0 | | | | | 80 | 180.0 | 3.51 | 4000 |
| | | | | | | *3.150* | *2.362* | *2.362* | *1.181* | *1.181* | | | *3.150* | | | | | *1160* | | | |
| 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 | 180.0 | 4.43 | 6000 |
| | | | | | | *3.937* | *1.260* | *2.362* | *2.559* | *.787* | *1.142* | *2.559* | *1.890* | *1.890* | *3.937* | | | *1160* | | | |
| | 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 | 300.0 | 4.87 | 5000 |
| | | | | | | *3.937* | *1.575* | *2.362* | *2.756* | *.984* | *1.339* | *2.756* | *2.205* | *2.205* | *3.937* | | | *1160* | | | |
| | 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 | 120.0 | 5.44 | 4500 |
| | | | | | | *3.937* | *1.969* | *3.150* | *2.165* | *.394* | *.748* | *2.165* | *2.756* | *2.756* | *3.937* | | | *1160* | | | |
| | 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 | 180.0 | 5.93 | 4000 |
| | | | | | | *3.937* | *2.362* | *3.543* | *1.575* | *.157* | *1.575* | | *3.307* | *3.937* | | | | *1160* | | | |

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

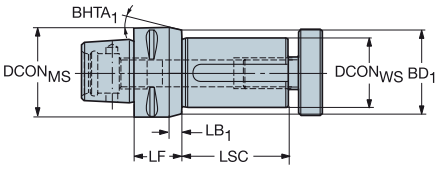
M1 N22 N15

# Coromant Capto® to side and face-mill arbor adapter

DSGN 1



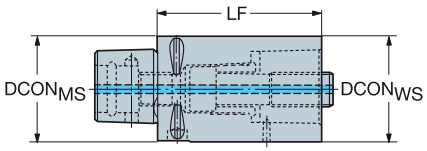

DSGN 3




**Inch pilot**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| C4 | 1 | 3 | 1 | 1 | C4-A391.10-25 025 | 40.0 | 25.4 | 50 | 25.0 | 25.0 | | 40.0 | | | 80 | 65.0 | 0.55 | 7000 |
| | | | | | | *1.575* | *1.000* | *1.969* | *.984* | *.984* | | *1.575* | | | *1160* | | | |
| | 1 1/4 | 3 | 1 | 1 | C4-A391.10-31 035 | 40.0 | 31.8 | 60 | 35.0 | 35.0 | | 50.0 | | | 80 | 120.0 | 0.96 | 6000 |
| | | | | | | *1.575* | *1.250* | *2.362* | *1.378* | *1.378* | | *1.969* | | | *1160* | | | |
| C5 | 1 | 3 | 1 | 3 | C5-A391.10-25 025 | 50.0 | 25.4 | 50 | 25.0 | 5.0 | 25.0 | 43.0 | 50.0 | 35° | 80 | 65.0 | 0.76 | 7000 |
| | | | | | | *1.969* | *1.000* | *1.969* | *.984* | *.197* | *.984* | *1.693* | *1.969* | | *1160* | | | |
| | 1 1/4 | 3 | 1 | 1 | C5-A391.10-31 025 | 50.0 | 31.8 | 60 | 25.0 | 25.0 | | 50.0 | | | 80 | 120.0 | 0.99 | 6000 |
| | | | | | | *1.969* | *1.250* | *2.362* | *.984* | *.984* | | *1.969* | | | *1160* | | | |
| | 1 1/2 | 3 | 1 | 1 | C5-A391.10-38 030 | 50.0 | 38.1 | 60 | 30.0 | 30.0 | | 57.0 | | | 80 | 220.0 | 1.28 | 5000 |
| | | | | | | *1.969* | *1.500* | *2.362* | *1.181* | *1.181* | | *2.244* | | | *1160* | | | |
| C6 | 1 | 3 | 1 | 3 | C6-A391.10-25 030 | 63.0 | 25.4 | 50 | 30.0 | 8.0 | 30.0 | 43.0 | 63.0 | 52° | 80 | 65.0 | 1.20 | 7000 |
| | | | | | | *2.480* | *1.000* | *1.969* | *1.181* | *.315* | *1.181* | *1.693* | *2.480* | | *1160* | | | |
| | 1 1/4 | 3 | 1 | 3 | C6-A391.10-31 025 | 63.0 | 31.8 | 60 | 25.0 | 3.0 | 25.0 | 48.0 | 63.0 | 68° | 80 | 120.0 | 1.33 | 6000 |
| | | | | | | *2.480* | *1.250* | *2.362* | *.984* | *.118* | *.984* | *1.890* | *2.480* | | *1160* | | | |
| | 1 1/2 | 3 | 1 | 3 | C6-A391.10-38 025 | 63.0 | 38.1 | 60 | 25.0 | 3.0 | 25.0 | 56.0 | 63.0 | 50° | 80 | 220.0 | 1.53 | 5000 |
| | | | | | | *2.480* | *1.500* | *2.362* | *.984* | *.118* | *.984* | *2.205* | *2.480* | | *1160* | | | |
| C8 | 1 1/2 | 3 | 1 | 3 | C8-A391.10-38 030 | 80.0 | 38.1 | 60 | 30.0 | 8.0 | 30.0 | 56.0 | 80.0 | 56° | 80 | 220.0 | 2.35 | 5000 |
| | | | | | | *3.150* | *1.500* | *2.362* | *1.181* | *.315* | *1.181* | *2.205* | *3.150* | | *1160* | | | |
| | 2 | 3 | 1 | 3 | C8-A391.10-50 030 | 80.0 | 50.8 | 60 | 30.0 | 3.0 | 30.0 | 70.0 | 80.0 | 59° | 80 | 120.0 | 3.07 | 4500 |
| | | | | | | *3.150* | *2.000* | *2.362* | *1.181* | *.118* | *1.181* | *2.756* | *3.150* | | *1160* | | | |
| | 2 1/2 | 3 | 1 | 1 | C8-A391.10-63 040 | 80.0 | 63.5 | 60 | 40.0 | 40.0 | | 86.0 | | | 80 | 120.0 | 4.10 | 4000 |
| | | | | | | *3.150* | *2.500* | *2.362* | *1.575* | *1.575* | | *3.386* | | | *1160* | | | |

# Coromant Capto® to VL adapter




| | | | | | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | BAR PSI | NM | KG |
| C8 | 80 | 3 | 1 | C8-391.01-V80 065 | 80.0 | 80.0 | 65.0 | 80 | 170.0 | 3.05 |
| | | | | | *3.150* | *3.150* | *2.559* | *1160* | | |

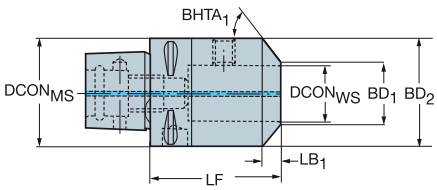
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

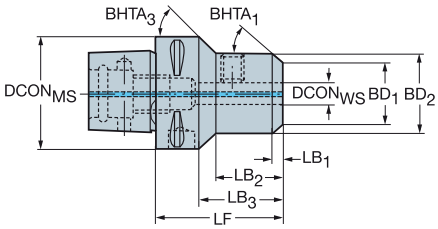
# Coromant Capto® to Weldon adapter

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

DSGN 3




DSGN 14




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | $BHTA_3$ | BAR PSI | 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 | 17.0 | 25.0 | 25.0 | 32 | 45° | 60° | 20 | 3.0 | 0.22 | 32000 |
| | | | | | | *1.260* | *.236* | *1.811* | *.157* | *1.083* | *1.161* | *.669* | *.984* | *.984* | *1.260* | | | *290* | | | |
| | 8 | 3 | 1 | 14 | C3-391.20-08 045A | 32.0 | 8.0 | 46.0 | 4.0 | 29.0 | 31.0 | 20.0 | 28.0 | 28.0 | 32 | 45° | 45° | 20 | 7.0 | 0.24 | 32000 |
| | | | | | | *1.260* | *.315* | *1.811* | *.157* | *1.142* | *1.220* | *.787* | *1.102* | *1.102* | *1.260* | | | *290* | | | |
| | 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 | 10.0 | 0.34 | 32000 |
| | | | | | | *1.260* | *.394* | *1.969* | *.157* | *1.969* | | *1.063* | *1.378* | | | | | *290* | | | |
| | 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 | 12.0 | 0.47 | 32000 |
| | | | | | | *1.260* | *.472* | *2.165* | *.197* | *2.165* | | *1.260* | *1.654* | | | | | *290* | | | |
| C4 | 6 | 3 | 1 | 14 | C4-391.20-06 050 | 40.0 | 6.0 | 50.0 | 4.0 | 25.5 | 29.8 | 17.0 | 25.0 | 25.0 | 40 | 45° | 60° | 20 | 3.0 | 0.35 | 30000 |
| | | | | | | *1.575* | *.236* | *1.969* | *.157* | *1.004* | *1.173* | *.669* | *.984* | *.984* | *1.575* | | | *290* | | | |
| | 8 | 3 | 1 | 14 | C4-391.20-08 050 | 40.0 | 8.0 | 50.0 | 4.0 | 26.5 | 32.5 | 20.0 | 28.0 | 28.0 | 40 | 45° | 45° | 20 | 7.0 | 0.37 | 30000 |
| | | | | | | *1.575* | *.315* | *1.969* | *.157* | *1.043* | *1.280* | *.787* | *1.102* | *1.102* | *1.575* | | | *290* | | | |
| | 10 | 3 | 1 | 14 | C4-391.20-10 050A | 40.0 | 10.0 | 51.0 | 4.0 | 29.6 | 31.0 | 27.0 | 35.0 | 35.0 | 40 | 45° | 60° | 20 | 10.0 | 0.44 | 30000 |
| | | | | | | *1.575* | *.394* | *2.008* | *.157* | *1.165* | *1.220* | *1.063* | *1.378* | *1.378* | *1.575* | | | *290* | | | |
| | 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 | 12.0 | 0.57 | 30000 |
| | | | | | | *1.575* | *.472* | *2.205* | *.197* | *2.205* | | *1.260* | *1.654* | | | | | *290* | | | |
| | 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 | 12.0 | 0.58 | 30000 |
| | | | | | | *1.575* | *.551* | *2.165* | *.197* | *2.165* | | *1.339* | *1.732* | | | | | *290* | | | |
| | 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 | 15.0 | 0.63 | 30000 |
| | | | | | | *1.575* | *.630* | *2.165* | *.197* | *2.165* | | *1.496* | *1.890* | | | | | *290* | | | |
| C5 | 6 | 3 | 1 | 14 | C5-391.20-06 050 | 50.0 | 6.0 | 50.0 | 4.0 | 25.5 | 30.0 | 17.0 | 25.0 | 25.0 | 50 | 45° | 70° | 20 | 3.0 | 0.54 | 28000 |
| | | | | | | *1.969* | *.236* | *1.969* | *.157* | *1.004* | *1.181* | *.669* | *.984* | *.984* | *1.969* | | | *290* | | | |
| | 8 | 3 | 1 | 14 | C5-391.20-08 050 | 50.0 | 8.0 | 50.0 | 4.0 | 26.0 | 30.0 | 20.0 | 28.0 | 28.0 | 50 | 45° | 70° | 20 | 7.0 | 0.56 | 28000 |
| | | | | | | *1.969* | *.315* | *1.969* | *.157* | *1.024* | *1.181* | *.787* | *1.102* | *1.102* | *1.969* | | | *290* | | | |
| | 10 | 3 | 1 | 14 | C5-391.20-10 055 | 50.0 | 10.0 | 55.0 | 4.0 | 27.5 | 35.0 | 27.0 | 35.0 | 35.0 | 50 | 45° | 45° | 20 | 10.0 | 0.67 | 28000 |
| | | | | | | *1.969* | *.394* | *2.165* | *.157* | *1.083* | *1.378* | *1.063* | *1.378* | *1.378* | *1.969* | | | *290* | | | |
| | 12 | 3 | 1 | 14 | C5-391.20-12 060 | 50.0 | 12.0 | 60.0 | 5.0 | 36.0 | 40.0 | 32.0 | 42.0 | 42.0 | 50 | 45° | 45° | 20 | 12.0 | 0.79 | 28000 |
| | | | | | | *1.969* | *.472* | *2.362* | *.197* | *1.417* | *1.575* | *1.260* | *1.654* | *1.654* | *1.969* | | | *290* | | | |
| | 14 | 3 | 1 | 14 | C5-391.20-14 060 | 50.0 | 14.0 | 60.0 | 5.0 | 37.0 | 40.0 | 34.0 | 44.0 | 44.0 | 50 | 45° | 45° | 20 | 12.0 | 0.82 | 28000 |
| | | | | | | *1.969* | *.551* | *2.362* | *.197* | *1.457* | *1.575* | *1.339* | *1.732* | *1.732* | *1.969* | | | *290* | | | |
| | 16 | 3 | 1 | 14 | C5-391.20-16 060 | 50.0 | 16.0 | 60.0 | 5.0 | 39.0 | 40.0 | 38.0 | 48.0 | 48.0 | 50 | 45° | 45° | 20 | 15.0 | 0.88 | 28000 |
| | | | | | | *1.969* | *.630* | *2.362* | *.197* | *1.535* | *1.575* | *1.496* | *1.890* | *1.890* | *1.969* | | | *290* | | | |
| | 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 | 15.0 | 0.90 | 28000 |
| | | | | | | *1.969* | *.709* | *2.362* | *.197* | *2.362* | | *1.575* | *1.969* | | | | | *290* | | | |
| | 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 | 20.0 | 0.92 | 28000 |
| | | | | | | *1.969* | *.787* | *2.362* | *.197* | *2.362* | | *1.654* | *2.047* | | | | | *290* | | | |
| | 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 | 25.0 | 1.59 | 28000 |
| | | | | | | *1.969* | *.984* | *3.150* | *.315* | *3.150* | | *1.929* | *2.559* | | | | | *290* | | | |

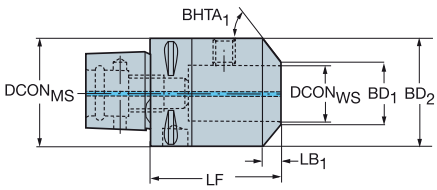
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

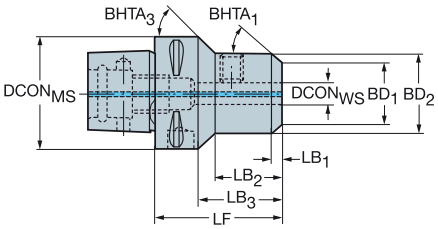
# Coromant Capto® to Weldon adapter

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

DSGN 3




DSGN 14




## Metric bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | $BHTA_3$ | BAR PSI | NM | KG | RPMX |
| C6 | 6 | 3 | 1 | 14 | C6-391.20-06 055 | 63.0 | 6.0 | 55.0 | 4.0 | 25.0 | 32.7 | 17.0 | 25.0 | 25.0 | 63 | 45° | 68° | 20 | 3.0 | 0.92 | 20000 |
| | | | | | | *2.480* | *.236* | *2.165* | *.157* | *.984* | *1.287* | *.669* | *.984* | *.984* | *2.480* | | | *290* | | | |
| | 8 | 3 | 1 | 14 | C6-391.20-08 055 | 63.0 | 8.0 | 55.0 | 4.0 | 26.0 | 33.1 | 20.0 | 28.0 | 28.0 | 63 | 45° | 68° | 20 | 7.0 | 0.93 | 20000 |
| | | | | | | *2.480* | *.315* | *2.165* | *.157* | *1.024* | *1.303* | *.787* | *1.102* | *1.102* | *2.480* | | | *290* | | | |
| | 10 | 3 | 1 | 14 | C6-391.20-10 060 | 63.0 | 10.0 | 60.0 | 4.0 | 30.0 | 38.1 | 27.0 | 35.0 | 35.0 | 63 | 45° | 60° | 20 | 10.0 | 1.05 | 20000 |
| | | | | | | *2.480* | *.394* | *2.362* | *.157* | *1.181* | *1.500* | *1.063* | *1.378* | *1.378* | *2.480* | | | *290* | | | |
| | 12 | 3 | 1 | 14 | C6-391.20-12 060 | 63.0 | 12.0 | 60.0 | 5.0 | 33.0 | 37.9 | 32.0 | 42.0 | 42.0 | 63 | 45° | 65° | 20 | 12.0 | 1.13 | 20000 |
| | | | | | | *2.480* | *.472* | *2.362* | *.197* | *1.299* | *1.492* | *1.260* | *1.654* | *1.654* | *2.480* | | | *290* | | | |
| | 14 | 3 | 1 | 14 | C6-391.20-14 060 | 63.0 | 14.0 | 60.0 | 5.0 | 33.5 | 37.9 | 34.0 | 44.0 | 44.0 | 63 | 45° | 65° | 20 | 12.0 | 1.15 | 20000 |
| | | | | | | *2.480* | *.551* | *2.362* | *.197* | *1.319* | *1.492* | *1.339* | *1.732* | *1.732* | *2.480* | | | *290* | | | |
| | 16 | 3 | 1 | 14 | C6-391.20-16 065 | 63.0 | 16.0 | 65.0 | 5.0 | 35.5 | 43.0 | 38.0 | 48.0 | 48.0 | 63 | 45° | 45° | 20 | 15.0 | 1.29 | 20000 |
| | | | | | | *2.480* | *.630* | *2.559* | *.197* | *1.398* | *1.693* | *1.496* | *1.890* | *1.890* | *2.480* | | | *290* | | | |
| | 18 | 3 | 1 | 14 | C6-391.20-18 065 | 63.0 | 18.0 | 65.0 | 5.0 | 39.0 | 42.7 | 40.0 | 50.0 | 50.0 | 63 | 45° | 60° | 20 | 15.0 | 1.30 | 20000 |
| | | | | | | *2.480* | *.709* | *2.559* | *.197* | *1.535* | *1.681* | *1.575* | *1.969* | *1.969* | *2.480* | | | *290* | | | |
| | 20 | 3 | 1 | 14 | C6-391.20-20 065 | 63.0 | 20.0 | 65.0 | 5.0 | 37.5 | 43.0 | 42.0 | 52.0 | 52.0 | 63 | 45° | 45° | 20 | 20.0 | 1.33 | 20000 |
| | | | | | | *2.480* | *.787* | *2.559* | *.197* | *1.476* | *1.693* | *1.654* | *2.047* | *2.047* | *2.480* | | | *290* | | | |
| | 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 | 25.0 | 1.91 | 20000 |
| | | | | | | *2.480* | *.984* | *3.150* | *.315* | *3.150* | | *1.929* | *2.559* | | | | | *290* | | | |
| | 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 | 45.0 | 2.36 | 20000 |
| | | | | | | *2.480* | *1.260* | *3.543* | *.315* | *3.543* | | *2.205* | *2.835* | | | | | *290* | | | |
| | 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 | 45.0 | 3.70 | 20000 |
| | | | | | | *2.480* | *1.575* | *3.937* | *.315* | *3.937* | | *2.913* | *3.543* | | | | | *290* | | | |
| C8 | 6 | 3 | 1 | 14 | C8-391.20-06 070 | 80.0 | 6.0 | 70.0 | 4.0 | 27.0 | 40.0 | 17.0 | 25.0 | 25.0 | 80 | 45° | 65° | 20 | 3.0 | 2.00 | 14000 |
| | | | | | | *3.150* | *.236* | *2.756* | *.157* | *1.063* | *1.575* | *.669* | *.984* | *.984* | *3.150* | | | *290* | | | |
| | 8 | 3 | 1 | 14 | C8-391.20-08 070 | 80.0 | 8.0 | 70.0 | 4.0 | 28.0 | 40.0 | 20.0 | 28.0 | 28.0 | 80 | 45° | 65° | 20 | 7.0 | 2.02 | 14000 |
| | | | | | | *3.150* | *.315* | *2.756* | *.157* | *1.102* | *1.575* | *.787* | *1.102* | *1.102* | *3.150* | | | *290* | | | |
| | 10 | 3 | 1 | 14 | C8-391.20-10 070 | 80.0 | 10.0 | 70.0 | 4.0 | 29.5 | 40.0 | 27.0 | 35.0 | 35.0 | 80 | 45° | 65° | 20 | 10.0 | 2.10 | 14000 |
| | | | | | | *3.150* | *.394* | *2.756* | *.157* | *1.161* | *1.575* | *1.063* | *1.378* | *1.378* | *3.150* | | | *290* | | | |
| | 12 | 3 | 1 | 14 | C8-391.20-12 070 | 80.0 | 12.0 | 70.0 | 5.0 | 31.0 | 40.0 | 32.0 | 42.0 | 42.0 | 80 | 45° | 65° | 20 | 12.0 | 2.18 | 14000 |
| | | | | | | *3.150* | *.472* | *2.756* | *.197* | *1.220* | *1.575* | *1.260* | *1.654* | *1.654* | *3.150* | | | *290* | | | |
| | 14 | 3 | 1 | 14 | C8-391.20-14 070 | 80.0 | 14.0 | 70.0 | 5.0 | 31.6 | 40.0 | 34.0 | 44.0 | 44.0 | 80 | 45° | 65° | 20 | 12.0 | 2.20 | 14000 |
| | | | | | | *3.150* | *.551* | *2.756* | *.197* | *1.244* | *1.575* | *1.339* | *1.732* | *1.732* | *3.150* | | | *290* | | | |
| | 16 | 3 | 1 | 14 | C8-391.20-16 070 | 80.0 | 16.0 | 70.0 | 5.0 | 33.0 | 40.0 | 38.0 | 48.0 | 48.0 | 80 | 45° | 65° | 20 | 15.0 | 2.25 | 14000 |
| | | | | | | *3.150* | *.630* | *2.756* | *.197* | *1.299* | *1.575* | *1.496* | *1.890* | *1.890* | *3.150* | | | *290* | | | |
| | 18 | 3 | 1 | 14 | C8-391.20-18 070 | 80.0 | 18.0 | 70.0 | 5.0 | 33.0 | 40.0 | 40.0 | 50.0 | 50.0 | 80 | 45° | 65° | 20 | 15.0 | 2.27 | 14000 |
| | | | | | | *3.150* | *.709* | *2.756* | *.197* | *1.299* | *1.575* | *1.575* | *1.969* | *1.969* | *3.150* | | | *290* | | | |
| | 20 | 3 | 1 | 14 | C8-391.20-20 070 | 80.0 | 20.0 | 70.0 | 5.0 | 35.5 | 40.0 | 42.0 | 52.0 | 52.0 | 80 | 45° | 70° | 20 | 20.0 | 2.27 | 14000 |
| | | | | | | *3.150* | *.787* | *2.756* | *.197* | *1.398* | *1.575* | *1.654* | *2.047* | *2.047* | *3.150* | | | *290* | | | |
| | 25 | 3 | 1 | 14 | C8-391.20-25 080 | 80.0 | 25.0 | 80.0 | 8.0 | 53.7 | 58.0 | 49.0 | 65.0 | 65.0 | 80 | 45° | 60° | 20 | 25.0 | 2.58 | 14000 |
| | | | | | | *3.150* | *.984* | *3.150* | *.315* | *2.114* | *2.283* | *1.929* | *2.559* | *2.559* | *3.150* | | | *290* | | | |
| | 32 | 3 | 1 | 14 | C8-391.20-32 080 | 80.0 | 32.0 | 80.0 | 8.0 | 55.7 | 58.0 | 56.0 | 72.0 | 72.0 | 80 | 45° | 60° | 20 | 45.0 | 2.73 | 14000 |
| | | | | | | *3.150* | *1.260* | *3.150* | *.315* | *2.193* | *2.283* | *2.205* | *2.835* | *2.835* | *3.150* | | | *290* | | | |
| | 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 | 45.0 | 4.77 | 14000 |
| | | | | | | *3.150* | *1.575* | *4.331* | *.315* | *4.331* | | *2.913* | *3.543* | | | | | *290* | | | |
| | 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 | 60.0 | 5.69 | 14000 |
| | | | | | | *3.150* | *1.969* | *4.724* | *.315* | *4.724* | | *3.307* | *3.937* | | | | | *290* | | | |

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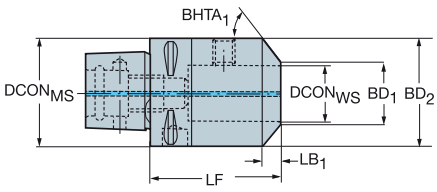
M1 N22 N15

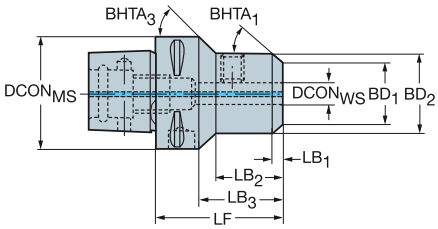
# Coromant Capto® to Weldon adapter

**Workpiece side interface ANSI B94.19**

DSGN 3




DSGN 14




**Inch bore**

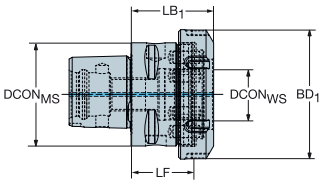
| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | $BHTA_3$ | BAR PSI | NM | KG | RPMX |
| C4 | 3/8 | 3 | 1 | 14 | C4-A391.20-09 050A | 40.0 | 9.5 | 51.0 | 7.5 | 28.3 | 31.0 | 16.7 | 25.4 | 25.4 | 40 | 30° | 70° | 20 | 8.0 | 0.34 | 30000 |
| | | | | | | *1.575* | *.375* | *2.008* | *.295* | *1.114* | *1.220* | *.657* | *1.000* | *1.000* | *1.575* | | | *290* | | | |
| | 1/2 | 3 | 1 | 14 | C4-A391.20-12 055A | 40.0 | 12.7 | 56.0 | 7.5 | 31.8 | 36.0 | 23.0 | 31.7 | 31.7 | 40 | 30° | 45° | 20 | 12.0 | 0.41 | 30000 |
| | | | | | | *1.575* | *.500* | *2.205* | *.295* | *1.252* | *1.417* | *.906* | *1.248* | *1.248* | *1.575* | | | *290* | | | |
| | 5/8 | 3 | 1 | 3 | C4-A391.20-15 055 | 40.0 | 15.9 | 55.0 | 7.5 | 55.0 | | 32.3 | 41.0 | | | 30° | | 20 | 13.0 | 0.51 | 30000 |
| | | | | | | *1.575* | *.625* | *2.165* | *.295* | *2.165* | | *1.272* | *1.614* | | | | | *290* | | | |
| | 3/4 | 3 | 1 | 3 | C4-A391.20-19 060 | 40.0 | 19.1 | 60.0 | 7.5 | 60.0 | | 35.8 | 44.5 | | | 30° | | 20 | 20.0 | 0.58 | 30000 |
| | | | | | | *1.575* | *.750* | *2.362* | *.295* | *2.362* | | *1.409* | *1.752* | | | | | *290* | | | |
| C5 | 3/8 | 3 | 1 | 14 | C5-A391.20-09 055 | 50.0 | 9.5 | 55.0 | 7.5 | 28.0 | 35.1 | 16.7 | 25.4 | 25.4 | 50 | 30° | 60° | 20 | 8.0 | 0.55 | 28000 |
| | | | | | | *1.969* | *.375* | *2.165* | *.295* | *1.102* | *1.382* | *.657* | *1.000* | *1.000* | *1.969* | | | *290* | | | |
| | 1/2 | 3 | 1 | 14 | C5-A391.20-12 060 | 50.0 | 12.7 | 60.0 | 7.5 | 35.7 | 40.0 | 23.0 | 31.7 | 31.7 | 50 | 30° | 60° | 20 | 12.0 | 0.62 | 28000 |
| | | | | | | *1.969* | *.500* | *2.362* | *.295* | *1.406* | *1.575* | *.906* | *1.248* | *1.248* | *1.969* | | | *290* | | | |
| | 5/8 | 3 | 1 | 14 | C5-A391.20-15 060A | 50.0 | 15.9 | 60.0 | 7.5 | 38.4 | 40.0 | 32.3 | 41.0 | 41.0 | 50 | 30° | 60° | 20 | 13.0 | 0.74 | 28000 |
| | | | | | | *1.969* | *.625* | *2.362* | *.295* | *1.512* | *1.575* | *1.272* | *1.614* | *1.614* | *1.969* | | | *290* | | | |
| | 3/4 | 3 | 1 | 14 | C5-A391.20-19 060 | 50.0 | 19.1 | 60.0 | 7.5 | 38.4 | 40.0 | 35.8 | 44.5 | 44.5 | 50 | 30° | 60° | 20 | 20.0 | 0.76 | 28000 |
| | | | | | | *1.969* | *.750* | *2.362* | *.295* | *1.512* | *1.575* | *1.409* | *1.752* | *1.752* | *1.969* | | | *290* | | | |
| | 1 | 3 | 1 | 3 | C5-A391.20-25 085 | 50.0 | 25.4 | 85.0 | 7.5 | 85.0 | | 48.4 | 57.1 | | | 30° | | 20 | 25.0 | 1.37 | 28000 |
| | | | | | | *1.969* | *1.000* | *3.346* | *.295* | *3.346* | | *1.906* | *2.248* | | | | | *290* | | | |
| | 1 1/4 | 3 | 1 | 3 | C5-A391.20-31 085 | 50.0 | 31.8 | 85.0 | 7.5 | 85.0 | | 54.3 | 63.0 | | | 30° | | 20 | 40.0 | 1.50 | 28000 |
| | | | | | | *1.969* | *1.250* | *3.347* | *.295* | *3.346* | | *2.138* | *2.480* | | | | | *290* | | | |
| C6 | 3/8 | 3 | 1 | 14 | C6-A391.20-09 060 | 63.0 | 9.5 | 60.0 | 7.5 | 29.0 | 37.8 | 16.7 | 25.4 | 25.4 | 63 | 30° | 65° | 20 | 8.0 | 0.93 | 20000 |
| | | | | | | *2.480* | *.375* | *2.362* | *.295* | *1.142* | *1.488* | *.657* | *1.000* | *1.000* | *2.480* | | | *290* | | | |
| | 1/2 | 3 | 1 | 14 | C6-A391.20-12 060 | 63.0 | 12.7 | 60.0 | 7.5 | 32.0 | 37.7 | 23.0 | 31.7 | 31.7 | 63 | 30° | 70° | 20 | 12.0 | 0.97 | 20000 |
| | | | | | | *2.480* | *.500* | *2.362* | *.295* | *1.260* | *1.484* | *.906* | *1.248* | *1.248* | *2.480* | | | *290* | | | |
| C8 | 3/8 | 3 | 1 | 14 | C8-A391.20-09 070 | 80.0 | 9.5 | 70.0 | 7.5 | 27.5 | 40.2 | 16.7 | 25.4 | 25.4 | 80 | 30° | 65° | 20 | 8.0 | 1.99 | 14000 |
| | | | | | | *3.150* | *.375* | *2.756* | *.295* | *1.083* | *1.583* | *.657* | *1.000* | *1.000* | *3.150* | | | *290* | | | |
| | 1/2 | 3 | 1 | 14 | C8-A391.20-12 070 | 80.0 | 12.7 | 70.0 | 7.5 | 31.0 | 39.8 | 23.0 | 31.7 | 31.7 | 80 | 30° | 70° | 20 | 12.0 | 2.01 | 14000 |
| | | | | | | *3.150* | *.500* | *2.756* | *.295* | *1.220* | *1.567* | *.906* | *1.248* | *1.248* | *3.150* | | | *290* | | | |

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

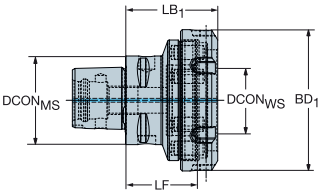
M1 N22 N15

# Coromant Capto® to MDI adapter

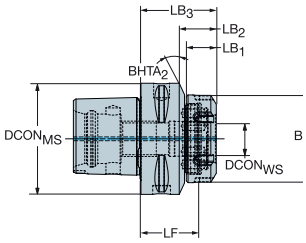
DSGN 1




1




2



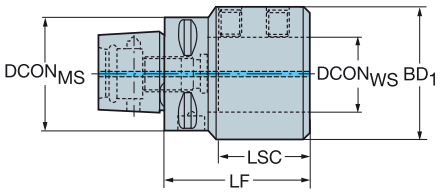

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C3 | MDI-20 | 3 | 1 | 1 | **C3-DM20-N-032** | 32.0 | 20.0 | 32.0 | 42.0 | | 49.7 | | 80 | 135.0 | 0.31 | 55000 |
| | | | | | | *1.260* | *.787* | *1.260* | *1.654* | | *1.957* | | *1160* | | | |
| C4 | MDI-20 | 3 | 1 | 1 | **C4-DM20-N-028** | 40.0 | 20.0 | 28.0 | 38.0 | | 49.7 | | 80 | 135.0 | 0.40 | 39000 |
| | | | | | | *1.575* | *.787* | *1.102* | *1.496* | | *1.957* | | *1160* | | | |
| | MDI-25 | 3 | 1 | 1 | **C4-DM25-N-035** | 40.0 | 25.0 | 35.0 | 45.0 | | 62.7 | | 80 | 170.0 | 0.58 | 39000 |
| | | | | | | *1.575* | *.984* | *1.378* | *1.772* | | *2.469* | | *1160* | | | |
| | MDI-32 | 3 | 1 | 1 | **C4-DM32-N-042** | 40.0 | 32.0 | 42.0 | 52.0 | | 67.7 | | 80 | 200.0 | 0.71 | 39000 |
| | | | | | | *1.575* | *1.260* | *1.654* | *2.047* | | *2.665* | | *1160* | | | |
| 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 | 135.0 | 0.57 | 28000 |
| | | | | | | *1.969* | *.787* | *1.102* | *.709* | *1.496* | *1.957* | *1.969* | *1160* | | | |
| | MDI-25 | 3 | 1 | 1 | **C5-DM25-N-030** | 50.0 | 25.0 | 30.0 | 40.0 | | 62.7 | | 80 | 170.0 | 0.67 | 28000 |
| | | | | | | *1.969* | *.984* | *1.181* | *1.575* | | *2.469* | | *1160* | | | |
| | MDI-32 | 3 | 1 | 1 | **C5-DM32-N-035** | 50.0 | 32.0 | 35.0 | 45.0 | | 67.7 | | 80 | 200.0 | 0.77 | 28000 |
| | | | | | | *1.969* | *1.260* | *1.378* | *1.772* | | *2.665* | | *1160* | | | |
| | MDI-40 | 3 | 1 | 1 | **C5-DM40-N-040** | 50.0 | 40.0 | 40.0 | 52.0 | | 79.7 | | 80 | 230.0 | 1.00 | 28000 |
| | | | | | | *1.969* | *1.575* | *1.575* | *2.047* | | *3.138* | | *1160* | | | |
| 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 | 135.0 | 0.96 | 20000 |
| | | | | | | *2.480* | *.787* | *1.299* | *.709* | *1.693* | *1.957* | *2.480* | *1160* | | | |
| | MDI-25 | 3 | 1 | 2 | **C6-DM25-N-030** | 63.0 | 25.0 | 30.0 | 18.0 | 40.0 | 62.7 | 63.0 | 80 | 170.0 | 1.00 | 20000 |
| | | | | | | *2.480* | *.984* | *1.181* | *.709* | *1.575* | *2.469* | *2.480* | *1160* | | | |
| | MDI-32 | 3 | 1 | 1 | **C6-DM32-N-030** | 63.0 | 32.0 | 30.0 | 40.0 | | 67.7 | | 80 | 200.0 | 0.99 | 20000 |
| | | | | | | *2.480* | *1.260* | *1.181* | *1.575* | | *2.665* | | *1160* | | | |
| | MDI-40 | 3 | 1 | 1 | **C6-DM40-N-040** | 63.0 | 40.0 | 40.0 | 52.0 | | 79.7 | | 80 | 230.0 | 1.34 | 20000 |
| | | | | | | *2.480* | *1.575* | *1.575* | *2.047* | | *3.138* | | *1160* | | | |
| 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 | 200.0 | 2.01 | 14000 |
| | | | | | | *3.150* | *1.260* | *1.575* | *.709* | *1.969* | *2.665* | *3.150* | *1160* | | | |
| | MDI-40 | 3 | 1 | 2 | **C8-DM40-N-040** | 80.0 | 40.0 | 40.0 | 22.0 | 52.0 | 79.7 | 80.0 | 80 | 230.0 | 2.09 | 14000 |
| | | | | | | *3.150* | *1.575* | *1.575* | *.866* | *2.047* | *3.138* | *3.150* | *1160* | | | |

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

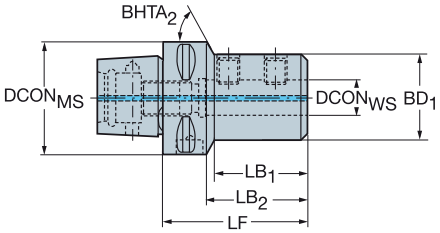
M1 N22 N15 N5

# Coromant Capto® to ISO 9766 adapter

DSGN 1




DSGN 7




**Metric bore**

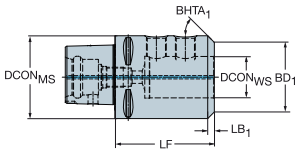
| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_2$ | BAR PSI | 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 | 10.0 | 0.35 | 32000 |
| | | | | | | *1.260* | *.630* | *1.949* | *2.205* | *2.205* | | | *1.417* | | | | *290* | | | |
| | 20 | 3 | 1 | 1 | C3-391.27-20 060 | 32.0 | 20.0 | 51 | 60.0 | 60.0 | | | 40.0 | | | | 20 | 12.0 | 0.42 | 32000 |
| | | | | | | *1.260* | *.787* | *2.028* | *2.362* | *2.362* | | | *1.575* | | | | *290* | | | |
| | 25 | 3 | 1 | 1 | C3-391.27-25 080 | 32.0 | 25.0 | 57 | 80.0 | 80.0 | | | 45.0 | | | | 20 | 20.0 | 0.66 | 32000 |
| | | | | | | *1.260* | *.984* | *2.264* | *3.150* | *3.150* | | | *1.772* | | | | *290* | | | |
| 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 | 10.0 | 0.45 | 30000 |
| | | | | | | *1.575* | *.630* | *1.949* | *2.205* | *1.280* | *1.417* | *2.205* | *1.417* | *1.417* | *1.575* | | *290* | | | |
| | 20 | 3 | 1 | 1 | C4-391.27-20 060 | 40.0 | 20.0 | 51 | 60.0 | 60.0 | | | 40.0 | | | | 20 | 12.0 | 0.51 | 30000 |
| | | | | | | *1.575* | *.787* | *2.028* | *2.362* | *2.362* | | | *1.575* | | | | *290* | | | |
| | 25 | 3 | 1 | 1 | C4-391.27-25 077 | 40.0 | 25.0 | 57 | 77.0 | 77.0 | | | 45.0 | | | | 20 | 20.0 | 0.70 | 30000 |
| | | | | | | *1.575* | *.984* | *2.264* | *3.032* | *3.032* | | | *1.772* | | | | *290* | | | |
| | 32 | 3 | 1 | 1 | C4-391.27-32 088 | 40.0 | 32.0 | 61 | 88.0 | 88.0 | | | 52.0 | | | | 20 | 30.0 | 0.94 | 30000 |
| | | | | | | *1.575* | *1.260* | *2.421* | *3.465* | *3.465* | | | *2.047* | | | | *290* | | | |
| 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 | 10.0 | 0.70 | 28000 |
| | | | | | | *1.969* | *.630* | *1.949* | *2.559* | *1.642* | *1.772* | *2.559* | *1.417* | *1.417* | *1.969* | | *290* | | | |
| | 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 | 12.0 | 0.69 | 28000 |
| | | | | | | *1.969* | *.787* | *2.028* | *2.362* | *1.484* | *1.575* | *2.362* | *1.575* | *1.575* | *1.969* | | *290* | | | |
| | 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 | 20.0 | 0.82 | 28000 |
| | | | | | | *1.969* | *.984* | *2.264* | *2.795* | *1.839* | *2.008* | *2.795* | *1.772* | *1.772* | *1.969* | | *290* | | | |
| | 32 | 3 | 1 | 1 | C5-391.27-32 075 | 50.0 | 32.0 | 61 | 75.0 | 75.0 | | | 52.0 | | | | 20 | 30.0 | 0.92 | 28000 |
| | | | | | | *1.969* | *1.260* | *2.421* | *2.953* | *2.953* | | | *2.047* | | | | *290* | | | |
| | 40 | 3 | 1 | 1 | C5-391.27-40 100 | 50.0 | 40.0 | 71 | 100.0 | 100.0 | | | 65.0 | | | | 20 | 40.0 | 1.69 | 28000 |
| | | | | | | *1.969* | *1.575* | *2.815* | *3.937* | *3.937* | | | *2.559* | | | | *290* | | | |
| 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 | 10.0 | 1.08 | 20000 |
| | | | | | | *2.480* | *.630* | *1.949* | *2.756* | *1.693* | *1.886* | *2.756* | *1.417* | *1.417* | *2.480* | | *290* | | | |
| | 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 | 12.0 | 1.11 | 20000 |
| | | | | | | *2.480* | *.787* | *2.028* | *2.756* | *1.724* | *1.890* | *2.756* | *1.575* | *1.575* | *2.480* | | *290* | | | |
| | 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 | 20.0 | 1.15 | 20000 |
| | | | | | | *2.480* | *.984* | *2.264* | *2.835* | *1.803* | *1.969* | *2.835* | *1.772* | *1.772* | *2.480* | | *290* | | | |
| | 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 | 30.0 | 1.24 | 20000 |
| | | | | | | *2.480* | *1.260* | *2.421* | *2.953* | *1.961* | *2.087* | *2.953* | *2.047* | *2.047* | *2.480* | | *290* | | | |
| | 40 | 3 | 1 | 1 | C6-391.27-40 085 | 63.0 | 40.0 | 71 | 85.0 | 85.0 | | | 65.0 | | | | 20 | 40.0 | 1.63 | 20000 |
| | | | | | | *2.480* | *1.575* | *2.815* | *3.346* | *3.346* | | | *2.559* | | | | *290* | | | |
| | 50 | 3 | 1 | 1 | C6-391.27-50 115 | 63.0 | 50.0 | 81 | 115.0 | 115.0 | | | 75.0 | | | | 20 | 45.0 | 2.59 | 20000 |
| | | | | | | *2.480* | *1.969* | *3.209* | *4.528* | *4.528* | | | *2.953* | | | | *290* | | | |
| 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 | 10.0 | 2.14 | 14000 |
| | | | | | | *3.150* | *.630* | *1.949* | *3.150* | *1.654* | *1.969* | *3.150* | *1.417* | *1.417* | *3.150* | | *290* | | | |
| | 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 | 12.0 | 2.15 | 14000 |
| | | | | | | *3.150* | *.787* | *2.028* | *3.150* | *1.724* | *1.965* | *3.150* | *1.575* | *1.575* | *3.150* | | *290* | | | |
| | 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 | 20.0 | 2.20 | 14000 |
| | | | | | | *3.150* | *.984* | *2.264* | *3.346* | *1.961* | *2.169* | *3.346* | *1.772* | *1.772* | *3.150* | | *290* | | | |
| | 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 | 30.0 | 2.35 | 14000 |
| | | | | | | *3.150* | *1.260* | *2.421* | *3.543* | *2.118* | *2.362* | *3.543* | *2.047* | *2.047* | *3.150* | | *290* | | | |
| | 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 | 40.0 | 2.65 | 14000 |
| | | | | | | *3.150* | *1.575* | *2.815* | *3.740* | *2.472* | *2.563* | *3.740* | *2.559* | *2.559* | *3.150* | | *290* | | | |
| | 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 | 45.0 | 2.83 | 14000 |
| | | | | | | *3.150* | *1.969* | *3.209* | *3.937* | *2.701* | *2.756* | *3.937* | *2.953* | *2.953* | *3.150* | | *290* | | | |

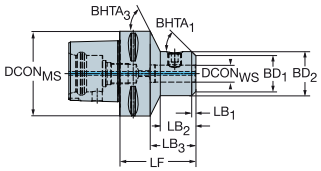
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

# Coromant Capto® to Weldon/ISO 9766 adapter

DSGN 3 14




## Metric bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | $BHTA_3$ | BAR PSI | 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 | 42.0 | 52.0 | 52.0 | 100 | 45° | 63° | 20 | 20.0 | 4.00 | 10000 |
| | | | | | | 3.937 | .787 | 3.543 | .197 | 1.654 | 2.126 | 1.654 | 2.047 | 2.047 | 3.937 | | | 290 | | | |
| | 25 | 3 | 1 | 14 | C10-391.23-25 105 | 100.0 | 25.0 | 105.0 | 8.0 | 61.0 | 69.0 | 49.0 | 65.0 | 65.0 | 100 | 45° | 65° | 20 | 25.0 | 4.90 | 10000 |
| | | | | | | 3.937 | .984 | 4.134 | .315 | 2.402 | 2.717 | 1.929 | 2.559 | 2.559 | 3.937 | | | 290 | | | |
| | 32 | 3 | 1 | 14 | C10-391.23-32 110 | 100.0 | 32.0 | 110.0 | 8.0 | 66.0 | 74.0 | 56.0 | 72.0 | 72.0 | 100 | 45° | 60° | 20 | 45.0 | 5.22 | 10000 |
| | | | | | | 3.937 | 1.260 | 4.331 | .315 | 2.598 | 2.913 | 2.205 | 2.835 | 2.835 | 3.937 | | | 290 | | | |
| | 40 | 3 | 1 | 14 | C10-391.23-40 115 | 100.0 | 40.0 | 115.0 | 8.0 | 76.0 | 79.0 | 74.0 | 90.0 | 90.0 | 100 | 45° | 59° | 20 | 45.0 | 6.35 | 10000 |
| | | | | | | 3.937 | 1.575 | 4.528 | .315 | 2.992 | 3.110 | 2.913 | 3.543 | 3.543 | 3.937 | | | 290 | | | |
| | 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 | 60.0 | 6.95 | 10000 |
| | | | | | | 3.937 | 1.969 | 4.724 | .315 | 4.724 | | 3.307 | 3.937 | | | | | 290 | | | |

## Inch bore

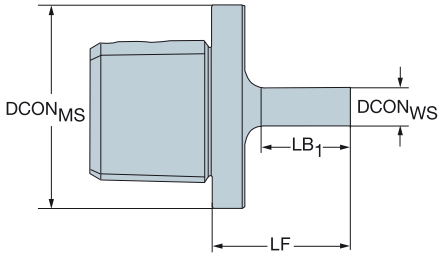
| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | $BHTA_3$ | BAR PSI | NM | KG | |
| C6 | 5/8 | 3 | 1 | 14 | C6-A391.23-15 065 | 63.0 | 15.9 | 65.0 | 7.5 | 36.6 | 43.0 | 32.4 | 41.0 | 41.0 | 63 | 30° | 60° | 20 | 50.0 | 1.19 | |
| | | | | | | *2.480* | *.625* | *2.559* | *.295* | *1.441* | *1.693* | *1.276* | *1.614* | *1.614* | *2.480* | | | *290* | | | |
| | 3/4 | 3 | 1 | 14 | C6-A391.23-19 066 | 63.0 | 19.1 | 66.0 | 7.5 | 38.7 | 44.0 | 35.8 | 44.5 | 44.5 | 63 | 30° | 60° | 20 | 20.0 | 1.24 | |
| | | | | | | *2.480* | *.750* | *2.598* | *.295* | *1.524* | *1.732* | *1.409* | *1.752* | *1.752* | *2.480* | | | *290* | | | |
| | 1 | 3 | 1 | 14 | C6-A391.23-25 085 | 63.0 | 25.4 | 85.0 | 7.5 | 61.0 | 63.0 | 48.4 | 57.1 | 57.1 | 63 | 30° | 56° | 20 | 25.0 | 1.80 | |
| | | | | | | *2.480* | *1.000* | *3.346* | *.295* | *2.402* | *2.480* | *1.906* | *2.248* | *2.248* | *2.480* | | | *290* | | | |
| | 1 1/4 | 3 | 1 | 3 | C6-A391.23-31 085 | 63.0 | 31.8 | 85.0 | 7.5 | 85.0 | | 54.4 | 63.0 | | | 30° | | 20 | 45.0 | 1.92 | |
| | | | | | | *2.480* | *1.250* | *3.346* | *.295* | *3.346* | | *2.142* | *2.480* | | | | | *290* | | | |
| | 1 1/2 | 3 | 1 | 3 | C6-A391.23-38 090 | 63.0 | 38.1 | 90.0 | 7.5 | 90.0 | | 61.4 | 70.0 | | | 30° | | 20 | 45.0 | 2.18 | |
| | | | | | | *2.480* | *1.500* | *3.543* | *.295* | *3.543* | | *2.417* | *2.756* | | | | | *290* | | | |
| C8 | 5/8 | 3 | 1 | 14 | C8-A391.23-15 070 | 80.0 | 15.9 | 70.0 | 7.5 | 34.0 | 40.0 | 32.4 | 41.0 | 41.0 | 80 | 30° | 72° | 20 | 13.0 | 2.20 | |
| | | | | | | *3.150* | *.625* | *2.756* | *.295* | *1.339* | *1.575* | *1.276* | *1.614* | *1.614* | *3.150* | | | *290* | | | |
| | 3/4 | 3 | 1 | 14 | C8-A391.23-19 075 | 80.0 | 19.1 | 75.0 | 7.5 | 36.5 | 44.8 | 35.8 | 44.5 | 44.5 | 80 | 30° | 65° | 20 | 20.0 | 2.33 | |
| | | | | | | *3.150* | *.750* | *2.953* | *.295* | *1.437* | *1.764* | *1.409* | *1.752* | *1.752* | *3.150* | | | *290* | | | |
| | 1 | 3 | 1 | 14 | C8-A391.23-25 080 | 80.0 | 25.4 | 80.0 | 7.5 | 51.4 | 58.0 | 48.4 | 57.1 | 57.1 | 80 | 30° | 60° | 20 | 25.0 | 2.43 | |
| | | | | | | *3.150* | *1.000* | *3.150* | *.295* | *2.024* | *2.283* | *1.906* | *2.248* | *2.248* | *3.150* | | | *290* | | | |
| | 1 1/4 | 3 | 1 | 14 | C8-A391.23-31 080 | 80.0 | 31.8 | 80.0 | 7.5 | 53.1 | 58.0 | 54.3 | 63.0 | 63.0 | 80 | 30° | 60° | 20 | 45.0 | 2.52 | |
| | | | | | | *3.150* | *1.250* | *3.150* | *.295* | *2.091* | *2.283* | *2.138* | *2.480* | *2.480* | *3.150* | | | *290* | | | |
| | 1 1/2 | 3 | 1 | 14 | C8-A391.23-38 085 | 80.0 | 38.1 | 85.0 | 7.5 | 36.5 | 44.8 | 35.8 | 44.5 | 44.5 | 80 | 30° | 65° | 20 | 45.0 | 2.72 | |
| | | | | | | *3.150* | *1.500* | *3.346* | *.295* | *1.437* | *1.764* | *1.409* | *1.752* | *1.752* | *3.150* | | | *290* | | | |
| | 2 | 3 | 1 | 3 | C8-A391.23-50 115 | 80.0 | 50.8 | 115.0 | 7.5 | 115.0 | | 84.8 | 93.5 | | | 30° | | 20 | 50.0 | 4.96 | |
| | | | | | | *3.150* | *2.000* | *4.528* | *.295* | *4.528* | | *3.339* | *3.681* | | | | | *290* | | | |
| C10 | 1 1/4 | 3 | 1 | 14 | C10-A391.23-31 110 | 100.0 | 31.8 | 110.0 | 7.5 | 62.0 | 74.0 | 54.3 | 63.0 | 63.0 | 100 | 30° | 57° | 20 | 45.0 | 4.99 | |
| | | | | | | *3.937* | *1.250* | *4.331* | *.295* | *2.441* | *2.913* | *2.138* | *2.480* | *2.480* | *3.937* | | | *290* | | | |
| | 1 1/2 | 3 | 1 | 14 | C10-A391.23-38 115 | 100.0 | 38.1 | 115.0 | 7.5 | 72.0 | 79.0 | 61.3 | 70.0 | 70.0 | 100 | 30° | 65° | 20 | 45.0 | 5.23 | |
| | | | | | | *3.937* | *1.500* | *4.528* | *.295* | *2.835* | *3.110* | *2.413* | *2.756* | *2.756* | *3.937* | | | *290* | | | |
| | 2 | 3 | 1 | 14 | C10-A391.23-50 120 | 100.0 | 50.8 | 120.0 | 7.5 | 82.5 | 84.0 | 84.4 | 93.5 | 93.5 | 100 | 30° | 65° | 20 | 50.0 | 6.55 | |
| | | | | | | *3.937* | *2.000* | *4.724* | *.295* | *3.248* | *3.307* | *3.323* | *3.681* | *3.681* | *3.937* | | | *290* | | | |

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

M1 N22 N15

# Coromant Capto® to CoroMill® 327 adapter

**Short design, for segment clamping only**




| | | | Dimensions, mm, inch | | | | | |
|---|---|---|---|---|---|---|---|---|
| CZC$_{MS}$ | CZC$_{WS}$ | Ordering code | DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | NM | KG |
| C3 | 09 | C3-391.327-09 035 | 32.0 | 9.0 | 35.0 | 22.0 | 4.3 | 0.14 |
| | | | *1.260* | *.354* | *1.378* | *.866* | | |
| C4 | 09 | C4-391.327-09 035 | 40.0 | 9.0 | 35.0 | 22.0 | 4.3 | 0.21 |
| | | | *1.575* | *.354* | *1.378* | *.866* | | |
| | 12 | C4-391.327-12 043 | 40.0 | 12.0 | 43.0 | 30.0 | 6.5 | 0.29 |
| | | | *1.575* | *.472* | *1.693* | *1.181* | | |
| C5 | 12 | C5-391.327-12 043 | 50.0 | 12.0 | 43.0 | 30.0 | 6.5 | 0.41 |
| | | | *1.969* | *.472* | *1.693* | *1.181* | | |
| | 14 | C5-391.327-14 048 | 50.0 | 14.3 | 48.0 | 35.0 | 6.5 | 0.43 |
| | | | *1.969* | *.563* | *1.890* | *1.378* | | |

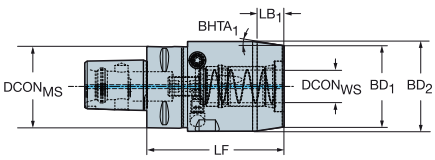
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

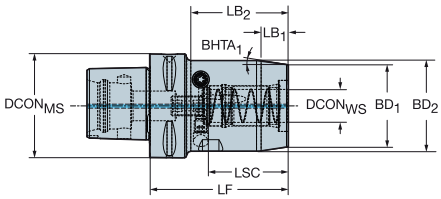
# Coromant Capto® to CoroChuck™ 930

**Heavy-duty design**

DSGN 3




DSGN 6




## Metric bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | 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 PSI | 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 | 10.0 | 1.25 | 39000 |
| | | | | | | *1.575* | *.787* | *2.008* | *3.307* | *.701* | *3.307* | | *1.969* | *2.165* | | | *1160* | | | |
| 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 | 10.0 | 1.40 | 28000 |
| | | | | | | *1.969* | *.787* | *2.008* | *3.228* | *.701* | *3.228* | | *1.969* | *2.165* | | | *1160* | | | |
| | 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 | 10.0 | 1.86 | 28000 |
| | | | | | | *1.969* | *.984* | *2.244* | *3.465* | *.740* | *3.465* | | *2.244* | *2.559* | | | *1160* | | | |
| 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 | 10.0 | 1.76 | 20000 |
| | | | | | | *2.480* | *.787* | *2.008* | *3.307* | *.701* | *2.323* | *3.307* | *1.969* | *2.165* | *2.480* | | *1160* | | | |
| | 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 | 10.0 | 2.16 | 20000 |
| | | | | | | *2.480* | *.984* | *2.244* | *3.425* | *.740* | *3.425* | | *2.244* | *2.559* | | | *1160* | | | |
| | 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 | 10.0 | 3.63 | 20000 |
| | | | | | | *2.480* | *.984* | *2.244* | *5.906* | *.740* | *5.906* | | *2.244* | *2.559* | | | *1160* | | | |
| | 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 | 10.0 | 2.75 | 20000 |
| | | | | | | *2.480* | *1.260* | *2.402* | *3.583* | *.740* | *3.583* | | *2.677* | *2.992* | | | *1160* | | | |
| 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 | 10.0 | 2.88 | 14000 |
| | | | | | | *3.150* | *.787* | *2.008* | *3.819* | *.701* | *2.441* | *3.819* | *1.969* | *2.165* | *3.150* | | *1160* | | | |
| | 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 | 10.0 | 3.22 | 14000 |
| | | | | | | *3.150* | *.984* | *2.244* | *3.819* | *.740* | *2.480* | *3.819* | *2.244* | *2.559* | *3.150* | | *1160* | | | |
| | 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 | 10.0 | 3.25 | 14000 |
| | | | | | | *3.150* | *1.260* | *2.402* | *3.346* | *.740* | *2.098* | *3.346* | *2.669* | *2.992* | *3.150* | | *1160* | | | |
| | 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 | 10.0 | 6.54 | 14000 |
| | | | | | | *3.150* | *1.260* | *2.402* | *7.087* | *.740* | *5.827* | *7.087* | *2.677* | *2.992* | *3.150* | | *1160* | | | |
| 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 | 10.0 | 4.49 | 10000 |
| | | | | | | *3.937* | *.787* | *2.008* | *4.016* | *.701* | *2.323* | *4.016* | *1.969* | *2.165* | *3.937* | | *1160* | | | |
| | 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 | 10.0 | 4.89 | 10000 |
| | | | | | | *3.937* | *.984* | *2.244* | *4.134* | *.740* | *2.480* | *4.134* | *2.244* | *2.559* | *3.937* | | *1160* | | | |
| | 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 | 10.0 | 5.14 | 10000 |
| | | | | | | *3.937* | *1.260* | *2.402* | *3.858* | *.740* | *2.213* | *3.858* | *2.669* | *2.992* | *3.937* | | *1160* | | | |

## Inch bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | 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 PSI | NM | KG | RPMX |
| C6 | 1 1/4 | 3 | 1 | 3 | **930-C6-HD-A31-091** | 63.0 | 31.8 | 61 | 91.0 | 18.8 | 91.0 | | 68.0 | 76.0 | | 12° | 80 | 10.0 | 2.74 | 20000 |
| | | | | | | *2.480* | *1.250* | *2.402* | *3.583* | *.740* | *3.583* | | *2.677* | *2.992* | | | *1160* | | | |
| C8 | 1 1/4 | 3 | 1 | 6 | **930-C8-HD-A31-085** | 80.0 | 31.8 | 61 | 85.0 | 18.8 | 53.3 | 85.0 | 67.8 | 76.0 | 80.0 | 12° | 80 | 10.0 | 3.24 | 14000 |
| | | | | | | *3.150* | *1.250* | *2.402* | *3.346* | *.740* | *2.098* | *3.346* | *2.669* | *2.992* | *3.150* | | *1160* | | | |

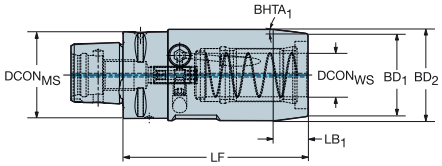
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15 N4

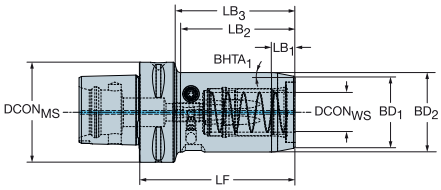
# Coromant Capto® to CoroChuck™ 930

## Slender design

DSGN 3




6




## Metric bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | 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 PSI | 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 | 8.0 | 0.32 | 55000 |
| | | | | | | *1.260* | *.236* | *1.457* | *2.520* | *.445* | *1.307* | *2.520* | *.866* | *1.024* | *1.260* | | *1160* | | | |
| | 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 | 8.0 | 0.36 | 55000 |
| | | | | | | *1.260* | *.315* | *1.457* | *2.559* | *.445* | *1.390* | *2.559* | *.945* | *1.102* | *1.260* | | *1160* | | | |
| | 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 | 8.0 | 0.38 | 55000 |
| | | | | | | *1.260* | *.394* | *1.614* | *2.756* | *.445* | *1.559* | *2.756* | *1.024* | *1.181* | *1.260* | | *1160* | | | |
| | 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 | 8.0 | 0.45 | 55000 |
| | | | | | | *1.260* | *.472* | *1.811* | *2.913* | *.445* | *2.913* | | *1.102* | *1.260* | | | *1160* | | | |
| 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 | 8.0 | 0.48 | 39000 |
| | | | | | | *1.575* | *.236* | *1.457* | *2.598* | *.445* | *1.189* | *2.598* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| | 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 | 8.0 | 0.50 | 39000 |
| | | | | | | *1.575* | *.315* | *1.457* | *2.598* | *.445* | *1.189* | *2.598* | *.945* | *1.102* | *1.575* | | *1160* | | | |
| | 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 | 8.0 | 0.55 | 39000 |
| | | | | | | *1.575* | *.394* | *1.614* | *2.835* | *.445* | *1.346* | *2.835* | *1.024* | *1.181* | *1.575* | | *1160* | | | |
| | 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 | 8.0 | 0.65 | 39000 |
| | | | | | | *1.575* | *.472* | *1.811* | *3.150* | *.445* | *1.575* | *3.150* | *1.102* | *1.260* | *1.575* | | *1160* | | | |
| | 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 | 8.0 | 0.85 | 39000 |
| | | | | | | *1.575* | *.787* | *2.008* | *3.543* | *.630* | *3.543* | | *1.496* | *1.654* | | | *1160* | | | |
| 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 | 8.0 | 0.75 | 28000 |
| | | | | | | *1.969* | *.236* | *1.457* | *2.677* | *.445* | *1.189* | *2.677* | *.866* | *1.024* | *1.969* | | *1160* | | | |
| | 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 | 8.0 | 0.77 | 28000 |
| | | | | | | *1.969* | *.315* | *1.457* | *2.756* | *.445* | *1.268* | *2.756* | *.945* | *1.102* | *1.969* | | *1160* | | | |
| | 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 | 8.0 | 0.80 | 20000 |
| | | | | | | *1.969* | *.394* | *1.614* | *2.835* | *.445* | *1.346* | *2.835* | *1.024* | *1.181* | *1.969* | | *1160* | | | |
| | 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 | 8.0 | 0.85 | 28000 |
| | | | | | | *1.969* | *.472* | *1.811* | *2.953* | *.445* | *1.504* | *2.953* | *1.102* | *1.260* | *1.969* | | *1160* | | | |
| | 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 | 8.0 | 1.04 | 28000 |
| | | | | | | *1.969* | *.787* | *2.008* | *3.346* | *.630* | *1.937* | *3.346* | *1.496* | *1.654* | *1.969* | | *1160* | | | |
| | 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 | 8.0 | 1.63 | 28000 |
| | | | | | | *1.969* | *.787* | *2.008* | *4.921* | *.630* | *1.937* | *4.921* | *1.496* | *1.654* | *1.969* | | *1160* | | | |
| | 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 | 8.0 | 1.28 | 28000 |
| | | | | | | *1.969* | *.984* | *2.244* | *3.583* | *.508* | *3.583* | | *1.772* | *1.969* | | | *1160* | | | |
| 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 | 8.0 | 1.70 | 20000 |
| | | | | | | *2.480* | *.984* | *2.244* | *3.858* | *.508* | *2.839* | *3.858* | *1.772* | *1.969* | *2.480* | | *1160* | | | |
| 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 | 8.0 | 2.74 | 14000 |
| | | | | | | *3.150* | *.984* | *2.244* | *4.252* | *.508* | *2.835* | *4.252* | *1.772* | *1.969* | *3.150* | | *1160* | | | |

## Inch bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | 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 PSI | NM | KG | RPMX |
| C5 | 1 | 3 | 1 | 3 | 930-C5-S-A25-091 | 50.0 | 25.4 | 57 | 91.0 | 12.9 | 91.0 | | 45.0 | 50.0 | | 11° | 80 | 8.0 | 1.27 | 28000 |
| | | | | | | *1.969* | *1.000* | *2.244* | *3.583* | *.508* | *3.583* | | *1.772* | *1.969* | | | *1160* | | | |
| C6 | 1 | 3 | 1 | 6 | 930-C6-S-A25-098 | 63.0 | 25.4 | 57 | 98.0 | 12.9 | 72.1 | 76.0 | 45.0 | 50.0 | 63 | 11° | 80 | 8.0 | 1.60 | 20000 |
| | | | | | | *2.480* | *1.000* | *2.244* | *3.858* | *.508* | *2.839* | *2.992* | *1.772* | *1.969* | *2.480* | | *1160* | | | |

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

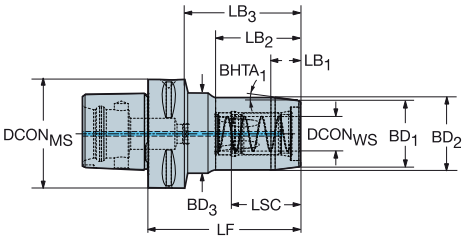
M1 N22 N6 N15 N4



SANDVIK Coromant

# Coromant Capto® to CoroChuck™ 930

**Slender design**




**Metric bore**

| | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| C6 | 6 | 3 | 1 | **930-C6-S-06-074** | 63.0 | 6.0 | 37 | 74.0 | 11.3 | 30.2 | 48.1 | 22.0 | 26.0 | 50.0 | 63.0 | 10° | 80 | 8.0 | 1.15 | 20000 |
| | | | | | *2.480* | *.236* | *1.457* | *2.913* | *.445* | *1.189* | *1.894* | *.866* | *1.024* | *1.969* | *2.480* | | *1160* | | | |
| | 8 | 3 | 1 | **930-C6-S-08-076** | 63.0 | 8.0 | 37 | 76.0 | 11.3 | 32.2 | 50.1 | 24.0 | 28.0 | 50.0 | 63.0 | 10° | 80 | 8.0 | 1.17 | 20000 |
| | | | | | *2.480* | *.315* | *1.457* | *2.992* | *.445* | *1.268* | *1.972* | *.945* | *1.102* | *1.969* | *2.480* | | *1160* | | | |
| | 10 | 3 | 1 | **930-C6-S-10-078** | 63.0 | 10.0 | 41 | 78.0 | 11.3 | 34.2 | 52.1 | 26.0 | 30.0 | 50.0 | 63.0 | 10° | 80 | 8.0 | 1.20 | 20000 |
| | | | | | *2.480* | *.394* | *1.614* | *3.071* | *.445* | *1.346* | *2.051* | *1.024* | *1.181* | *1.969* | *2.480* | | *1160* | | | |
| | 12 | 3 | 1 | **930-C6-S-12-082** | 63.0 | 12.0 | 46 | 82.0 | 11.3 | 38.2 | 56.0 | 28.0 | 32.0 | 50.0 | 63.0 | 10° | 80 | 8.0 | 1.26 | 20000 |
| | | | | | *2.480* | *.472* | *1.811* | *3.228* | *.445* | *1.504* | *2.205* | *1.102* | *1.260* | *1.969* | *2.480* | | *1160* | | | |
| | 20 | 3 | 1 | **930-C6-S-20-091** | 63.0 | 20.0 | 51 | 91.0 | 16.0 | 49.2 | 65.1 | 38.0 | 42.0 | 50.0 | 63.0 | 7° | 80 | 8.0 | 1.45 | 20000 |
| | | | | | *2.480* | *.787* | *2.008* | *3.583* | *.630* | *1.937* | *2.563* | *1.496* | *1.654* | *1.969* | *2.480* | | *1160* | | | |
| | 20 | 3 | 1 | **930-C6-S-20-150** | 63.0 | 20.0 | 51 | 150.0 | 16.0 | 49.2 | 66.8 | 38.0 | 42.0 | 50.0 | 63.0 | 7° | 80 | 8.0 | 2.55 | 20000 |
| | | | | | *2.480* | *.787* | *2.008* | *5.906* | *.630* | *1.937* | *2.630* | *1.496* | *1.654* | *1.969* | *2.480* | | *1160* | | | |
| C8 | 12 | 3 | 1 | **930-C8-S-12-094** | 80.0 | 12.0 | 46 | 94.0 | 11.3 | 38.2 | 59.0 | 28.0 | 32.0 | 50.0 | 80.0 | 10° | 80 | 8.0 | 2.36 | 14000 |
| | | | | | *3.150* | *.472* | *1.811* | *3.701* | *.445* | *1.504* | *2.323* | *1.102* | *1.260* | *1.969* | *3.150* | | *1160* | | | |
| | 20 | 3 | 1 | **930-C8-S-20-103** | 80.0 | 20.0 | 51 | 103.0 | 16.0 | 49.2 | 68.0 | 38.0 | 42.0 | 50.0 | 80.0 | 7° | 80 | 8.0 | 2.54 | 14000 |
| | | | | | *3.150* | *.787* | *2.008* | *4.055* | *.630* | *1.937* | *2.677* | *1.496* | *1.654* | *1.969* | *3.150* | | *1160* | | | |
| | 20 | 3 | 1 | **930-C8-S-20-175** | 80.0 | 20.0 | 51 | 175.0 | 16.0 | 49.2 | 70.0 | 38.0 | 42.0 | 50.0 | 80.0 | 7° | 80 | 8.0 | 4.39 | 14000 |
| | | | | | *3.150* | *.787* | *2.008* | *6.890* | *.630* | *1.937* | *2.756* | *1.496* | *1.654* | *1.969* | *3.150* | | *1160* | | | |

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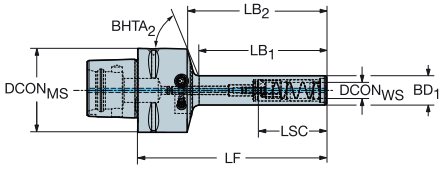
M1 N22 N6 N15 N4

# Coromant Capto® to CoroChuck™ 930

## Pencil design

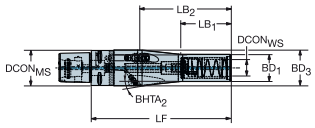
DSGN 5




### Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C5 | 6 | 3 | 1 | 5 | **930-C5-P-06-088** | 50.0 | 6.0 | 37 | 88.0 | 47.9 | 65.0 | 14.5 | 40.0 | 80 | 8.0 | 0.67 | 28000 |
| | | | | | | 1.969 | .236 | 1.457 | 3.465 | 1.886 | 2.559 | .571 | 1.575 | 1160 | | | |
| | 8 | 3 | 1 | 5 | **930-C5-P-08-088** | 50.0 | 8.0 | 37 | 88.0 | 45.8 | 64.9 | 17.5 | 40.0 | 80 | 8.0 | 0.65 | 28000 |
| | | | | | | 1.969 | .315 | 1.457 | 3.465 | 1.803 | 2.555 | .689 | 1.575 | 1160 | | | |
| | 10 | 3 | 1 | 5 | **930-C5-P-10-098** | 50.0 | 10.0 | 41 | 98.0 | 55.8 | 74.9 | 20.0 | 40.0 | 80 | 8.0 | 0.70 | 28000 |
| | | | | | | 1.969 | .394 | 1.614 | 3.858 | 2.197 | 2.949 | .787 | 1.575 | 1160 | | | |
| | 10 | 3 | 1 | 5 | **930-C5-P-10-138** | 50.0 | 10.0 | 41 | 138.0 | 95.8 | 114.9 | 20.0 | 40.0 | 80 | 8.0 | 0.80 | 28000 |
| | | | | | | 1.969 | .394 | 1.614 | 5.433 | 3.772 | 4.524 | .787 | 1.575 | 1160 | | | |
| | 12 | 3 | 1 | 5 | **930-C5-P-12-103** | 50.0 | 12.0 | 46 | 103.0 | 60.8 | 80.0 | 22.0 | 40.0 | 80 | 8.0 | 0.78 | 28000 |
| | | | | | | 1.969 | .472 | 1.811 | 4.055 | 2.394 | 3.150 | .866 | 1.575 | 1160 | | | |
| | 12 | 3 | 1 | 5 | **930-C5-P-12-138** | 50.0 | 12.0 | 46 | 138.0 | 95.8 | 115.0 | 22.0 | 40.0 | 80 | 8.0 | 0.88 | 28000 |
| | | | | | | 1.969 | .472 | 1.811 | 5.433 | 3.772 | 4.528 | .866 | 1.575 | 1160 | | | |
| C6 | 6 | 3 | 1 | 5 | **930-C6-P-06-091** | 63.0 | 6.0 | 37 | 91.0 | 47.9 | 64.9 | 14.5 | 40.0 | 80 | 8.0 | 1.03 | 20000 |
| | | | | | | 2.480 | .236 | 1.457 | 3.583 | 1.886 | 2.555 | .571 | 1.575 | 1160 | | | |
| | 8 | 3 | 1 | 5 | **930-C6-P-08-091** | 63.0 | 8.0 | 37 | 91.0 | 45.8 | 64.9 | 17.5 | 40.0 | 80 | 8.0 | 1.00 | 20000 |
| | | | | | | 2.480 | .315 | 1.457 | 3.583 | 1.803 | 2.555 | .689 | 1.575 | 1160 | | | |
| | 10 | 3 | 1 | 5 | **930-C6-P-10-102** | 63.0 | 10.0 | 41 | 102.0 | 55.8 | 75.0 | 20.0 | 40.0 | 80 | 8.0 | 1.07 | 20000 |
| | | | | | | 2.480 | .394 | 1.614 | 4.016 | 2.197 | 2.953 | .787 | 1.575 | 1160 | | | |
| | 10 | 3 | 1 | 5 | **930-C6-P-10-142** | 63.0 | 10.0 | 41 | 142.0 | 95.8 | 115.0 | 20.0 | 40.0 | 80 | 8.0 | 1.16 | 20000 |
| | | | | | | 2.480 | .394 | 1.614 | 5.591 | 3.772 | 4.528 | .787 | 1.575 | 1160 | | | |
| | 12 | 3 | 1 | 5 | **930-C6-P-12-107** | 63.0 | 12.0 | 46 | 107.0 | 60.8 | 80.0 | 22.0 | 40.0 | 80 | 8.0 | 1.14 | 20000 |
| | | | | | | 2.480 | .472 | 1.811 | 4.213 | 2.394 | 3.150 | .866 | 1.575 | 1160 | | | |
| | 12 | 3 | 1 | 5 | **930-C6-P-12-142** | 63.0 | 12.0 | 46 | 142.0 | 95.8 | 115.0 | 22.0 | 40.0 | 80 | 8.0 | 1.25 | 20000 |
| | | | | | | 2.480 | .472 | 1.811 | 5.591 | 3.772 | 4.528 | .866 | 1.575 | 1160 | | | |
| C8 | 12 | 3 | 1 | 5 | **930-C8-P-12-120** | 80.0 | 12.0 | 46 | 120.0 | 60.8 | 83.0 | 22.0 | 40.0 | 80 | 8.0 | 2.23 | 14000 |
| | | | | | | 3.150 | .472 | 1.811 | 4.724 | 2.394 | 3.268 | .866 | 1.575 | 1160 | | | |
| | 12 | 3 | 1 | 5 | **930-C8-P-12-155** | 80.0 | 12.0 | 46 | 155.0 | 95.8 | 118.0 | 22.0 | 40.0 | 80 | 8.0 | 2.38 | 14000 |
| | | | | | | 3.150 | .472 | 1.811 | 6.102 | 3.772 | 4.646 | .866 | 1.575 | 1160 | | | |

DSGN 7




### Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_3$ | BHTA$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C4 | 20 | 3 | 1 | 7 | **930-C4-P-20-160** | 40.0 | 20.0 | 51 | 160.0 | 60.0 | 108.0 | 32.0 | 42.0 | 5° | 80 | 8.0 | 1.22 | 39000 |
| | | | | | | *1.575* | *.787* | *2.008* | *6.299* | *2.362* | *4.252* | *1.260* | *1.654* | | *1160* | | | |

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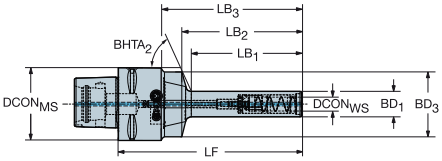
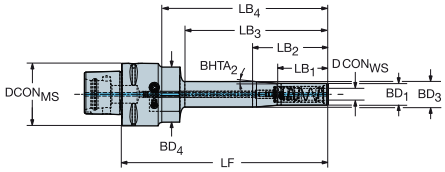
# Coromant Capto® to CoroChuck™ 930

**Pencil design**

DSGN 11




17




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_3$ | $BD_4$ | $BHTA_2$ | | | | 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 | 40 | 4° | 80 | 8.0 | 0.94 | 39000 |
| | | | | | | *1.575* | *.472* | *1.811* | *7.283* | *1.969* | *2.953* | *5.740* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| C5 | 12 | 3 | 1 | 17 | **930-C5-P-12-188** | 50.0 | 12.0 | 46 | 188.0 | 50.0 | 75.0 | 145.8 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 1.18 | 28000 |
| | | | | | | *1.969* | *.472* | *1.811* | *7.402* | *1.969* | *2.953* | *5.740* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| | 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 | 50 | 6° | 80 | 8.0 | 1.32 | 28000 |
| | | | | | | *1.969* | *.787* | *2.008* | *5.945* | *2.362* | *4.252* | *5.039* | *1.260* | *1.654* | *1.969* | | *1160* | | | |
| | 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 | 50 | 2° | 80 | 8.0 | 2.00 | 28000 |
| | | | | | | *1.969* | *.787* | *2.008* | *9.094* | *2.362* | *7.402* | *8.189* | *1.260* | *1.654* | *1.969* | | *1160* | | | |
| C6 | 12 | 3 | 1 | 17 | **930-C6-P-12-192** | 63.0 | 12.0 | 46 | 192.0 | 50.0 | 75.0 | 145.8 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 1.57 | 20000 |
| | | | | | | *2.480* | *.472* | *1.811* | *7.559* | *1.969* | *2.953* | *5.740* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| | 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 | 63 | 6° | 80 | 8.0 | 1.68 | 20000 |
| | | | | | | *2.480* | *.787* | *2.008* | *6.102* | *2.362* | *4.252* | *5.043* | *1.260* | *1.654* | *2.480* | | *1160* | | | |
| | 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 | 63 | 2° | 80 | 8.0 | 2.38 | 20000 |
| | | | | | | *2.480* | *.787* | *2.008* | *9.252* | *2.362* | *7.402* | *8.193* | *1.260* | *1.654* | *2.480* | | *1160* | | | |
| C8 | 12 | 3 | 1 | 17 | **930-C8-P-12-205** | 80.0 | 12.0 | 46 | 205.0 | 50.0 | 75.0 | 145.8 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 2.63 | 14000 |
| | | | | | | *3.150* | *.472* | *1.811* | *8.071* | *1.969* | *2.953* | *5.740* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| | 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 | 80 | 6° | 80 | 8.0 | 2.80 | 14000 |
| | | | | | | *3.150* | *.787* | *2.008* | *6.496* | *2.362* | *4.252* | *5.043* | *1.260* | *1.654* | *3.150* | | *1160* | | | |
| | 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 | 80 | 2° | 80 | 8.0 | 3.44 | 14000 |
| | | | | | | *3.150* | *.787* | *2.008* | *9.646* | *2.362* | *7.402* | *8.193* | *1.260* | *1.654* | *3.150* | | *1160* | | | |

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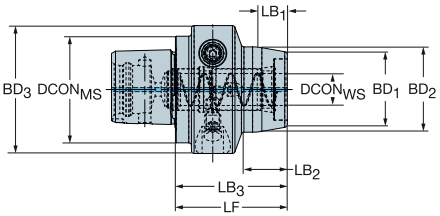
M1 N22 N6 N15 N4

# Coromant Capto® to CoroChuck™ 930

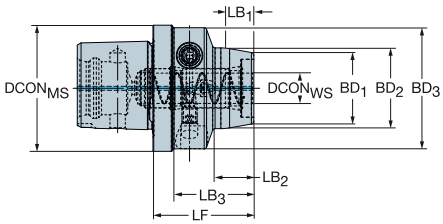
**For driven toolholders**

**Segment clamping and manual tool change only**

DSGN 6




10




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | | | | RPMX |
| C3 | 6 | 3 | 1 | 6 | 930-C3-T-06-036 | 32.0 | 6.0 | 37 | 36.0 | 9.3 | 12.8 | 36.0 | 22.0 | 26.0 | 42.0 | | 12° | 80 | 8.0 | 0.26 | 10000 |
| | | | | | | *1.260* | *.236* | *1.457* | *1.417* | *.366* | *.504* | *1.417* | *.866* | *1.024* | *1.654* | | | *1160* | | | |
| | 8 | 3 | 1 | 6 | 930-C3-T-08-036 | 32.0 | 8.0 | 37 | 36.0 | 9.3 | 12.8 | 36.0 | 24.0 | 28.0 | 44.0 | | 12° | 80 | 8.0 | 0.28 | 10000 |
| | | | | | | *1.260* | *.315* | *1.457* | *1.417* | *.366* | *.504* | *1.417* | *.945* | *1.102* | *1.732* | | | *1160* | | | |
| | 10 | 3 | 1 | 6 | 930-C3-T-10-038 | 32.0 | 10.0 | 41 | 38.0 | 11.3 | 14.8 | 38.0 | 26.0 | 30.0 | 46.0 | | 10° | 80 | 8.0 | 0.31 | 10000 |
| | | | | | | *1.260* | *.394* | *1.614* | *1.496* | *.445* | *.583* | *1.496* | *1.024* | *1.181* | *1.811* | | | *1160* | | | |
| | 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 | 8.0 | 0.39 | 10000 |
| | | | | | | *1.260* | *.472* | *1.811* | *1.811* | *.445* | *.898* | *1.811* | *1.102* | *1.260* | *1.890* | | | *1160* | | | |
| C4 | 6 | 3 | 1 | 6 | 930-C4-T-06-036 | 40.0 | 6.0 | 37 | 36.0 | 9.3 | 12.8 | 36.0 | 22.0 | 26.0 | 42.0 | | 12° | 80 | 8.0 | 0.33 | 10000 |
| | | | | | | *1.575* | *.236* | *1.457* | *1.417* | *.366* | *.504* | *1.417* | *.866* | *1.024* | *1.654* | | | *1160* | | | |
| | 8 | 3 | 1 | 6 | 930-C4-T-08-036 | 40.0 | 8.0 | 37 | 36.0 | 9.3 | 12.8 | 36.0 | 24.0 | 28.0 | 44.0 | | 12° | 80 | 8.0 | 0.34 | 10000 |
| | | | | | | *1.575* | *.315* | *1.457* | *1.417* | *.366* | *.504* | *1.417* | *.945* | *1.102* | *1.732* | | | *1160* | | | |
| | 10 | 3 | 1 | 6 | 930-C4-T-10-038 | 40.0 | 10.0 | 41 | 38.0 | 11.3 | 14.8 | 38.0 | 26.0 | 30.0 | 46.0 | | 10° | 80 | 8.0 | 0.37 | 10000 |
| | | | | | | *1.575* | *.394* | *1.614* | *1.496* | *.445* | *.583* | *1.496* | *1.024* | *1.181* | *1.811* | | | *1160* | | | |
| | 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 | 8.0 | 0.46 | 10000 |
| | | | | | | *1.575* | *.472* | *1.811* | *1.654* | *.445* | *.669* | *1.654* | *1.102* | *1.260* | *1.890* | | | *1160* | | | |
| | 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 | 8.0 | 0.70 | 10000 |
| | | | | | | *1.575* | *.787* | *2.008* | *2.283* | *.630* | *1.350* | *2.283* | *1.500* | *1.654* | *2.244* | | | *1160* | | | |
| C5 | 6 | 3 | 1 | 6 | 930-C5-T-06-036 | 50.0 | 6.0 | 37 | 36.0 | 9.3 | 12.8 | 36.0 | 22.0 | 26.0 | 50.0 | | 12° | 80 | 8.0 | 0.49 | 10000 |
| | | | | | | *1.969* | *.236* | *1.457* | *1.417* | *.366* | *.504* | *1.417* | *.866* | *1.024* | *1.969* | | | *1160* | | | |
| | 8 | 3 | 1 | 6 | 930-C5-T-08-036 | 50.0 | 8.0 | 37 | 36.0 | 9.3 | 12.8 | 36.0 | 24.0 | 28.0 | 50.0 | | 12° | 80 | 8.0 | 0.50 | 10000 |
| | | | | | | *1.969* | *.315* | *1.457* | *1.417* | *.366* | *.504* | *1.417* | *.945* | *1.102* | *1.969* | | | *1160* | | | |
| | 10 | 3 | 1 | 6 | 930-C5-T-10-038 | 50.0 | 10.0 | 41 | 38.0 | 11.3 | 14.8 | 38.0 | 26.0 | 30.0 | 50.0 | | 10° | 80 | 8.0 | 0.51 | 10000 |
| | | | | | | *1.969* | *.394* | *1.614* | *1.496* | *.445* | *.583* | *1.496* | *1.024* | *1.181* | *1.969* | | | *1160* | | | |
| | 12 | 3 | 1 | 10 | 930-C5-T-12-040 | 50.0 | 12.0 | 46 | 40.0 | 11.3 | 16.1 | 32.0 | 28.0 | 32.0 | 48.0 | 50 | 10° | 80 | 8.0 | 0.56 | 10000 |
| | | | | | | *1.969* | *.472* | *1.811* | *1.575* | *.445* | *.634* | *1.260* | *1.102* | *1.260* | *1.890* | *1.969* | | *1160* | | | |
| | 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 | 8.0 | 0.68 | 10000 |
| | | | | | | *1.969* | *.787* | *2.008* | *1.811* | *.445* | *.870* | *1.811* | *1.500* | *1.654* | *2.244* | | | *1160* | | | |

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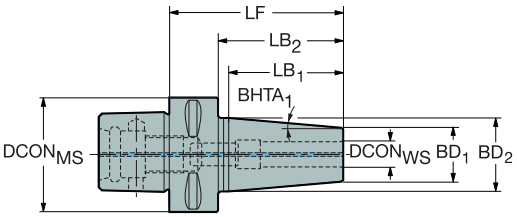
M1 N22 N6 N15 N4



SANDVIK Coromant

# Coromant Capto® to shrink-fit chuck

## Short design




## Metric bore

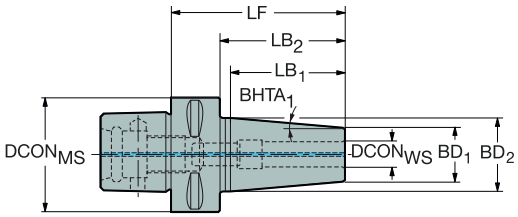
| | | | | | Dimensions, mm, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BHTA_1$ | BAR PSI | KG | RPMX |
| C4 | 6 | 3 | 1 | C4-391.19-06 075 | 40.0 | 6.0 | 75.0 | 44.1 | 55.0 | 20.0 | 27.0 | 4° | 80 | 0.43 | 39000 |
| | | | | | *1.575* | *.236* | *2.953* | *1.736* | *2.165* | *.787* | *1.063* | | *1160* | | |
| | 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 |
| | | | | | *1.575* | *.315* | *2.953* | *1.736* | *2.165* | *.787* | *1.063* | | *1160* | | |
| | 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 |
| | | | | | *1.575* | *.394* | *2.953* | *1.988* | *2.165* | *.945* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *1.575* | *.472* | *2.953* | *1.988* | *2.165* | *.945* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *1.575* | *.551* | *3.150* | *1.736* | *2.362* | *1.063* | *1.339* | | *1160* | | |
| | 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 |
| | | | | | *1.575* | *.630* | *3.150* | *1.736* | *2.362* | *1.063* | *1.339* | | *1160* | | |
| 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 |
| | | | | | *1.969* | *.236* | *2.953* | *1.736* | *2.165* | *.787* | *1.063* | | *1160* | | |
| | 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 |
| | | | | | *1.969* | *.315* | *2.953* | *1.728* | *2.165* | *.787* | *1.063* | | *1160* | | |
| | 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 |
| | | | | | *1.969* | *.394* | *2.953* | *1.976* | *2.165* | *.945* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *1.969* | *.472* | *2.953* | *1.976* | *2.165* | *.945* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *1.969* | *.551* | *3.150* | *1.736* | *2.362* | *1.063* | *1.339* | | *1160* | | |
| | 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 |
| | | | | | *1.969* | *.630* | *3.150* | *1.736* | *2.362* | *1.063* | *1.339* | | *1160* | | |
| | 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 |
| | | | | | *1.969* | *.709* | *3.150* | *2.240* | *2.362* | *1.299* | *1.654* | | *1160* | | |
| | 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 |
| | | | | | *1.969* | *.787* | *3.346* | *2.240* | *2.559* | *1.299* | *1.654* | | *1160* | | |
| 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 |
| | | | | | *2.480* | *.236* | *3.150* | *1.736* | *2.283* | *.787* | *1.063* | | *1160* | | |
| | 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 |
| | | | | | *2.480* | *.315* | *3.150* | *1.736* | *2.283* | *.787* | *1.063* | | *1160* | | |
| | 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 |
| | | | | | *2.480* | *.394* | *3.150* | *1.988* | *2.283* | *.945* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *2.480* | *.472* | *3.150* | *1.988* | *2.283* | *.945* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *2.480* | *.551* | *3.346* | *1.736* | *2.480* | *1.063* | *1.339* | | *1160* | | |
| | 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 |
| | | | | | *2.480* | *.630* | *3.346* | *1.736* | *2.480* | *1.063* | *1.339* | | *1160* | | |
| | 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 |
| | | | | | *2.480* | *.709* | *3.346* | *2.240* | *2.480* | *1.299* | *1.654* | | *1160* | | |
| | 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 |
| | | | | | *2.480* | *.787* | *3.346* | *2.240* | *2.480* | *1.299* | *1.654* | | *1160* | | |
| | 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 |
| | | | | | *2.480* | *.984* | *3.543* | *2.240* | *2.677* | *1.732* | *2.087* | | *1160* | | |
| | 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 |
| | | | | | *2.480* | *1.260* | *3.740* | *2.240* | *2.874* | *1.732* | *2.087* | | *1160* | | |

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

M1 N22 N15

# Coromant Capto® to shrink-fit chuck

**Short design**




**Metric bore**

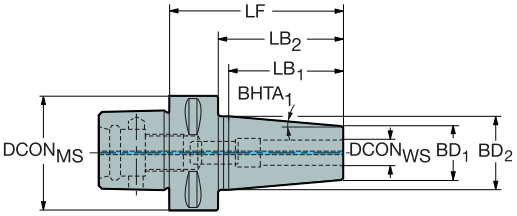
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BHTA$_1$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C8 | 10 | 3 | 1 | **C8-391.19-10 090** | 80.0 | 10.0 | 90.0 | 50.2 | 60.0 | 24.0 | 32.0 | 4° | 80 | 2.07 | 14000 |
| | | | | | *3.150* | *.394* | *3.543* | *1.976* | *2.362* | *.945* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *3.150* | *.472* | *3.543* | *1.976* | *2.362* | *.945* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *3.150* | *.630* | *3.740* | *1.724* | *2.559* | *1.063* | *1.339* | | *1160* | | |
| | 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 |
| | | | | | *3.150* | *.787* | *3.740* | *2.224* | *2.559* | *1.299* | *1.654* | | *1160* | | |
| | 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 |
| | | | | | *3.150* | *.984* | *3.937* | *2.224* | *2.756* | *1.732* | *2.087* | | *1160* | | |
| 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 |
| | | | | | *3.937* | *.472* | *3.740* | *1.988* | *2.323* | *.945* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *3.937* | *.630* | *3.937* | *1.736* | *2.520* | *1.063* | *1.339* | | *1160* | | |
| | 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 |
| | | | | | *3.937* | *.787* | *3.937* | *2.240* | *2.520* | *1.299* | *1.654* | | *1160* | | |
| | 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 |
| | | | | | *3.937* | *.984* | *4.331* | *2.240* | *2.913* | *1.732* | *2.087* | | *1160* | | |

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

M1 N22 N15

# Coromant Capto® to shrink-fit chuck

**Short design**




**Inch bore**

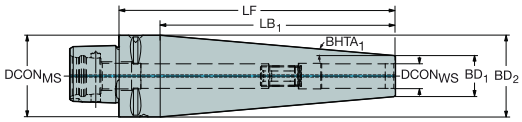
| | | | | | Dimensions, mm, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BHTA_1$ | BAR PSI | KG | RPMX |
| C6 | 3/8 | 3 | 1 | **C6-A391.19-09 080** | 63.0 | 9.5 | 80.0 | 50.2 | 56.0 | 24.0 | 32.0 | 4° | 80 | 1.05 | 20000 |
| | | | | | *2.480* | *.375* | *3.150* | *1.976* | *2.205* | *.945* | *1.260* | | *1160* | | |
| | 1/2 | 3 | 1 | **C6-A391.19-12 080** | 63.0 | 12.7 | 80.0 | 50.2 | 56.0 | 24.0 | 32.0 | 4° | 80 | 1.04 | 20000 |
| | | | | | *2.480* | *.500* | *3.150* | *1.976* | *2.205* | *.945* | *1.260* | | *1160* | | |
| | 5/8 | 3 | 1 | **C6-A391.19-15 085** | 63.0 | 15.9 | 85.0 | 43.8 | 61.0 | 27.0 | 34.0 | 4° | 80 | 1.12 | 20000 |
| | | | | | *2.480* | *.625* | *3.346* | *1.724* | *2.402* | *1.063* | *1.339* | | *1160* | | |
| | 3/4 | 3 | 1 | **C6-A391.19-19 085** | 63.0 | 19.1 | 85.0 | 56.5 | 61.0 | 33.0 | 42.0 | 4° | 80 | 1.25 | 20000 |
| | | | | | *2.480* | *.750* | *3.346* | *2.224* | *2.402* | *1.299* | *1.654* | | *1160* | | |
| C8 | 3/8 | 3 | 1 | **C8-A391.19-09 090** | 80.0 | 9.5 | 90.0 | 50.2 | 58.0 | 24.0 | 32.0 | 4° | 80 | 2.08 | 14000 |
| | | | | | *3.150* | *.375* | *3.543* | *1.976* | *2.283* | *.945* | *1.260* | | *1160* | | |
| | 1/2 | 3 | 1 | **C8-A391.19-12 090** | 80.0 | 12.7 | 90.0 | 50.2 | 58.0 | 24.0 | 32.0 | 4° | 80 | 2.05 | 14000 |
| | | | | | *3.150* | *.500* | *3.543* | *1.976* | *2.283* | *.945* | *1.260* | | *1160* | | |
| | 5/8 | 3 | 1 | **C8-A391.19-15 095** | 80.0 | 15.9 | 95.0 | 43.8 | 63.0 | 27.0 | 34.0 | 4° | 80 | 2.11 | 14000 |
| | | | | | *3.150* | *.625* | *3.740* | *1.724* | *2.480* | *1.063* | *1.339* | | *1160* | | |
| | 3/4 | 3 | 1 | **C8-A391.19-19 095** | 80.0 | 19.1 | 95.0 | 56.5 | 63.0 | 33.0 | 42.0 | 4° | 80 | 2.24 | 14000 |
| | | | | | *3.150* | *.750* | *3.740* | *2.224* | *2.480* | *1.299* | *1.654* | | *1160* | | |

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

M1 N22 N15

# Coromant Capto® to shrink-fit chuck

**Long conical design**




## Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BD$_1$ | BD$_2$ | BHTA$_1$ | BAR PSI | 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 |
| | | | | | *1.260* | *.236* | *4.646* | *4.055* | *.551* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *1.260* | *.315* | *4.213* | *3.622* | *.630* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *1.260* | *.394* | *3.740* | *3.150* | *.709* | *1.260* | | *1160* | | |
| | 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 |
| | | | | | *1.260* | *.472* | *3.307* | *2.717* | *.787* | *1.260* | | *1160* | | |
| 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 |
| | | | | | *1.575* | *.472* | *5.315* | *4.528* | *.787* | *1.575* | | *1160* | | |
| | 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 |
| | | | | | *1.575* | *.630* | *4.409* | *3.622* | *.945* | *1.575* | | *1160* | | |
| | 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 |
| | | | | | *1.575* | *.709* | *3.150* | *2.240* | *1.299* | *1.654* | | *1160* | | |
| | 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 |
| | | | | | *1.575* | *.787* | *3.346* | *2.240* | *1.299* | *1.654* | | *1160* | | |
| 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 |
| | | | | | *1.969* | *.787* | *5.748* | *4.961* | *1.102* | *1.969* | | *1160* | | |
| | 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 |
| | | | | | *1.969* | *.984* | *3.543* | *2.240* | *1.732* | *2.087* | | *1160* | | |
| | 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 |
| | | | | | *1.969* | *.984* | *4.646* | *3.858* | *1.299* | *1.969* | | *1160* | | |

## Inch bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BD$_1$ | BHTA$_1$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C3 | 1/4 | 3 | 1 | C3-A391.19-06 116 | 32.0 | 6.4 | 116.0 | 101.0 | 14.4 | 5° | 80 | 0.45 | 55000 |
| | | | | | *1.260* | *.250* | *4.567* | *3.976* | *.567* | | *1160* | | |
| | 3/8 | 3 | 1 | C3-A391.19-09 098 | 32.0 | 9.5 | 98.0 | 83.0 | 17.5 | 5° | 80 | 0.41 | 55000 |
| | | | | | *1.260* | *.375* | *3.858* | *3.268* | *.689* | | *1160* | | |
| | 1/2 | 3 | 1 | C3-A391.19-12 080 | 32.0 | 12.7 | 80.0 | 65.0 | 20.7 | 5° | 80 | 0.36 | 55000 |
| | | | | | *1.260* | *.500* | *3.150* | *2.559* | *.815* | | *1160* | | |
| C4 | 1/2 | 3 | 1 | C4-A391.19-12 131 | 40.0 | 12.7 | 131.0 | 111.0 | 20.7 | 5° | 80 | 0.83 | 39000 |
| | | | | | *1.575* | *.500* | *5.157* | *4.370* | *.815* | | *1160* | | |
| | 5/8 | 3 | 1 | C4-A391.19-15 112 | 40.0 | 15.9 | 112.0 | 92.0 | 23.9 | 5° | 80 | 0.76 | 39000 |
| | | | | | *1.575* | *.625* | *4.409* | *3.622* | *.941* | | *1160* | | |
| | 3/4 | 3 | 1 | C4-A391.19-19 094 | 40.0 | 19.1 | 94.0 | 74.0 | 27.1 | 5° | 80 | 0.65 | 39000 |
| | | | | | *1.575* | *.750* | *3.701* | *2.913* | *1.067* | | *1160* | | |
| C5 | 3/4 | 3 | 1 | C5-A391.19-19 151 | 50.0 | 19.1 | 151.0 | 131.0 | 27.1 | 5° | 80 | 1.48 | 28000 |
| | | | | | *1.969* | *.750* | *5.945* | *5.157* | *1.067* | | *1160* | | |
| | 1 | 3 | 1 | C5-A391.19-25 115 | 50.0 | 25.4 | 115.0 | 95.0 | 33.4 | 5° | 80 | 1.22 | 28000 |
| | | | | | *1.969* | *1.000* | *4.528* | *3.740* | *1.315* | | *1160* | | |

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

M1 N22 N15

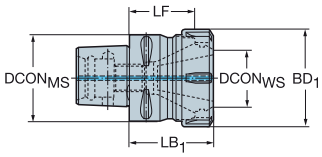


SANDVIK Coromant

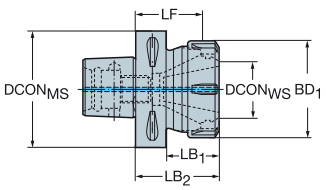
# Coromant Capto® to ER collet chuck

**Workpiece side interface DIN 6499-B**

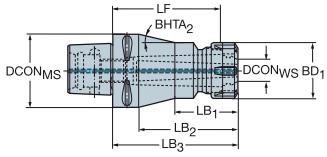
DSGN 1




2




7




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BHTA$_2$ | BAR PSI | 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 | | 0° | 80 | 0.20 | 55000 |
| | | | | | | *1.260* | *.669* | *1.354* | *1.142* | *1.772* | | *1.102* | *1.260* | | | *1160* | | |
| | ER20 | 3 | 1 | 1 | C3-391.14-20 045 | 32.0 | 21.0 | 33.5 | 45.0 | | | 33.7 | | | | 80 | 0.22 | 55000 |
| | | | | | | *1.260* | *.827* | *1.319* | *1.772* | | | *1.327* | | | | *1160* | | |
| C4 | ER16 | 3 | 1 | 7 | C4-391.14-16 070 | 40.0 | 17.0 | 59.4 | 44.0 | 50.0 | 70.0 | 28.0 | 28.0 | 40.0 | 45° | 80 | 0.42 | 39000 |
| | | | | | | *1.575* | *.669* | *2.339* | *1.732* | *1.969* | *2.756* | *1.102* | *1.102* | *1.575* | | *1160* | | |
| | ER20 | 3 | 1 | 2 | C4-391.14-20 052 | 40.0 | 21.0 | 40.5 | 30.8 | 52.0 | | 33.7 | 40.0 | | 0° | 80 | 0.37 | 39000 |
| | | | | | | *1.575* | *.827* | *1.594* | *1.213* | *2.047* | | *1.327* | *1.575* | | | *1160* | | |
| | ER25 | 3 | 1 | 1 | C4-391.14-25 052 | 40.0 | 26.0 | 40.0 | 52.0 | | | 42.0 | | | | 80 | 0.42 | 39000 |
| | | | | | | *1.575* | *1.024* | *1.575* | *2.047* | | | *1.654* | | | | *1160* | | |
| | ER32 | 3 | 1 | 1 | C4-391.14-32 054 | 40.0 | 33.0 | 41.0 | 54.0 | | | 50.0 | | | | 80 | 0.46 | 39000 |
| | | | | | | *1.575* | *1.299* | *1.614* | *2.126* | | | *1.969* | | | | *1160* | | |
| C5 | ER16 | 3 | 1 | 7 | C5-391.14-16 100 | 50.0 | 17.0 | 89.4 | 60.0 | 80.0 | 100.0 | 28.0 | 28.0 | 50.0 | 29° | 80 | 0.90 | 28000 |
| | | | | | | *1.969* | *.669* | *3.520* | *2.362* | *3.150* | *3.937* | *1.102* | *1.102* | *1.969* | | *1160* | | |
| | ER20 | 3 | 1 | 2 | C5-391.14-20 055 | 50.0 | 21.0 | 43.5 | 31.1 | 55.0 | | 33.7 | 50.0 | | 0° | 80 | 0.62 | 28000 |
| | | | | | | *1.969* | *.827* | *1.713* | *1.224* | *2.165* | | *1.327* | *1.969* | | | *1160* | | |
| | ER20 | 3 | 1 | 7 | C5-391.14-20 100 | 50.0 | 21.0 | 88.5 | 55.0 | 80.0 | 100.0 | 35.0 | 35.0 | 50.0 | 16° | 80 | 1.00 | 28000 |
| | | | | | | *1.969* | *.827* | *3.484* | *2.165* | *3.150* | *3.937* | *1.378* | *1.378* | *1.969* | | *1160* | | |
| | ER20 | 3 | 1 | 7 | C5-391.14-20 130 | 50.0 | 21.0 | 118.5 | 55.0 | 109.9 | 130.0 | 35.0 | 35.0 | 50.0 | 7° | 80 | 1.31 | 28000 |
| | | | | | | *1.969* | *.827* | *4.665* | *2.165* | *4.327* | *5.118* | *1.378* | *1.378* | *1.969* | | *1160* | | |
| | ER25 | 3 | 1 | 2 | C5-391.14-25 055 | 50.0 | 26.0 | 43.0 | 33.0 | 55.0 | | 42.0 | 50.0 | | 0° | 80 | 0.63 | 28000 |
| | | | | | | *1.969* | *1.024* | *1.693* | *1.299* | *2.165* | | *1.654* | *1.969* | | | *1160* | | |
| | ER25 | 3 | 1 | 7 | C5-391.14-25 100 | 50.0 | 26.0 | 88.0 | 65.0 | 80.0 | 100.0 | 42.0 | 42.0 | 50.0 | 14° | 80 | 1.13 | 28000 |
| | | | | | | *1.969* | *1.024* | *3.465* | *2.559* | *3.150* | *3.937* | *1.654* | *1.654* | *1.969* | | *1160* | | |
| | ER32 | 3 | 1 | 1 | C5-391.14-32 057 | 50.0 | 33.0 | 44.0 | 57.0 | | | 50.0 | | | | 80 | 0.68 | 28000 |
| | | | | | | *1.969* | *1.299* | *1.732* | *2.244* | | | *1.969* | | | | *1160* | | |
| | ER32 | 3 | 1 | 1 | C5-391.14-32 100 | 50.0 | 33.0 | 87.0 | 100.0 | | | 50.0 | | | | 80 | 1.28 | 28000 |
| | | | | | | *1.969* | *1.299* | *3.425* | *3.937* | | | *1.969* | | | | *1160* | | |
| | ER40 | 3 | 1 | 1 | C5-391.14-40 060 | 50.0 | 41.0 | 45.0 | 60.0 | | | 63.0 | | | | 80 | 0.81 | 28000 |
| | | | | | | *1.969* | *1.614* | *1.772* | *2.362* | | | *2.480* | | | | *1160* | | |
| C6 | ER16 | 3 | 1 | 7 | C6-391.14-16 100 | 63.0 | 17.0 | 89.4 | 60.0 | 78.0 | 100.0 | 28.0 | 28.0 | 63.0 | 44° | 80 | 1.26 | 20000 |
| | | | | | | *2.480* | *.669* | *3.520* | *2.362* | *3.071* | *3.937* | *1.102* | *1.102* | *2.480* | | *1160* | | |
| | ER20 | 3 | 1 | 7 | C6-391.14-20 060 | 63.0 | 21.0 | 48.5 | 31.1 | 38.0 | 60.0 | 33.7 | 33.7 | 63.0 | 65° | 80 | 1.00 | 20000 |
| | | | | | | *2.480* | *.827* | *1.909* | *1.224* | *1.496* | *2.362* | *1.327* | *1.327* | *2.480* | | *1160* | | |
| | ER25 | 3 | 1 | 2 | C6-391.14-25 060 | 63.0 | 26.0 | 48.0 | 32.9 | 60.0 | | 42.0 | 63.0 | | 0° | 80 | 1.04 | 20000 |
| | | | | | | *2.480* | *1.024* | *1.890* | *1.295* | *2.362* | | *1.654* | *2.480* | | | *1160* | | |
| | ER25 | 3 | 1 | 2 | C6-391.14-25 100 | 63.0 | 26.0 | 88.0 | 75.0 | 100.0 | | 42.0 | 63.0 | | 0° | 80 | 1.44 | 20000 |
| | | | | | | *2.480* | *1.024* | *3.465* | *2.953* | *3.937* | | *1.654* | *2.480* | | | *1160* | | |
| | ER25 | 3 | 1 | 7 | C6-391.14-25 130 | 63.0 | 26.0 | 118.0 | 65.0 | 108.0 | 130.0 | 42.0 | 42.0 | 63.0 | 13° | 80 | 1.90 | 20000 |
| | | | | | | *2.480* | *1.024* | *4.646* | *2.559* | *4.252* | *5.118* | *1.654* | *1.654* | *2.480* | | *1160* | | |
| | ER25 | 3 | 1 | 7 | C6-391.14-25 160 | 63.0 | 26.0 | 148.0 | 65.0 | 138.0 | 160.0 | 42.0 | 42.0 | 63.0 | 8° | 80 | 2.50 | 20000 |
| | | | | | | *2.480* | *1.024* | *5.827* | *2.559* | *5.433* | *6.299* | *1.654* | *1.654* | *2.480* | | *1160* | | |
| | ER32 | 3 | 1 | 2 | C6-391.14-32 060 | 63.0 | 33.0 | 47.0 | 35.3 | 60.0 | | 50.0 | 63.0 | | 0° | 80 | 1.06 | 20000 |
| | | | | | | *2.480* | *1.299* | *1.850* | *1.390* | *2.362* | | *1.969* | *2.480* | | | *1160* | | |
| | ER32 | 3 | 1 | 2 | C6-391.14-32 100 | 63.0 | 33.0 | 87.0 | 75.0 | 100.0 | | 50.0 | 63.0 | | 0° | 80 | 1.60 | 20000 |
| | | | | | | *2.480* | *1.299* | *3.425* | *2.953* | *3.937* | | *1.969* | *2.480* | | | *1160* | | |
| | ER32 | 3 | 1 | 7 | C6-391.14-32 130 | 63.0 | 33.0 | 117.0 | 75.0 | 108.0 | 130.0 | 50.0 | 50.0 | 63.0 | 11° | 80 | 2.22 | 20000 |
| | | | | | | *2.480* | *1.299* | *4.606* | *2.953* | *4.252* | *5.118* | *1.969* | *1.969* | *2.480* | | *1160* | | |
| | ER40 | 3 | 1 | 1 | C6-391.14-40 065 | 63.0 | 41.0 | 50.0 | 65.0 | | | 63.0 | | | | 80 | 1.22 | 20000 |
| | | | | | | *2.480* | *1.614* | *1.969* | *2.559* | | | *2.480* | | | | *1160* | | |
| | ER40 | 3 | 1 | 1 | C6-391.14-40 130 | 63.0 | 41.0 | 115.0 | 130.0 | | | 63.0 | | | | 80 | 2.77 | 20000 |
| | | | | | | *2.480* | *1.614* | *4.528* | *5.118* | | | *2.480* | | | | *1160* | | |

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

M1

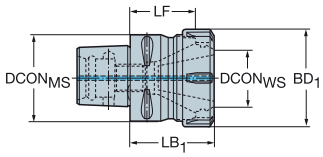
N22

N15

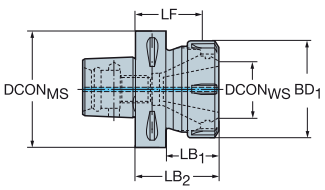
# Coromant Capto® to ER collet chuck

**Workpiece side interface DIN 6499-B**

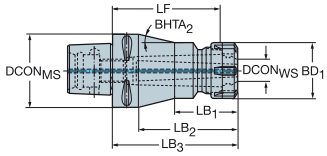
DSGN 1




DSGN 2




DSGN 7




| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_2$ | BAR PSI | KG | RPMX |
| C8 | ER20 | 3 | 1 | 2 | C8-391.14-20 065 | 80.0 | 21.0 | 53.5 | 29.9 | 65.0 | | 35.0 | 80.0 | | 0° | 80 | 2.02 | 14000 |
| | | | | | | *3.150* | *.827* | *2.106* | *1.177* | *2.559* | | *1.378* | *3.150* | | | *1160* | | |
| | ER25 | 3 | 1 | 2 | C8-391.14-25 070 | 80.0 | 26.0 | 58.0 | 32.4 | 70.0 | | 42.0 | 80.0 | | 0° | 80 | 2.10 | 14000 |
| | | | | | | *3.150* | *1.024* | *2.283* | *1.276* | *2.756* | | *1.654* | *3.150* | | | *1160* | | |
| | ER32 | 3 | 1 | 2 | C8-391.14-32 070 | 80.0 | 33.0 | 57.0 | 35.0 | 70.0 | | 50.0 | 80.0 | | 0° | 80 | 2.13 | 14000 |
| | | | | | | *3.150* | *1.299* | *2.244* | *1.378* | *2.756* | | *1.969* | *3.150* | | | *1160* | | |
| | ER32 | 3 | 1 | 7 | C8-391.14-32 160 | 80.0 | 33.0 | 147.0 | 75.0 | 130.0 | 160.0 | 50.0 | 50.0 | 80.0 | 15° | 80 | 0.30 | 14000 |
| | | | | | | *3.150* | *1.299* | *5.787* | *2.953* | *5.118* | *6.299* | *1.969* | *1.969* | *3.150* | | *1160* | | |
| | ER40 | 3 | 1 | 2 | C8-391.14-40 070 | 80.0 | 41.0 | 55.0 | 38.0 | 70.0 | | 63.0 | 80.0 | | 0° | 80 | 2.19 | 14000 |
| | | | | | | *3.150* | *1.614* | *2.165* | *1.496* | *2.756* | | *2.480* | *3.150* | | | *1160* | | |
| | ER40 | 3 | 1 | 7 | C8-391.14-40 160 | 80.0 | 41.0 | 145.0 | 95.0 | 130.0 | 160.0 | 63.0 | 63.0 | 80.0 | 13° | 80 | 4.58 | 14000 |
| | | | | | | *3.150* | *1.614* | *5.709* | *3.740* | *5.118* | *6.299* | *2.480* | *2.480* | *3.150* | | *1160* | | |
| | ER50 | 3 | 1 | 2 | C8-391.14-50 080 | 80.0 | 52.0 | 59.0 | 50.0 | 80.0 | | 78.0 | 80.0 | | 0° | 80 | 2.46 | 14000 |
| | | | | | | *3.150* | *2.047* | *2.323* | *1.969* | *3.150* | | *3.071* | *3.150* | | | *1160* | | |
| C10 | ER32 | 3 | 1 | 7 | C10-391.14-32 160 | 100.0 | 33.0 | 147.0 | 75.0 | 124.0 | 160.0 | 50.0 | 50.0 | 100.0 | 27° | 80 | 5.98 | 10000 |
| | | | | | | *3.937* | *1.299* | *5.787* | *2.953* | *4.882* | *6.299* | *1.969* | *1.969* | *3.937* | | *1160* | | |
| | ER40 | 3 | 1 | 7 | C10-391.14-40 160 | 100.0 | 41.0 | 145.0 | 95.0 | 124.0 | 160.0 | 63.0 | 63.0 | 100.0 | 32° | 80 | 6.32 | 10000 |
| | | | | | | *3.937* | *1.614* | *5.709* | *3.740* | *4.882* | *6.299* | *2.480* | *2.480* | *3.937* | | *1160* | | |
| | ER50 | 3 | 1 | 7 | C10-391.14-50 160 | 100.0 | 52.0 | 139.0 | 100.0 | 124.0 | 160.0 | 80.0 | 80.0 | 100.0 | 22° | 80 | 7.21 | 10000 |
| | | | | | | *3.937* | *2.047* | *5.472* | *3.937* | *4.882* | *6.299* | *3.150* | *3.150* | *3.937* | | *1160* | | |

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

M1

N22

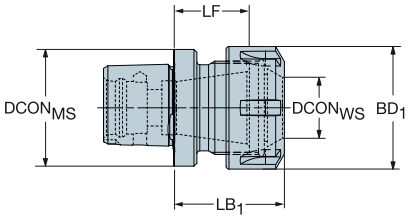
N15

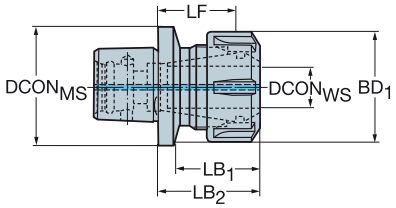
# Coromant Capto® to ER collet chuck

**Short design, for segment clamping only**

**Workpiece side interface DIN 6499-B**

DSGN 1 2



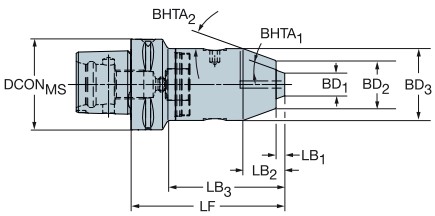



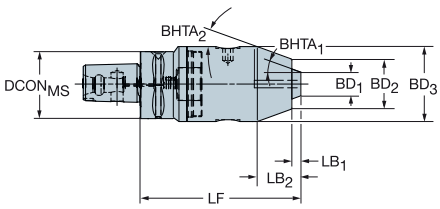

| | | | | | Dimensions, mm, inch | | | | | | | BAR PSI | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | | | RPMX |
| C3 | ER16 | 3 | 1 | C3-391.14-16 035 | 32.0 | 17.0 | 24.0 | 26.6 | 34.6 | 28.0 | 32.0 | 80 | 0.10 | 55000 |
| | | | | | *1.260* | *.669* | *.945* | *1.047* | *1.362* | *1.102* | *1.260* | *1160* | | |
| | ER20 | 3 | 1 | C3-391.14-20 036 | 32.0 | 21.0 | 24.5 | 36.0 | | 33.7 | | 80 | 0.17 | 55000 |
| | | | | | *1.260* | *.827* | *.965* | *1.417* | | *1.327* | | *1160* | | |
| C4 | ER16 | 3 | 1 | C4-391.14-16 035 | 40.0 | 17.0 | 24.0 | 26.6 | 34.6 | 28.0 | 40.0 | 80 | 0.20 | 39000 |
| | | | | | *1.575* | *.669* | *.945* | *1.047* | *1.362* | *1.102* | *1.575* | *1160* | | |
| | ER20 | 3 | 1 | C4-391.14-20 035 | 40.0 | 21.0 | 23.5 | 27.0 | 35.0 | 33.7 | 40.0 | 80 | 0.25 | 39000 |
| | | | | | *1.575* | *.827* | *.925* | *1.063* | *1.378* | *1.327* | *1.575* | *1160* | | |
| | ER25 | 3 | 1 | C4-391.14-25 038 | 40.0 | 26.0 | 26.0 | 38.0 | | 42.0 | | 80 | 0.30 | 39000 |
| | | | | | *1.575* | *1.024* | *1.024* | *1.496* | | *1.654* | | *1160* | | |
| C5 | ER20 | 3 | 1 | C5-391.14-20 036 | 50.0 | 21.0 | 24.0 | 27.5 | 35.5 | 35.0 | 50.0 | 80 | 0.30 | 28000 |
| | | | | | *1.969* | *.827* | *.945* | *1.083* | *1.398* | *1.378* | *1.969* | *1160* | | |
| | ER25 | 3 | 1 | C5-391.14-25 037 | 50.0 | 26.0 | 25.0 | 29.0 | 37.0 | 42.0 | 50.0 | 80 | 0.30 | 28000 |
| | | | | | *1.969* | *1.024* | *.984* | *1.142* | *1.457* | *1.654* | *1.969* | *1160* | | |
| | ER32 | 3 | 1 | C5-391.14-32 045 | 50.0 | 33.0 | 32.0 | 45.0 | | 50.0 | | 80 | 0.52 | 28000 |
| | | | | | *1.969* | *1.299* | *1.260* | *1.772* | | *1.969* | | *1160* | | |

# Coromant Capto® to drill chuck

**Internal and external coolant supply**

DSGN 16 8




| | | | | | | Dimensions, mm, inch | | | | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | $BHTA_2$ | | | | 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 | 10.0 | 0.54 | 8000 |
| | | | | | | *1.260* | *2.992* | *.118* | *.752* | *2.992* | *.390* | *.949* | *1.417* | | | | *725* | | | |
| | 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 | 20.0 | 1.14 | 8000 |
| | | | | | | *1.260* | *3.780* | *.236* | *.874* | *4.016* | *.618* | *1.500* | *1.969* | | | | *725* | | | |
| C4 | 8 - 1 | 3 | 1 | 16 | C4-391.32-08 077 | 40.0 | 77.0 | 3.0 | 19.1 | 55.8 | 9.9 | 24.1 | 36.0 | 40 | 19° | 20° | 50 | 10.0 | 0.64 | 8000 |
| | | | | | | *1.575* | *3.032* | *.118* | *.752* | *2.197* | *.390* | *.949* | *1.417* | *1.575* | | | *725* | | | |
| | 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 | 20.0 | 1.24 | 8000 |
| | | | | | | *1.575* | *3.858* | *.236* | *.874* | *4.094* | *.618* | *1.500* | *1.969* | | | | *725* | | | |
| C5 | 8 - 1 | 3 | 1 | 16 | C5-391.32-08 079 | 50.0 | 76.0 | 3.0 | 19.1 | 53.6 | 9.9 | 24.1 | 36.0 | 50 | 19° | 20° | 50 | 10.0 | 0.85 | 8000 |
| | | | | | | *1.969* | *2.992* | *.118* | *.752* | *2.110* | *.390* | *.949* | *1.417* | *1.969* | | | *725* | | | |
| | 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 | 20.0 | 1.41 | 8000 |
| | | | | | | *1.969* | *3.819* | *.236* | *.874* | *4.055* | *.618* | *1.500* | *1.969* | | | | *725* | | | |
| C6 | 1 - 13 | 3 | 1 | 16 | C6-391.32-13 107 | 63.0 | 101.0 | 6.0 | 22.2 | 79.8 | 15.7 | 38.1 | 50.0 | 63 | 19° | 20° | 50 | 20.0 | 1.79 | 8000 |
| | | | | | | *2.480* | *3.976* | *.236* | *.874* | *3.142* | *.618* | *1.500* | *1.969* | *2.480* | | | *725* | | | |
| | 16 - 1 | 3 | 1 | 16 | C6-391.32-16 112 | 63.0 | 106.0 | 6.0 | 22.2 | 88.4 | 15.7 | 45.1 | 57.0 | 63 | 19° | 20° | 50 | 20.0 | 2.02 | 8000 |
| | | | | | | *2.480* | *4.173* | *.236* | *.874* | *3.480* | *.618* | *1.776* | *2.244* | *2.480* | | | *725* | | | |
| C8 | 1 - 13 | 3 | 1 | 16 | C8-391.32-13 112 | 80.0 | 106.0 | 6.0 | 22.2 | 77.1 | 15.7 | 38.1 | 50.0 | 80 | 19° | 20° | 50 | 20.0 | 2.78 | 8000 |
| | | | | | | *3.150* | *4.173* | *.236* | *.874* | *3.035* | *.618* | *1.500* | *1.969* | *3.150* | | | *725* | | | |
| | 16 - 1 | 3 | 1 | 16 | C8-391.32-16 117 | 80.0 | 111.0 | 6.0 | 31.2 | 84.2 | 15.7 | 38.1 | 57.0 | 80 | 19° | 20° | 50 | 20.0 | 3.02 | 8000 |
| | | | | | | *3.150* | *4.370* | *.236* | *1.230* | *3.315* | *.618* | *1.500* | *2.244* | *3.150* | | | *725* | | | |

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

M1

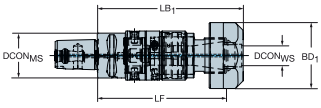
N22

N15

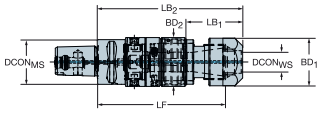
# Coromant Capto® to CoroChuck™ 970

**Workpiece side interface DIN 6499-B**

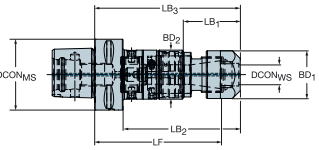
DSGN 1




2




5

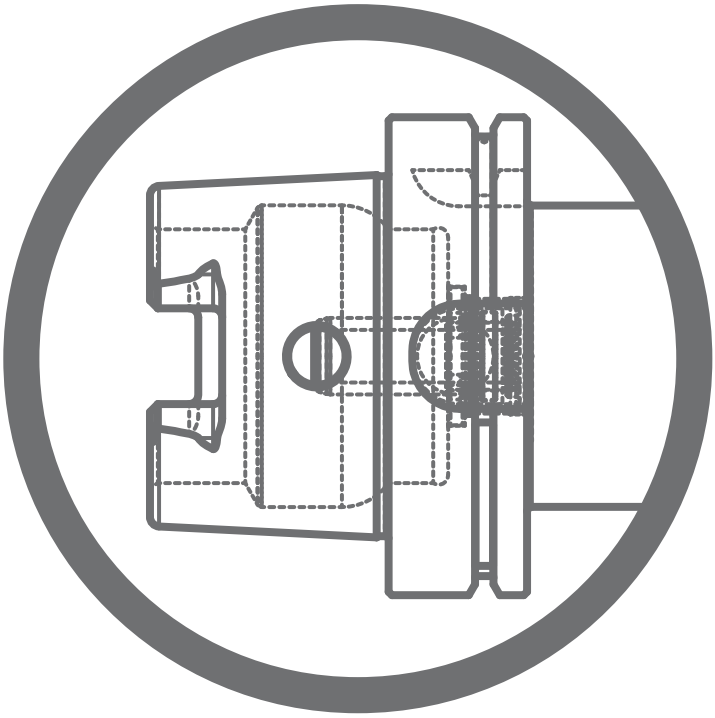



| | | | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | TRMAX | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | 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 |
| | | | | | | | *1.260* | *.445* | *2.921* | *.949* | *2.480* | *3.071* | *.736* | *.925* | *1.260* | *1160* | | |
| | 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 |
| | | | | | | | *1.260* | *.819* | *3.512* | *1.390* | *3.827* | | *1.327* | *1.378* | | *1160* | | |
| 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 |
| | | | | | | | *1.575* | *.445* | *3.000* | *.949* | *2.362* | *3.150* | *.736* | *.925* | *1.575* | *1160* | | |
| | 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 |
| | | | | | | | *1.575* | *.819* | *3.512* | *1.390* | *3.028* | *3.827* | *1.327* | *1.378* | *1.575* | *1160* | | |
| | 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 |
| | | | | | | | *1.575* | *1.016* | *4.256* | *1.461* | *4.591* | | *1.654* | *1.732* | | *1160* | | |
| 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 |
| | | | | | | | *1.969* | *.819* | *3.532* | *1.390* | *3.055* | *3.846* | *1.327* | *1.378* | *1.969* | *1160* | | |
| | 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 |
| | | | | | | | *1.969* | *1.016* | *4.276* | *1.461* | *3.823* | *4.610* | *1.654* | *1.732* | *1.969* | *1160* | | |
| | ER40 | M30 | 3 | 1 | 1 | 970-C5-40-154 | 50.0 | 40.8 | 137.2 | 148.6 | | | 63.0 | | | 80 | 2.66 | 8000 |
| | | | | | | | *1.969* | *1.606* | *5.402* | *5.850* | | | *2.480* | | | *1160* | | |
| 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 |
| | | | | | | | *2.480* | *.819* | *3.610* | *1.390* | *3.055* | *3.925* | *1.327* | *1.378* | *2.480* | *1160* | | |
| | 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 |
| | | | | | | | *2.480* | *1.016* | *4.354* | *1.461* | *3.823* | *4.689* | *1.654* | *1.732* | *2.480* | *1160* | | |
| | ER32 | M20 | 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 |
| | | | | | | | *2.480* | *1.291* | *4.657* | *4.165* | *5.032* | | *1.969* | *2.480* | | *1160* | | |
| | ER40 | M30 | 3 | 1 | 1 | 970-C6-40-154 | 63.0 | 40.8 | 136.7 | 148.1 | | | 63.0 | | | 80 | 2.95 | 8000 |
| | | | | | | | *2.480* | *1.606* | *5.382* | *5.831* | | | *2.480* | | | *1160* | | |
| | 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 |
| | | | | | | | *2.480* | *2.047* | *7.382* | *3.012* | *5.295* | *8.189* | *3.059* | *3.150* | *3.386* | *1160* | | |
| 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 |
| | | | | | | | *3.150* | *.819* | *3.886* | *1.390* | *3.016* | *4.201* | *1.327* | *1.378* | *3.150* | *1160* | | |
| | 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 |
| | | | | | | | *3.150* | *1.016* | *4.630* | *1.461* | *3.783* | *4.965* | *1.654* | *1.732* | *3.150* | *1160* | | |
| | ER32 | M20 | 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 |
| | | | | | | | *3.150* | *1.291* | *4.933* | *4.126* | *5.307* | | *1.969* | *3.150* | | *1160* | | |
| | 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 |
| | | | | | | | *3.150* | *1.606* | *5.657* | *4.925* | *6.106* | | *2.480* | *3.150* | | *1160* | | |
| | 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 |
| | | | | | | | *3.150* | *2.047* | *7.559* | *3.012* | *5.295* | *8.366* | *3.059* | *3.150* | *3.386* | *1160* | | |
| 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 |
| | | | | | | | *3.937* | *1.016* | *5.102* | *1.461* | *4.020* | *5.437* | *1.654* | *1.732* | *3.937* | *1160* | | |
| | 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 |
| | | | | | | | *3.937* | *1.606* | *6.130* | *5.161* | *6.579* | | *2.480* | *3.937* | | *1160* | | |

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

M1 N22 N15 N5

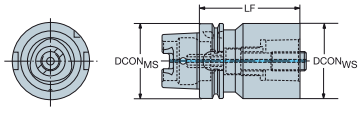
# Machine-side interface HSK



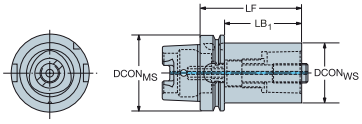
# HSK to Coromant Capto® adapter

**Machine side interface HSK A/C**

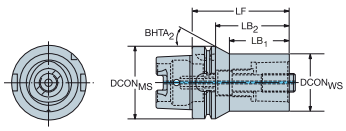
DSGN 1




DSGN 2




DSGN 7




| | | | | | | Dimensions, mm, inch | | | | | | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_2$ | $BD_3$ | $BHTA_2$ | | | |
| 50.0 | C3 | 1 | 1 | 2 | C3-390.410-50 075A | 50.0 | 32.0 | 75.0 | 49.0 | 75.0 | | 50.0 | | 0° | 100 | 45.0 | 0.67 |
| | | | | | | *1.969* | *1.260* | *2.953* | *1.929* | *2.953* | | *1.969* | | | *1450* | | |
| | C4 | 1 | 1 | 2 | C4-390.410-50 080A | 50.0 | 40.0 | 80.0 | 54.0 | 80.0 | | 50.0 | | 0° | 100 | 55.0 | 0.85 |
| | | | | | | *1.969* | *1.575* | *3.150* | *2.126* | *3.150* | | *1.969* | | | *1450* | | |
| 63.0 | C3 | 1 | 1 | 2 | C3-390.410-63 075C | 63.0 | 32.0 | 75.0 | 49.0 | 75.0 | | 63.0 | | 0° | 100 | 45.0 | 0.97 |
| | | | | | | *2.480* | *1.260* | *2.953* | *1.929* | *2.953* | | *2.480* | | | *1450* | | |
| | C4 | 1 | 1 | 2 | C4-390.410-63 080C | 63.0 | 40.0 | 80.0 | 54.0 | 80.0 | | 63.0 | | 0° | 100 | 55.0 | 1.14 |
| | | | | | | *2.480* | *1.575* | *3.150* | *2.126* | *3.150* | | *2.480* | | | *1450* | | |
| | C5 | 1 | 1 | 2 | C5-390.410-63 090C | 63.0 | 50.0 | 90.0 | 64.0 | 90.0 | | 63.0 | | 0° | 100 | 95.0 | 1.47 |
| | | | | | | *2.480* | *1.969* | *3.543* | *2.520* | *3.543* | | *2.480* | | | *1450* | | |
| 80.0 | C4 | 1 | 1 | 2 | C4-390.410-80 090 | 80.0 | 40.0 | 90.0 | 64.0 | 90.0 | | 80.0 | | 0° | 100 | 55.0 | 1.69 |
| | | | | | | *3.150* | *1.575* | *3.543* | *2.520* | *3.543* | | *3.150* | | | *1450* | | |
| | C5 | 1 | 1 | 2 | C5-390.410-80 095 | 80.0 | 50.0 | 95.0 | 69.0 | 95.0 | | 80.0 | | 0° | 100 | 95.0 | 2.02 |
| | | | | | | *3.150* | *1.969* | *3.740* | *2.717* | *3.740* | | *3.150* | | | *1450* | | |
| | C6 | 1 | 1 | 2 | C6-390.410-80 110 | 80.0 | 63.0 | 110.0 | 84.0 | 110.0 | | 80.0 | | 0° | 100 | 170.0 | 2.79 |
| | | | | | | *3.150* | *2.480* | *4.331* | *3.307* | *4.331* | | *3.150* | | | *1450* | | |
| 100.0 | 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 | 45.0 | 2.42 |
| | | | | | | *3.937* | *1.260* | *3.150* | *1.693* | *2.008* | *3.150* | *1.260* | *3.937* | | *1450* | | |
| | C4 | 1 | 1 | 2 | C4-390.410-100 090A | 100.0 | 40.0 | 90.0 | 61.0 | 90.0 | | 100.0 | | 0° | 100 | 55.0 | 2.63 |
| | | | | | | *3.937* | *1.575* | *3.543* | *2.402* | *3.543* | | *3.937* | | | *1450* | | |
| | C5 | 1 | 1 | 2 | C5-390.410-100 100A | 100.0 | 50.0 | 100.0 | 71.0 | 100.0 | | 100.0 | | 0° | 100 | 95.0 | 3.02 |
| | | | | | | *3.937* | *1.969* | *3.937* | *2.795* | *3.937* | | *3.937* | | | *1450* | | |
| | C6 | 1 | 1 | 2 | C6-390.410-100 110A | 100.0 | 63.0 | 110.0 | 81.0 | 110.0 | | 100.0 | | 0° | 100 | 170.0 | 3.70 |
| | | | | | | *3.937* | *2.480* | *4.331* | *3.189* | *4.331* | | *3.937* | | | *1450* | | |
| | C8 | 1 | 1 | 2 | C8-390.410-100 120A | 100.0 | 80.0 | 120.0 | 91.0 | 120.0 | | 100.0 | | 0° | 100 | 170.0 | 4.87 |
| | | | | | | *3.937* | *3.150* | *4.724* | *3.583* | *4.724* | | *3.937* | | | *1450* | | |
| | C10 | 1 | 1 | 1 | C10-390.410-100 155 | 100.0 | 100.0 | 155.0 | 155.0 | | | | | | 100 | 380.0 | 7.64 |
| | | | | | | *3.937* | *3.937* | *6.102* | *6.102* | | | | | | *1450* | | |
| 125.0 | 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 | 55.0 | 4.15 |
| | | | | | | *4.921* | *1.575* | *3.740* | *1.811* | *2.598* | *3.740* | *1.575* | *4.921* | | *1450* | | |
| | 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 | 95.0 | 4.46 |
| | | | | | | *4.921* | *1.969* | *4.134* | *2.598* | *2.992* | *4.134* | *1.969* | *4.921* | | *1450* | | |
| | C6 | 1 | 1 | 2 | C6-390.410-125 120 | 125.0 | 63.0 | 120.0 | 91.0 | 120.0 | | 125.0 | | 0° | 100 | 170.0 | 5.35 |
| | | | | | | *4.921* | *2.480* | *4.724* | *3.583* | *4.724* | | *4.921* | | | *1450* | | |
| | C8 | 1 | 1 | 2 | C8-390.410-125 130 | 125.0 | 80.0 | 130.0 | 101.0 | 130.0 | | 125.0 | | 0° | 100 | 170.0 | 6.70 |
| | | | | | | *4.921* | *3.150* | *5.118* | *3.976* | *5.118* | | *4.921* | | | *1450* | | |
| | C10 | 1 | 1 | 2 | C10-390.410-125 160 | 125.0 | 100.0 | 160.0 | 131.0 | 160.0 | | 125.0 | | 0° | 100 | 380.0 | 9.66 |
| | | | | | | *4.921* | *3.937* | *6.299* | *5.157* | *6.299* | | *4.921* | | | *1450* | | |
| 160.0 | C6 | 1 | 1 | 2 | C6-390.410-160 125 | 160.0 | 63.0 | 125.0 | 94.0 | 125.0 | | 160.0 | | 0° | 100 | 170.0 | 8.55 |
| | | | | | | *6.299* | *2.480* | *4.921* | *3.701* | *4.921* | | *6.299* | | | *1450* | | |
| | C8 | 1 | 1 | 2 | C8-390.410-160 135 | 160.0 | 80.0 | 135.0 | 104.0 | 135.0 | | 160.0 | | 0° | 100 | 170.0 | 10.16 |
| | | | | | | *6.299* | *3.150* | *5.315* | *4.094* | *5.315* | | *6.299* | | | *1450* | | |
| | C10 | 1 | 1 | 2 | C10-390.410-160 160 | 160.0 | 100.0 | 160.0 | 129.0 | 160.0 | | 160.0 | | 0° | 100 | 380.0 | 12.94 |
| | | | | | | *6.299* | *3.937* | *6.299* | *5.079* | *6.299* | | *6.299* | | | *1450* | | |

A special coolant tube is delivered together with the HSK basic holders.

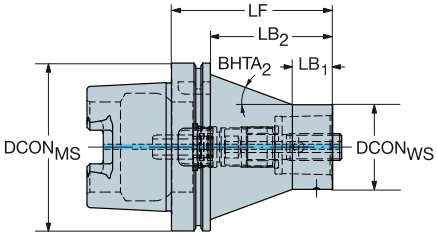
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

# HSK to Coromant Capto® adapter

**Machine side interface HSK A/C**

**Heavy-duty design**




| | | | | | Dimensions, mm, inch | | | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $BHTA_2$ | | | |
| 100.0 | C3 | 1 | 1 | **C3-390.410-100080HD** | 100.0 | 32.0 | 80.0 | 20.0 | 51.0 | 41° | 100 | 45.0 | 2.93 |
| | | | | | *3.937* | *1.260* | *3.150* | *.787* | *2.008* | | *1450* | | |
| | C4 | 1 | 1 | **C4-390.410-100090HD** | 100.0 | 40.0 | 90.0 | 20.0 | 61.0 | 29° | 100 | 55.0 | 3.27 |
| | | | | | *3.937* | *1.575* | *3.543* | *.787* | *2.402* | | *1450* | | |
| | C5 | 1 | 1 | **C5-390.410-100100HD** | 100.0 | 50.0 | 100.0 | 30.0 | 71.0 | 23° | 100 | 95.0 | 3.58 |
| | | | | | *3.937* | *1.969* | *3.937* | *1.181* | *2.795* | | *1450* | | |
| | C6 | 1 | 1 | **C6-390.410-100110HD** | 100.0 | 63.0 | 110.0 | 30.0 | 81.0 | 12° | 100 | 170.0 | 4.22 |
| | | | | | *3.937* | *2.480* | *4.331* | *1.181* | *3.189* | | *1450* | | |
| 125.0 | C4 | 1 | 1 | **C4-390.410-125095HD** | 125.0 | 40.0 | 95.0 | 20.0 | 66.0 | 36° | 100 | 55.0 | 5.25 |
| | | | | | *4.921* | *1.575* | *3.740* | *.787* | *2.598* | | *1450* | | |
| | C5 | 1 | 1 | **C5-390.410-125105HD** | 125.0 | 50.0 | 105.0 | 20.0 | 76.0 | 27° | 100 | 95.0 | 5.82 |
| | | | | | *4.921* | *1.969* | *4.134* | *.787* | *2.992* | | *1450* | | |
| | C6 | 1 | 1 | **C6-390.410-125120HD** | 125.0 | 63.0 | 120.0 | 30.0 | 91.0 | 20° | 100 | 170.0 | 6.57 |
| | | | | | *4.921* | *2.480* | *4.724* | *1.181* | *3.583* | | *1450* | | |
| | C8 | 1 | 1 | **C8-390.410-125130HD** | 125.0 | 80.0 | 130.0 | 30.0 | 101.0 | 11° | 100 | 170.0 | 7.76 |
| | | | | | *4.921* | *3.150* | *5.118* | *1.181* | *3.976* | | *1450* | | |

A special coolant tube is delivered together with the HSK basic holders.

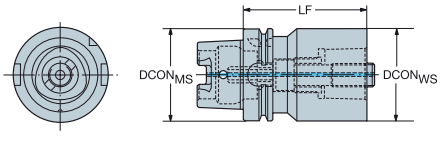
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

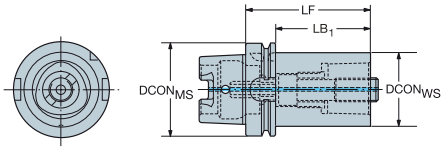
# HSK to Coromant Capto® adapter

## Machine side interface HSK A/C/T

DSGN 1



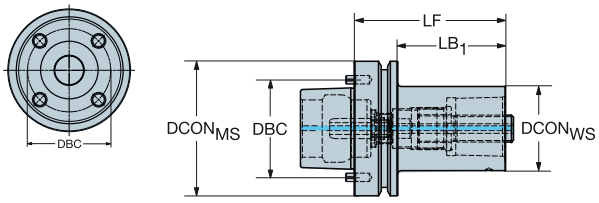

2




| | | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $BD_2$ | BAR PSI | NM | KG |
| 40.0 | C3 | 1 | 1 | 2 | C3-390.419-40 065 | 40.0 | 32.0 | 65.0 | 45.0 | 65.0 | 40.0 | 100 | 45.0 | 0.46 |
| | | | | | | *1.575* | *1.260* | *2.559* | *1.772* | *2.559* | *1.575* | *1450* | | |
| | C4 | 1 | 1 | 1 | C4-390.419-40 075 | 40.0 | 40.0 | 75.0 | 75.0 | | | 100 | 55.0 | 0.60 |
| | | | | | | *1.575* | *1.575* | *2.953* | *2.953* | | | *1450* | | |
| 63.0 | C5 | 1 | 1 | 2 | C5-390.419-63 090 | 63.0 | 50.0 | 90.0 | 64.0 | 90.0 | 63.0 | 100 | 95.0 | 1.46 |
| | | | | | | *2.480* | *1.969* | *3.543* | *2.520* | *3.543* | *2.480* | *1450* | | |
| | C6 | 1 | 1 | 1 | C6-390.419-63 110 | 63.0 | 63.0 | 110.0 | 110.0 | | | 100 | 170.0 | 2.14 |
| | | | | | | *2.480* | *2.480* | *4.331* | *4.331* | | | *1450* | | |
| 100.0 | C6 | 1 | 1 | 2 | C6-390.419-100 110 | 100.0 | 63.0 | 110.0 | 81.0 | 110.0 | 100.0 | 100 | 170.0 | 3.72 |
| | | | | | | *3.937* | *2.480* | *4.331* | *3.189* | *4.331* | *3.937* | *1450* | | |
| | C8 | 1 | 1 | 2 | C8-390.419-100 120 | 100.0 | 80.0 | 120.0 | 91.0 | 120.0 | 100.0 | 100 | 170.0 | 4.88 |
| | | | | | | *3.937* | *3.150* | *4.724* | *3.583* | *4.724* | *3.937* | *1450* | | |

## Machine side interface HSK F with pins

### For Makino MAG machine family




| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | DBC | LF | $LB_1$ | BAR PSI | NM | KG |
| 80.0 | C5 | 1 | 1 | C5-390.612-80 090 | 80.0 | 50.0 | 58.0 | 90.0 | 64.0 | 100 | 95.0 | 1.92 |
| | | | | | *3.150* | *1.969* | *2.283* | *3.543* | *2.520* | *1450* | | |

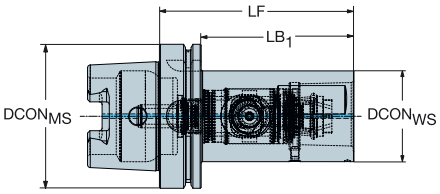
A special coolant tube is delivered together with the HSK basic holders.
HSK80F - Compatible with the Makino MAG machine family 1, 3, 4, 7 - for aerospace frame aluminum machining

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

M1 N22 N15

# HSK to Coromant Capto® adapter with Quick change

**Machine side interface HSK A/C**



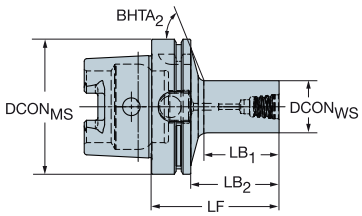

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | BAR PSI | NM | KG | RPMX |
| 63.0 | C5 | 1 | 1 | **HA06-QC-C5-115** | 63.0 | 50.0 | 115.0 | 88.0 | 100 | 70.0 | 1.77 | 20500 |
| | | | | | *2.480* | *1.969* | *4.528* | *3.465* | *1450* | | | |
| 100.0 | C6 | 1 | 1 | **HA10-QC-C6-135** | 100.0 | 63.0 | 135.0 | 105.0 | 100 | 90.0 | 4.17 | 12500 |
| | | | | | *3.937* | *2.480* | *5.315* | *4.134* | *1450* | | | |
| | C8 | 1 | 1 | **HA10-QC-C8-165** | 100.0 | 80.0 | 165.0 | 135.0 | 100 | 130.0 | 6.32 | 12500 |
| | | | | | *3.937* | *3.150* | *6.496* | *5.315* | *1450* | | | |

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

M1 N22 N6 N15

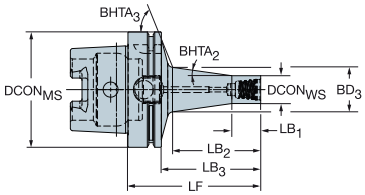
# HSK to Coromant EH adapter

**Machine side interface HSK A/C**




## Short design

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | BHTA$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | E10 | 1 | 1 | 392.410EH-40 10 040 | 40.0 | 9.6 | 40.0 | 13.0 | 20.0 | 59° | 100 | 12.0 | 0.28 | 30000 |
| | | | | | *1.575* | *.378* | *1.575* | *.512* | *.787* | | *1450* | | | |
| | E12 | 1 | 1 | 392.410EH-40 12 043 | 40.0 | 11.6 | 43.0 | 16.3 | 23.0 | 58° | 100 | 15.0 | 0.30 | 30000 |
| | | | | | *1.575* | *.457* | *1.693* | *.642* | *.906* | | *1450* | | | |
| | E16 | 1 | 1 | 392.410EH-40 16 048 | 40.0 | 15.4 | 48.0 | 21.9 | 28.0 | 55° | 100 | 30.0 | 0.35 | 30000 |
| | | | | | *1.575* | *.606* | *1.890* | *.862* | *1.102* | | *1450* | | | |
| | E20 | 1 | 1 | 392.410EH-40 20 045 | 40.0 | 19.2 | 45.0 | 19.4 | 25.0 | 50° | 100 | 50.0 | 0.37 | 30000 |
| | | | | | *1.575* | *.756* | *1.772* | *.764* | *.984* | | *1450* | | | |
| 50.0 | E10 | 1 | 1 | 392.410EH-50 10 047 | 50.0 | 9.6 | 47.0 | 13.0 | 21.0 | 63° | 100 | 12.0 | 0.49 | 25000 |
| | | | | | *1.969* | *.378* | *1.850* | *.512* | *.827* | | *1450* | | | |
| | E12 | 1 | 1 | 392.410EH-50 12 050 | 50.0 | 11.6 | 50.0 | 16.3 | 24.0 | 62° | 100 | 15.0 | 0.51 | 25000 |
| | | | | | *1.969* | *.457* | *1.969* | *.642* | *.945* | | *1450* | | | |
| | E16 | 1 | 1 | 392.410EH-50 16 055 | 50.0 | 15.4 | 55.0 | 21.8 | 29.0 | 60° | 100 | 30.0 | 0.57 | 25000 |
| | | | | | *1.969* | *.606* | *2.165* | *.858* | *1.142* | | *1450* | | | |
| | E20 | 1 | 1 | 392.410EH-50 20 052 | 50.0 | 19.2 | 52.0 | 19.3 | 26.0 | 58° | 100 | 50.0 | 0.58 | 25000 |
| | | | | | *1.969* | *.756* | *2.047* | *.760* | *1.024* | | *1450* | | | |
| | E25 | 1 | 1 | 392.410EH-50 25 057 | 50.0 | 24.1 | 57.0 | 24.9 | 31.0 | 54° | 100 | 65.0 | 0.63 | 25000 |
| | | | | | *1.969* | *.949* | *2.244* | *.980* | *1.220* | | *1450* | | | |
| 63.0 | E10 | 1 | 1 | 392.410EH-63 10 049 | 63.0 | 9.6 | 49.0 | 13.5 | 23.0 | 66° | 100 | 12.0 | 0.78 | 20500 |
| | | | | | *2.480* | *.378* | *1.929* | *.531* | *.906* | | *1450* | | | |
| | E12 | 1 | 1 | 392.410EH-63 12 051 | 63.0 | 11.6 | 51.0 | 15.8 | 25.0 | 65° | 100 | 15.0 | 0.81 | 20500 |
| | | | | | *2.480* | *.457* | *2.008* | *.622* | *.984* | | *1450* | | | |
| | E16 | 1 | 1 | 392.410EH-63 16 056 | 63.0 | 15.4 | 56.0 | 21.3 | 30.0 | 65° | 100 | 30.0 | 0.85 | 20500 |
| | | | | | *2.480* | *.606* | *2.205* | *.839* | *1.181* | | *1450* | | | |
| | E20 | 1 | 1 | 392.410EH-63 20 053 | 63.0 | 19.2 | 53.0 | 18.8 | 27.0 | 63° | 100 | 50.0 | 0.87 | 20500 |
| | | | | | *2.480* | *.756* | *2.087* | *.740* | *1.063* | | *1450* | | | |
| | E25 | 1 | 1 | 392.410EH-63 25 059 | 63.0 | 24.1 | 59.0 | 25.5 | 33.0 | 61° | 100 | 65.0 | 0.93 | 20500 |
| | | | | | *2.480* | *.949* | *2.323* | *1.004* | *1.299* | | *1450* | | | |




## Long design

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BHTA$_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | E10 | 1 | 1 | 392.410EH-63 10 062 | 63.0 | 9.6 | 62.0 | 10.0 | 27.9 | 36.0 | 14.6 | 63.0 | 8° | 66° | 100 | 12.0 | 0.80 | 20500 |
| | | | | | *2.480* | *.378* | *2.441* | *.394* | *1.098* | *1.417* | *.575* | *2.480* | | | *1450* | | | |
| | E12 | 1 | 1 | 392.410EH-63 12 068 | 63.0 | 11.6 | 68.0 | 12.0 | 34.3 | 42.0 | 17.9 | 63.0 | 8° | 65° | 100 | 15.0 | 0.83 | 20500 |
| | | | | | *2.480* | *.457* | *2.677* | *.472* | *1.350* | *1.654* | *.705* | *2.480* | | | *1450* | | | |
| | E16 | 1 | 1 | 392.410EH-63 16 078 | 63.0 | 15.4 | 78.0 | 16.0 | 45.1 | 52.0 | 23.6 | 63.0 | 8° | 64° | 100 | 30.0 | 0.92 | 20500 |
| | | | | | *2.480* | *.606* | *3.071* | *.630* | *1.776* | *2.047* | *.929* | *2.480* | | | *1450* | | | |
| | E20 | 1 | 1 | 392.410EH-63 20 091 | 63.0 | 19.2 | 91.0 | 20.0 | 59.0 | 65.0 | 30.1 | 63.0 | 8° | 61° | 100 | 50.0 | 1.01 | 20500 |
| | | | | | *2.480* | *.756* | *3.583* | *.787* | *2.323* | *2.559* | *1.185* | *2.480* | | | *1450* | | | |
| | E25 | 1 | 1 | 392.410EH-63 25 105 | 63.0 | 24.1 | 105.0 | 25.0 | 74.0 | 79.0 | 37.6 | 63.0 | 8° | 54° | 100 | 65.0 | 1.21 | 20500 |
| | | | | | *2.480* | *.949* | *4.134* | *.984* | *2.913* | *3.110* | *1.480* | *2.480* | | | *1450* | | | |
| 100.0 | E20 | 1 | 1 | 392.410EH-100 20 100 | 100.0 | 19.2 | 100.0 | 20.0 | 60.3 | 71.0 | 30.5 | 100.0 | 8° | 70° | 100 | 50.0 | 2.58 | 12500 |
| | | | | | *3.937* | *.756* | *3.937* | *.787* | *2.374* | *2.795* | *1.201* | *3.937* | | | *1450* | | | |
| | E25 | 1 | 1 | 392.410EH-100 25 115 | 100.0 | 24.1 | 115.0 | 25.0 | 76.4 | 86.0 | 38.6 | 100.0 | 8° | 70° | 100 | 65.0 | 2.68 | 12500 |
| | | | | | *3.937* | *.949* | *4.528* | *.984* | *3.008* | *3.386* | *1.520* | *3.937* | | | *1450* | | | |

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

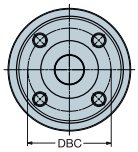
M1 N22 N6 N15 N3

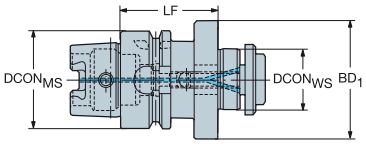
# HSK to arbor adapter

**Machine side interface HSK A/C**

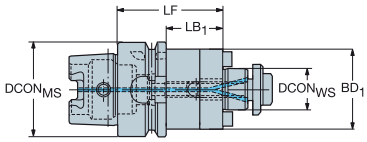
**Coolant through arbor**

DSGN 1




DSGN 2




## Metric pilot

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | DCON$_{MS}$ | DCON$_{WS}$ | DBC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 16 | 1 | 4 | 2 | **392.41005C-4016050** | 40.0 | 16.0 | | 50.0 | 30.0 | 50.0 | 32.0 | 40.0 | 80 | 22.0 | 0.45 | 30000 |
| | | | | | | *1.575* | *.630* | | *1.969* | *1.181* | *1.969* | *1.260* | *1.575* | *1160* | | | |
| | 22 | 1 | 4 | 1 | **392.41005C-4022050** | 40.0 | 22.0 | | 50.0 | 50.0 | | 48.0 | | 80 | 45.0 | 0.60 | 30000 |
| | | | | | | *1.575* | *.866* | | *1.969* | *1.969* | | *1.890* | | *1160* | | | |
| 50.0 | 16 | 1 | 4 | 2 | **392.41005C-5016050** | 50.0 | 16.0 | | 50.0 | 24.0 | 50.0 | 32.0 | 50.0 | 80 | 22.0 | 0.62 | 25000 |
| | | | | | | *1.969* | *.630* | | *1.969* | *.945* | *1.969* | *1.260* | *1.969* | *1160* | | | |
| | 22 | 1 | 4 | 2 | **392.41005C-5022060** | 50.0 | 22.0 | | 60.0 | 34.0 | 60.0 | 48.0 | 50.0 | 80 | 45.0 | 0.92 | 25000 |
| | | | | | | *1.969* | *.866* | | *2.362* | *1.339* | *2.362* | *1.890* | *1.969* | *1160* | | | |
| 63.0 | 16 | 1 | 4 | 2 | **392.41005C6316050** | 63.0 | 16.0 | | 50.0 | 24.0 | 50.0 | 32.0 | 63.0 | 80 | 22.0 | 0.87 | 20500 |
| | | | | | | *2.480* | *.630* | | *1.969* | *.945* | *1.969* | *1.260* | *2.480* | *1160* | | | |
| | 22 | 1 | 4 | 2 | **392.41005C6322050** | 63.0 | 22.0 | | 50.0 | 24.0 | 50.0 | 50.0 | 63.0 | 80 | 45.0 | 1.12 | 20500 |
| | | | | | | *2.480* | *.866* | | *1.969* | *.945* | *1.969* | *1.969* | *2.480* | *1160* | | | |
| | 27 | 1 | 4 | 2 | **392.41005C6327060** | 63.0 | 27.0 | | 60.0 | 24.0 | 60.0 | 60.0 | 63.0 | 80 | 80.0 | 1.45 | 20500 |
| | | | | | | *2.480* | *1.063* | | *2.362* | *.945* | *2.362* | *2.362* | *2.480* | *1160* | | | |
| | 32 | 1 | 4 | 1 | **392.41005C6332060** | 63.0 | 32.0 | | 60.0 | 60.0 | | 78.0 | | 80 | 180.0 | 1.80 | 20500 |
| | | | | | | *2.480* | *1.260* | | *2.362* | *2.362* | | *3.071* | | *1160* | | | |
| | 40S | 1 | 4 | 1 | **392.41005C6340060M** | 63.0 | 40.0 | 66.7 | 60.0 | 60.0 | | 87.0 | | 80 | 300.0 | 2.13 | 20500 |
| | | | | | | *2.480* | *1.575* | *2.626* | *2.362* | *2.362* | | *3.425* | | *1160* | | | |
| 80.0 | 22 | 1 | 4 | 2 | **392.41005C8022050** | 80.0 | 22.0 | | 50.0 | 24.0 | 50.0 | 50.0 | 80.0 | 80 | 45.0 | 1.59 | 14000 |
| | | | | | | *3.150* | *.866* | | *1.969* | *.945* | *1.969* | *1.969* | *3.150* | *1160* | | | |
| | 27 | 1 | 4 | 2 | **392.41005C8027050** | 80.0 | 27.0 | | 50.0 | 24.0 | 50.0 | 60.0 | 80.0 | 80 | 80.0 | 1.78 | 14000 |
| | | | | | | *3.150* | *1.063* | | *1.969* | *.945* | *1.969* | *2.362* | *3.150* | *1160* | | | |
| | 32 | 1 | 4 | 2 | **392.41005C8032060** | 80.0 | 32.0 | | 60.0 | 34.0 | 60.0 | 78.0 | 80.0 | 80 | 180.0 | 2.42 | 14000 |
| | | | | | | *3.150* | *1.260* | | *2.362* | *1.341* | *2.362* | *3.071* | *3.150* | *1160* | | | |
| | 40 | 1 | 4 | 1 | **392.41005C8040060** | 80.0 | 40.0 | | 60.0 | 60.0 | | 87.0 | | 80 | 300.0 | 2.74 | 14000 |
| | | | | | | *3.150* | *1.575* | | *2.362* | *2.362* | | *3.425* | | *1160* | | | |
| 100.0 | 22 | 1 | 4 | 2 | **392.41005C10022100** | 100.0 | 22.0 | | 100.0 | 71.0 | 100.0 | 50.0 | 100.0 | 80 | 45.0 | 3.25 | 12500 |
| | | | | | | *3.937* | *.866* | | *3.937* | *2.795* | *3.937* | *1.969* | *3.937* | *1160* | | | |
| | 27 | 1 | 4 | 2 | **392.41005C10027100** | 100.0 | 27.0 | | 100.0 | 71.0 | 100.0 | 60.0 | 100.0 | 80 | 80.0 | 3.76 | 12500 |
| | | | | | | *3.937* | *1.063* | | *3.937* | *2.795* | *3.937* | *2.362* | *3.937* | *1160* | | | |
| | 32 | 1 | 4 | 2 | **392.41005C10032100** | 100.0 | 32.0 | | 100.0 | 71.0 | 100.0 | 78.0 | 100.0 | 80 | 180.0 | 4.90 | 12500 |
| | | | | | | *3.937* | *1.260* | | *3.937* | *2.795* | *3.937* | *3.071* | *3.937* | *1160* | | | |
| | 40S | 1 | 4 | 2 | **392.41005C10040100M** | 100.0 | 40.0 | 66.7 | 100.0 | 71.0 | 100.0 | 87.0 | 100.0 | 80 | 300.0 | 5.62 | 12500 |
| | | | | | | *3.937* | *1.575* | *2.626* | *3.937* | *2.795* | *3.937* | *3.425* | *3.937* | *1160* | | | |
| 125.0 | 32 | 1 | 4 | 2 | **392.41005C12532100** | 125.0 | 32.0 | | 100.0 | 71.0 | 100.0 | 78.0 | 125.0 | 80 | 180.0 | 6.19 | 9500 |
| | | | | | | *4.921* | *1.260* | | *3.937* | *2.795* | *3.937* | *3.071* | *4.921* | *1160* | | | |
| | 40S | 1 | 4 | 2 | **392.41005C12540100M** | 125.0 | 40.0 | 66.7 | 100.0 | 71.0 | 100.0 | 87.0 | 125.0 | 80 | 300.0 | 7.05 | 9500 |
| | | | | | | *4.921* | *1.575* | *2.626* | *3.937* | *2.795* | *3.937* | *3.425* | *4.921* | *1160* | | | |

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

M1

N22

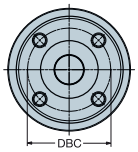
N15

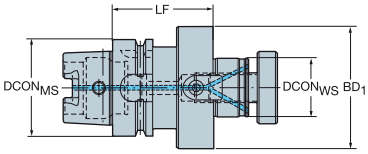
# HSK to arbor adapter

**Machine side interface HSK A/C**

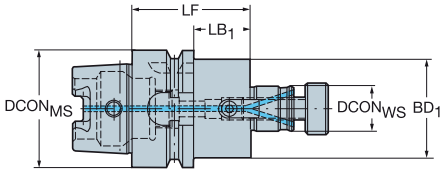
**Coolant through arbor**

DSGN 1



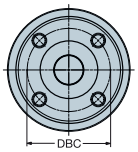

DSGN 2

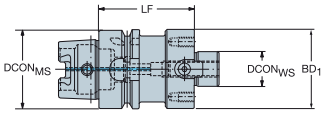



## Inch pilot

| | | | | | | Dimensions, mm, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | DBC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | BAR PSI | NM | KG | RPMX |
| 63.0 | 3/4 | 1 | 4 | 2 | A392.41005C6319050 | 63.0 | 19.1 | | 50.0 | 24.0 | 50.0 | 43.0 | 63.0 | 80 | 25.0 | 1.02 | 20500 |
| | | | | | | *2.480* | *.750* | | *1.969* | *.945* | *1.969* | *1.693* | *2.480* | *1160* | | | |
| | 1 | 1 | 4 | 2 | A392.41005C6325060 | 63.0 | 25.4 | | 60.0 | 34.0 | 60.0 | 50.0 | 63.0 | 80 | 65.0 | 1.36 | 20500 |
| | | | | | | *2.480* | *1.000* | | *2.362* | *1.339* | *2.362* | *1.969* | *2.480* | *1160* | | | |
| | 1 1/2 | 1 | 4 | 1 | A392.41005C6338065M | 63.0 | 38.1 | 66.7 | 65.0 | 65.0 | | 87.0 | | 80 | 220.0 | 2.42 | 20500 |
| | | | | | | *2.480* | *1.500* | *2.626* | *2.559* | *2.559* | | *3.425* | | *1160* | | | |
| 100.0 | 3/4 | 1 | 4 | 2 | A392.41005C10019100 | 100.0 | 19.1 | | 100.0 | 71.0 | 100.0 | 43.0 | 100.0 | 80 | 25.0 | 2.95 | 12500 |
| | | | | | | *3.937* | *.750* | | *3.937* | *2.795* | *3.937* | *1.693* | *3.937* | *1160* | | | |
| | 1 | 1 | 4 | 2 | A392.41005C10025100 | 100.0 | 25.4 | | 100.0 | 71.0 | 100.0 | 50.0 | 100.0 | 80 | 65.0 | 3.32 | 12500 |
| | | | | | | *3.937* | *1.000* | | *3.937* | *2.795* | *3.937* | *1.969* | *3.937* | *1160* | | | |
| | 1 1/2 | 1 | 4 | 2 | A392.41005C10038100M | 100.0 | 38.1 | 66.7 | 100.0 | 71.0 | 100.0 | 87.0 | 100.0 | 80 | 220.0 | 5.65 | 12500 |
| | | | | | | *3.937* | *1.500* | *2.626* | *3.937* | *2.795* | *3.937* | *3.425* | *3.937* | *1160* | | | |
| 125.0 | 1 1/2 | 1 | 4 | 2 | A392.41005C12538100M | 125.0 | 38.1 | 66.7 | 100.0 | 71.0 | 100.0 | 87.0 | 125.0 | 80 | 220.0 | 7.13 | 9500 |
| | | | | | | *4.921* | *1.500* | *2.626* | *3.937* | *2.795* | *3.937* | *3.425* | *4.921* | *1160* | | | |

DSGN 1




## Metric pilot

| | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | DBC | LF | $BD_1$ | NM | KG | RPMX |
| 100.0 | 60 | 1 | 392.41005-10060075 | 100.0 | 60.0 | 101.6 | 75.0 | 130.0 | 180.0 | 6.30 | 12500 |
| | | | | *3.937* | *2.362* | *4.000* | *2.953* | *5.118* | | | |
| 125.0 | 60 | 1 | 392.41005-12560085 | 125.0 | 60.0 | 101.6 | 85.0 | 130.0 | 180.0 | 9.70 | 9500 |
| | | | | *4.921* | *2.362* | *4.000* | *3.346* | *5.118* | | | |

## Inch pilot

| | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | DSGN | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | DBC | LF | $BD_1$ | NM | KG | RPMX |
| 100.0 | 2 1/2 | 1 | A392.41005-10063075 | 100.0 | 63.5 | 101.6 | 75.0 | 130.0 | 120.0 | 6.49 | 12500 |
| | | | | *3.937* | *2.500* | *4.000* | *2.953* | *5.118* | | | |
| 125.0 | 2 1/2 | 1 | A392.41005-12563085 | 125.0 | 63.5 | 101.6 | 85.0 | 130.0 | 120.0 | 9.28 | 9500 |
| | | | | *4.921* | *2.500* | *4.000* | *3.346* | *5.118* | | | |

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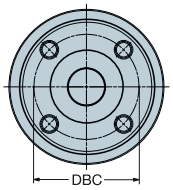
M1 N22 N15

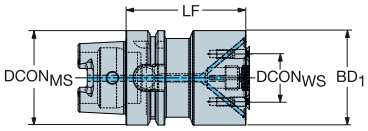
# HSK to arbor with driving screws adapter

**Machine side interface HSK A/C**

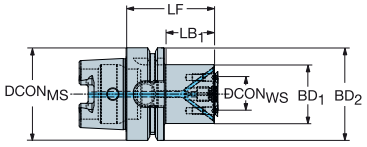
**For CoroMill® QD with internal coolant supply**




DSGN 1




2

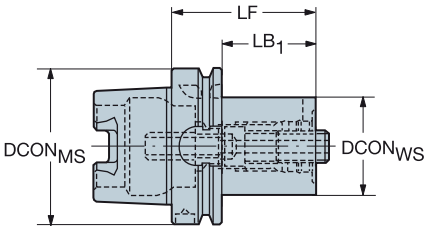



**Metric pilot**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | DBC | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | BAR PSI | NM | KG | RPMX |
| 63.0 | X10 | 1 | 3 | 2 | **HA06-X10-032-055** | 63.0 | 10.0 | 22.0 | 2 | 55.0 | 28.0 | 55.0 | 32.0 | 63.0 | 80 | 6.4 | 0.85 | 12000 |
| | | | | | | *2.480* | *.394* | *.866* | *.094* | *2.165* | *1.102* | *2.165* | *1.260* | *2.480* | *1160* | | | |
| | X22 | 1 | 3 | 2 | **HA06-X22-040-060** | 63.0 | 22.0 | 32.0 | 2 | 60.0 | 33.0 | 60.0 | 40.0 | 63.0 | 80 | 3.9 | 1.01 | 11000 |
| | | | | | | *2.480* | *.866* | *1.260* | *.094* | *2.362* | *1.299* | *2.362* | *1.575* | *2.480* | *1160* | | | |
| | X32 | 1 | 3 | 1 | **HA06-X32-063-080** | 63.0 | 32.0 | 45.0 | 2 | 80.0 | 80.0 | | 63.0 | | 80 | 6.4 | 1.82 | 10000 |
| | | | | | | *2.480* | *1.260* | *1.772* | *.094* | *3.150* | *3.150* | | *2.480* | | *1160* | | | |

# HSK to VL adapter

**Machine side interface HSK A/C**




| | | | | Dimensions, mm, inch | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | BAR PSI | NM | KG |
| 100.0 | 80 | 1 | 1 | **390.410-100 80 090** | 100.0 | 80.0 | 90.0 | 61.0 | 100 | 170.0 | 4.39 |
| | | | | | *3.937* | *3.150* | *3.543* | *2.402* | *1450* | | |

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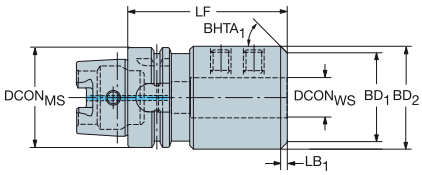
M1 N22 N15

# HSK to Weldon adapter

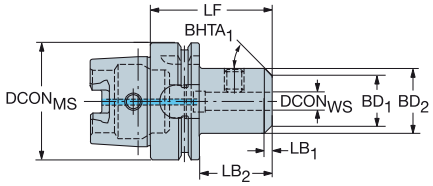
**Machine side interface HSK A/C**

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

DSGN 3




DSGN 6




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | 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 PSI | NM | KG | RPMX |
| 63.0 | 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 | 7.0 | 0.83 | 20500 |
| | | | | | | *2.480* | *.315* | *2.559* | *.079* | *1.535* | *2.559* | *.945* | *1.102* | *2.480* | | *290* | | | |
| | 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 | 10.0 | 1.02 | 20500 |
| | | | | | | *2.480* | *.394* | *2.559* | *.079* | *1.535* | *2.559* | *1.220* | *1.378* | *2.480* | | *290* | | | |
| | 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 | 12.0 | 1.18 | 20500 |
| | | | | | | *2.480* | *.472* | *3.150* | *.079* | *2.126* | *3.150* | *1.496* | *1.654* | *2.480* | | *290* | | | |
| | 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 | 15.0 | 1.32 | 20500 |
| | | | | | | *2.480* | *.630* | *3.150* | *.079* | *2.126* | *3.150* | *1.732* | *1.890* | *2.480* | | *290* | | | |
| | 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 | 20.0 | 1.39 | 20500 |
| | | | | | | *2.480* | *.787* | *3.150* | *.157* | *2.126* | *3.150* | *1.732* | *2.047* | *2.480* | | *290* | | | |
| | 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 | 25.0 | 2.35 | 20500 |
| | | | | | | *2.480* | *.984* | *4.331* | *.197* | *4.331* | | *2.165* | *2.559* | | | *290* | | | |
| | 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 | 45.0 | 2.60 | 20500 |
| | | | | | | *2.480* | *1.260* | *4.331* | *.197* | *4.331* | | *2.441* | *2.835* | | | *290* | | | |
| 100.0 | 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 | 12.0 | 2.62 | 12500 |
| | | | | | | *3.937* | *.472* | *3.150* | *.197* | *2.008* | *3.150* | *1.260* | *1.654* | *3.937* | | *290* | | | |
| | 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 | 15.0 | 2.98 | 12500 |
| | | | | | | *3.937* | *.630* | *3.937* | *.197* | *2.795* | *3.937* | *1.260* | *1.654* | *3.937* | | *290* | | | |
| | 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 | 20.0 | 3.12 | 12500 |
| | | | | | | *3.937* | *.787* | *3.937* | *.197* | *2.795* | *3.937* | *1.654* | *2.047* | *3.937* | | *290* | | | |
| | 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 | 25.0 | 3.59 | 12500 |
| | | | | | | *3.937* | *.984* | *3.937* | *.315* | *2.795* | *3.937* | *1.929* | *2.559* | *3.937* | | *290* | | | |
| | 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 | 45.0 | 3.84 | 12500 |
| | | | | | | *3.937* | *1.260* | *3.937* | *.315* | *2.795* | *3.937* | *2.205* | *2.835* | *3.937* | | *290* | | | |
| | 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 | 45.0 | 5.64 | 12500 |
| | | | | | | *3.937* | *1.575* | *4.724* | *.315* | *3.583* | *4.724* | *2.913* | *3.543* | *3.937* | | *290* | | | |

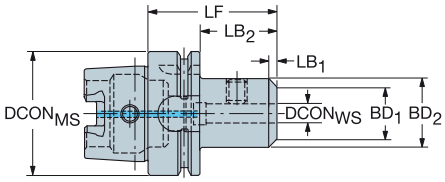
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

# HSK to Weldon adapter

**Machine side interface HSK A/C**

**Workpiece side interface ANSI B94.19**




## Inch bore

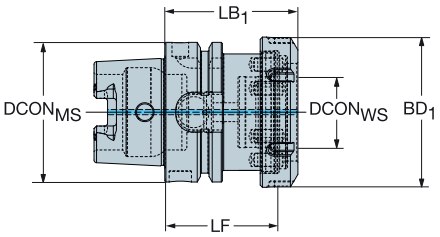
| | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 63.0 | 3/4 | 1 | 1 | **A392.41020-63 19 080B** | 63.0 | 19.1 | 80.0 | 7.5 | 54.0 | 80.0 | 35.8 | 44.5 | 63.0 | 30° | 20 | 20.0 | 1.17 | 20500 |
| | | | | | *2.480* | *.750* | *3.150* | *.295* | *2.126* | *3.150* | *1.409* | *1.752* | *2.480* | | *290* | | | |
| | 1 | 1 | 1 | **A392.41020-63 25 105B** | 63.0 | 25.4 | 105.0 | 7.5 | 79.0 | 105.0 | 48.4 | 57.1 | 63.0 | 30° | 20 | 25.0 | 1.90 | 20500 |
| | | | | | *2.480* | *1.000* | *4.134* | *.295* | *3.110* | *4.134* | *1.906* | *2.248* | *2.480* | | *290* | | | |
| | 1 1/4 | 1 | 1 | **A392.41020-63 31 105B** | 63.0 | 31.8 | 105.0 | 7.5 | 105.0 | | 54.3 | 63.0 | | 30° | 20 | 45.0 | 2.01 | 20500 |
| | | | | | *2.480* | *1.250* | *4.134* | *.295* | *4.134* | | *2.138* | *2.480* | | | *290* | | | |
| 100.0 | 3/4 | 1 | 1 | **A392.41020-100 19 090A** | 100.0 | 19.1 | 90.0 | 7.5 | 53.3 | 90.0 | 35.8 | 44.5 | 100.0 | 30° | 20 | 20.0 | 2.71 | 12500 |
| | | | | | *3.937* | *.750* | *3.543* | *.295* | *2.098* | *3.543* | *1.409* | *1.752* | *3.937* | | *290* | | | |
| | 1 | 1 | 1 | **A392.41020-100 25 100A** | 100.0 | 25.4 | 100.0 | 7.5 | 66.3 | 100.0 | 48.4 | 57.1 | 100.0 | 30° | 20 | 25.0 | 3.24 | 12500 |
| | | | | | *3.937* | *1.000* | *3.937* | *.295* | *2.610* | *3.937* | *1.906* | *2.248* | *3.937* | | *290* | | | |
| | 1 1/4 | 1 | 1 | **A392.41020-100 31 100A** | 100.0 | 31.8 | 100.0 | 7.5 | 71.0 | 100.0 | 54.3 | 63.0 | 100.0 | 30° | 20 | 45.0 | 3.35 | 12500 |
| | | | | | *3.937* | *1.250* | *3.937* | *.295* | *2.795* | *3.937* | *2.138* | *2.480* | *3.937* | | *290* | | | |
| | 1 1/2 | 1 | 1 | **A392.41020-100 38 110A** | 100.0 | 38.1 | 110.0 | 7.5 | 81.0 | 110.0 | 61.3 | 70.0 | 100.0 | 30° | 20 | 45.0 | 3.95 | 12500 |
| | | | | | *3.937* | *1.500* | *4.331* | *.295* | *3.189* | *4.331* | *2.413* | *2.756* | *3.937* | | *290* | | | |
| | 2 | 1 | 1 | **A392.41020-100 50 130A** | 100.0 | 50.8 | 130.0 | 7.5 | 101.0 | 130.0 | 84.8 | 93.5 | 100.0 | 30° | 20 | 60.0 | 5.93 | 12500 |
| | | | | | *3.937* | *2.000* | *5.118* | *.295* | *3.976* | *5.118* | *3.339* | *3.681* | *3.937* | | *290* | | | |

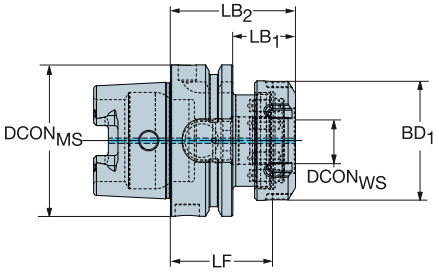
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

# HSK to MDI adapter

**Machine side interface HSK A/C/T**




**Metric bore**

| | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | BAR PSI | NM | KG | RPMX |
| 63.0 | MDI-20 | 1 | 1 | **HT06-DM20-N-042** | 63.0 | 20.0 | 42.0 | 26.0 | 52.0 | 49.7 | 63.0 | 80 | 135.0 | 0.86 | 20000 |
| | | | | | *2.480* | *.787* | *1.654* | *1.026* | *2.047* | *1.957* | *2.480* | *1160* | | | |
| | MDI-25 | 1 | 1 | **HT06-DM25-N-050** | 63.0 | 25.0 | 50.0 | 34.0 | 60.0 | 62.7 | 63.0 | 80 | 170.0 | 1.10 | 20000 |
| | | | | | *2.480* | *.984* | *1.969* | *1.341* | *2.362* | *2.469* | *2.480* | *1160* | | | |
| | MDI-32 | 1 | 1 | **HT06-DM32-N-050** | 63.0 | 32.0 | 50.0 | 60.0 | | 67.7 | | 80 | 200.0 | 1.18 | 20000 |
| | | | | | *2.480* | *1.260* | *1.969* | *2.362* | | *2.665* | | *1160* | | | |

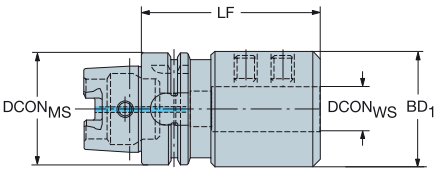
For spare parts, visit www.sandvik.coromant.com

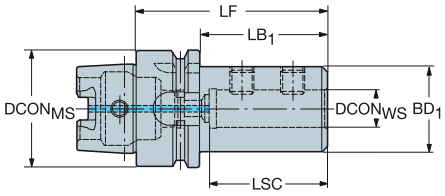
M1 N22 N15 N5

# HSK to ISO 9766 adapter

**Machine side interface HSK A/C**

DSGN 1 2



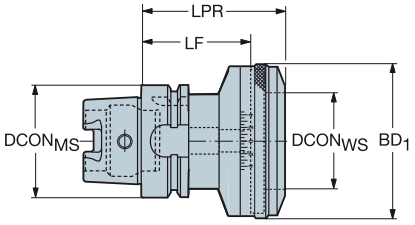




**Metric bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 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 | 10.0 | 1.02 | 20500 |
| | | | | | | *2.480* | *.630* | *1.949* | *3.150* | *2.126* | *3.150* | *1.417* | *2.480* | *290* | | | |
| | 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 | 12.0 | 1.06 | 20500 |
| | | | | | | *2.480* | *.787* | *2.028* | *3.150* | *2.126* | *3.150* | *1.575* | *2.480* | *290* | | | |
| | 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 | 20.0 | 0.12 | 20500 |
| | | | | | | *2.480* | *.984* | *2.264* | *3.543* | *2.520* | *3.543* | *1.772* | *2.480* | *290* | | | |
| | 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 | 30.0 | 1.32 | 20500 |
| | | | | | | *2.480* | *1.260* | *2.421* | *3.543* | *2.520* | *3.543* | *2.047* | *2.480* | *290* | | | |
| | 40 | 1 | 1 | 1 | 392.41027-63 40 110 | 63.0 | 40.0 | 71 | 110.0 | 110.0 | | 65.0 | | 20 | 40.0 | 1.93 | 20500 |
| | | | | | | *2.480* | *1.575* | *2.815* | *4.331* | *4.331* | | *2.559* | | *290* | | | |
| 80.0 | 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 | 12.0 | 1.59 | 14000 |
| | | | | | | *3.150* | *.787* | *2.028* | *3.346* | *2.325* | *3.346* | *1.575* | *3.150* | *290* | | | |
| | 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 | 20.0 | 1.70 | 14000 |
| | | | | | | *3.150* | *.984* | *2.264* | *3.543* | *2.522* | *3.543* | *1.772* | *3.150* | *290* | | | |
| | 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 | 30.0 | 1.88 | 14000 |
| | | | | | | *3.150* | *1.260* | *2.421* | *3.740* | *2.719* | *3.740* | *2.047* | *3.150* | *290* | | | |
| | 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 | 40.0 | 2.58 | 14000 |
| | | | | | | *3.150* | *1.575* | *2.815* | *4.331* | *3.309* | *4.331* | *2.559* | *3.150* | *290* | | | |
| 100.0 | 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 | 10.0 | 2.52 | 12500 |
| | | | | | | *3.937* | *.630* | *1.949* | *3.543* | *2.402* | *3.543* | *1.417* | *3.937* | *290* | | | |
| | 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 | 12.0 | 2.58 | 12500 |
| | | | | | | *3.937* | *.787* | *2.028* | *3.543* | *2.402* | *3.543* | *1.575* | *3.937* | *290* | | | |
| | 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 | 20.0 | 2.73 | 12500 |
| | | | | | | *3.937* | *.984* | *2.264* | *3.937* | *2.795* | *3.937* | *1.772* | *3.937* | *290* | | | |
| | 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 | 30.0 | 2.84 | 12500 |
| | | | | | | *3.937* | *1.260* | *2.421* | *3.937* | *2.795* | *3.937* | *2.047* | *3.937* | *290* | | | |
| | 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 | 40.0 | 3.43 | 12500 |
| | | | | | | *3.937* | *1.575* | *2.815* | *4.331* | *3.189* | *4.331* | *2.559* | *3.937* | *290* | | | |
| | 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 | 45.0 | 3.95 | 12500 |
| | | | | | | *3.937* | *1.969* | *3.209* | *4.724* | *3.583* | *4.724* | *2.953* | *3.937* | *290* | | | |

# HSK to ISO 9766 adjustable adapter

**Machine side interface HSK A/C**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BD$_1$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 1 | 1 | 1 | 392.410277-63 01 060B | 63.0 | 78.0 | 60.0 | 84.6 | 86.0 | 20 | 2.09 | 12000 |
| | | | | | *2.480* | *3.071* | *2.362* | *3.331* | *3.386* | *290* | | |
| 100.0 | 2 | 1 | 1 | 392.410277-100 02 065A | 100.0 | 98.0 | 65.0 | 89.6 | 106.0 | 20 | 4.64 | 9000 |
| | | | | | *3.937* | *3.858* | *2.559* | *3.528* | *4.173* | *290* | | |
| | 3 | 1 | 1 | 392.410277-100 03 085A | 100.0 | 136.0 | 85.0 | 95.0 | 140.0 | 20 | 6.58 | 6000 |
| | | | | | *3.937* | *5.354* | *3.346* | *3.740* | *5.512* | *290* | | |

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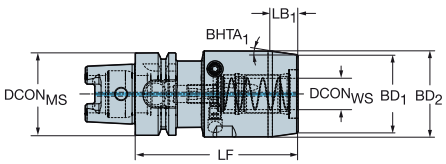
M1 N22 N15

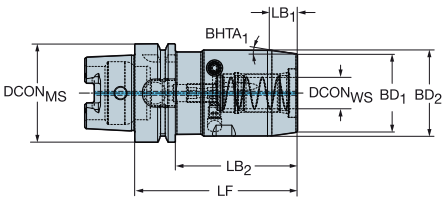
# HSK to CoroChuck™ 930

**Heavy-duty design**

**Machine side interface HSK A/C**

DSGN 3 6



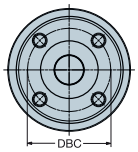

**Metric bore**

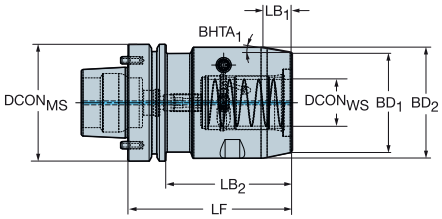
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 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 | 10.0 | 1.89 | 20000 |
| | | | | | | *2.480* | *.787* | *2.008* | *4.094* | *.701* | *3.071* | *4.094* | *1.969* | *2.165* | *2.476* | | *1160* | | | |
| | 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 | 10.0 | 2.35 | 20000 |
| | | | | | | *2.480* | *.984* | *2.244* | *4.331* | *.740* | *4.331* | | *2.244* | *2.559* | | | *1160* | | | |
| | 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 | 10.0 | 2.90 | 20000 |
| | | | | | | *2.480* | *1.260* | *2.402* | *4.409* | *.740* | *4.409* | | *2.677* | *2.992* | | | *1160* | | | |
| 80.0 | 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 | 10.0 | 3.44 | 14000 |
| | | | | | | *3.150* | *1.260* | *2.402* | *4.331* | *.740* | *3.307* | *4.331* | *2.677* | *2.992* | *3.150* | | *1160* | | | |
| 100.0 | 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 | 10.0 | 3.18 | 10000 |
| | | | | | | *3.937* | *.787* | *2.008* | *3.937* | *.701* | *2.795* | *3.937* | *1.969* | *2.165* | *3.933* | | *1160* | | | |
| | 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 | 10.0 | 3.72 | 10000 |
| | | | | | | *3.937* | *.984* | *2.244* | *4.173* | *.740* | *3.032* | *4.173* | *2.244* | *2.559* | *3.933* | | *1160* | | | |
| | 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 | 10.0 | 4.40 | 10000 |
| | | | | | | *3.937* | *1.260* | *2.402* | *4.331* | *.740* | *3.189* | *4.331* | *2.677* | *2.992* | *3.933* | | *1160* | | | |
| | 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 | 10.0 | 6.84 | 10000 |
| | | | | | | *3.937* | *1.260* | *2.402* | *7.087* | *.740* | *5.945* | *7.087* | *2.677* | *2.992* | *3.937* | | *1160* | | | |

**Inch bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BD$_3$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 100.0 | 1 1/4 | 1 | 1 | 6 | 930-HA10-HD-A31-110 | 100.0 | 31.8 | 61 | 110.0 | 18.8 | 81.0 | 68.0 | 76.0 | 99.9 | 12° | 80 | 10.0 | 4.41 | 10000 |
| | | | | | | *3.937* | *1.250* | *2.402* | *4.331* | *.740* | *3.189* | *2.677* | *2.992* | *3.933* | | *1160* | | | |

**Machine-side interface HSK F with pins for Makino**




**Metric bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 80.0 | 32 | 1 | 1 | 930-HF08-HD-32-112 | 80.0 | 32.0 | 58.0 | 61 | 112.0 | 18.8 | 86.0 | 68.0 | 76.0 | 12° | 80 | 10.0 | 3.48 | 24000 |
| | | | | | *3.150* | *1.260* | *2.283* | *2.402* | *4.409* | *.740* | *3.386* | *2.677* | *2.992* | | *1160* | | | |

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

M1 N22 N6 N15 N4

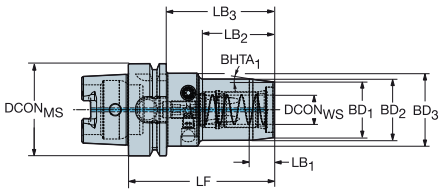


SANDVIK Coromant

# HSK to CoroChuck™ 930

**Slender design**

**Machine side interface HSK A/C**




## Metric bore

| | | | | | Dimensions, mm, inch | | | | | | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | | | | RPMX |
| 40.0 | 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 | 40.0 | 10° | 80 | 8.0 | 0.40 | 30000 |
| | | | | | *1.575* | *.236* | *1.457* | *2.756* | *.445* | *1.307* | *1.969* | *.866* | *1.024* | *1.260* | *1.575* | | *1160* | | | |
| | 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 | 40.0 | 10° | 80 | 8.0 | 0.42 | 30000 |
| | | | | | *1.575* | *.315* | *1.457* | *2.756* | *.445* | *1.390* | *1.969* | *.945* | *1.102* | *1.260* | *1.575* | | *1160* | | | |
| | 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 | 40.0 | 10° | 80 | 8.0 | 0.46 | 30000 |
| | | | | | *1.575* | *.394* | *1.614* | *2.953* | *.445* | *1.559* | *2.165* | *1.024* | *1.181* | *1.260* | *1.575* | | *1160* | | | |
| | 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 | 40.0 | 10° | 80 | 8.0 | 0.51 | 30000 |
| | | | | | *1.575* | *.472* | *1.811* | *3.150* | *.445* | *1.614* | *2.362* | *1.102* | *1.260* | *1.319* | *1.575* | | *1160* | | | |
| 50.0 | 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 | 50.0 | 10° | 80 | 8.0 | 0.64 | 25000 |
| | | | | | *1.969* | *.236* | *1.457* | *2.913* | *.445* | *1.189* | *1.890* | *.866* | *1.024* | *1.575* | *1.969* | | *1160* | | | |
| | 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 | 50.0 | 10° | 80 | 8.0 | 0.65 | 25000 |
| | | | | | *1.969* | *.315* | *1.457* | *2.913* | *.445* | *1.189* | *1.890* | *.945* | *1.102* | *1.575* | *1.969* | | *1160* | | | |
| | 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 | 50.0 | 10° | 80 | 8.0 | 0.71 | 25000 |
| | | | | | *1.969* | *.394* | *1.614* | *3.150* | *.445* | *1.346* | *2.126* | *1.024* | *1.181* | *1.575* | *1.969* | | *1160* | | | |
| | 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 | 50.0 | 10° | 80 | 8.0 | 0.75 | 25000 |
| | | | | | *1.969* | *.472* | *1.811* | *3.346* | *.445* | *1.504* | *2.323* | *1.102* | *1.260* | *1.575* | *1.969* | | *1160* | | | |
| 63.0 | 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 | 63.0 | 10° | 80 | 8.0 | 0.90 | 20000 |
| | | | | | *2.480* | *.236* | *1.457* | *2.913* | *.445* | *1.189* | *1.890* | *.866* | *1.024* | *1.575* | *2.480* | | *1160* | | | |
| | 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 | 63.0 | 10° | 80 | 8.0 | 0.91 | 20000 |
| | | | | | *2.480* | *.315* | *1.457* | *2.913* | *.445* | *1.189* | *1.890* | *.945* | *1.102* | *1.575* | *2.480* | | *1160* | | | |
| | 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 | 63.0 | 10° | 80 | 8.0 | 0.99 | 20000 |
| | | | | | *2.480* | *.394* | *1.614* | *3.150* | *.445* | *1.346* | *2.126* | *1.024* | *1.181* | *1.575* | *2.480* | | *1160* | | | |
| | 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 | 63.0 | 10° | 80 | 8.0 | 1.21 | 20000 |
| | | | | | *2.480* | *.472* | *1.811* | *3.543* | *.445* | *1.504* | *2.520* | *1.102* | *1.260* | *1.969* | *2.480* | | *1160* | | | |
| | 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 | 63.0 | 7° | 80 | 8.0 | 1.40 | 20000 |
| | | | | | *2.480* | *.787* | *2.008* | *3.937* | *.630* | *1.937* | *2.913* | *1.496* | *1.654* | *1.969* | *2.480* | | *1160* | | | |
| 100.0 | 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 | 100.0 | 10° | 80 | 8.0 | 2.63 | 10000 |
| | | | | | *3.937* | *.472* | *1.811* | *3.740* | *.445* | *1.504* | *2.598* | *1.102* | *1.260* | *1.969* | *3.937* | | *1160* | | | |
| | 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 | 100.0 | 7° | 80 | 8.0 | 2.74 | 10000 |
| | | | | | *3.937* | *.787* | *2.008* | *3.937* | *.630* | *1.937* | *2.795* | *1.496* | *1.654* | *1.969* | *3.937* | | *1160* | | | |

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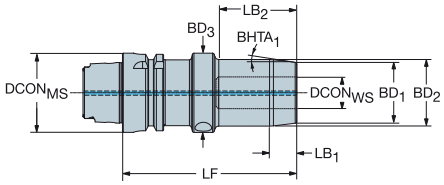
M1 N22 N6 N15 N4

# HSK to CoroChuck™ 930

**Slender design**




**Metric bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 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 | 8.0 | 0.70 | 40000 |
| | | | | | *1.575* | *.472* | *1.811* | *3.780* | *.445* | *1.504* | *1.102* | *1.260* | | *1160* | | | |
| 50.0 | 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 | 8.0 | 0.89 | 25000 |
| | | | | | *1.969* | *.787* | *2.008* | *3.543* | *.630* | *2.520* | *1.480* | *1.634* | | *1160* | | | |
| | 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 | 8.0 | 1.19 | 36000 |
| | | | | | *1.969* | *.787* | *2.008* | *4.331* | *.630* | *1.937* | *1.496* | *1.654* | | *1160* | | | |
| 63.0 | 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 | 8.0 | 1.66 | 20000 |
| | | | | | *2.480* | *.984* | *2.244* | *4.252* | *.508* | *3.193* | *1.772* | *1.969* | | *1160* | | | |
| 80.0 | 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 | 8.0 | 2.13 | 14000 |
| | | | | | *3.150* | *.984* | *2.244* | *4.331* | *.508* | *3.272* | *1.772* | *1.969* | | *1160* | | | |
| 100.0 | 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 | 8.0 | 3.02 | 10000 |
| | | | | | *3.937* | *.984* | *2.244* | *4.331* | *.508* | *3.154* | *1.772* | *1.969* | | *1160* | | | |

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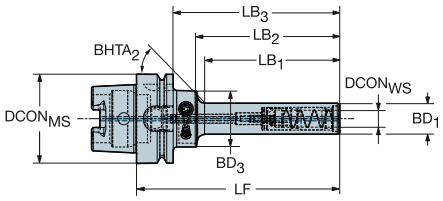
M1 N22 N6 N15 N4

# HSK to CoroChuck™ 930

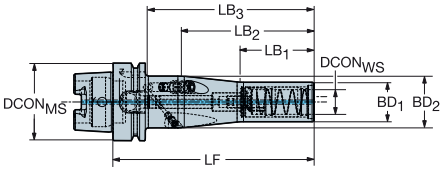
**Pencil design**

**Machine side interface HSK A/C**



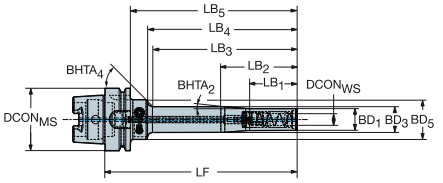

### Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BD$_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 6 | 1 | 1 | 930-HA06-P-06-094 | 63.0 | 6.0 | 37 | 94.0 | 45.8 | 68.0 | 14.5 | 40.0 | 63.0 | 80 | 8.0 | 0.89 | 20000 |
| | | | | | *2.480* | *.236* | *1.457* | *3.701* | *1.803* | *2.677* | *.571* | *1.575* | *2.480* | *1160* | | | |
| | 8 | 1 | 1 | 930-HA06-P-08-094 | 63.0 | 8.0 | 37 | 94.0 | 45.8 | 65.5 | 17.5 | 40.0 | 63.0 | 80 | 8.0 | 0.87 | 20000 |
| | | | | | *2.480* | *.315* | *1.457* | *3.701* | *1.803* | *2.579* | *.689* | *1.575* | *2.480* | *1160* | | | |
| | 10 | 1 | 1 | 930-HA06-P-10-104 | 63.0 | 10.0 | 41 | 104.0 | 55.8 | 75.5 | 20.0 | 40.0 | 63.0 | 80 | 8.0 | 0.91 | 20000 |
| | | | | | *2.480* | *.394* | *1.614* | *4.094* | *2.197* | *2.972* | *.787* | *1.575* | *2.480* | *1160* | | | |
| | 10 | 1 | 1 | 930-HA06-P-10-144 | 63.0 | 10.0 | 41 | 144.0 | 95.8 | 115.5 | 20.0 | 40.0 | 63.0 | 80 | 8.0 | 1.01 | 20000 |
| | | | | | *2.480* | *.394* | *1.614* | *5.669* | *3.772* | *4.547* | *.787* | *1.575* | *2.480* | *1160* | | | |
| | 12 | 1 | 1 | 930-HA06-P-12-109 | 63.0 | 12.0 | 46 | 109.0 | 60.8 | 83.0 | 22.0 | 40.0 | 63.0 | 80 | 8.0 | 0.98 | 20000 |
| | | | | | *2.480* | *.472* | *1.811* | *4.291* | *2.394* | *3.268* | *.866* | *1.575* | *2.480* | *1160* | | | |
| | 12 | 1 | 1 | 930-HA06-P-12-144 | 63.0 | 12.0 | 46 | 144.0 | 95.8 | 118.0 | 22.0 | 40.0 | 63.0 | 80 | 8.0 | 1.09 | 20000 |
| | | | | | *2.480* | *.472* | *1.811* | *5.669* | *3.772* | *4.646* | *.866* | *1.575* | *2.480* | *1160* | | | |
| 100.0 | 12 | 1 | 1 | 930-HA10-P-12-115 | 100.0 | 12.0 | 46 | 115.0 | 60.8 | 86.0 | 22.0 | 40.0 | 100.0 | 80 | 8.0 | 2.40 | 10000 |
| | | | | | *3.937* | *.472* | *1.811* | *4.528* | *2.394* | *3.386* | *.866* | *1.575* | *3.937* | *1160* | | | |
| | 12 | 1 | 1 | 930-HA10-P-12-150 | 100.0 | 12.0 | 46 | 150.0 | 95.8 | 121.0 | 22.0 | 40.0 | 100.0 | 80 | 8.0 | 2.51 | 10000 |
| | | | | | *3.937* | *.472* | *1.811* | *5.906* | *3.772* | *4.764* | *.866* | *1.575* | *3.937* | *1160* | | | |




### Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 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 | 63.0 | 6° | 80 | 8.0 | 1.59 | 20000 |
| | | | | | *2.480* | *.787* | *2.008* | *6.417* | *2.362* | *4.252* | *5.394* | *1.260* | *1.654* | *2.480* | | *1160* | | | |
| 100.0 | 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 | 100.0 | 6° | 80 | 8.0 | 3.06 | 10000 |
| | | | | | *3.937* | *.787* | *2.008* | *6.693* | *2.362* | *4.252* | *5.551* | *1.260* | *1.654* | *3.937* | | *1160* | | | |




### Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 12 | 1 | 1 | 930-HA06-P-12-194 | 63.0 | 12.0 | 46 | 194.0 | 50.0 | 75.0 | 145.8 | 22.0 | 26.0 | 40.0 | 4° | 80 | 8.0 | 1.39 | 20000 |
| | | | | | *2.480* | *.472* | *1.811* | *7.638* | *1.969* | *2.953* | *5.740* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| 100.0 | 12 | 1 | 1 | 930-HA10-P-12-200 | 100.0 | 12.0 | 46 | 200.0 | 50.0 | 75.0 | 145.8 | 22.0 | 26.0 | 40.0 | 4° | 80 | 8.0 | 2.79 | 10000 |
| | | | | | *3.937* | *.472* | *1.811* | *7.874* | *1.969* | *2.953* | *5.740* | *.866* | *1.024* | *1.575* | | *1160* | | | |

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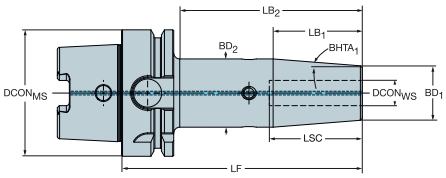
M1 N22 N6 N15 N4

# HSK to shrink fit chuck adaptor

**Machine side interface HSK A/C**

**Internal coolant supply**




**Metric bore**

| | | | | | Dimensions, mm, inch | | | | | | | | | BAR PSI | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BHTA_1$ | | | RPMX |
| 63.0 | 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 |
| | | | | | *2.480* | *.236* | *.866* | *3.150* | *1.502* | *2.126* | *.827* | *1.063* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.236* | *.866* | *4.724* | *1.502* | *3.701* | *.827* | *1.063* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.315* | *1.024* | *3.150* | *1.502* | *2.126* | *.827* | *1.063* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.315* | *1.024* | *4.724* | *1.502* | *3.701* | *.827* | *1.063* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.394* | *1.220* | *3.346* | *2.002* | *2.323* | *.945* | *1.260* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.394* | *1.220* | *4.724* | *2.002* | *3.701* | *.945* | *1.260* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.472* | *1.339* | *3.543* | *2.002* | *2.520* | *.945* | *1.260* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.472* | *1.339* | *4.724* | *2.002* | *3.701* | *.945* | *1.260* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.630* | *1.535* | *3.740* | *1.752* | *2.717* | *1.063* | *1.339* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.630* | *1.535* | *4.724* | *1.752* | *3.701* | *1.063* | *1.339* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.787* | *1.614* | *3.937* | *2.252* | *2.913* | *1.299* | *1.654* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.787* | *1.614* | *4.724* | *2.252* | *3.701* | *1.299* | *1.654* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *.984* | *1.850* | *4.528* | *2.252* | *3.504* | *1.732* | *2.087* | | *145* | | |
| | 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 |
| | | | | | *2.480* | *1.260* | *2.008* | *4.724* | *2.252* | *3.701* | *1.732* | *2.087* | | *145* | | |
| 100.0 | 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 |
| | | | | | *3.937* | *.236* | *.866* | *3.346* | *1.502* | *2.205* | *.827* | *1.063* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.236* | *.866* | *4.724* | *1.502* | *3.583* | *.827* | *1.063* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.315* | *1.024* | *3.346* | *1.502* | *2.205* | *.827* | *1.063* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.315* | *1.024* | *4.724* | *1.502* | *3.583* | *.827* | *1.063* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.394* | *1.220* | *3.543* | *2.002* | *2.402* | *.945* | *1.260* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.394* | *1.220* | *4.724* | *2.002* | *3.583* | *.945* | *1.260* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.472* | *1.339* | *3.740* | *2.002* | *2.598* | *.945* | *1.260* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.472* | *1.339* | *4.724* | *2.002* | *3.583* | *.945* | *1.260* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.630* | *1.535* | *3.937* | *1.752* | *2.795* | *1.063* | *1.339* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.630* | *1.535* | *5.118* | *1.752* | *3.976* | *1.063* | *1.339* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.787* | *1.614* | *4.134* | *2.252* | *2.992* | *1.299* | *1.654* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.787* | *1.614* | *5.118* | *2.252* | *3.976* | *1.299* | *1.654* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *.984* | *1.850* | *4.528* | *2.252* | *3.386* | *1.732* | *2.087* | | *145* | | |
| | 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 |
| | | | | | *3.937* | *1.260* | *2.008* | *4.724* | *2.252* | *3.583* | *1.732* | *2.087* | | *145* | | |

For MQL machining

Balance: Fine adjustment possibility

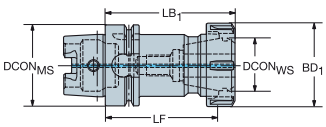
M1 N22 N15

# HSK to ER collet chuck

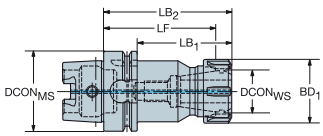
**Machine side interface HSK A/C**

**Workpiece side interface DIN 6499-B**

DSGN 1




2




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | ER25 | 1 | 1 | 1 | 392.41014-4025062 | 40.0 | 26.0 | 50.0 | 62.0 | | 42.0 | | 80 | 0.42 | 30000 |
| | | | | | | *1.575* | *1.024* | *1.969* | *2.441* | | *1.654* | | *1160* | | |
| 50.0 | ER32 | 1 | 1 | 1 | 392.41014-5032072 | 50.0 | 33.0 | 59.0 | 72.0 | | 50.0 | | 80 | 0.70 | 25000 |
| | | | | | | *1.969* | *1.299* | *2.323* | *2.835* | | *1.969* | | *1160* | | |
| 63.0 | 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 |
| | | | | | | *2.480* | *.669* | *3.520* | *2.797* | *3.937* | *1.102* | *2.480* | *1160* | | |
| | ER20 | 1 | 1 | 2 | 392.41014-63 20 100 | 63.0 | 21.0 | 88.5 | 71.0 | 100.0 | 34.0 | 63.0 | 80 | 1.02 | 20500 |
| | | | | | | *2.480* | *.827* | *3.484* | *2.797* | *3.937* | *1.339* | *2.480* | *1160* | | |
| | 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 |
| | | | | | | *2.480* | *1.024* | *3.465* | *2.913* | *3.937* | *1.654* | *2.480* | *1160* | | |
| | 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 |
| | | | | | | *2.480* | *1.299* | *3.425* | *2.913* | *3.937* | *1.969* | *2.480* | *1160* | | |
| | ER40 | 1 | 1 | 1 | 392.41014-63 40 120B | 63.0 | 41.0 | 105.0 | 120.0 | | 63.0 | | 80 | 1.88 | 20500 |
| | | | | | | *2.480* | *1.614* | *4.134* | *4.724* | | *2.480* | | *1160* | | |
| 100.0 | 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 |
| | | | | | | *3.937* | *1.299* | *3.425* | *2.795* | *3.937* | *1.969* | *3.937* | *1160* | | |
| | 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 |
| | | | | | | *3.937* | *1.614* | *4.134* | *3.583* | *4.724* | *2.480* | *3.937* | *1160* | | |
| | 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 |
| | | | | | | *3.937* | *2.047* | *4.291* | *3.976* | *5.118* | *3.071* | *3.937* | *1160* | | |

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

M1

N22

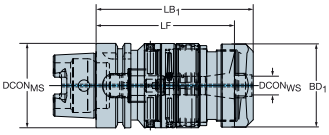
N15

# HSK to CoroChuck™ 970

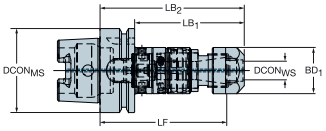
**Machine side interface HSK A/C**

**Workpiece side interface DIN 6499-B**

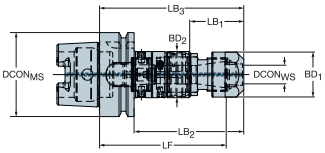
DSGN 1




2




5




| | | | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | TRMAX | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | KG | RPMX |
| 63.0 | 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 | 63.0 | 80 | 1.09 | 8000 |
| | | | | | | | *2.480* | *.819* | *3.744* | *1.390* | *3.035* | *4.059* | *1.327* | *1.378* | *2.480* | *1160* | | |
| | 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 | 63.0 | 80 | 1.44 | 8000 |
| | | | | | | | *2.480* | *1.016* | *4.488* | *1.461* | *3.799* | *4.823* | *1.654* | *1.732* | *2.480* | *1160* | | |
| | ER32 | M20 | 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 |
| | | | | | | | *2.480* | *1.291* | *4.791* | *4.142* | *5.165* | | *1.969* | *2.480* | | *1160* | | |
| | ER40 | M30 | 1 | 1 | 1 | **970-HA06-40-160** | 63.0 | 41.0 | 143.1 | 154.5 | | | 63.0 | | | 80 | 2.91 | 8000 |
| | | | | | | | *2.480* | *1.614* | *5.634* | *6.083* | | | *2.480* | | | *1160* | | |
| 100.0 | 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 | 100.0 | 80 | 2.58 | 8000 |
| | | | | | | | *3.937* | *.819* | *4.000* | *1.390* | *3.169* | *4.315* | *1.327* | *1.378* | *3.937* | *1160* | | |
| | 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 | 100.0 | 80 | 2.92 | 8000 |
| | | | | | | | *3.937* | *1.016* | *4.744* | *1.461* | *3.937* | *5.079* | *1.654* | *1.732* | *3.937* | *1160* | | |
| | ER32 | M20 | 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 |
| | | | | | | | *3.937* | *1.291* | *5.047* | *4.280* | *5.421* | | *1.969* | *3.937* | | *1160* | | |
| | 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 |
| | | | | | | | *3.937* | *1.606* | *5.772* | *5.083* | *6.220* | | *2.480* | *3.937* | | *1160* | | |

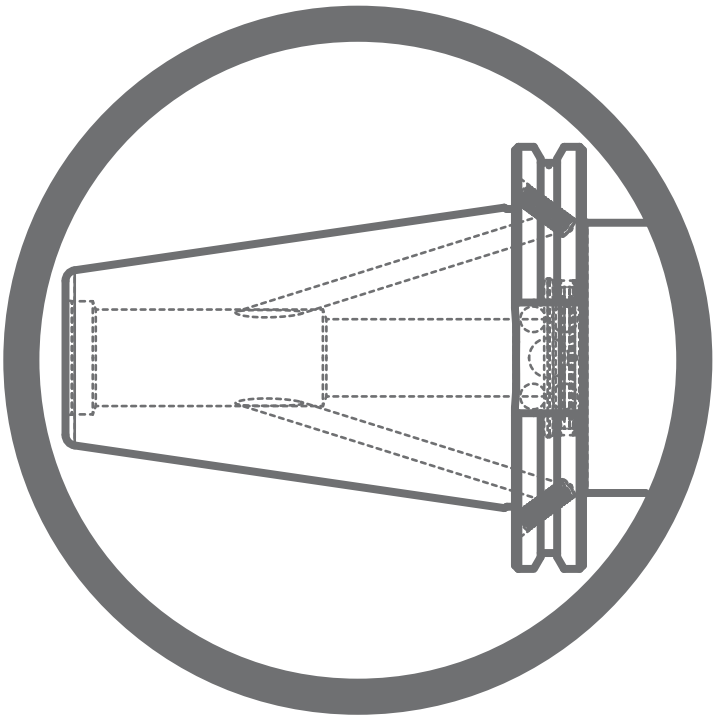
**For MQL machining**

| | | | | | | | Dimensions, mm, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | TRMAX | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | BAR PSI | KG | RPMX |
| 63.0 | 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 |
| | | | | | | | *2.480* | *.819* | *3.744* | *1.587* | *3.232* | *4.256* | *1.327* | *1.362* | *1160* | | |
| | 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 |
| | | | | | | | *2.480* | *1.016* | *4.488* | *1.701* | *3.996* | *5.020* | *1.642* | *1.732* | *1160* | | |
| 100.0 | 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 |
| | | | | | | | *3.937* | *.819* | *4.000* | *1.602* | *3.370* | *4.512* | *1.327* | *1.362* | *1160* | | |
| | 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 |
| | | | | | | | *3.937* | *1.016* | *4.744* | *1.657* | *4.134* | *5.276* | *1.642* | *1.732* | *1160* | | |

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

M1 N22 N15 N5

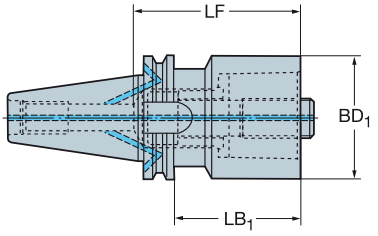
# Machine side interface BIG-PLUS® ISO

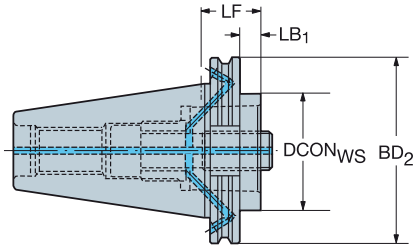


# BIG-PLUS ISO to Coromant Capto® adapter

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

DSGN 1 2

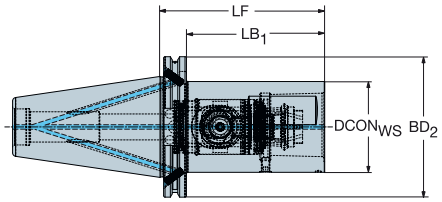



| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | C3 | 7 | 1 | 2 | C3-390B.540-40 030 | 32.0 | M16 | 30.0 | 10.9 | 30.0 | 63.5 | 80 | 45.0 | 0.89 |
| | | | | | | *1.260* | | *1.181* | *.429* | *1.181* | *2.500* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.540-40 040 | 40.0 | M16 | 40.0 | 20.9 | 40.0 | 63.5 | 80 | 55.0 | 0.96 |
| | | | | | | *1.575* | | *1.575* | *.823* | *1.575* | *2.500* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.540-40 050 | 50.0 | M16 | 50.0 | 30.9 | 50.0 | 63.5 | 80 | 95.0 | 1.12 |
| | | | | | | *1.969* | | *1.969* | *1.217* | *1.969* | *2.500* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390B.540-40 085 | 63.0 | M16 | 85.0 | 30.9 | 50.0 | 63.5 | 80 | 170.0 | 1.81 |
| | | | | | | *2.480* | | *3.346* | *1.217* | *1.969* | *2.500* | *1160* | | |
| 50.0 | C3 | 7 | 1 | 2 | C3-390.540-50 030A | 32.0 | M24 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 45.0 | 2.80 |
| | | | | | | *1.260* | | *1.181* | *.429* | *1.181* | *3.839* | *1160* | | |
| | C3 | 7 | 1 | 2 | C3-390.540-50 060 | 32.0 | M24 | 60.0 | 40.9 | 60.0 | 97.5 | 80 | 45.0 | 2.91 |
| | | | | | | *1.260* | | *2.362* | *1.610* | *2.362* | *3.839* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390.540-50 030A | 40.0 | M24 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 55.0 | 2.80 |
| | | | | | | *1.575* | | *1.181* | *.429* | *1.181* | *3.839* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390.540-50 060 | 40.0 | M24 | 60.0 | 40.9 | 60.0 | 97.5 | 80 | 55.0 | 3.01 |
| | | | | | | *1.575* | | *2.362* | *1.610* | *2.362* | *3.839* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390.540-50 030A | 50.0 | M24 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 95.0 | 2.75 |
| | | | | | | *1.969* | | *1.181* | *.429* | *1.181* | *3.839* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390.540-50 070 | 50.0 | M24 | 70.0 | 50.9 | 70.0 | 97.5 | 80 | 95.0 | 3.27 |
| | | | | | | *1.969* | | *2.756* | *2.004* | *2.756* | *3.839* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390.540-50 050A | 63.0 | M24 | 50.0 | 30.9 | 50.0 | 97.5 | 80 | 170.0 | 3.10 |
| | | | | | | *2.480* | | *1.969* | *1.217* | *1.969* | *3.839* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390.540-50 100 | 63.0 | M24 | 100.0 | 80.9 | 100.0 | 97.5 | 80 | 170.0 | 4.22 |
| | | | | | | *2.480* | | *3.937* | *3.185* | *3.937* | *3.839* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-390.540-50 070A | 80.0 | M24 | 70.0 | 50.9 | 70.0 | 97.5 | 80 | 170.0 | 3.90 |
| | | | | | | *3.150* | | *2.756* | *2.004* | *2.756* | *3.839* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-390.540-50 120 | 80.0 | M24 | 120.0 | 100.9 | 120.0 | 97.5 | 80 | 170.0 | 5.74 |
| | | | | | | *3.150* | | *4.724* | *3.972* | *4.724* | *3.839* | *1160* | | |
| | C10 | 7 | 1 | 1 | C10-390.540-50 140 | 100.0 | M24 | 140.0 | 140.0 | | | 80 | 380.0 | 7.72 |
| | | | | | | *3.937* | | *5.512* | *5.512* | | | *1160* | | |

# BIG-PLUS ISO to Coromant Capto® adapter with Quick change

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




**Metric bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | C6 | 7 | 1 | IB50-QC-C6-115 | 63.0 | M24 | 115.0 | 95.0 | 97.4 | 80 | 90.0 | 4.48 |
| | | | | | *2.480* | | *4.528* | *3.740* | *3.835* | *1160* | | |

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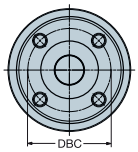
M1 N22 N15

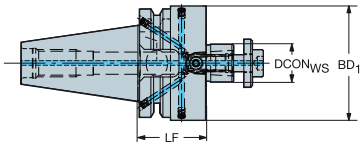
# BIG-PLUS ISO to arbor adapter

**Coolant through arbor**

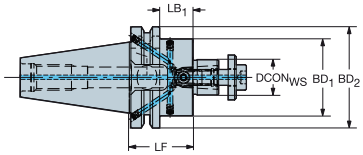
**Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB**

DSGN 1



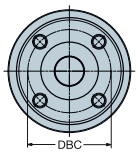



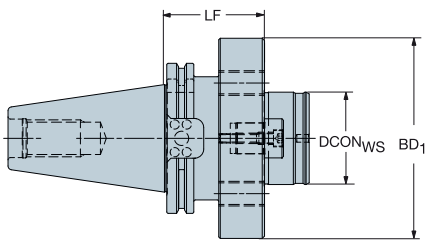

DSGN 2




## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 16 | 7 | 4 | 2 | 392.54005C4016045 | 16.0 | | M16 | 45.0 | 25.9 | 45.0 | 32.0 | 63.5 | 80 | 22.0 | 1.04 | 18000 |
| | | | | | | *.630* | | | *1.772* | *1.020* | *1.772* | *1.260* | *2.500* | *1160* | | | |
| | 22 | 7 | 4 | 2 | 392.54005C4022040 | 22.0 | | M16 | 40.0 | 20.9 | 40.0 | 48.0 | 63.5 | 80 | 45.0 | 1.20 | 18000 |
| | | | | | | *.866* | | | *1.575* | *.823* | *1.575* | *1.890* | *2.500* | *1160* | | | |
| | 27 | 7 | 4 | 2 | 392.54005C4027050 | 27.0 | | M16 | 50.0 | 30.9 | 50.0 | 60.0 | 63.5 | 80 | 80.0 | 1.51 | 18000 |
| | | | | | | *1.063* | | | *1.969* | *1.217* | *1.969* | *2.362* | *2.500* | *1160* | | | |
| | 32 | 7 | 4 | 1 | 392.54005C4032055 | 32.0 | | M16 | 55.0 | 55.0 | | 78.0 | | 80 | 180.0 | 2.03 | 18000 |
| | | | | | | *1.260* | | | *2.165* | *2.165* | | *3.071* | | *1160* | | | |
| | 40S | 7 | 4 | 1 | 392.54005C4040055M | 40.0 | 66.7 | M16 | 55.0 | 55.0 | | 87.0 | | 80 | 300.0 | 2.37 | 18000 |
| | | | | | | *1.575* | *2.626* | | *2.165* | *2.165* | | *3.425* | | *1160* | | | |
| 50.0 | 22 | 7 | 4 | 2 | 392.54005C5022040 | 22.0 | | M24 | 40.0 | 21.0 | 40.0 | 48.0 | 97.5 | 80 | 45.0 | 3.04 | 12000 |
| | | | | | | *.866* | | | *1.575* | *.827* | *1.575* | *1.890* | *3.837* | *1160* | | | |
| | 27 | 7 | 4 | 2 | 392.54005C5027050 | 27.0 | | M24 | 50.0 | 30.9 | 50.0 | 60.0 | 97.5 | 80 | 80.0 | 3.45 | 12000 |
| | | | | | | *1.063* | | | *1.969* | *1.219* | *1.969* | *2.362* | *3.837* | *1160* | | | |
| | 32 | 7 | 4 | 2 | 392.54005C5032055 | 32.0 | | M24 | 55.0 | 35.9 | 55.0 | 78.0 | 97.5 | 80 | 180.0 | 4.11 | 12000 |
| | | | | | | *1.260* | | | *2.165* | *1.415* | *2.165* | *3.071* | *3.837* | *1160* | | | |
| | 40S | 7 | 4 | 2 | 392.54005C5040060 | 40.0 | 66.7 | M24 | 60.0 | 40.9 | 60.0 | 87.0 | 97.0 | 80 | 300.0 | 4.65 | 12000 |
| | | | | | | *1.575* | *2.626* | | *2.362* | *1.612* | *2.362* | *3.425* | *3.819* | *1160* | | | |




## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LF | BD$_1$ | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 60 | 392.54005-5060065 | 60.0 | 101.6 | M24 | 65.0 | 130.0 | 180.0 | 7.70 | 12000 |
| | | | *2.362* | *4.000* | | *2.559* | *5.118* | | | |

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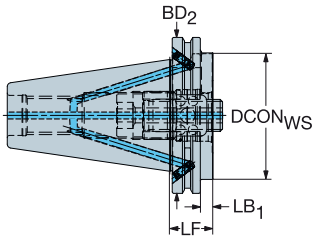
M1 N22 N15

# BIG-PLUS ISO to VL adapter

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

**Workpiece side interface DIN 6499-B**




| | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_2$ | BAR PSI | NM | KG | RPMX |
| 50.0 | 80 | 7 | 1 | **390B.540-50 80 027** | 80.0 | M24 | 27.0 | 7.9 | 97.5 | 80 | 170.0 | 2.87 | 12000 |
| | | | | | *3.150* | | *1.063* | *.313* | *3.837* | *1160* | | | |

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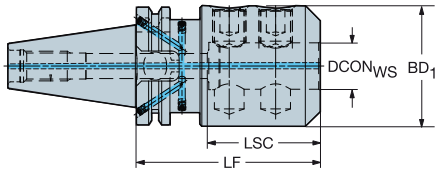
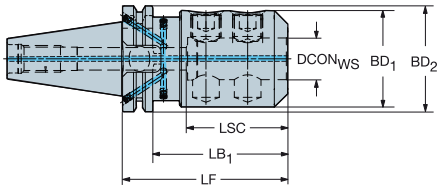
# BIG-PLUS ISO to Weldon / ISO 9766 adapter

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

DSGN 1




2




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 16 | 7 | 1 | 2 | **392.54023-4016060** | 16.0 | M16 | | 60.0 | 40.9 | 60.0 | 48.0 | 63.5 | 20 | 25.0 | 1.32 | 18000 |
| | | | | | | *.630* | | | *2.362* | *1.610* | *2.362* | *1.890* | *2.500* | *290* | | | |
| | 20 | 7 | 1 | 2 | **392.54023-4020070** | 20.0 | M16 | | 70.0 | 50.9 | 70.0 | 52.0 | 63.5 | 20 | 25.0 | 1.52 | 18000 |
| | | | | | | *.787* | | | *2.756* | *2.004* | *2.756* | *2.047* | *2.500* | *290* | | | |
| | 25 | 7 | 1 | 1 | **392.54023-4025100** | 25.0 | M16 | | 100.0 | 100.0 | | 65.0 | | 20 | 25.0 | 2.43 | 18000 |
| | | | | | | *.984* | | | *3.937* | *3.937* | | *2.559* | | *290* | | | |
| | 32 | 7 | 1 | 1 | **392.54023-4032105** | 32.0 | M16 | | 105.0 | 105.0 | | 72.0 | | 20 | 45.0 | 2.80 | 18000 |
| | | | | | | *1.260* | | | *4.134* | *4.134* | | *2.835* | | *290* | | | |
| | 40 | 7 | 1 | 1 | **392.54023-4040115** | 40.0 | M16 | | 115.0 | 115.0 | | 90.0 | | 20 | 45.0 | 4.28 | 18000 |
| | | | | | | *1.575* | | | *4.528* | *4.528* | | *3.543* | | *290* | | | |
| 50.0 | 25 | 7 | 1 | 2 | **392.54023-5025085** | 25.0 | M24 | 60 | 85.0 | 65.9 | 85.0 | 65.0 | 97.5 | 20 | 25.0 | 4.05 | 12000 |
| | | | | | | *.984* | | *2.362* | *3.346* | *2.596* | *3.346* | *2.559* | *3.837* | *290* | | | |
| | 32 | 7 | 1 | 2 | **392.54023-5032090** | 32.0 | M24 | 64 | 90.0 | 69.9 | 90.0 | 72.0 | 97.5 | 20 | 45.0 | 4.42 | 12000 |
| | | | | | | *1.260* | | *2.520* | *3.543* | *2.754* | *3.543* | *2.835* | *3.837* | *290* | | | |
| | 40 | 7 | 1 | 2 | **392.54023-5040115** | 40.0 | M24 | 74 | 115.0 | 95.9 | 115.0 | 90.0 | 97.0 | 20 | 45.0 | 6.35 | 12000 |
| | | | | | | *1.575* | | *2.913* | *4.528* | *3.778* | *4.528* | *3.543* | *3.819* | *290* | | | |

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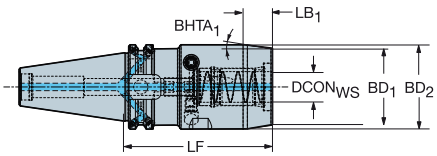
M1 N22 N15

# BIG-PLUS ISO to CoroChuck™ 930

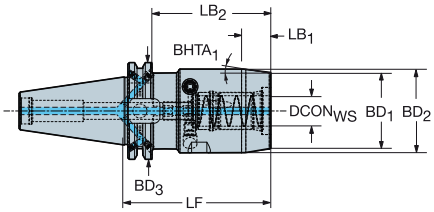
**Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB**

**Heavy-duty design**

DSGN 3




6

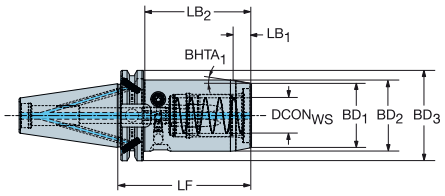



### Metric bore

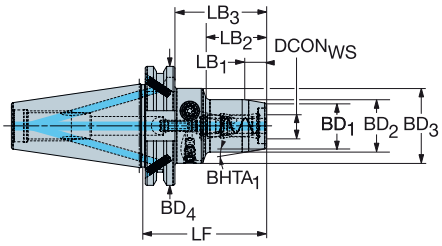
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 20 | 7 | 1 | 6 | 930-IB40-HD-20-097 | 20.0 | M16 | 51 | 97.0 | 17.8 | 77.9 | 97.0 | 50.0 | 55.0 | 63.5 | 8° | 80 | 10.0 | 2.03 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.819* | *.701* | *3.067* | *3.819* | *1.969* | *2.165* | *2.500* | | *1160* | | | |
| | 25 | 7 | 1 | 3 | 930-IB40-HD-25-103 | 25.0 | M16 | 57 | 103.0 | 18.8 | 103.0 | | 57.0 | 65.0 | | 12° | 80 | 10.0 | 2.50 | 18000 |
| | | | | | | *.984* | | *2.244* | *4.055* | *.740* | *4.055* | | *2.244* | *2.559* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 6 | 930-IB50-HD-20-083 | 20.0 | M24 | 51 | 83.0 | 17.8 | 63.9 | 83.0 | 50.0 | 55.0 | 97.4 | 8° | 80 | 10.0 | 3.72 | 12000 |
| | | | | | | *.787* | | *2.008* | *3.268* | *.701* | *2.516* | *3.268* | *1.969* | *2.165* | *3.835* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | 930-IB50-HD-25-087 | 25.0 | M24 | 57 | 87.0 | 18.8 | 67.9 | 87.0 | 57.0 | 65.0 | 97.4 | 12° | 80 | 10.0 | 4.17 | 12000 |
| | | | | | | *.984* | | *2.244* | *3.425* | *.740* | *2.673* | *3.425* | *2.244* | *2.559* | *3.835* | | *1160* | | | |
| | 32 | 7 | 1 | 6 | 930-IB50-HD-32-077 | 32.0 | M24 | 61 | 77.0 | 18.8 | 57.9 | 77.0 | 68.0 | 76.0 | 97.4 | 12° | 80 | 10.0 | 4.27 | 12000 |
| | | | | | | *1.260* | | *2.402* | *3.032* | *.740* | *2.280* | *3.032* | *2.677* | *2.992* | *3.835* | | *1160* | | | |

**Slender design**

DSGN 6




10




### Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BD$_4$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 6 | 7 | 1 | 10 | 930-IB40-S-06-068 | 6.0 | M16 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 22.0 | 26.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.08 | 18000 |
| | | | | | | *.236* | | *1.457* | *2.677* | *.445* | *1.189* | *1.925* | *.866* | *1.024* | *1.575* | *2.500* | | *1160* | | | |
| | 8 | 7 | 1 | 10 | 930-IB40-S-08-068 | 8.0 | M16 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 24.0 | 28.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.10 | 18000 |
| | | | | | | *.315* | | *1.457* | *2.677* | *.445* | *1.189* | *1.925* | *.945* | *1.102* | *1.575* | *2.500* | | *1160* | | | |
| | 10 | 7 | 1 | 10 | 930-IB40-S-10-072 | 10.0 | M16 | 41 | 72.0 | 11.3 | 34.2 | 52.9 | 26.0 | 30.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.13 | 18000 |
| | | | | | | *.394* | | *1.614* | *2.835* | *.445* | *1.346* | *2.083* | *1.024* | *1.181* | *1.575* | *2.500* | | *1160* | | | |
| | 12 | 7 | 1 | 10 | 930-IB40-S-12-080 | 12.0 | M16 | 46 | 80.0 | 11.3 | 38.2 | 60.9 | 28.0 | 32.0 | 50.0 | 63 | 10° | 80 | 8.0 | 1.33 | 18000 |
| | | | | | | *.472* | | *1.811* | *3.150* | *.445* | *1.504* | *2.398* | *1.102* | *1.260* | *1.969* | *2.500* | | *1160* | | | |
| | 20 | 7 | 1 | 10 | 930-IB40-S-20-090 | 20.0 | M16 | 51 | 90.0 | 16.0 | 49.2 | 70.9 | 38.0 | 42.0 | 50.0 | 63 | 7° | 80 | 8.0 | 1.52 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.543* | *.630* | *1.937* | *2.791* | *1.496* | *1.654* | *1.969* | *2.500* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | 930-IB40-S-25-095 | 25.0 | M16 | 57 | 95.0 | 12.9 | 75.0 | 95.0 | 45.0 | 50.0 | 63.5 | | 11° | 80 | 8.0 | 1.74 | 18000 |
| | | | | | | *.984* | | *2.244* | *3.740* | *.508* | *2.953* | *3.740* | *1.772* | *1.969* | *2.500* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 10 | 930-IB50-S-20-089 | 20.0 | M24 | 51 | 89.0 | 16.0 | 49.2 | 69.9 | 38.0 | 42.0 | 50.0 | 97 | 7° | 80 | 8.0 | 3.40 | 12000 |
| | | | | | | *.787* | | *2.008* | *3.504* | *.630* | *1.937* | *2.752* | *1.496* | *1.654* | *1.969* | *3.837* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | 930-IB50-S-25-095 | 25.0 | M24 | 57 | 95.0 | 12.9 | 73.5 | 95.0 | 45.0 | 50.0 | 97.4 | | 11° | 80 | 8.0 | 3.61 | 12000 |
| | | | | | | *.984* | | *2.244* | *3.740* | *.508* | *2.894* | *3.740* | *1.772* | *1.969* | *3.835* | | | *1160* | | | |

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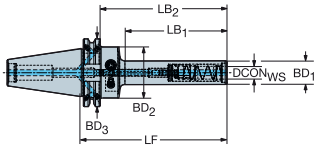
M1 N22 N15 N4

# BIG-PLUS ISO to CoroChuck™ 930

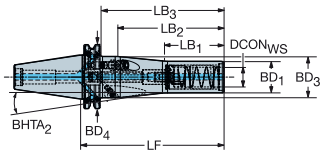
**Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB**

**Pencil design**

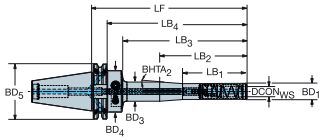
DSGN 5




11



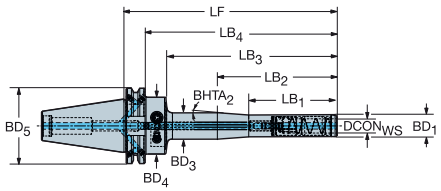

17




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $LB_4$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_2$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 8 | 7 | 1 | 5 | 930-IB40-P-08-088 | 8.0 | M16 | 37 | 88.0 | 45.8 | 66.5 | 88.0 | | 17.5 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.06 | 18000 |
| | | | | | | .315 | | 1.457 | 3.465 | 1.803 | 2.618 | 3.465 | | .689 | 1.575 | 2.500 | | | 1160 | | | |
| | 10 | 7 | 1 | 5 | 930-IB40-P-10-098 | 10.0 | M16 | 41 | 98.0 | 55.8 | 76.5 | 98.0 | | 20.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.10 | 18000 |
| | | | | | | .394 | | 1.614 | 3.858 | 2.197 | 3.012 | 3.858 | | .787 | 1.575 | 2.500 | | | 1160 | | | |
| | 10 | 7 | 1 | 5 | 930-IB40-P-10-138 | 10.0 | M16 | 41 | 138.0 | 95.8 | 116.5 | 138.0 | | 20.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.20 | 18000 |
| | | | | | | .394 | | 1.614 | 5.433 | 3.772 | 4.587 | 5.433 | | .787 | 1.575 | 2.500 | | | 1160 | | | |
| | 12 | 7 | 1 | 5 | 930-IB40-P-12-103 | 12.0 | M16 | 46 | 103.0 | 65.0 | 83.9 | 103.0 | | 22.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.19 | 18000 |
| | | | | | | .472 | | 1.811 | 4.055 | 2.559 | 3.303 | 4.055 | | .866 | 1.575 | 2.500 | | | 1160 | | | |
| | 12 | 7 | 1 | 5 | 930-IB40-P-12-138 | 12.0 | M16 | 46 | 138.0 | 100.0 | 118.9 | 138.0 | | 22.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.29 | 18000 |
| | | | | | | .472 | | 1.811 | 5.433 | 3.937 | 4.681 | 5.433 | | .866 | 1.575 | 2.500 | | | 1160 | | | |
| | 20 | 7 | 1 | 11 | 930-IB40-P-20-145 | 20.0 | M16 | 51 | 145.0 | 60.0 | 108.0 | 125.9 | 145.0 | 32.0 | 32.0 | 42.0 | 63 | 5° | 80 | 8.0 | 1.66 | 18000 |
| | | | | | | .787 | | 2.008 | 5.709 | 2.362 | 4.252 | 4.957 | 5.709 | 1.260 | 1.260 | 1.654 | 2.500 | | 1160 | | | |

DSGN 17




| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $LB_4$ | $BD_1$ | $BD_3$ | $BD_4$ | $BHTA_2$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 12 | 7 | 1 | 17 | 930-IB40-P-12-188 | 12.0 | M16 | 46 | 188.0 | 50.0 | 75.0 | 150.0 | 168.9 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 1.58 | 18000 |
| | | | | | | .472 | | 1.811 | 7.402 | 1.969 | 2.953 | 5.906 | 6.650 | .866 | 1.024 | 1.575 | | 1160 | | | |

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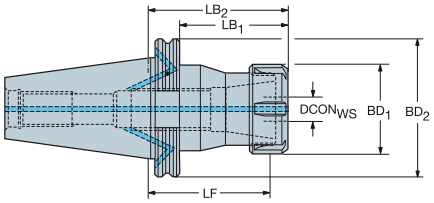
M1 N22 N15 N4

# 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**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | ER25 | 7 | 1 | **392.54014-4025070** | 26.0 | M16 | 58.0 | 30.9 | 70.0 | 42.0 | 63.5 | 80 | 1.17 | 18000 |
| | | | | | *1.024* | | *2.283* | *1.217* | *2.756* | *1.654* | *2.500* | *1160* | | |
| | ER40 | 7 | 1 | **392.54014-4040075** | 41.0 | M16 | 60.0 | 55.9 | 75.0 | 63.0 | 63.5 | 80 | 1.43 | 18000 |
| | | | | | *1.614* | | *2.362* | *2.201* | *2.953* | *2.480* | *2.500* | *1160* | | |

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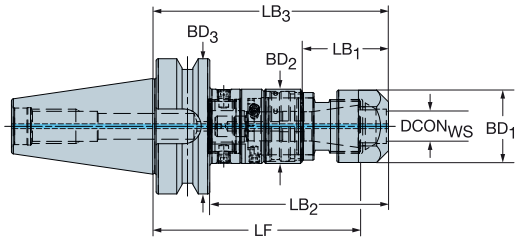
M1 N22 N15

# BIG-PLUS ISO to CoroChuck™ 970




## Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | TRMAX | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | ER20 | M12 | 7 | 1 | **970-IB50-20-106** | 20.8 | M24 | 93.2 | 35.3 | 82.1 | 101.2 | 33.7 | 35.0 | 97.5 | 80 | 3.00 | 8000 |
| | | | | | | *.819* | | *3.669* | *1.390* | *3.232* | *3.984* | *1.327* | *1.378* | *3.839* | *1160* | | |
| | ER25 | M20 | 7 | 1 | **970-IB50-25-126** | 25.8 | M24 | 112.1 | 37.1 | 101.5 | 120.6 | 42.0 | 44.0 | 97.5 | 80 | 3.50 | 8000 |
| | | | | | | *1.016* | | *4.413* | *1.461* | *3.996* | *4.748* | *1.654* | *1.732* | *3.839* | *1160* | | |

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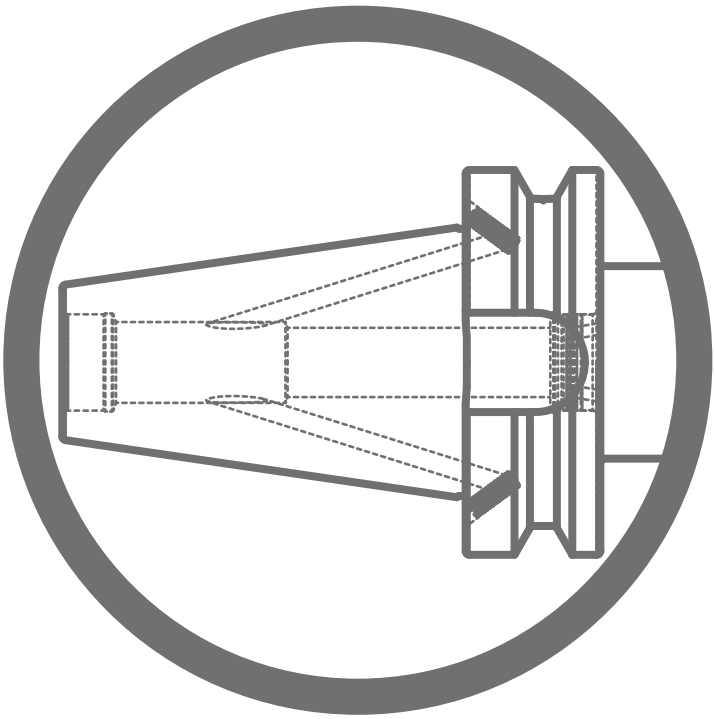
N22 N15 N5

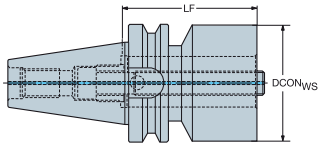
# Machine side interface BIG-PLUS® MAS-BT

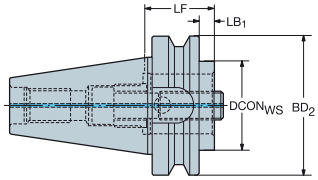


# BIG-PLUS MAS-BT to Coromant Capto® adapter

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

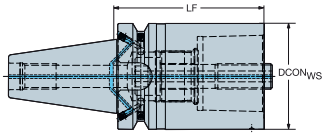
DSGN 1 2

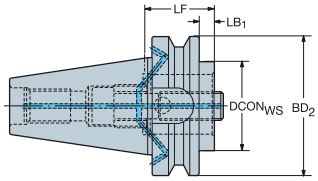



| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | C3 | 1 | 1 | 2 | C3-390.555-30 040 | 32.0 | M12 | 40.0 | 18.0 | 40.0 | 46.0 | 80 | 45.0 | 0.48 |
| | | | | | | *1.260* | | *1.575* | *.709* | *1.575* | *1.811* | *1160* | | |
| | C4 | 1 | 1 | 2 | C4-390.555-30 060 | 40.0 | M12 | 60.0 | 38.0 | 60.0 | 46.0 | 80 | 55.0 | 0.67 |
| | | | | | | *1.575* | | *2.362* | *1.496* | *2.362* | *1.811* | *1160* | | |
| | C5 | 1 | 1 | 1 | C5-390.555-30 080 | 50.0 | M12 | 80.0 | 80.0 | | | 80 | 95.0 | 1.08 |
| | | | | | | *1.969* | | *3.150* | *3.150* | | | *1160* | | |

DSGN 1 2




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | C3 | 7 | 1 | 2 | C3-390B.555-40 030 | 32.0 | M16 | 30.0 | 3.0 | 30.0 | 63.0 | 80 | 45.0 | 1.00 |
| | | | | | | *1.260* | | *1.181* | *.118* | *1.181* | *2.480* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.555-40 040 | 40.0 | M16 | 40.0 | 13.0 | 40.0 | 63.0 | 80 | 55.0 | 1.04 |
| | | | | | | *1.575* | | *1.575* | *.512* | *1.575* | *2.480* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.555-40 070 | 40.0 | M16 | 70.0 | 43.0 | 70.0 | 63.0 | 80 | 55.0 | 1.32 |
| | | | | | | *1.575* | | *2.756* | *1.693* | *2.756* | *2.480* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.555-40 050 | 50.0 | M16 | 50.0 | 23.0 | 50.0 | 63.0 | 80 | 95.0 | 1.16 |
| | | | | | | *1.969* | | *1.969* | *.906* | *1.969* | *2.480* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.555-40 090 | 50.0 | M16 | 90.0 | 63.0 | 90.0 | 63.0 | 80 | 95.0 | 1.73 |
| | | | | | | *1.969* | | *3.543* | *2.480* | *3.543* | *2.480* | *1160* | | |
| | C6 | 7 | 1 | 1 | C6-390B.555-40 075 | 63.0 | M16 | 75.0 | 75.0 | | | 80 | 170.0 | 1.75 |
| | | | | | | *2.480* | | *2.953* | *2.953* | | | *1160* | | |
| 50.0 | C3 | 7 | 1 | 2 | C3-390B.558-50 040 | 32.0 | M24 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 45.0 | 3.72 |
| | | | | | | *1.260* | | *1.575* | *.079* | *1.575* | *3.937* | *1160* | | |
| | C3 | 7 | 1 | 2 | C3-390B.558-50 070 | 32.0 | M24 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 45.0 | 3.82 |
| | | | | | | *1.260* | | *2.756* | *1.260* | *2.756* | *3.937* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.558-50 040 | 40.0 | M24 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 55.0 | 3.72 |
| | | | | | | *1.575* | | *1.575* | *.079* | *1.575* | *3.937* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.558-50 070 | 40.0 | M24 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 55.0 | 3.90 |
| | | | | | | *1.575* | | *2.756* | *1.260* | *2.756* | *3.937* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.558-50 040 | 50.0 | M24 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 95.0 | 3.59 |
| | | | | | | *1.969* | | *1.575* | *.079* | *1.575* | *3.937* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.558-50 080 | 50.0 | M24 | 80.0 | 42.0 | 80.0 | 100.0 | 80 | 95.0 | 4.13 |
| | | | | | | *1.969* | | *3.150* | *1.654* | *3.150* | *3.937* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390B.558-50 050 | 63.0 | M24 | 50.0 | 12.0 | 50.0 | 100.0 | 80 | 170.0 | 3.64 |
| | | | | | | *2.480* | | *1.969* | *.472* | *1.969* | *3.937* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390B.558-50 100 | 63.0 | M24 | 100.0 | 62.0 | 100.0 | 100.0 | 80 | 170.0 | 4.75 |
| | | | | | | *2.480* | | *3.937* | *2.441* | *3.937* | *3.937* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-390B.558-50 070 | 80.0 | M24 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 170.0 | 4.16 |
| | | | | | | *3.150* | | *2.756* | *1.260* | *2.756* | *3.937* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-390B.558-50 120 | 80.0 | M24 | 120.0 | 82.0 | 120.0 | 100.0 | 80 | 170.0 | 6.02 |
| | | | | | | *3.150* | | *4.724* | *3.228* | *4.724* | *3.937* | *1160* | | |
| | C10 | 7 | 1 | 1 | C10-390B.558-50 140 | 100.0 | M24 | 140.0 | 140.0 | | | 80 | 380.0 | 8.01 |
| | | | | | | *3.937* | | *5.512* | *5.512* | | | *1160* | | |

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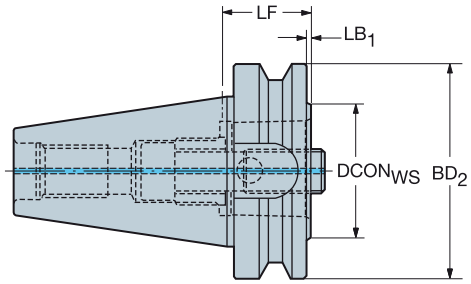
M1 N22 N15

# BIG-PLUS MAS-BT to Coromant Capto® adapter

**90° rotated polygon for precision tool tip control**

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




| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_2$ | BAR PSI | NM | KG |
| 40.0 | C5 | 1 | 1 | **C5-390.562-40 050** | 50.0 | M16 | 50.0 | 23.0 | 63.0 | 80 | 45.0 | 1.16 |
| | | | | | *1.969* | | *1.969* | *.906* | *2.480* | *1160* | | |
| 50.0 | C6 | 1 | 1 | **C6-390.562-50 050** | 63.0 | M24 | 50.0 | 12.0 | 100.0 | 80 | 65.0 | 3.66 |
| | | | | | *2.480* | | *1.969* | *.472* | *3.937* | *1160* | | |
| | C8 | 1 | 1 | **C8-390.562-50 070** | 80.0 | M24 | 70.0 | 32.0 | 100.0 | 80 | 65.0 | 4.18 |
| | | | | | *3.150* | | *2.756* | *1.260* | *3.937* | *1160* | | |

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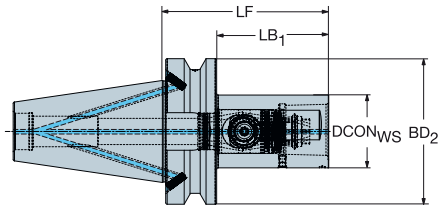
# BIG-PLUS MAS-BT to Coromant Capto® adapter with Quick change

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




**Metric bore**

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_2$ | BAR PSI | NM | KG |
| 50.0 | C6 | 7 | 1 | **BB50-QC-C6-135** | 63.0 | M24 | 135.0 | 96.0 | 135.0 | 80 | 90.0 | 5.52 |
| | | | | | *2.480* | | *5.315* | *3.780* | *5.315* | *1160* | | |

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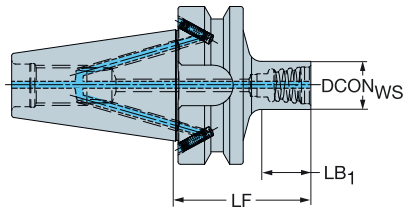
M1 N22 N15

# BIG-PLUS MAS-BT to Coromant EH adapter




| | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | **Ordering code** | DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
| 30.0 | E12 | 1 | 1 | **EH-BB30-12-044** | 11.6 | M12 | 44.0 | 15.4 | 46.0 | 80 | 15.0 | 0.41 | 25000 |
| | | | | | *.457* | | *1.732* | *.606* | *1.811* | *1160* | | | |
| | E16 | 1 | 1 | **EH-BB30-16-050** | 15.4 | M12 | 50.0 | 22.0 | 46.0 | 80 | 30.0 | 0.43 | 25000 |
| | | | | | *.606* | | *1.969* | *.866* | *1.811* | *1160* | | | |
| | E20 | 1 | 1 | **EH-BB30-20-047** | 19.2 | M12 | 47.0 | 19.4 | 46.0 | 80 | 50.0 | 0.43 | 25000 |
| | | | | | *.756* | | *1.850* | *.764* | *1.811* | *1160* | | | |
| | E25 | 1 | 1 | **EH-BB30-25-052** | 24.1 | M12 | 52.0 | 25.1 | 46.0 | 80 | 65.0 | 0.46 | 25000 |
| | | | | | *.949* | | *2.047* | *.988* | *1.811* | *1160* | | | |

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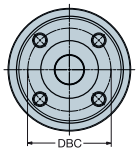
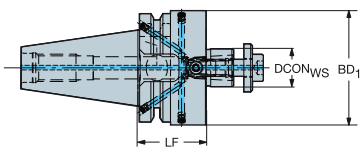
M1 N22 N6 N15 N3

# BIG-PLUS MAS-BT to arbor adapter

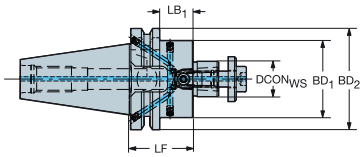
**Machine side interface compatible with MAS-BT 403 and JIS B 6339**

DSGN 1



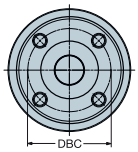

DSGN 2

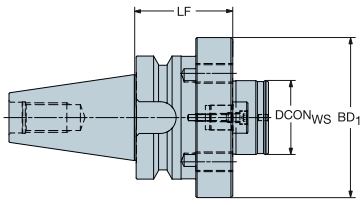



## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | 16 | 1 | 4 | 2 | 392.55505C3016040 | 16.0 | | M12 | 40.0 | 18.0 | 40.0 | 32.0 | 46.0 | 80 | 22.0 | 0.55 | 25000 |
| | | | | | | *.630* | | | *1.575* | *.709* | *1.575* | *1.260* | *1.811* | *1160* | | | |
| | 22 | 1 | 4 | 1 | 392.55505C3022040 | 22.0 | | M12 | 40.0 | 40.0 | | 48.0 | | 80 | 45.0 | 0.73 | 25000 |
| | | | | | | *.866* | | | *1.575* | *1.575* | | *1.890* | | *1160* | | | |
| | 27 | 1 | 4 | 1 | 392.55505C3027040 | 27.0 | | M12 | 40.0 | 40.0 | | 60.0 | | 80 | 80.0 | 0.91 | 25000 |
| | | | | | | *1.063* | | | *1.575* | *1.575* | | *2.362* | | *1160* | | | |
| | 32 | 1 | 4 | 1 | 392.55505C3032045 | 32.0 | | M12 | 45.0 | 45.0 | | 78.0 | | 80 | 180.0 | 1.40 | 25000 |
| | | | | | | *1.260* | | | *1.772* | *1.772* | | *3.071* | | *1160* | | | |
| 40.0 | 16 | 7 | 4 | 2 | 392.55505C4016050 | 16.0 | | M16 | 50.0 | 23.0 | 50.0 | 32.0 | 63.0 | 80 | 22.0 | 1.18 | 18000 |
| | | | | | | *.630* | | | *1.969* | *.906* | *1.969* | *1.260* | *2.480* | *1160* | | | |
| | 22 | 7 | 4 | 2 | 392.55505C4022045 | 22.0 | | M16 | 45.0 | 18.0 | 45.0 | 48.0 | 63.0 | 80 | 45.0 | 1.32 | 18000 |
| | | | | | | *.866* | | | *1.772* | *.709* | *1.772* | *1.890* | *2.480* | *1160* | | | |
| | 27 | 7 | 4 | 2 | 392.55505C4027045 | 27.0 | | M16 | 45.0 | 18.0 | 45.0 | 60.0 | 63.0 | 80 | 80.0 | 1.50 | 18000 |
| | | | | | | *1.063* | | | *1.772* | *.709* | *1.772* | *2.362* | *2.480* | *1160* | | | |
| | 32 | 7 | 4 | 1 | 392.55505C4032050 | 32.0 | | M16 | 50.0 | 50.0 | | 78.0 | | 80 | 180.0 | 2.01 | 18000 |
| | | | | | | *1.260* | | | *1.969* | *1.969* | | *3.071* | | *1160* | | | |
| | 40S | 7 | 4 | 1 | 392.55505C4040055M | 40.0 | 66.7 | M16 | 55.0 | 55.0 | | 87.0 | | 80 | 300.0 | 2.58 | 18000 |
| | | | | | | *1.575* | *2.626* | | *2.165* | *2.165* | | *3.425* | | *1160* | | | |
| 50.0 | 22 | 7 | 4 | 2 | 392.55805C5022055 | 22.0 | | M24 | 55.0 | 17.0 | 55.0 | 48.0 | 100.0 | 80 | 45.0 | 3.96 | 12000 |
| | | | | | | *.866* | | | *2.165* | *.669* | *2.165* | *1.890* | *3.937* | *1160* | | | |
| | 27 | 7 | 4 | 2 | 392.55805C5027055 | 27.0 | | M24 | 55.0 | 17.0 | 55.0 | 60.0 | 100.0 | 80 | 80.0 | 4.14 | 12000 |
| | | | | | | *1.063* | | | *2.165* | *.669* | *2.165* | *2.362* | *3.937* | *1160* | | | |
| | 32 | 7 | 4 | 2 | 392.55805C5032055 | 32.0 | | M24 | 55.0 | 17.0 | 55.0 | 78.0 | 100.0 | 80 | 180.0 | 4.43 | 12000 |
| | | | | | | *1.260* | | | *2.165* | *.669* | *2.165* | *3.071* | *3.937* | *1160* | | | |
| | 40S | 7 | 4 | 2 | 392.55805C5040055 | 40.0 | 66.7 | M24 | 55.0 | 17.0 | 55.0 | 87.0 | 100.0 | 80 | 300.0 | 4.69 | 12000 |
| | | | | | | *1.575* | *2.626* | | *2.165* | *.669* | *2.165* | *3.425* | *3.937* | *1160* | | | |

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




## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LF | BD$_1$ | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 60 | 392.55805-5060080 | 60.0 | 101.6 | M24 | 80.0 | 130.0 | 180.0 | 8.82 | 12000 |
| | | | *2.362* | *4.000* | | *3.150* | *5.118* | | | |

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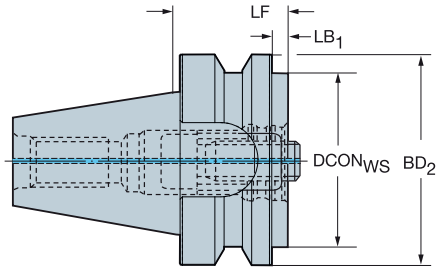
M1 N22 N15

# BIG-PLUS MAS-BT to VL adapter

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

**Coolant through center**



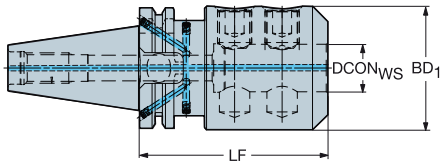

**Metric pilot**

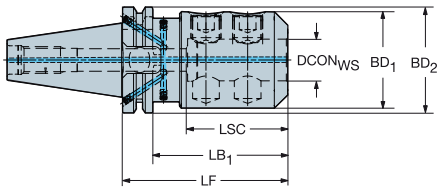
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 80 | 1 | 1 | 390.558-50 80 040 | 80.0 | M24 | 40.0 | 2.0 | 100.0 | 80 | 170.0 | 3.50 |
| | | | | | *3.150* | | *1.575* | *.079* | *3.937* | *1160* | | |

# BIG-PLUS MAS-BT to Weldon / ISO 9766 adapter

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

DSGN 1 2




**Metric bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | 16 | 1 | 1 | 1 | 392.55523-3016060 | 16.0 | M12 | 60.0 | 60.0 | | 48.0 | | 20 | 20.0 | 0.86 | 25000 |
| | | | | | | *.630* | | *2.362* | *2.362* | | *1.890* | | *290* | | | |
| | 20 | 1 | 1 | 1 | 392.55523-3020065 | 20.0 | M12 | 65.0 | 65.0 | | 52.0 | | 20 | 20.0 | 0.97 | 25000 |
| | | | | | | *.787* | | *2.559* | *2.559* | | *2.047* | | *290* | | | |
| | 25 | 1 | 1 | 1 | 392.55523-3025090 | 25.0 | M12 | 90.0 | 90.0 | | 65.0 | | 20 | 65.0 | 1.80 | 25000 |
| | | | | | | *.984* | | *3.543* | *3.543* | | *2.559* | | *290* | | | |
| | 32 | 1 | 1 | 1 | 392.55523-3032095 | 32.0 | M12 | 95.0 | 95.0 | | 72.0 | | 20 | 45.0 | 2.16 | 25000 |
| | | | | | | *1.260* | | *3.740* | *3.740* | | *2.835* | | *290* | | | |
| 40.0 | 16 | 7 | 1 | 2 | 392.55523-4016065 | 16.0 | M16 | 65.0 | 38.0 | 65.0 | 48.0 | 63.0 | 20 | 20.0 | 1.43 | 18000 |
| | | | | | | *.630* | | *2.559* | *1.496* | *2.559* | *1.890* | *2.480* | *290* | | | |
| | 20 | 7 | 1 | 2 | 392.55523-4020065 | 20.0 | M16 | 65.0 | 38.0 | 65.0 | 52.0 | 63.0 | 20 | 20.0 | 1.49 | 18000 |
| | | | | | | *.787* | | *2.559* | *1.496* | *2.559* | *2.047* | *2.480* | *290* | | | |
| | 25 | 7 | 1 | 1 | 392.55523-4025090 | 25.0 | M16 | 90.0 | 90.0 | | 65.0 | | 20 | 25.0 | 2.30 | 18000 |
| | | | | | | *.984* | | *3.543* | *3.543* | | *2.559* | | *290* | | | |
| | 32 | 7 | 1 | 1 | 392.55523-4032100 | 32.0 | M16 | 100.0 | 100.0 | | 72.0 | | 20 | 45.0 | 2.80 | 18000 |
| | | | | | | *1.260* | | *3.937* | *3.937* | | *2.835* | | *290* | | | |
| | 40 | 7 | 1 | 1 | 392.55523-4040110 | 40.0 | M16 | 110.0 | 110.0 | | 90.0 | | 20 | 45.0 | 4.28 | 18000 |
| | | | | | | *1.575* | | *4.331* | *4.331* | | *3.543* | | *290* | | | |
| 50.0 | 25 | 7 | 1 | 2 | 392.55823-5025100 | 25.0 | M24 | 100.0 | 62.0 | 100.0 | 65.0 | 100.0 | 20 | 25.0 | 4.94 | 12000 |
| | | | | | | *.984* | | *3.937* | *2.441* | *3.937* | *2.559* | *3.937* | *290* | | | |
| | 32 | 7 | 1 | 2 | 392.55823-5032105 | 32.0 | M24 | 105.0 | 67.0 | 105.0 | 72.0 | 100.0 | 20 | 45.0 | 5.26 | 12000 |
| | | | | | | *1.260* | | *4.134* | *2.638* | *4.134* | *2.835* | *3.937* | *290* | | | |
| | 40 | 7 | 1 | 2 | 392.55823-5040115 | 40.0 | M24 | 115.0 | 77.0 | 115.0 | 90.0 | 100.0 | 20 | 45.0 | 6.60 | 12000 |
| | | | | | | *1.575* | | *4.528* | *3.032* | *4.528* | *3.543* | *3.937* | *290* | | | |
| | 50 | 7 | 1 | 1 | 392.55823-5050130 | 50.0 | M24 | 130.0 | 100.0 | | 100.0 | | 20 | 60.0 | 7.81 | 12000 |
| | | | | | | *1.969* | | *5.118* | *3.937* | | *3.937* | | *290* | | | |

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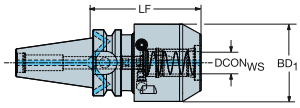
M1 N22 N15

# BIG-PLUS MAS-BT to CoroChuck™ 930

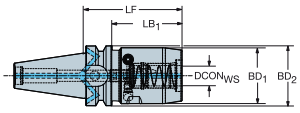
**Machine side interface compatible with MAS-BT 403 and JIS B 6339**

**Metric bore**

DSGN 3



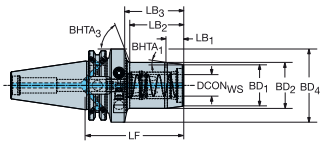

6



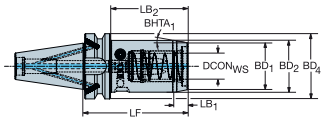

## Heavy-duty design

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 20 | 7 | 1 | 6 | **930-BB40-HD-20-088** | 20.0 | M16 | 51 | 88.0 | 17.8 | 61.0 | 88.0 | 50.0 | 55.0 | 63.0 | 8° | 80 | 10.0 | 1.95 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.465* | *.701* | *2.402* | *3.465* | *1.969* | *2.165* | *2.480* | | *1160* | | | |
| | 25 | 7 | 1 | 3 | **930-BB40-HD-25-094** | 25.0 | M16 | 57 | 94.0 | 18.8 | 94.0 | | 57.0 | 65.0 | | 12° | 80 | 10.0 | 2.40 | 18000 |
| | | | | | | *.984* | | *2.244* | *3.701* | *.740* | *3.701* | | *2.244* | *2.559* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 6 | **930-BB50-HD-20-102** | 20.0 | M24 | 51 | 102.0 | 17.8 | 64.0 | 102.0 | 50.0 | 55.0 | 100.0 | 8° | 80 | 10.0 | 4.75 | 12000 |
| | | | | | | *.787* | | *2.008* | *4.016* | *.701* | *2.520* | *4.016* | *1.969* | *2.165* | *3.937* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | **930-BB50-HD-25-106** | 25.0 | M24 | 57 | 106.0 | 18.8 | 68.0 | 106.0 | 57.0 | 65.0 | 100.0 | 12° | 80 | 10.0 | 5.16 | 12000 |
| | | | | | | *.984* | | *2.244* | *4.173* | *.740* | *2.677* | *4.173* | *2.244* | *2.559* | *3.937* | | *1160* | | | |
| | 32 | 7 | 1 | 6 | **930-BB50-HD-32-096** | 32.0 | M24 | 61 | 96.0 | 18.8 | 58.0 | 96.0 | 68.0 | 76.0 | 100.0 | 12° | 80 | 10.0 | 5.25 | 12000 |
| | | | | | | *1.260* | | *2.402* | *3.780* | *.740* | *2.283* | *3.780* | *2.677* | *2.992* | *3.937* | | *1160* | | | |

DSGN 10




6




## Slender design

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $LB_4$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 30.0 | 6 | 1 | 1 | 6 | **930-BB30-S-06-048** | 6.0 | M12 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 22.0 | 26.0 | 46.0 | | 12° | 80 | 8.0 | 0.56 | 25000 |
| | | | | | | *.236* | | *1.457* | *1.890* | *.366* | *.504* | *1.890* | | *.866* | *1.024* | *1.811* | | | *1160* | | | |
| | 8 | 1 | 1 | 6 | **930-BB30-S-08-048** | 8.0 | M12 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 24.0 | 28.0 | 46.0 | | 12° | 80 | 8.0 | 0.57 | 25000 |
| | | | | | | *.315* | | *1.457* | *1.890* | *.366* | *.504* | *1.890* | | *.945* | *1.102* | *1.811* | | | *1160* | | | |
| | 10 | 1 | 1 | 6 | **930-BB30-S-10-048** | 10.0 | M12 | 41 | 48.0 | 9.3 | 13.8 | 48.0 | | 26.0 | 30.0 | 46.0 | | 12° | 80 | 8.0 | 0.56 | 25000 |
| | | | | | | *.394* | | *1.614* | *1.890* | *.366* | *.543* | *1.890* | | *1.024* | *1.181* | *1.811* | | | *1160* | | | |
| | 12 | 1 | 1 | 6 | **930-BB30-S-12-082** | 12.0 | M12 | 46 | 82.0 | 11.3 | 38.2 | 60.0 | 82.0 | 28.0 | 32.0 | 40.0 | 46 | 10° | 80 | 8.0 | 0.76 | 25000 |
| | | | | | | *.472* | | *1.811* | *3.228* | *.445* | *1.504* | *2.362* | *3.228* | *1.102* | *1.260* | *1.575* | *1.811* | | *1160* | | | |
| | 20 | 1 | 1 | 6 | **930-BB30-S-20-088** | 20.0 | M12 | 51 | 88.0 | 16.0 | 66.0 | 88.0 | | 38.0 | 42.0 | 46.0 | | 7° | 80 | 8.0 | 0.94 | 25000 |
| | | | | | | *.787* | | *2.008* | *3.465* | *.630* | *2.598* | *3.465* | | *1.496* | *1.654* | *1.811* | | | *1160* | | | |
| 40.0 | 6 | 7 | 1 | 10 | **930-BB40-S-06-075** | 6.0 | M16 | 37 | 75.0 | 11.3 | 30.2 | 48.0 | 75.0 | 22.0 | 26.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.23 | 18000 |
| | | | | | | *.236* | | *1.457* | *2.953* | *.445* | *1.189* | *1.890* | *2.953* | *.866* | *1.024* | *1.575* | *2.480* | | *1160* | | | |
| | 8 | 7 | 1 | 10 | **930-BB40-S-08-075** | 8.0 | M16 | 37 | 75.0 | 11.3 | 30.2 | 48.0 | 75.0 | 24.0 | 28.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.25 | 18000 |
| | | | | | | *.315* | | *1.457* | *2.953* | *.445* | *1.189* | *1.890* | *2.953* | *.945* | *1.102* | *1.575* | *2.480* | | *1160* | | | |
| | 10 | 7 | 1 | 10 | **930-BB40-S-10-080** | 10.0 | M16 | 41 | 80.0 | 11.3 | 34.2 | 53.0 | 80.0 | 26.0 | 30.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.29 | 18000 |
| | | | | | | *.394* | | *1.614* | *3.150* | *.445* | *1.346* | *2.087* | *3.150* | *1.024* | *1.181* | *1.575* | *2.480* | | *1160* | | | |
| | 12 | 7 | 1 | 10 | **930-BB40-S-12-085** | 12.0 | M16 | 46 | 85.0 | 11.3 | 40.0 | 58.0 | 85.0 | 26.0 | 32.0 | 50.0 | 63 | 10° | 80 | 8.0 | 1.40 | 18000 |
| | | | | | | *.472* | | *1.811* | *3.346* | *.445* | *1.575* | *2.283* | *3.346* | *1.024* | *1.260* | *1.969* | *2.480* | | *1160* | | | |
| | 20 | 7 | 1 | 10 | **930-BB40-S-20-094** | 20.0 | M16 | 51 | 94.0 | 16.0 | 49.2 | 67.0 | 94.0 | 37.9 | 42.0 | 50.0 | 63 | 7° | 80 | 8.0 | 1.62 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.701* | *.630* | *1.937* | *2.638* | *3.701* | *1.492* | *1.654* | *1.969* | *2.480* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | **930-BB40-S-25-102** | 25.0 | M16 | 57 | 102.0 | 12.9 | 74.0 | 102.0 | | 45.0 | 50.0 | 63.0 | | 11° | 80 | 10.0 | 1.87 | 18000 |
| | | | | | | *.984* | | *2.244* | *4.016* | *.508* | *2.913* | *4.016* | | *1.772* | *1.969* | *2.480* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 10 | **930-BB50-S-20-108** | 20.0 | M24 | 51 | 108.0 | 16.0 | 49.2 | 70.0 | 108.0 | 37.9 | 42.0 | 50.0 | 100 | 7° | 80 | 8.0 | 4.41 | 12000 |
| | | | | | | *.787* | | *2.008* | *4.252* | *.630* | *1.937* | *2.756* | *4.252* | *1.492* | *1.654* | *1.969* | *3.937* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | **930-BB50-S-25-114** | 25.0 | M24 | 57 | 114.0 | 12.9 | 73.5 | 114.0 | | 45.0 | 50.0 | 100.0 | | 11° | 80 | 10.0 | 4.62 | 12000 |
| | | | | | | *.984* | | *2.244* | *4.488* | *.508* | *2.894* | *4.488* | | *1.772* | *1.969* | *3.937* | | | *1160* | | | |

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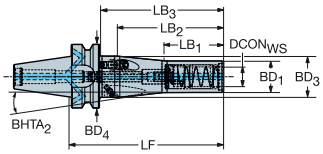
M1 N22 N6 N15 N4

# BIG-PLUS MAS-BT to CoroChuck™ 930

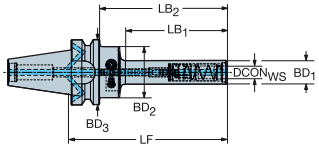
**Machine side interface compatible with MAS-BT 403 and JIS B 6339**

**Metric bore**

DSGN 11



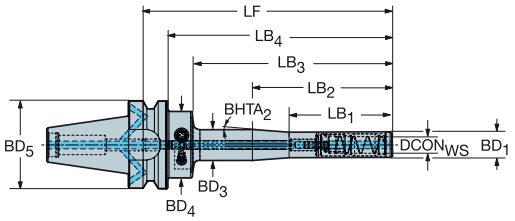

DSGN 5




**Pencil design**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | LB$_4$ | BD$_1$ | BD$_2$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | 6 | 1 | 1 | 5 | 930-BB30-P-06-088 | 6.0 | M12 | 37 | 88.0 | 50.0 | 66.0 | 88.0 | | 14.5 | 40.0 | 46.0 | | 0° | 80 | 8.0 | 0.62 | 25000 |
| | | | | | | *.236* | | *1.457* | *3.465* | *1.969* | *2.598* | *3.465* | | *.571* | *1.575* | *1.811* | | | *1160* | | | |
| | 8 | 1 | 1 | 5 | 930-BB30-P-08-088 | 8.0 | M12 | 37 | 88.0 | 45.8 | 66.0 | 88.0 | | 17.5 | 40.0 | 46.0 | | 0° | 80 | 8.0 | 0.60 | 25000 |
| | | | | | | *.315* | | *1.457* | *3.465* | *1.803* | *2.598* | *3.465* | | *.689* | *1.575* | *1.811* | | | *1160* | | | |
| | 10 | 1 | 1 | 5 | 930-BB30-P-10-098 | 10.0 | M12 | 41 | 98.0 | 55.8 | 76.0 | 98.0 | | 20.0 | 40.0 | 46.0 | | 0° | 80 | 8.0 | 0.64 | 25000 |
| | | | | | | *.394* | | *1.614* | *3.858* | *2.197* | *2.992* | *3.858* | | *.787* | *1.575* | *1.811* | | | *1160* | | | |
| | 10 | 1 | 1 | 5 | 930-BB30-P-10-138 | 10.0 | M12 | 41 | 138.0 | 95.8 | 116.0 | 138.0 | | 20.0 | 40.0 | 46.0 | | 0° | 80 | 8.0 | 0.74 | 25000 |
| | | | | | | *.394* | | *1.614* | *5.433* | *3.772* | *4.567* | *5.433* | | *.787* | *1.575* | *1.811* | | | *1160* | | | |
| | 12 | 1 | 1 | 5 | 930-BB30-P-12-103 | 12.0 | M12 | 46 | 103.0 | 65.0 | 81.0 | 103.0 | | 22.0 | 40.0 | 46.0 | | 0° | 80 | 8.0 | 0.71 | 25000 |
| | | | | | | *.472* | | *1.811* | *4.055* | *2.559* | *3.189* | *4.055* | | *.866* | *1.575* | *1.811* | | | *1160* | | | |
| | 12 | 1 | 1 | 5 | 930-BB30-P-12-138 | 12.0 | M12 | 46 | 138.0 | 100.0 | 116.0 | 138.0 | | 22.0 | 40.0 | 46.0 | | 0° | 80 | 8.0 | 0.80 | 25000 |
| | | | | | | *.472* | | *1.811* | *5.433* | *3.937* | *4.567* | *5.433* | | *.866* | *1.575* | *1.811* | | | *1160* | | | |
| 40.0 | 8 | 7 | 1 | 5 | 930-BB40-P-08-095 | 8.0 | M16 | 37 | 95.0 | 45.8 | 65.5 | 95.0 | | 17.5 | 40.0 | 63.0 | | 0° | 80 | 8.0 | 1.21 | 18000 |
| | | | | | | *.315* | | *1.457* | *3.740* | *1.803* | *2.579* | *3.740* | | *.689* | *1.575* | *2.480* | | | *1160* | | | |
| | 10 | 7 | 1 | 5 | 930-BB40-P-10-105 | 10.0 | M16 | 41 | 105.0 | 55.8 | 75.5 | 105.0 | | 20.0 | 40.0 | 63.0 | | 0° | 80 | 8.0 | 1.25 | 18000 |
| | | | | | | *.394* | | *1.614* | *4.134* | *2.197* | *2.972* | *4.134* | | *.787* | *1.575* | *2.480* | | | *1160* | | | |
| | 10 | 7 | 1 | 5 | 930-BB40-P-10-145 | 10.0 | M16 | 41 | 145.0 | 95.8 | 115.5 | 145.0 | | 20.0 | 40.0 | 63.0 | | 0° | 80 | 8.0 | 1.35 | 18000 |
| | | | | | | *.394* | | *1.614* | *5.709* | *3.772* | *4.547* | *5.709* | | *.787* | *1.575* | *2.480* | | | *1160* | | | |
| | 12 | 7 | 1 | 5 | 930-BB40-P-12-110 | 12.0 | M16 | 46 | 110.0 | 65.0 | 83.0 | 110.0 | | 22.0 | 40.0 | 63.0 | | 0° | 80 | 8.0 | 1.33 | 18000 |
| | | | | | | *.472* | | *1.811* | *4.331* | *2.559* | *3.268* | *4.331* | | *.866* | *1.575* | *2.480* | | | *1160* | | | |
| | 12 | 7 | 1 | 5 | 930-BB40-P-12-145 | 12.0 | M16 | 46 | 145.0 | 100.0 | 118.0 | 145.0 | | 22.0 | 40.0 | 63.0 | | 0° | 80 | 8.0 | 1.47 | 18000 |
| | | | | | | *.472* | | *1.811* | *5.709* | *3.937* | *4.646* | *5.709* | | *.866* | *1.575* | *2.480* | | | *1160* | | | |
| | 20 | 7 | 1 | 11 | 930-BB40-P-20-153 | 20.0 | M16 | 51 | 153.0 | 60.0 | 108.0 | 126.0 | 153.0 | 32.0 | 32.0 | 42.0 | 63 | 5° | 80 | 8.0 | 1.85 | 18000 |
| | | | | | | *.787* | | *2.008* | *6.024* | *2.362* | *4.252* | *4.961* | *6.024* | *1.260* | *1.260* | *1.654* | *2.480* | | *1160* | | | |

DSGN 17




**Pencil design**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | LB$_4$ | BD$_1$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | 12 | 1 | 1 | 17 | 930-BB30-P-12-188 | 12.0 | M12 | 46 | 188.0 | 50.0 | 75.0 | 150.0 | 166.0 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 1.08 | 25000 |
| | | | | | | .472 | | 1.811 | 7.402 | 1.969 | 2.953 | 5.906 | 6.535 | .866 | 1.024 | 1.575 | | 1160 | | | |
| 40.0 | 12 | 7 | 1 | 17 | 930-BB40-P-12-195 | 12.0 | M16 | 46 | 195.0 | 50.0 | 75.0 | 150.0 | 168.0 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 1.68 | 18000 |
| | | | | | | .472 | | 1.811 | 7.677 | 1.969 | 2.953 | 5.906 | 6.614 | .866 | 1.024 | 1.575 | | 1160 | | | |

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M1 N22 N6 N15 N4



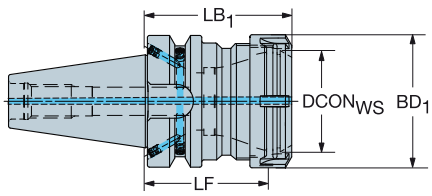
SANDVIK Coromant

# BIG-PLUS MAS-BT to ER collet chuck

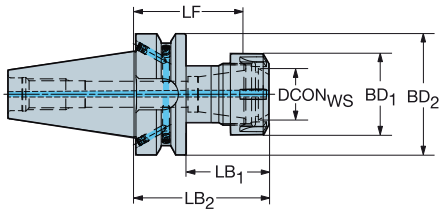
**Machine side interface compatible with MAS-BT 403 and JIS B 6339**

**Workpiece side interface DIN 6499-B**

DSGN 1




2




| | | | | | | Dimensions, mm, inch | | | | | | | BAR PSI | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | | | RPMX |
| 30.0 | ER11 | 1 | 1 | 2 | **392.55514-3011050** | 11.4 | M12 | 43.4 | 28.0 | 50.0 | 18.7 | 46.0 | 80 | 0.45 | 25000 |
| | | | | | | *.449* | | *1.709* | *1.102* | *1.969* | *.736* | *1.811* | *1160* | | |
| | ER16 | 1 | 1 | 2 | **392.55514-3016050** | 17.0 | M12 | 39.4 | 28.0 | 50.0 | 28.0 | 46.0 | 80 | 0.47 | 25000 |
| | | | | | | *.669* | | *1.551* | *1.102* | *1.969* | *1.102* | *1.811* | *1160* | | |
| | ER20 | 1 | 1 | 2 | **392.55514-3020052** | 21.0 | M12 | 40.5 | 30.0 | 52.0 | 33.7 | 46.0 | 80 | 0.49 | 25000 |
| | | | | | | *.827* | | *1.594* | *1.181* | *2.047* | *1.327* | *1.811* | *1160* | | |
| | ER25 | 1 | 1 | 2 | **392.55514-3025060** | 26.0 | M12 | 48.0 | 38.0 | 60.0 | 42.0 | 46.0 | 80 | 0.60 | 25000 |
| | | | | | | *1.024* | | *1.890* | *1.496* | *2.362* | *1.654* | *1.811* | *1160* | | |
| | ER32 | 1 | 1 | 1 | **392.55514-3032060** | 33.0 | M12 | 47.0 | 60.0 | | 50.0 | | 80 | 0.64 | 25000 |
| | | | | | | *1.299* | | *1.850* | *2.362* | | *1.969* | | *1160* | | |
| 40.0 | ER25 | 7 | 1 | 2 | **392.55514-4025070** | 26.0 | M16 | 58.0 | 43.0 | 70.0 | 42.0 | 63.0 | 80 | 1.24 | 18000 |
| | | | | | | *1.024* | | *2.283* | *1.693* | *2.756* | *1.654* | *2.480* | *1160* | | |
| | ER40 | 7 | 1 | 1 | **392.55514-4040070** | 41.0 | M16 | 55.0 | 70.0 | | 63.0 | | 80 | 1.39 | 18000 |
| | | | | | | *1.614* | | *2.165* | *2.756* | | *2.480* | | *1160* | | |

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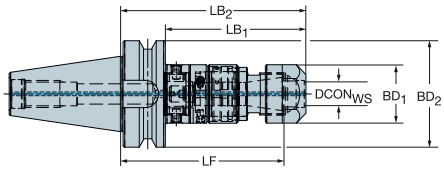
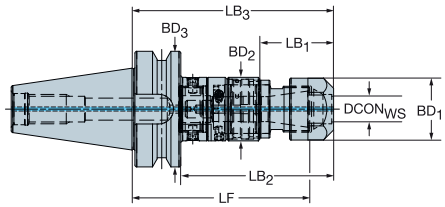
M1 N22 N15

# BIG-PLUS MAS-BT to CoroChuck™ 970

DSGN 2




5




## Metric bore

| | | | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | TRMAX | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | KG | RPMX |
| 30.0 | ER11 | M5 | 1 | 1 | 5 | **970-BB30-11-082** | 11.3 | M12 | 78.2 | 24.1 | 60.0 | 82.0 | 18.7 | 23.5 | 46.0 | 80 | 0.52 | 8000 |
| | | | | | | | *.445* | | *3.079* | *.949* | *2.362* | *3.228* | *.736* | *.925* | *1.811* | *1160* | | |
| | ER20 | M12 | 1 | 1 | 5 | **970-BB30-20-105** | 20.8 | M12 | 92.2 | 40.3 | 83.1 | 105.2 | 33.7 | 35.0 | 46.0 | 80 | 0.84 | 8000 |
| | | | | | | | *.819* | | *3.630* | *1.587* | *3.272* | *4.142* | *1.327* | *1.378* | *1.811* | *1160* | | |
| | ER25 | M20 | 1 | 1 | 5 | **970-BB30-25-125** | 25.8 | M12 | 111.1 | 42.1 | 102.6 | 124.6 | 42.0 | 44.0 | 46.0 | 80 | 1.20 | 8000 |
| | | | | | | | *1.016* | | *4.374* | *1.657* | *4.039* | *4.906* | *1.654* | *1.732* | *1.811* | *1160* | | |
| 40.0 | ER20 | M12 | 7 | 1 | 5 | **970-BB40-20-110** | 20.8 | M16 | 97.2 | 40.3 | 83.1 | 110.2 | 33.7 | 35.0 | 63.0 | 80 | 1.43 | 8000 |
| | | | | | | | *.819* | | *3.827* | *1.587* | *3.272* | *4.339* | *1.327* | *1.378* | *2.480* | *1160* | | |
| | ER25 | M20 | 7 | 1 | 5 | **970-BB40-25-130** | 25.8 | M16 | 116.1 | 42.1 | 102.6 | 129.6 | 42.0 | 44.0 | 63.0 | 80 | 1.79 | 8000 |
| | | | | | | | *1.016* | | *4.571* | *1.657* | *4.039* | *5.102* | *1.654* | *1.732* | *2.480* | *1160* | | |
| 50.0 | ER20 | M12 | 7 | 1 | 5 | **970-BB50-20-125** | 20.8 | M24 | 112.2 | 40.3 | 87.1 | 125.2 | 33.7 | 35.0 | 100.0 | 80 | 4.11 | 8000 |
| | | | | | | | *.819* | | *4.417* | *1.587* | *3.429* | *4.929* | *1.327* | *1.378* | *3.937* | *1160* | | |
| | ER25 | M20 | 7 | 1 | 5 | **970-BB50-25-145** | 25.8 | M24 | 131.1 | 42.1 | 106.6 | 144.6 | 42.0 | 44.0 | 100.0 | 80 | 4.50 | 8000 |
| | | | | | | | *1.016* | | *5.161* | *1.657* | *4.197* | *5.693* | *1.654* | *1.732* | *3.937* | *1160* | | |
| | ER40 | M30 | 7 | 1 | 2 | **970-BB50-40-174** | 40.8 | M24 | 157.2 | 136.0 | 174.0 | | 63.0 | 100.0 | | 80 | 5.66 | 8000 |
| | | | | | | | *1.606* | | *6.189* | *5.354* | *6.850* | | *2.480* | *3.937* | | *1160* | | |

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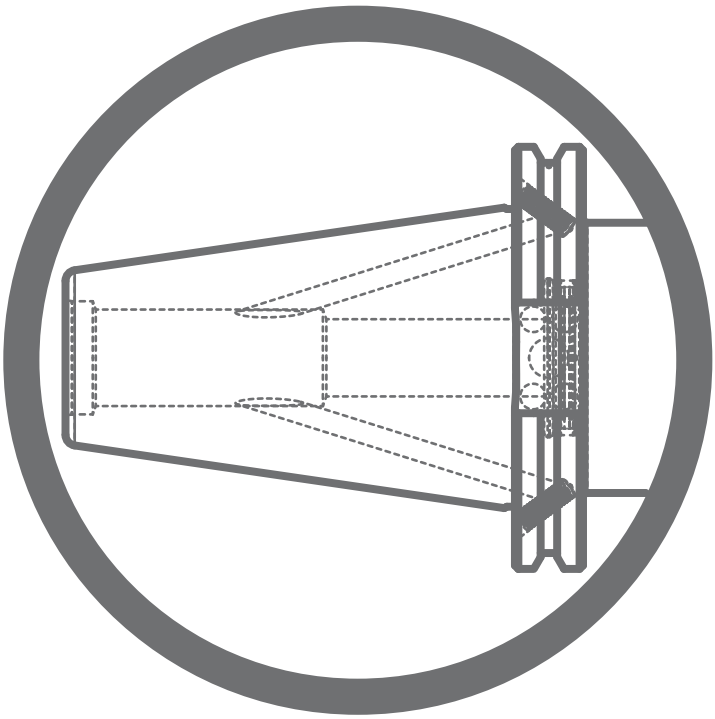
M1 N22 N15 N5

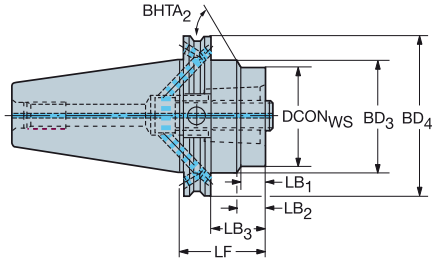
# Machine-side interface BIG-PLUS® CAT-V

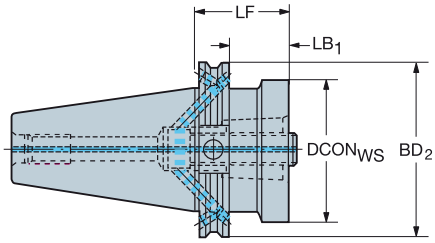


# BIG-PLUS CAT-V to Coromant Capto® adapter

## Machine side interface ASME B5.50-1985

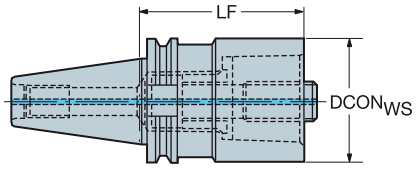
DSGN 11 2




## Machine side interface ASME B5.50-1985

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_2$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | C3 | 7 | 1 | 11 | C3-A390.545-40 040A | 32.0 | 5/8"-11 | 40.0 | 2.7 | 5.0 | 21.0 | 32.0 | 44.5 | 63 | 70° | 80 | 45.0 | 1.04 |
| | | | | | | *1.260* | | *1.575* | *.106* | *.197* | *.827* | *1.260* | *1.752* | *2.500* | | *1160* | | |
| | C4 | 7 | 1 | 11 | C4-A390.545-40 040A | 40.0 | 5/8"-11 | 40.0 | 3.6 | 5.0 | 20.9 | 40.0 | 44.7 | 63 | 60° | 80 | 55.0 | 1.02 |
| | | | | | | *1.575* | | *1.575* | *.142* | *.197* | *.823* | *1.575* | *1.760* | *2.500* | | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-A390.545-40 050A | 50.0 | 5/8"-11 | 50.0 | 30.9 | 50.0 | | 63.5 | | | 0° | 80 | 95.0 | 1.08 |
| | | | | | | *1.969* | | *1.969* | *1.217* | *1.969* | | *2.500* | | | | *1160* | | |
| 50.0 | C3 | 7 | 1 | 11 | C3-A390.545-50 040A | 32.0 | 1"-8 | 40.0 | 1.7 | 5.0 | 21.0 | 32.0 | 69.9 | 98 | 80° | 80 | 45.0 | 3.22 |
| | | | | | | *1.260* | | *1.575* | *.067* | *.197* | *.827* | *1.260* | *2.752* | *3.874* | | *1160* | | |
| | C3 | 7 | 1 | 11 | C3-A390.545-50 070 | 32.0 | 1"-8 | 70.0 | 30.0 | 35.0 | 51.0 | 32.0 | 69.9 | 98 | 75° | 80 | 45.0 | 3.34 |
| | | | | | | *1.260* | | *2.756* | *1.181* | *1.378* | *2.008* | *1.260* | *2.752* | *3.874* | | *1160* | | |
| | C4 | 7 | 1 | 11 | C4-A390.545-50 040A | 40.0 | 1"-8 | 40.0 | 2.4 | 5.0 | 20.9 | 40.0 | 70.1 | 98 | 80° | 80 | 55.0 | 3.20 |
| | | | | | | *1.575* | | *1.575* | *.094* | *.197* | *.823* | *1.575* | *2.760* | *3.874* | | *1160* | | |
| | C4 | 7 | 1 | 11 | C4-A390.545-50 070 | 40.0 | 1"-8 | 70.0 | 31.0 | 35.0 | 50.9 | 40.0 | 70.1 | 98 | 75° | 80 | 55.0 | 3.42 |
| | | | | | | *1.575* | | *2.756* | *1.220* | *1.378* | *2.004* | *1.575* | *2.760* | *3.874* | | *1160* | | |
| | C5 | 7 | 1 | 11 | C5-A390.545-50 040A | 50.0 | 1"-8 | 40.0 | 2.4 | 5.0 | 20.9 | 50.0 | 70.1 | 98 | 75° | 80 | 95.0 | 3.12 |
| | | | | | | *1.969* | | *1.575* | *.094* | *.197* | *.823* | *1.969* | *2.760* | *3.874* | | *1160* | | |
| | C5 | 7 | 1 | 11 | C5-A390.545-50 080 | 50.0 | 1"-8 | 80.0 | 42.3 | 45.0 | 60.9 | 50.0 | 70.1 | 98 | 75° | 80 | 95.0 | 3.64 |
| | | | | | | *1.969* | | *3.150* | *1.665* | *1.772* | *2.398* | *1.969* | *2.760* | *3.874* | | *1160* | | |
| | C6 | 7 | 1 | 11 | C6-A390.545-50 040A | 63.0 | 1"-8 | 40.0 | 3.0 | 5.0 | 20.9 | 63.0 | 70.1 | 98 | 60° | 80 | 170.0 | 2.92 |
| | | | | | | *2.480* | | *1.575* | *.118* | *.197* | *.823* | *2.480* | *2.760* | *3.874* | | *1160* | | |
| | C6 | 7 | 1 | 11 | C6-A390.545-50 090 | 63.0 | 1"-8 | 90.0 | 53.0 | 55.0 | 70.9 | 63.0 | 70.1 | 98 | 60° | 80 | 170.0 | 4.07 |
| | | | | | | *2.480* | | *3.543* | *2.087* | *2.165* | *2.791* | *2.480* | *2.760* | *3.874* | | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-A390.545-50 100A | 80.0 | 1"-8 | 100.0 | 80.9 | 100.0 | | 98.4 | | | 0° | 80 | 170.0 | 4.84 |
| | | | | | | *3.150* | | *3.937* | *3.185* | *3.937* | | *3.874* | | | | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-A390.545-50 150 | 80.0 | 1"-8 | 150.0 | 130.9 | 150.0 | | 98.4 | | | 0° | 80 | 170.0 | 6.68 |
| | | | | | | *3.150* | | *5.906* | *5.154* | *5.906* | | *3.874* | | | | *1160* | | |




## Machine side interface ASME B5.50-2009

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | C10 | 7 | 1 | C10-A390.544-50 140 | 100.0 | 1"-8 | 140.0 | 80 | 380.0 | 7.90 |
| | | | | | *3.937* | | *5.512* | *1160* | | |

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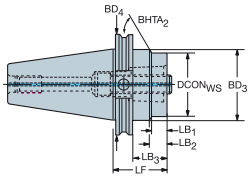
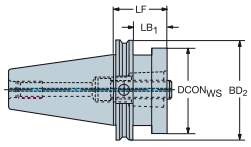
M1 N22 N15

# BIG-PLUS CAT-V to Coromant Capto® adapter

**90° rotated polygon for precision tool tip control**

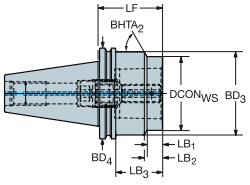
DSGN 11 2




**Machine side interface compatible with ASME B5.50-1985**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_2$ | BAR PSI | NM | KG |
| 40.0 | C4 | 1 | 1 | 11 | C4-A390.546-40 040 | 40.0 | 5/8"-11 | 40.0 | 3.6 | 5.0 | 20.9 | 40.0 | 44.7 | 63 | 60° | 80 | 45.0 | 1.02 |
| | | | | | | *1.575* | | *1.575* | *.142* | *.197* | *.823* | *1.575* | *1.760* | *2.500* | | *1160* | | |
| | C5 | 1 | 1 | 2 | C5-A390.546-40 050 | 50.0 | 5/8"-11 | 50.0 | 30.9 | 50.0 | | 63.5 | | | 0° | 80 | 45.0 | 1.08 |
| | | | | | | *1.969* | | *1.969* | *1.217* | *1.969* | | *2.500* | | | | *1160* | | |
| 50.0 | C6 | 1 | 1 | 11 | C6-A390.546-50 050 | 63.0 | 1"-8 | 50.0 | 13.0 | 15.0 | 30.9 | 63.0 | 70.1 | 98 | 60° | 80 | 65.0 | 3.20 |
| | | | | | | *2.480* | | *1.969* | *.512* | *.591* | *1.217* | *2.480* | *2.760* | *3.874* | | *1160* | | |
| | C8 | 1 | 1 | 2 | C8-A390.546-50 070 | 80.0 | 1"-8 | 70.0 | 50.9 | 70.0 | | 98.4 | | | 0° | 80 | 65.0 | 3.73 |
| | | | | | | *3.150* | | *2.756* | *2.004* | *2.756* | | *3.874* | | | | *1160* | | |

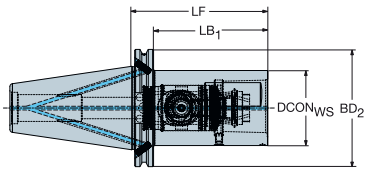



**Machine side interface heavy-duty version outside the ASME standard**

| | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_3$ | $BD_4$ | $BHTA_2$ | BAR PSI | NM | KG |
| 50.0 | C8 | 1 | 1 | C8-A390.547-50 070 | 80.0 | 1"-8 | 70.0 | 17.1 | 20.0 | 50.9 | 90.0 | 98.4 | 60° | 80 | 65.0 | 4.21 |
| | | | | | *3.150* | | *2.756* | *.673* | *.787* | *2.004* | *3.543* | *3.874* | | *1160* | | |

# BIG-PLUS CAT-V to Coromant Capto® adapter with Quick change

**Machine side interface ASME B5.50-2009**




**Metric bore**

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_2$ | BAR PSI | NM | KG |
| 50.0 | C6 | 7 | 1 | VB50-QC-C6-115 | 63.0 | 1"-8 | 115.0 | 95.0 | 98.4 | 80 | 90.0 | 4.48 |
| | | | | | *2.480* | | *4.528* | *3.740* | *3.874* | *1160* | | |

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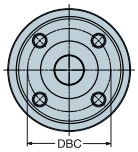
M1 N22 N6 N15

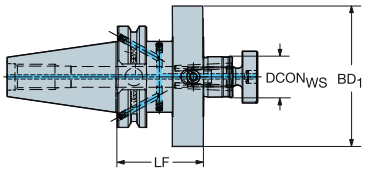
# BIG-PLUS CAT-V to arbor adapter

**Coolant through arbor**

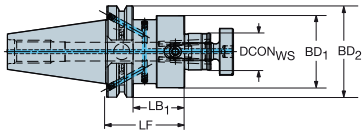
**Machine side interface compatible with ASME B5.50-1985**

DSGN 1




DSGN 2



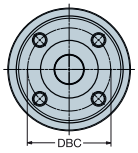

**Inch pilot**

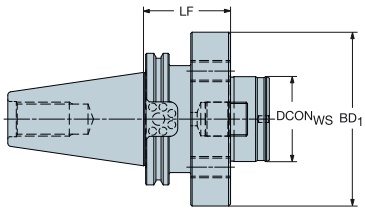
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 3/4 | 7 | 4 | 2 | A392.54505C4019040 | 19.1 | | 5/8"-11 | 40.0 | 20.9 | 40.0 | 44.5 | 63.5 | 80 | 25.0 | 1.17 |
| | | | | | | *.750* | | | *1.575* | *.823* | *1.575* | *1.752* | *2.500* | *1160* | | |
| | 1 | 7 | 4 | 2 | A392.54505C4025055 | 25.4 | | 5/8"-11 | 55.0 | 35.9 | 55.0 | 50.0 | 63.5 | 80 | 65.0 | 1.50 |
| | | | | | | *1.000* | | | *2.165* | *1.413* | *2.165* | *1.969* | *2.500* | *1160* | | |
| | 1 1/2 | 7 | 4 | 1 | A392.54505C4038060M | 38.1 | 66.7 | 5/8"-11 | 60.0 | 60.0 | | 87.0 | | 80 | 220.0 | 2.55 |
| | | | | | | *1.500* | *2.626* | | *2.362* | *2.362* | | *3.425* | | *1160* | | |

**Machine side interface compatible with ASME B5.50-2009**

**Inch pilot**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 3/4 | 7 | 4 | 2 | A392.54505C5019040 | 19.1 | | 1"-8 | 40.0 | 20.9 | 43.0 | 98.4 | 80 | 25.0 | 3.02 |
| | | | | | | *.750* | | | *1.575* | *.823* | *1.693* | *3.874* | *1160* | | |
| | 1 | 7 | 4 | 2 | A392.54505C5025050 | 25.4 | | 1"-8 | 50.0 | 30.9 | 50.0 | 98.4 | 80 | 65.0 | 3.23 |
| | | | | | | *1.000* | | | *1.969* | *1.217* | *1.969* | *3.874* | *1160* | | |
| | 1 1/2 | 7 | 4 | 2 | A392.54505C5038060 | 38.1 | 66.7 | 1"-8 | 60.0 | 40.9 | 87.0 | 98.4 | 80 | 220.0 | 4.83 |
| | | | | | | *1.500* | *2.626* | | *2.362* | *1.610* | *3.425* | *3.874* | *1160* | | |




**Inch pilot**

| CZC$_{MS}$ | CZC$_{WS}$ | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LF | BD$_1$ | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 2 1/2 | A392.54505-5063065 | 63.5 | 101.6 | 1"-8 | 65.0 | 130.0 | 120.0 | 7.30 | 12000 |
| | | | *2.500* | *4.000* | | *2.559* | *5.118* | | | |

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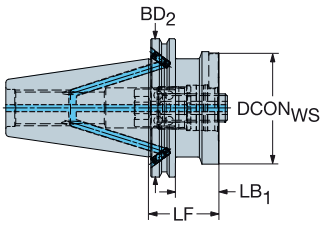
# BIG-PLUS CAT-V to VL adapter

**Machine side interface compatible with ASME B5.50-2009**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 80 | 7 | 1 | A390.545-50 80 050 | 80.0 | 1"-8 | 50.0 | 30.9 | 98.4 | 80 | 170.0 | 3.55 | 12000 |
| | | | | | *3.150* | | *1.969* | *1.219* | *3.874* | *1160* | | | |

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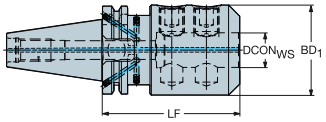
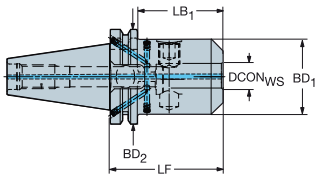
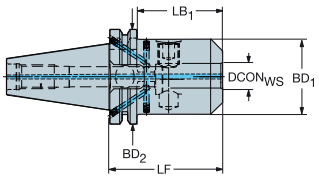
# BIG-PLUS CAT-V to Weldon / ISO 9766 adapter

**Machine side interface compatible with ASME B5.50-1985**

DSGN 1 2 6




**Inch bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 3/4 | 7 | 1 | 6 | A392.54523-4019065 | 19.1 | 5/8"-11 | 65.0 | 45.9 | 44.5 | 63.5 | 20 | 20.0 | 1.28 | 18000 |
| | | | | | | *.750* | | *2.559* | *1.807* | *1.752* | *2.500* | *290* | | | |
| | 1 | 7 | 1 | 6 | A392.54523-4025100 | 25.4 | 5/8"-11 | 100.0 | 80.9 | 57.1 | 63.5 | 20 | 25.0 | 2.05 | 18000 |
| | | | | | | *1.000* | | *3.937* | *3.185* | *2.248* | *2.500* | *290* | | | |
| | 1 1/4 | 7 | 1 | 6 | A392.54523-4031100 | 31.8 | 5/8"-11 | 100.0 | 80.9 | 63.0 | 63.5 | 20 | 45.0 | 2.15 | 18000 |
| | | | | | | *1.250* | | *3.937* | *3.185* | *2.480* | *2.500* | *290* | | | |

**Machine side interface compatible with ASME B5.50-2009**

**Inch bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 5/8 | 7 | 1 | 2 | A392.54523-4015060 | 15.9 | 5/8"-11 | 60.0 | 40.9 | 60.0 | 41.0 | 63.5 | 20 | 20.0 | 1.18 | 18000 |
| | | | | | | *.625* | | *2.362* | *1.610* | *2.362* | *1.614* | *2.500* | *290* | | | |
| | 1 1/2 | 7 | 1 | 1 | A392.54523-4038105 | 38.1 | 5/8"-11 | 105.0 | 105.0 | | 70.0 | | 20 | 45.0 | 2.62 | 18000 |
| | | | | | | *1.500* | | *4.134* | *4.134* | | *2.756* | | *290* | | | |
| 50.0 | 1 | 7 | 1 | 2 | A392.54523-5025085 | 25.4 | 1"-8 | 85.0 | 65.9 | 85.0 | 57.1 | 98.4 | 20 | 25.0 | 3.69 | 12000 |
| | | | | | | *1.000* | | *3.346* | *2.594* | *3.346* | *2.248* | *3.874* | *290* | | | |
| | 1 1/4 | 7 | 1 | 2 | A392.54523-5031085 | 31.8 | 1"-8 | 85.0 | 65.9 | 85.0 | 63.0 | 98.4 | 20 | 45.0 | 3.79 | 12000 |
| | | | | | | *1.250* | | *3.346* | *2.594* | *3.346* | *2.480* | *3.874* | *290* | | | |
| | 1 1/2 | 7 | 1 | 2 | A392.54523-5038090 | 38.1 | 1"-8 | 90.0 | 70.9 | 90.0 | 70.0 | 98.4 | 20 | 45.0 | 0.42 | 12000 |
| | | | | | | *1.500* | | *3.543* | *2.791* | *3.543* | *2.756* | *3.874* | *290* | | | |

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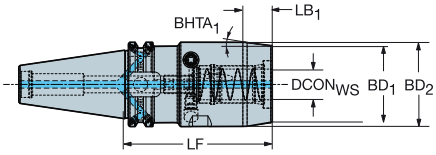
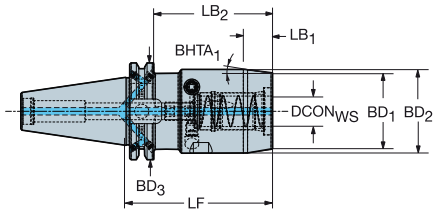
# BIG-PLUS CAT-V to CoroChuck™ 930

**Machine side interface ASME B5.50-2009**

**Heavy-duty design**

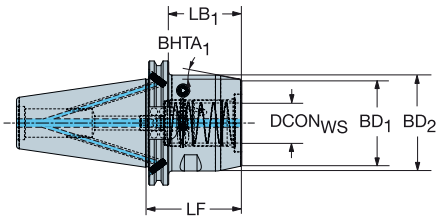
DSGN 3 6




## Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 20 | 7 | 1 | 6 | 930-VB40-HD-20-082 | 20.0 | 5/8"-11 | 51 | 82.0 | 17.8 | 62.9 | 82.0 | 50.0 | 55.0 | 63.5 | 8° | 80 | 10.0 | 1.83 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.228* | *.701* | *2.476* | *3.228* | *1.969* | *2.165* | *2.500* | | *1160* | | | |
| | 25 | 7 | 1 | 3 | 930-VB40-HD-25-101 | 25.0 | 5/8"-11 | 57 | 101.0 | 18.8 | 101.0 | | 57.0 | 65.0 | | 12° | 80 | 10.0 | 2.55 | 18000 |
| | | | | | | *.984* | | *2.244* | *3.976* | *.740* | *3.976* | | *2.244* | *2.559* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 6 | 930-VB50-HD-20-083 | 20.0 | 1"-8 | 51 | 83.0 | 17.8 | 63.9 | 83.0 | 50.0 | 55.0 | 98.4 | 8° | 80 | 10.0 | 3.70 | 12000 |
| | | | | | | *.787* | | *2.008* | *3.268* | *.701* | *2.516* | *3.268* | *1.969* | *2.165* | *3.874* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | 930-VB50-HD-25-087 | 25.0 | 1"-8 | 57 | 87.0 | 18.8 | 65.4 | 87.0 | 57.0 | 65.0 | 98.4 | 12° | 80 | 10.0 | 4.14 | 12000 |
| | | | | | | *.984* | | *2.244* | *3.425* | *.740* | *2.575* | *3.425* | *2.244* | *2.559* | *3.874* | | *1160* | | | |
| | 32 | 7 | 1 | 6 | 930-VB50-HD-32-077 | 32.0 | 1"-8 | 61 | 77.0 | 18.8 | 57.9 | 77.0 | 68.0 | 76.0 | 98.4 | 12° | 80 | 10.0 | 4.26 | 12000 |
| | | | | | | *1.260* | | *2.402* | *3.032* | *.740* | *2.280* | *3.032* | *2.677* | *2.992* | *3.874* | | *1160* | | | |




## Inch bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BD$_3$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 1 1/4 | 7 | 1 | 930-VB50-HD-A31-077 | 31.8 | 1"-8 | 61 | 77.0 | 18.8 | 57.9 | 68.0 | 76.0 | 98.4 | 12° | 80 | 10.0 | 4.28 | 12000 |
| | | | | | *1.250* | | *2.402* | *3.032* | *.740* | *2.280* | *2.677* | *2.992* | *3.874* | | *1160* | | | |

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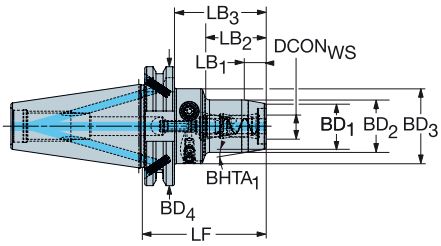
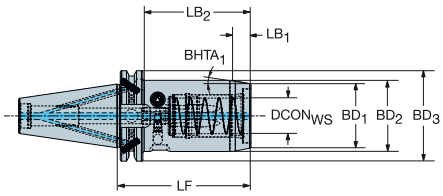
# BIG-PLUS CAT-V to CoroChuck™ 930

**Machine side interface compatible with ASME B5.50-2009**

**Slender design**

DSGN 10 6




## Metric bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 6 | 7 | 1 | 10 | **930-VB40-S-06-068** | 6.0 | 5/8"-11 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 22.0 | 26.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.09 | 18000 |
| | | | | | | *.236* | | *1.457* | *2.677* | *.445* | *1.189* | *1.925* | *.866* | *1.024* | *1.575* | *2.500* | | *1160* | | | |
| | 8 | 7 | 1 | 10 | **930-VB40-S-08-068** | 8.0 | 5/8"-11 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 24.0 | 28.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.11 | 18000 |
| | | | | | | *.315* | | *1.457* | *2.677* | *.445* | *1.189* | *1.925* | *.945* | *1.102* | *1.575* | *2.500* | | *1160* | | | |
| | 10 | 7 | 1 | 10 | **930-VB40-S-10-072** | 10.0 | 5/8"-11 | 41 | 72.0 | 11.3 | 34.2 | 52.9 | 26.0 | 30.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.14 | 18000 |
| | | | | | | *.394* | | *1.614* | *2.835* | *.445* | *1.346* | *2.083* | *1.024* | *1.181* | *1.575* | *2.500* | | *1160* | | | |
| | 12 | 7 | 1 | 10 | **930-VB40-S-12-080** | 12.0 | 5/8"-11 | 46 | 80.0 | 11.3 | 38.2 | 60.9 | 28.0 | 32.0 | 50.0 | 63 | 10° | 80 | 8.0 | 1.35 | 18000 |
| | | | | | | *.472* | | *1.811* | *3.150* | *.445* | *1.504* | *2.398* | *1.102* | *1.260* | *1.969* | *2.500* | | *1160* | | | |
| | 20 | 7 | 1 | 10 | **930-VB40-S-20-090** | 20.0 | 5/8"-11 | 51 | 90.0 | 16.0 | 49.2 | 70.9 | 38.0 | 42.0 | 50.0 | 63 | 7° | 80 | 8.0 | 1.53 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.543* | *.630* | *1.937* | *2.791* | *1.496* | *1.654* | *1.969* | *2.500* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | **930-VB40-S-25-095** | 25.0 | 5/8"-11 | 57 | 95.0 | 12.9 | 75.0 | 95.0 | 45.0 | 50.0 | 63 | | 11° | 80 | 8.0 | 1.73 | 18000 |
| | | | | | | *.984* | | *2.244* | *3.740* | *.508* | *2.953* | *3.740* | *1.772* | *1.969* | *2.500* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 10 | **930-VB50-S-20-089** | 20.0 | 1"-8 | 51 | 89.0 | 16.0 | 49.2 | 69.9 | 38.0 | 42.0 | 50.0 | 98 | 7° | 80 | 8.0 | 3.37 | 12000 |
| | | | | | | *.787* | | *2.008* | *3.504* | *.630* | *1.937* | *2.752* | *1.496* | *1.654* | *1.969* | *3.874* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | **930-VB50-S-25-095** | 25.0 | 1"-8 | 57 | 95.0 | 12.9 | 73.5 | 95.0 | 45.0 | 50.0 | 98 | | 11° | 80 | 8.0 | 3.61 | 12000 |
| | | | | | | *.984* | | *2.244* | *3.740* | *.508* | *2.894* | *3.740* | *1.772* | *1.969* | *3.874* | | | *1160* | | | |

## Inch bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 1 | 7 | 1 | 6 | **930-VB40-S-A25-095** | 25.4 | 5/8"-11 | 57 | 95.0 | 12.9 | 75.0 | 45.0 | 50.0 | 63 | 11° | 80 | 8.0 | 1.73 | 18000 |
| | | | | | | *1.000* | | *2.244* | *3.740* | *.508* | *2.953* | *1.772* | *1.969* | *2.500* | | *1160* | | | |

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

M1 N22 N6 N15 N4

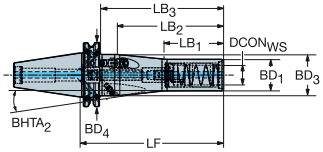
# BIG-PLUS CAT-V to CoroChuck™ 930

**Machine side interface compatible with ASME B5.50-2009**

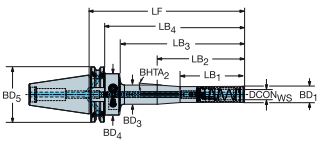
**Slender design**

**Pencil design**

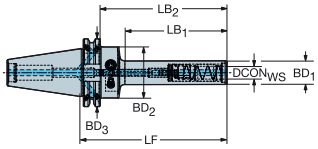
DSGN 11




DSGN 17




DSGN 5




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $LB_4$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_2$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 8 | 7 | 1 | 5 | 930-VB40-P-08-088 | 8.0 | 5/8"-11 | 37 | 88.0 | 45.8 | 66.5 | 88.0 | | 17.5 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.07 | 18000 |
| | | | | | | *.315* | | *1.457* | *3.465* | *1.803* | *2.618* | *3.465* | | *.689* | *1.575* | *2.500* | | | *1160* | | | |
| | 10 | 7 | 1 | 5 | 930-VB40-P-10-098 | 10.0 | 5/8"-11 | 41 | 98.0 | 55.8 | 76.5 | 98.0 | | 20.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.11 | 18000 |
| | | | | | | *.394* | | *1.614* | *3.858* | *2.197* | *3.012* | *3.858* | | *.787* | *1.575* | *2.500* | | | *1160* | | | |
| | 10 | 7 | 1 | 5 | 930-VB40-P-10-138 | 10.0 | 5/8"-11 | 41 | 138.0 | 95.8 | 116.5 | 138.0 | | 20.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.21 | 18000 |
| | | | | | | *.394* | | *1.614* | *5.433* | *3.772* | *4.587* | *5.433* | | *.787* | *1.575* | *2.500* | | | *1160* | | | |
| | 12 | 7 | 1 | 5 | 930-VB40-P-12-103 | 12.0 | 5/8"-11 | 46 | 103.0 | 65.0 | 83.9 | 103.0 | | 22.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.13 | 18000 |
| | | | | | | *.472* | | *1.811* | *4.055* | *2.559* | *3.303* | *4.055* | | *.866* | *1.575* | *2.500* | | | *1160* | | | |
| | 12 | 7 | 1 | 5 | 930-VB40-P-12-138 | 12.0 | 5/8"-11 | 46 | 138.0 | 100.0 | 118.9 | 138.0 | | 22.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.23 | 18000 |
| | | | | | | *.472* | | *1.811* | *5.433* | *3.937* | *4.681* | *5.433* | | *.866* | *1.575* | *2.500* | | | *1160* | | | |
| | 12 | 7 | 1 | 17 | 930-VB40-P-12-188 | 12.0 | 5/8"-11 | 46 | 188.0 | 50.0 | 75.0 | 150.0 | 168.9 | 22.0 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 1.49 | 18000 |
| | | | | | | *.472* | | *1.811* | *7.402* | *1.969* | *2.953* | *5.906* | *6.650* | *.866* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| | 20 | 7 | 1 | 11 | 930-VB40-P-20-145 | 20.0 | 5/8"-11 | 51 | 145.0 | 60.0 | 108.0 | 125.9 | 145.0 | 32.0 | 32.0 | 42.0 | 63 | 5° | 80 | 8.0 | 1.60 | 18000 |
| | | | | | | *.787* | | *2.008* | *5.709* | *2.362* | *4.252* | *4.957* | *5.709* | *1.260* | *1.260* | *1.654* | *2.500* | | *1160* | | | |

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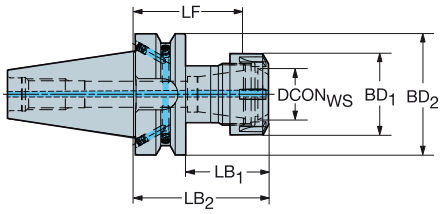
M1 N22 N6 N15 N4

# BIG-PLUS CAT-V to ER collet chuck

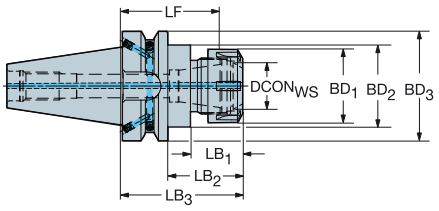
**Machine side interface compatible with ASME B5.50-1985**

**Workpiece side interface DIN 6499-B**

DSGN 2




DSGN 5




| | | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | KG | RPMX |
| 40.0 | ER25 | 7 | 1 | 5 | **A392.54514-4025070** | 26.0 | 5/8"-11 | 58.0 | 35.0 | 50.9 | 70.0 | 42.0 | 44.4 | 63.5 | 80 | 1.14 | 18000 |
| | | | | | | *1.024* | | *2.283* | *1.378* | *2.004* | *2.756* | *1.654* | *1.748* | *2.500* | *1160* | | |
| | ER40 | 7 | 1 | 2 | **A392.54514-4040075** | 41.0 | 5/8"-11 | 60.0 | 55.9 | 75.0 | | 63.0 | 63.5 | | 80 | 1.38 | 18000 |
| | | | | | | *1.614* | | *2.362* | *2.201* | *2.953* | | *2.480* | *2.500* | | *1160* | | |

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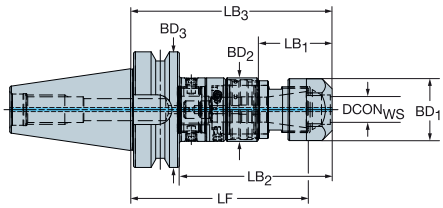
M1 N22 N15

# BIG-PLUS CAT-V to CoroChuck™ 970

**Machine side interface ASME B5.50-2009**




## Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | TRMAX | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | ER20 | M12 | 7 | 1 | **970-VB40-20-102** | 20.8 | 5/8"-11 | 89.2 | 35.3 | 78.1 | 97.2 | 33.7 | 35.0 | 63.5 | 80 | 1.28 | 8000 |
| | | | | | | *.819* | | *3.512* | *1.390* | *3.075* | *3.827* | *1.327* | *1.378* | *2.500* | *1160* | | |
| | ER25 | M20 | 7 | 1 | **970-VB40-25-122** | 25.8 | 5/8"-11 | 108.1 | 37.1 | 97.5 | 116.6 | 42.0 | 44.0 | 63.5 | 80 | 1.64 | 8000 |
| | | | | | | *1.016* | | *4.256* | *1.461* | *3.839* | *4.591* | *1.654* | *1.732* | *2.500* | *1160* | | |
| 50.0 | ER20 | M12 | 7 | 1 | **970-VB50-20-106** | 20.8 | 1"-8 | 93.2 | 35.3 | 82.1 | 101.2 | 33.7 | 35.0 | 98.4 | 80 | 3.13 | 8000 |
| | | | | | | *.819* | | *3.669* | *1.390* | *3.232* | *3.984* | *1.327* | *1.378* | *3.874* | *1160* | | |
| | ER25 | M20 | 7 | 1 | **970-VB50-25-126** | 25.8 | 1"-8 | 112.1 | 37.1 | 101.5 | 120.6 | 42.0 | 44.0 | 98.4 | 80 | 3.49 | 8000 |
| | | | | | | *1.016* | | *4.413* | *1.461* | *3.996* | *4.748* | *1.654* | *1.732* | *3.874* | *1160* | | |

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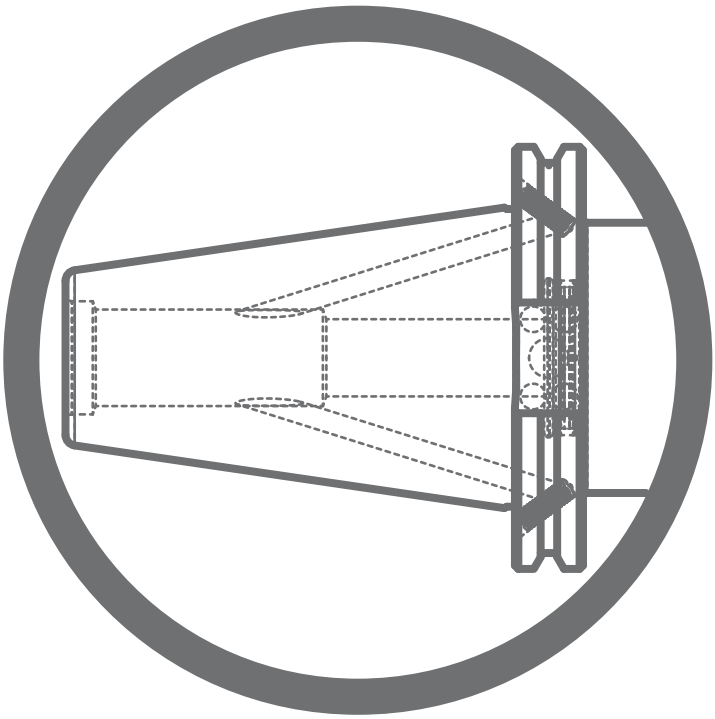
M1 N22 N15 N5

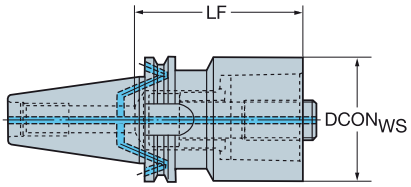
# Machine side interface ISO 7388-1



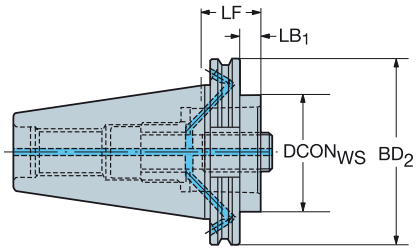
# ISO 7388-1 to Coromant Capto® adapter

**Machine side interface compatible with DIN 69871-ADB**

DSGN 1




2



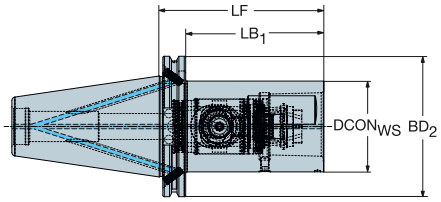

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | C3 | 7 | 1 | 2 | C3-390B.140-40 030 | 32.0 | M16 | 30.0 | 10.9 | 30.0 | 63.5 | 80 | 45.0 | 0.87 |
| | | | | | | *1.260* | | *1.181* | *.429* | *1.181* | *2.500* | *1160* | | |
| | C3 | 7 | 1 | 2 | C3-390B.140-40 060 | 32.0 | M16 | 60.0 | 40.9 | 60.0 | 63.5 | 80 | 45.0 | 1.02 |
| | | | | | | *1.260* | | *2.362* | *1.610* | *2.362* | *2.500* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.140-40 030 | 40.0 | M16 | 30.0 | 10.9 | 30.0 | 63.5 | 80 | 55.0 | 0.86 |
| | | | | | | *1.575* | | *1.181* | *.429* | *1.181* | *2.500* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.140-40 060 | 40.0 | M16 | 60.0 | 40.9 | 60.0 | 63.5 | 80 | 55.0 | 1.12 |
| | | | | | | *1.575* | | *2.362* | *1.610* | *2.362* | *2.500* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.140-40 040 | 50.0 | M16 | 40.0 | 20.9 | 40.0 | 63.5 | 80 | 95.0 | 0.96 |
| | | | | | | *1.969* | | *1.575* | *.823* | *1.575* | *2.500* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.140-40 080 | 50.0 | M16 | 80.0 | 60.9 | 80.0 | 63.5 | 80 | 95.0 | 1.52 |
| | | | | | | *1.969* | | *3.150* | *2.398* | *3.150* | *2.500* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390B.140-40 085 | 63.0 | M16 | 85.0 | 65.9 | 85.0 | 63.5 | 80 | 170.0 | 1.84 |
| | | | | | | *2.480* | | *3.346* | *2.594* | *3.346* | *2.500* | *1160* | | |
| 50.0 | C3 | 7 | 1 | 2 | C3-390B.140-50 030 | 32.0 | M24 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 45.0 | 2.73 |
| | | | | | | *1.260* | | *1.181* | *.429* | *1.181* | *3.839* | *1160* | | |
| | C3 | 7 | 1 | 2 | C3-390B.140-50 060 | 32.0 | M24 | 60.0 | 40.9 | 60.0 | 97.5 | 80 | 45.0 | 2.86 |
| | | | | | | *1.260* | | *2.362* | *1.610* | *2.362* | *3.839* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.140-50 030 | 40.0 | M24 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 55.0 | 2.74 |
| | | | | | | *1.575* | | *1.181* | *.429* | *1.181* | *3.839* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.140-50 060 | 40.0 | M24 | 60.0 | 40.9 | 60.0 | 97.5 | 80 | 55.0 | 2.96 |
| | | | | | | *1.575* | | *2.362* | *1.610* | *2.362* | *3.839* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.140-50 030 | 50.0 | M24 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 95.0 | 2.70 |
| | | | | | | *1.969* | | *1.181* | *.429* | *1.181* | *3.839* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.140-50 070 | 50.0 | M24 | 70.0 | 50.9 | 70.0 | 97.5 | 80 | 95.0 | 3.21 |
| | | | | | | *1.969* | | *2.756* | *2.004* | *2.756* | *3.839* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390B.140-50 030 | 63.0 | M24 | 30.0 | 10.9 | 30.0 | 97.5 | 80 | 170.0 | 2.62 |
| | | | | | | *2.480* | | *1.181* | *.429* | *1.181* | *3.839* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390B.140-50 080 | 63.0 | M24 | 80.0 | 60.9 | 80.0 | 97.5 | 80 | 170.0 | 3.71 |
| | | | | | | *2.480* | | *3.150* | *2.398* | *3.150* | *3.839* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-390B.140-50 070 | 80.0 | M24 | 70.0 | 50.9 | 70.0 | 97.5 | 80 | 170.0 | 3.83 |
| | | | | | | *3.150* | | *2.756* | *2.004* | *2.756* | *3.839* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-390B.140-50 120 | 80.0 | M24 | 120.0 | 100.9 | 120.0 | 97.5 | 80 | 170.0 | 5.69 |
| | | | | | | *3.150* | | *4.724* | *3.972* | *4.724* | *3.839* | *1160* | | |
| | C10 | 7 | 1 | 1 | C10-390B.140-50 140 | 100.0 | M24 | 140.0 | 140.0 | | | 80 | 380.0 | 7.66 |
| | | | | | | *3.937* | | *5.512* | *5.512* | | | *1160* | | |
| 60.0 | C8 | 1 | 1 | 2 | C8-390.140-60 120 | 80.0 | M30 | 120.0 | 100.9 | 120.0 | 155.0 | 80 | 170.0 | 12.57 |
| | | | | | | *3.150* | | *4.724* | *3.972* | *4.724* | *6.102* | *1160* | | |
| | C10 | 1 | 1 | 2 | C10-390.140-60 050 | 100.0 | M30 | 50.0 | 30.9 | 50.0 | 155.0 | 80 | 90.0 | 9.35 |
| | | | | | | *3.937* | | *1.969* | *1.217* | *1.969* | *6.102* | *1160* | | |

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

M1 N22 N15

# ISO 7388-1 to Coromant Capto® adapter with Quick change

**Machine side interface compatible with DIN 69871-ADB**




| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | C5 | 7 | 1 | I50-QC-C5-095 | 50.0 | M24 | 95.0 | 75.0 | 97.4 | 80 | 70.0 | 3.54 |
| | | | | | *1.969* | | *3.740* | *2.953* | *3.835* | *1160* | | |
| | C6 | 7 | 1 | I50-QC-C6-115 | 63.0 | M24 | 115.0 | 95.0 | 97.4 | 80 | 90.0 | 4.43 |
| | | | | | *2.480* | | *4.528* | *3.740* | *3.835* | *1160* | | |
| | C8 | 7 | 1 | I50-QC-C8-135 | 80.0 | M24 | 135.0 | 115.0 | 97.4 | 80 | 130.0 | 6.06 |
| | | | | | *3.150* | | *5.315* | *4.528* | *3.835* | *1160* | | |

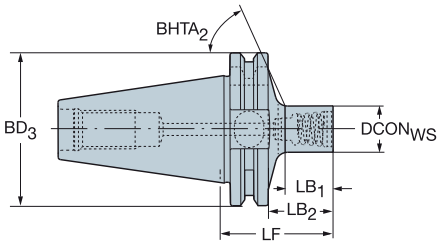
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15

# ISO 7388-1 to Coromant EH adapter

**Machine side interface compatible with DIN 69871-AD**

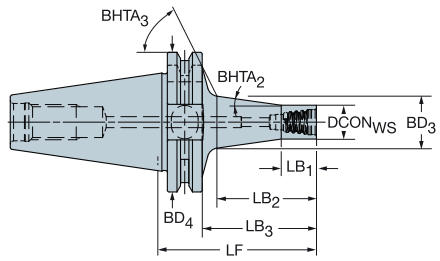
**Short design**




**Metric version**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_3$ | BHTA$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | E10 | 1 | 1 | 392.140EH-40 10 041 | 9.6 | M16 | 41.0 | 12.7 | 21.9 | 63.5 | 65° | 80 | 12.0 | 0.96 | 18000 |
| | | | | | *.378* | | *1.614* | *.500* | *.862* | *2.500* | | *1160* | | | |
| | E12 | 1 | 1 | 392.140EH-40 12 044 | 11.6 | M16 | 44.0 | 16.0 | 24.9 | 63.5 | 65° | 80 | 15.0 | 0.97 | 18000 |
| | | | | | *.457* | | *1.732* | *.630* | *.980* | *2.500* | | *1160* | | | |
| | E16 | 1 | 1 | 392.140EH-40 16 049 | 15.4 | M16 | 49.0 | 21.5 | 29.9 | 63.5 | 65° | 80 | 30.0 | 1.03 | 18000 |
| | | | | | *.606* | | *1.929* | *.846* | *1.177* | *2.500* | | *1160* | | | |
| | E20 | 1 | 1 | 392.140EH-40 20 046 | 19.2 | M16 | 46.0 | 19.0 | 27.0 | 63.5 | 63° | 80 | 50.0 | 1.05 | 18000 |
| | | | | | *.756* | | *1.811* | *.748* | *1.063* | *2.500* | | *1160* | | | |
| | E25 | 1 | 1 | 392.140EH-40 25 051 | 24.1 | M16 | 51.0 | 24.6 | 31.9 | 63.5 | 61° | 80 | 65.0 | 1.09 | 18000 |
| | | | | | *.949* | | *2.008* | *.969* | *1.256* | *2.500* | | *1160* | | | |

**Long design**




**Metric version**

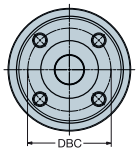
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BHTA$_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | E10 | 1 | 1 | 392.140EH-40 10 055 | 9.6 | M16 | 55.0 | 10.0 | 28.1 | 35.9 | 14.7 | 63.5 | 8° | 65° | 80 | 12.0 | 0.97 | 18000 |
| | | | | | *.378* | | *2.165* | *.394* | *1.106* | *1.413* | *.579* | *2.500* | | | *1160* | | | |
| | E12 | 1 | 1 | 392.140EH-40 12 060 | 11.6 | M16 | 60.0 | 12.0 | 33.5 | 40.9 | 17.6 | 63.5 | 8° | 65° | 80 | 15.0 | 1.00 | 18000 |
| | | | | | *.457* | | *2.362* | *.472* | *1.319* | *1.610* | *.693* | *2.500* | | | *1160* | | | |
| | E16 | 1 | 1 | 392.140EH-40 16 071 | 15.4 | M16 | 71.0 | 16.0 | 45.3 | 51.9 | 23.6 | 63.5 | 8° | 63° | 80 | 30.0 | 1.09 | 18000 |
| | | | | | *.606* | | *2.795* | *.630* | *1.783* | *2.043* | *.929* | *2.500* | | | *1160* | | | |
| | E20 | 1 | 1 | 392.140EH-40 20 084 | 19.2 | M16 | 84.0 | 20.0 | 59.1 | 64.9 | 30.2 | 63.5 | 8° | 61° | 80 | 50.0 | 1.19 | 18000 |
| | | | | | *.756* | | *3.307* | *.787* | *2.327* | *2.555* | *1.189* | *2.500* | | | *1160* | | | |
| | E25 | 1 | 1 | 392.140EH-40 25 100 | 24.1 | M16 | 100.0 | 25.0 | 76.2 | 80.9 | 38.5 | 63.5 | 8° | 51° | 80 | 65.0 | 1.40 | 18000 |
| | | | | | *.949* | | *3.937* | *.984* | *3.000* | *3.185* | *1.516* | *2.500* | | | *1160* | | | |

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

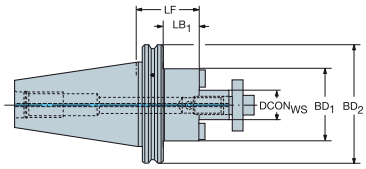
M1 N22 N6 N15 N3

# ISO 7388-1 to arbor adapter

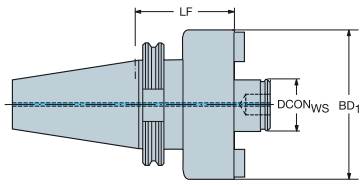
**Machine side interface compatible with DIN 69871-ADB**




DSGN 2




DSGN 1




## Metric pilot

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch $DCON_{WS}$ | DBC | CRKS | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 16 | 7 | 1 | 2 | **A1B05-40 16 035** | 16.0 | | M16 | 35.0 | 15.9 | 35.0 | 36.0 | 63.5 | 80 | 22.0 | 1.04 | 18000 |
| | | | | | | *.630* | | | *1.378* | *.626* | *1.378* | *1.417* | *2.500* | *1160* | | | |
| | 16 | 7 | 1 | 2 | **A1B05-40 16 100** | 16.0 | | M16 | 100.0 | 78.9 | 100.0 | 36.0 | 63.5 | 80 | 22.0 | 1.47 | 18000 |
| | | | | | | *.630* | | | *3.937* | *3.108* | *3.937* | *1.417* | *2.500* | *1160* | | | |
| | 22 | 7 | 1 | 2 | **A1B05-40 22 035** | 22.0 | | M16 | 35.0 | 13.9 | 35.0 | 48.0 | 63.5 | 80 | 45.0 | 1.15 | 18000 |
| | | | | | | *.866* | | | *1.378* | *.549* | *1.378* | *1.890* | *2.500* | *1160* | | | |
| | 22 | 7 | 1 | 2 | **A1B05-40 22 100** | 22.0 | | M16 | 100.0 | 78.9 | 100.0 | 48.0 | 63.5 | 80 | 45.0 | 2.02 | 18000 |
| | | | | | | *.866* | | | *3.937* | *3.108* | *3.937* | *1.890* | *2.500* | *1160* | | | |
| | 27 | 7 | 1 | 2 | **A1B05-40 27 035** | 27.0 | | M16 | 35.0 | 15.0 | 35.0 | 48.0 | 63.5 | 80 | 80.0 | 1.08 | 18000 |
| | | | | | | *1.063* | | | *1.378* | *.591* | *1.378* | *1.890* | *2.500* | *1160* | | | |
| | 27 | 7 | 1 | 2 | **A1B05-40 27 100** | 27.0 | | M16 | 100.0 | 80.9 | 100.0 | 60.0 | 63.5 | 80 | 80.0 | 2.59 | 18000 |
| | | | | | | *1.063* | | | *3.937* | *3.187* | *3.937* | *2.362* | *2.500* | *1160* | | | |
| | 32 | 7 | 1 | 1 | **A1B05-40 32 050** | 32.0 | | M16 | 50.0 | 50.0 | | 78.0 | | 80 | 180.0 | 1.82 | 18000 |
| | | | | | | *1.260* | | | *1.969* | *1.969* | | *3.071* | | *1160* | | | |
| 50.0 | 22 | 7 | 1 | 2 | **A1B05-50 22 035** | 22.0 | | M24 | 35.0 | 15.9 | 35.0 | 48.0 | 97.5 | 80 | 45.0 | 3.00 | 12000 |
| | | | | | | *.866* | | | *1.378* | *.626* | *1.378* | *1.890* | *3.839* | *1160* | | | |
| | 22 | 7 | 1 | 2 | **A1B05-50 22 100** | 22.0 | | M24 | 100.0 | 77.9 | 100.0 | 48.0 | 97.5 | 80 | 45.0 | 4.03 | 12000 |
| | | | | | | *.866* | | | *3.937* | *3.069* | *3.937* | *1.890* | *3.839* | *1160* | | | |
| | 27 | 7 | 1 | 2 | **A1B05-50 27 035** | 27.0 | | M24 | 35.0 | 12.9 | 35.0 | 60.0 | 97.5 | 80 | 80.0 | 3.26 | 12000 |
| | | | | | | *1.063* | | | *1.378* | *.510* | *1.378* | *2.362* | *3.839* | *1160* | | | |
| | 27 | 7 | 1 | 2 | **A1B05-50 27 100** | 27.0 | | M24 | 100.0 | 77.9 | 100.0 | 60.0 | 97.5 | 80 | 80.0 | 4.68 | 12000 |
| | | | | | | *1.063* | | | *3.937* | *3.069* | *3.937* | *2.362* | *3.839* | *1160* | | | |
| | 32 | 7 | 1 | 2 | **A1B05-50 32 035** | 32.0 | | M24 | 35.0 | 12.9 | 35.0 | 78.0 | 97.5 | 80 | 180.0 | 3.54 | 12000 |
| | | | | | | *1.260* | | | *1.378* | *.510* | *1.378* | *3.071* | *3.839* | *1160* | | | |
| | 32 | 7 | 1 | 2 | **A1B05-50 32 100** | 32.0 | | M24 | 100.0 | 77.9 | 100.0 | 78.0 | 97.5 | 80 | 180.0 | 5.78 | 12000 |
| | | | | | | *1.260* | | | *3.937* | *3.069* | *3.937* | *3.071* | *3.839* | *1160* | | | |
| | 40S | 7 | 1 | 2 | **A1B05-50 40 050** | 40.0 | 66.7 | M24 | 50.0 | 30.9 | 50.0 | 89.0 | 97.5 | 80 | 300.0 | 4.48 | 12000 |
| | | | | | | *1.575* | *2.626* | | *1.969* | *1.217* | *1.969* | *3.504* | *3.839* | *1160* | | | |
| | 60 | 7 | 1 | 1 | **A1F05-50 60 070** | 60.0 | 101.6 | M24 | 70.0 | 70.0 | | 127.0 | | 80 | 180.0 | 7.76 | 12000 |
| | | | | | | *2.362* | *4.000* | | *2.756* | *2.756* | | *5.000* | | *1160* | | | |

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 M12.

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

M1

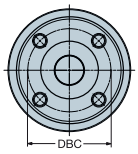
N22

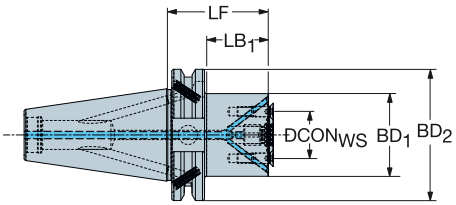
N15

# ISO 7388-1 to arbor with driving screws adapter

**Machine side interface compatible with DIN 69871-ADB**

**For CoroMill® QD with internal coolant supply**



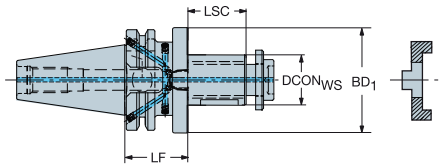

**Metric pilot**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LSC | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | X10 | 7 | 3 | I40-X10-032-045 | 10.0 | 22.0 | M16 | 2 | 45.0 | 24.5 | 32.0 | 63.5 | 80 | 6.4 | 1.00 | 12000 |
| | | | | | *.394* | *.866* | | *.094* | *1.772* | *.965* | *1.260* | *2.500* | *1160* | | | |
| | X22 | 7 | 3 | I40-X22-040-050 | 22.0 | 32.0 | M16 | 2 | 50.0 | 29.5 | 40.0 | 63.5 | 80 | 3.9 | 1.14 | 11000 |
| | | | | | *.866* | *1.260* | | *.094* | *1.969* | *1.161* | *1.575* | *2.500* | *1160* | | | |
| | X32 | 7 | 3 | I40-X32-063-070 | 32.0 | 45.0 | M16 | 2 | 70.0 | 50.5 | 63.0 | 63.5 | 80 | 6.4 | 1.89 | 10000 |
| | | | | | *1.260* | *1.772* | | *.094* | *2.756* | *1.988* | *2.480* | *2.500* | *1160* | | | |

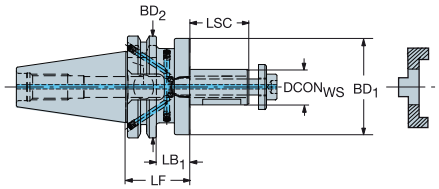
# ISO 7388-1 to side and face-mill arbor adapter

**Machine side interface compatible with DIN 69871-ADB**

DSGN 1




2



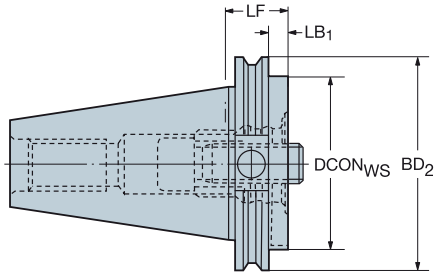

**Metric pilot**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 22 | 7 | 1 | 2 | A1B08-40 22 055 | 22.0 | M16 | 31 | 43.0 | 19.9 | 43.0 | 40.0 | 63.5 | 80 | 45.0 | 1.26 | 18000 |
| | | | | | | *.866* | | *1.220* | *1.693* | *.783* | *1.693* | *1.575* | *2.500* | *1160* | | | |
| | 27 | 7 | 1 | 2 | A1B08-40 27 055 | 27.0 | M16 | 33 | 43.0 | 22.9 | 43.0 | 48.0 | 63.5 | 80 | 80.0 | 1.45 | 18000 |
| | | | | | | *1.063* | | *1.299* | *1.693* | *.902* | *1.693* | *1.890* | *2.500* | *1160* | | | |
| | 32 | 7 | 1 | 2 | A1B08-40 32 060 | 32.0 | M16 | 37 | 46.0 | 26.9 | 46.0 | 58.0 | 63.5 | 80 | 180.0 | 1.76 | 18000 |
| | | | | | | *1.260* | | *1.457* | *1.811* | *1.059* | *1.811* | *2.283* | *2.500* | *1160* | | | |
| | 40 | 7 | 1 | 1 | A1B08-40 40 060 | 40.0 | M16 | 41 | 46.0 | 60.0 | | 70.0 | | 80 | 300.0 | 2.38 | 18000 |
| | | | | | | *1.575* | | *1.614* | *1.811* | *2.362* | | *2.756* | | *1160* | | | |

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

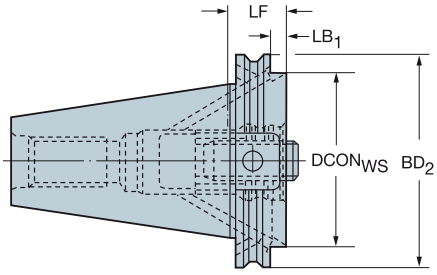
M1 N22 N15

# ISO 7388-1 to VL adapter




**Machine side interface compatible with DIN 69871-AD**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 80 | 1 | 1 | 390.140-50 80 027 | 80.0 | M24 | 27.0 | 7.9 | 97.5 | 20 | 180.0 | 2.88 |
| | | | | | *3.150* | | *1.063* | *.311* | *3.839* | *290* | | |




**Machine side interface compatible with DIN 69871-B**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 80 | 6 | 1 | 390.272-50 80 027 | 80.0 | M24 | 27.0 | 7.9 | 97.5 | 20 | 180.0 | 2.86 |
| | | | | | *3.150* | | *1.063* | *.311* | *3.839* | *290* | | |

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

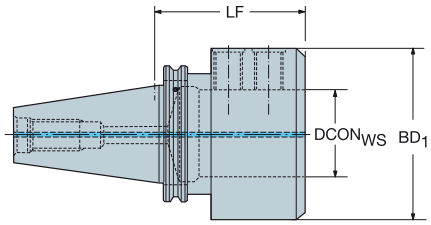
M1 N22 N15

# ISO 7388-1 to Weldon adapter

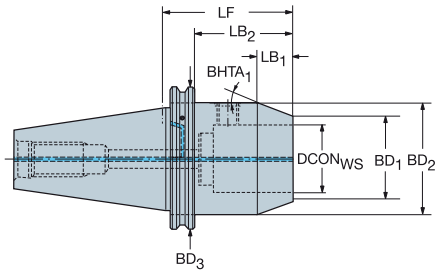
**Machine side interface compatible with DIN 69871-ADB**

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

DSGN 3




DSGN 6




## Metric bore

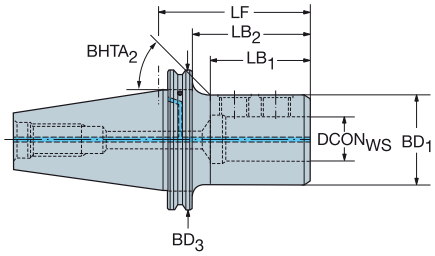
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 6 | 7 | 1 | 6 | A1B20-40 06 050 | 6.0 | M16 | 50.0 | 11.0 | 28.9 | 50.0 | 12.3 | 25.0 | 63.5 | 30° | 20 | 3.0 | 0.91 | 18000 |
| | | | | | | *.236* | | *1.969* | *.433* | *1.140* | *1.969* | *.484* | *.984* | *2.500* | | *290* | | | |
| | 6 | 7 | 1 | 6 | A1B20-40 06 100 | 6.0 | M16 | 100.0 | 11.0 | 78.9 | 100.0 | 12.3 | 25.0 | 63.5 | 30° | 20 | 3.0 | 1.06 | 18000 |
| | | | | | | *.236* | | *3.937* | *.433* | *3.108* | *3.937* | *.484* | *.984* | *2.500* | | *290* | | | |
| | 8 | 7 | 1 | 6 | A1B20-40 08 050 | 8.0 | M16 | 50.0 | 11.0 | 28.9 | 50.0 | 15.3 | 28.0 | 63.5 | 30° | 20 | 7.0 | 0.82 | 18000 |
| | | | | | | *.315* | | *1.969* | *.433* | *1.140* | *1.969* | *.602* | *1.102* | *2.500* | | *290* | | | |
| | 8 | 7 | 1 | 6 | A1B20-40 08 100 | 8.0 | M16 | 100.0 | 11.0 | 78.9 | 100.0 | 15.3 | 28.0 | 63.5 | 30° | 20 | 7.0 | 1.14 | 18000 |
| | | | | | | *.315* | | *3.937* | *.433* | *3.108* | *3.937* | *.602* | *1.102* | *2.500* | | *290* | | | |
| | 10 | 7 | 1 | 6 | A1B20-40 10 050 | 10.0 | M16 | 50.0 | 13.0 | 28.9 | 50.0 | 20.0 | 35.0 | 63.5 | 30° | 20 | 10.0 | 0.92 | 18000 |
| | | | | | | *.394* | | *1.969* | *.512* | *1.140* | *1.969* | *.787* | *1.378* | *2.500* | | *290* | | | |
| | 10 | 7 | 1 | 6 | A1B20-40 10 100 | 10.0 | M16 | 100.0 | 13.0 | 78.9 | 100.0 | 20.0 | 35.0 | 63.5 | 30° | 20 | 10.0 | 1.34 | 18000 |
| | | | | | | *.394* | | *3.937* | *.512* | *3.108* | *3.937* | *.787* | *1.378* | *2.500* | | *290* | | | |
| | 12 | 7 | 1 | 6 | A1B20-40 12 050 | 12.0 | M16 | 50.0 | 13.0 | 28.9 | 50.0 | 27.0 | 42.0 | 63.5 | 30° | 20 | 12.0 | 1.07 | 18000 |
| | | | | | | *.472* | | *1.969* | *.512* | *1.140* | *1.969* | *1.063* | *1.654* | *2.500* | | *290* | | | |
| | 12 | 7 | 1 | 6 | A1B20-40 12 100 | 12.0 | M16 | 100.0 | 13.0 | 78.9 | 100.0 | 27.0 | 42.0 | 63.5 | 30° | 20 | 12.0 | 1.57 | 18000 |
| | | | | | | *.472* | | *3.937* | *.512* | *3.108* | *3.937* | *1.063* | *1.654* | *2.500* | | *290* | | | |
| | 16 | 7 | 1 | 6 | A1B20-40 16 063 | 16.0 | M16 | 63.0 | 13.0 | 41.9 | 63.0 | 33.0 | 48.0 | 63.5 | 30° | 20 | 15.0 | 1.30 | 18000 |
| | | | | | | *.630* | | *2.480* | *.512* | *1.652* | *2.480* | *1.299* | *1.890* | *2.500* | | *290* | | | |
| | 16 | 7 | 1 | 6 | A1B20-40 16 100 | 16.0 | M16 | 100.0 | 13.0 | 78.9 | 100.0 | 33.0 | 48.0 | 63.5 | 30° | 20 | 15.0 | 1.79 | 18000 |
| | | | | | | *.630* | | *3.937* | *.512* | *3.108* | *3.937* | *1.299* | *1.890* | *2.500* | | *290* | | | |
| | 20 | 7 | 1 | 6 | A1B20-40 20 063 | 20.0 | M16 | 63.0 | 13.0 | 41.9 | 63.0 | 37.0 | 52.0 | 63.5 | 30° | 20 | 20.0 | 1.26 | 18000 |
| | | | | | | *.787* | | *2.480* | *.512* | *1.652* | *2.480* | *1.456* | *2.047* | *2.500* | | *290* | | | |
| | 20 | 7 | 1 | 6 | A1B20-40 20 100 | 20.0 | M16 | 100.0 | 13.0 | 78.9 | 100.0 | 37.0 | 52.0 | 63.5 | 30° | 20 | 20.0 | 1.89 | 18000 |
| | | | | | | *.787* | | *3.937* | *.512* | *3.108* | *3.937* | *1.456* | *2.047* | *2.500* | | *290* | | | |
| | 25 | 7 | 1 | 3 | A1B20-40 25 100 | 25.0 | M16 | 100.0 | 13.0 | 100.0 | | 50.0 | 65.0 | | 30° | 20 | 25.0 | 2.24 | 18000 |
| | | | | | | *.984* | | *3.937* | *.512* | *3.937* | | *1.968* | *2.559* | | | *290* | | | |
| | 32 | 7 | 1 | 3 | A1B20-40 32 100 | 32.0 | M16 | 100.0 | 12.0 | 100.0 | | 58.1 | 72.0 | | 30° | 20 | 45.0 | 2.54 | 18000 |
| | | | | | | *1.260* | | *3.937* | *.472* | *3.937* | | *2.289* | *2.835* | | | *290* | | | |
| 50.0 | 12 | 7 | 1 | 6 | A1B20-50 12 063 | 12.0 | M24 | 63.0 | 13.0 | 40.9 | 63.0 | 27.0 | 42.0 | 97.4 | 30° | 20 | 12.0 | 3.00 | 12000 |
| | | | | | | *.472* | | *2.480* | *.512* | *1.612* | *2.480* | *1.063* | *1.654* | *3.837* | | *290* | | | |
| | 16 | 7 | 1 | 6 | A1B20-50 16 063 | 16.0 | M24 | 63.0 | 13.0 | 40.9 | 63.0 | 33.0 | 48.0 | 97.4 | 30° | 20 | 15.0 | 3.20 | 12000 |
| | | | | | | *.630* | | *2.480* | *.512* | *1.612* | *2.480* | *1.299* | *1.890* | *3.837* | | *290* | | | |
| | 20 | 7 | 1 | 6 | A1B20-50 20 063 | 20.0 | M24 | 63.0 | 13.0 | 40.9 | 63.0 | 37.0 | 52.0 | 97.4 | 30° | 20 | 20.0 | 3.26 | 12000 |
| | | | | | | *.787* | | *2.480* | *.512* | *1.612* | *2.480* | *1.456* | *2.047* | *3.837* | | *290* | | | |
| | 20 | 7 | 1 | 6 | A1B20-50 20 100 | 20.0 | M24 | 100.0 | 13.0 | 77.9 | 100.0 | 37.0 | 52.0 | 97.4 | 30° | 20 | 20.0 | 3.87 | 12000 |
| | | | | | | *.787* | | *3.937* | *.512* | *3.069* | *3.937* | *1.456* | *2.047* | *3.837* | | *290* | | | |
| | 25 | 7 | 1 | 6 | A1B20-50 25 080 | 25.0 | M24 | 80.0 | 13.0 | 57.9 | 80.0 | 50.0 | 65.0 | 97.4 | 30° | 20 | 25.0 | 3.92 | 12000 |
| | | | | | | *.984* | | *3.150* | *.512* | *2.282* | *3.150* | *1.968* | *2.559* | *3.837* | | *290* | | | |
| | 25 | 7 | 1 | 6 | A1B20-50 25 100 | 25.0 | M24 | 100.0 | 13.0 | 77.9 | 100.0 | 50.0 | 65.0 | 97.4 | 30° | 20 | 25.0 | 4.45 | 12000 |
| | | | | | | *.984* | | *3.937* | *.512* | *3.069* | *3.937* | *1.968* | *2.559* | *3.837* | | *290* | | | |
| | 32 | 7 | 1 | 6 | A1B20-50 32 100 | 32.0 | M24 | 100.0 | 12.0 | 77.9 | 100.0 | 58.1 | 72.0 | 97.4 | 30° | 20 | 45.0 | 4.60 | 12000 |
| | | | | | | *1.260* | | *3.937* | *.472* | *3.069* | *3.937* | *2.289* | *2.835* | *3.837* | | *290* | | | |
| | 32 | 7 | 1 | 6 | A1B20-50 32 160 | 32.0 | M24 | 160.0 | 12.0 | 137.9 | 160.0 | 58.1 | 72.0 | 97.4 | 30° | 20 | 45.0 | 6.60 | 12000 |
| | | | | | | *1.260* | | *6.299* | *.472* | *5.431* | *6.299* | *2.289* | *2.835* | *3.837* | | *290* | | | |
| | 40 | 7 | 1 | 6 | A1B20-50 40 120 | 40.0 | M24 | 120.0 | 15.0 | 97.9 | 120.0 | 60.7 | 78.0 | 97.4 | 30° | 20 | 45.0 | 5.50 | 12000 |
| | | | | | | *1.575* | | *4.724* | *.591* | *3.856* | *4.724* | *2.389* | *3.071* | *3.837* | | *290* | | | |

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

M1 N22 N15

# ISO 7388-1 to ISO 9766 adapter

**Machine side interface compatible with DIN 69871-ADB**

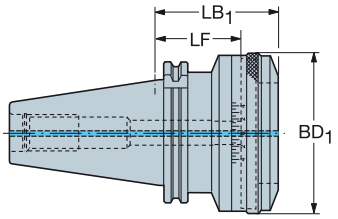



**Metric bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 16 | 7 | 1 | A1B27-40 16 080 | 16.0 | M16 | 49 | 80.0 | 55.9 | 36.0 | 63.5 | 20 | 10.0 | 1.21 | 18000 |
| | | | | | *.630* | | *1.949* | *3.150* | *2.203* | *1.417* | *2.500* | *290* | | | |
| | 20 | 7 | 1 | A1B27-40 20 080 | 20.0 | M16 | 51 | 80.0 | 55.9 | 40.0 | 63.5 | 20 | 12.0 | 1.27 | 18000 |
| | | | | | *.787* | | *2.028* | *3.150* | *2.203* | *1.575* | *2.500* | *290* | | | |
| | 25 | 7 | 1 | A1B27-40 25 085 | 25.0 | M16 | 57 | 85.0 | 64.9 | 45.0 | 63.5 | 20 | 20.0 | 1.38 | 18000 |
| | | | | | *.984* | | *2.264* | *3.346* | *2.557* | *1.772* | *2.500* | *290* | | | |
| | 32 | 7 | 1 | A1B27-40 32 090 | 32.0 | M16 | 61 | 90.0 | 69.9 | 52.0 | 63.5 | 20 | 30.0 | 1.50 | 18000 |
| | | | | | *1.260* | | *2.421* | *3.543* | *2.754* | *2.047* | *2.500* | *290* | | | |
| 50.0 | 16 | 7 | 1 | A1B27-50 16 080 | 16.0 | M24 | 49 | 80.0 | 59.9 | 36.0 | 97.5 | 20 | 10.0 | 3.16 | 12000 |
| | | | | | *.630* | | *1.949* | *3.150* | *2.360* | *1.417* | *3.837* | *290* | | | |
| | 20 | 7 | 1 | A1B27-50 20 080 | 20.0 | M24 | 51 | 80.0 | 59.9 | 40.0 | 97.5 | 20 | 12.0 | 3.20 | 12000 |
| | | | | | *.787* | | *2.028* | *3.150* | *2.360* | *1.575* | *3.837* | *290* | | | |
| | 25 | 7 | 1 | A1B27-50 25 085 | 25.0 | M24 | 57 | 85.0 | 64.9 | 45.0 | 97.5 | 20 | 20.0 | 3.36 | 12000 |
| | | | | | *.984* | | *2.264* | *3.346* | *2.557* | *1.772* | *3.837* | *290* | | | |
| | 32 | 7 | 1 | A1B27-50 32 090 | 32.0 | M24 | 61 | 90.0 | 69.9 | 52.0 | 97.5 | 20 | 30.0 | 3.52 | 12000 |
| | | | | | *1.260* | | *2.421* | *3.543* | *2.754* | *2.047* | *3.837* | *290* | | | |
| | 40 | 7 | 1 | A1B27-50 40 090 | 40.0 | M24 | 71 | 90.0 | 69.9 | 75.0 | 97.5 | 20 | 40.0 | 4.40 | 12000 |
| | | | | | *1.575* | | *2.815* | *3.543* | *2.754* | *2.953* | *3.837* | *290* | | | |
| | 50 | 7 | 1 | A1B27-50 50 100 | 50.0 | M24 | 81 | 100.0 | 79.9 | 75.0 | 97.5 | 20 | 45.0 | 4.22 | 12000 |
| | | | | | *1.969* | | *3.209* | *3.937* | *3.148* | *2.953* | *3.837* | *290* | | | |

# ISO 7388-1 to ISO 9766 adjustable adapter

**Machine side interface compatible with DIN 69871-AD**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_1$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 1 | 1 | 1 | 392.140277-40 01 055A | 78.0 | M16 | 55.0 | 79.6 | 86.0 | 20 | 2.26 | 12000 |
| | | | | | *3.071* | | *2.165* | *3.134* | *3.386* | *290* | | |
| 50.0 | 2 | 1 | 1 | 392.140277-50 02 055A | 98.0 | M24 | 55.0 | 79.6 | 106.0 | 20 | 5.16 | 9000 |
| | | | | | *3.858* | | *2.165* | *3.134* | *4.173* | *290* | | |
| | 3 | 1 | 1 | 392.140277-50 03 075A | 136.0 | M24 | 75.0 | 85.0 | 140.0 | 20 | 7.03 | 6000 |
| | | | | | *5.354* | | *2.953* | *3.346* | *5.512* | *290* | | |

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

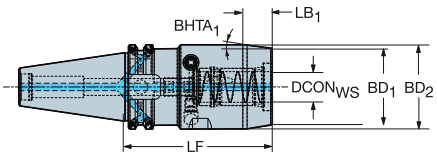
M1 N22 N15

# ISO 7388-1 to CoroChuck™ 930

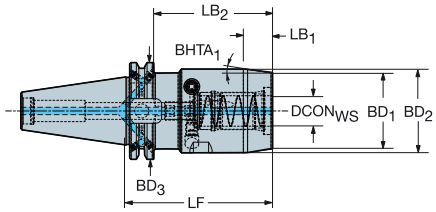
**Machine side interface compatible with DIN 69871-ADB**

**Metric bore**

DSGN 3




DSGN 6




**Heavy-duty design**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 20 | 7 | 1 | 6 | 930-I40-HD-20-097 | 20.0 | M16 | 51 | 97.0 | 17.8 | 77.9 | 97.0 | 50.0 | 55.0 | 63.5 | 8° | 80 | 10.0 | 2.03 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.819* | *.701* | *3.067* | *3.819* | *1.969* | *2.165* | *2.500* | | *1160* | | | |
| | 25 | 7 | 1 | 3 | 930-I40-HD-25-103 | 25.0 | M16 | 57 | 103.0 | 18.8 | 103.0 | | 57.0 | 65.0 | | 12° | 80 | 10.0 | 2.48 | 18000 |
| | | | | | | *.984* | | *2.244* | *4.055* | *.740* | *4.055* | | *2.244* | *2.559* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 6 | 930-I50-HD-20-083 | 20.0 | M24 | 51 | 83.0 | 17.8 | 63.9 | 83.0 | 50.0 | 55.0 | 97.4 | 8° | 80 | 10.0 | 3.68 | 12000 |
| | | | | | | *.787* | | *2.008* | *3.268* | *.701* | *2.516* | *3.268* | *1.969* | *2.165* | *3.835* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | 930-I50-HD-25-087 | 25.0 | M24 | 57 | 87.0 | 18.8 | 67.9 | 87.0 | 57.0 | 65.0 | 97.4 | 12° | 80 | 10.0 | 4.13 | 12000 |
| | | | | | | *.984* | | *2.244* | *3.425* | *.740* | *2.673* | *3.425* | *2.244* | *2.559* | *3.835* | | *1160* | | | |
| | 32 | 7 | 1 | 6 | 930-I50-HD-32-077 | 32.0 | M24 | 61 | 77.0 | 18.8 | 57.9 | 77.0 | 68.0 | 76.0 | 97.4 | 12° | 80 | 10.0 | 4.24 | 12000 |
| | | | | | | *1.260* | | *2.402* | *3.032* | *.740* | *2.280* | *3.032* | *2.677* | *2.992* | *3.835* | | *1160* | | | |
| | 32 | 7 | 1 | 6 | 930-I50-HD-32-170 | 32.0 | M24 | 61 | 170.0 | 18.8 | 150.9 | 170.0 | 68.0 | 76.0 | 97.4 | 12° | 80 | 10.0 | 7.43 | 12000 |
| | | | | | | *1.260* | | *2.402* | *6.693* | *.740* | *5.941* | *6.693* | *2.677* | *2.992* | *3.835* | | *1160* | | | |

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

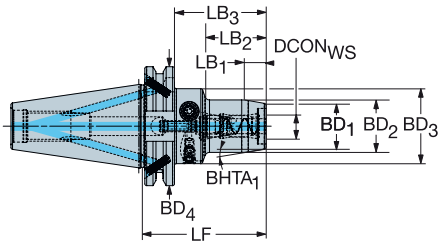
M1 N22 N6 N15 N4

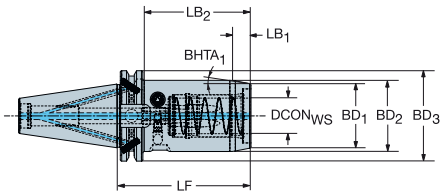
# ISO 7388-1 to CoroChuck™ 930

**Machine side interface compatible with DIN 69871-ADB**

**Metric bore**

DSGN 10 6




**Slender design**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | | | | RPMX |
| 40.0 | 6 | 7 | 1 | 10 | **930-I40-S-06-068** | 6.0 | M16 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 22.0 | 26.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.06 | 18000 |
| | | | | | | *.236* | | *1.457* | *2.677* | *.445* | *1.189* | *1.925* | *.866* | *1.024* | *1.575* | *2.500* | | *1160* | | | |
| | 8 | 7 | 1 | 10 | **930-I40-S-08-068** | 8.0 | M16 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 24.0 | 28.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.07 | 18000 |
| | | | | | | *.315* | | *1.457* | *2.677* | *.445* | *1.189* | *1.925* | *.945* | *1.102* | *1.575* | *2.500* | | *1160* | | | |
| | 10 | 7 | 1 | 10 | **930-I40-S-10-072** | 10.0 | M16 | 41 | 72.0 | 11.3 | 34.2 | 52.9 | 26.0 | 30.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.11 | 18000 |
| | | | | | | *.394* | | *1.614* | *2.835* | *.445* | *1.346* | *2.083* | *1.024* | *1.181* | *1.575* | *2.500* | | *1160* | | | |
| | 12 | 7 | 1 | 10 | **930-I40-S-12-080** | 12.0 | M16 | 46 | 80.0 | 11.3 | 38.2 | 60.9 | 28.0 | 32.0 | 50.0 | 63 | 10° | 80 | 8.0 | 1.32 | 18000 |
| | | | | | | *.472* | | *1.811* | *3.150* | *.445* | *1.504* | *2.398* | *1.102* | *1.260* | *1.969* | *2.500* | | *1160* | | | |
| | 20 | 7 | 1 | 10 | **930-I40-S-20-090** | 20.0 | M16 | 51 | 90.0 | 16.0 | 49.2 | 70.9 | 38.0 | 42.0 | 50.0 | 63 | 7° | 80 | 8.0 | 1.50 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.543* | *.630* | *1.937* | *2.791* | *1.496* | *1.654* | *1.969* | *2.500* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | **930-I40-S-25-095** | 25.0 | M16 | 57 | 95.0 | 12.9 | 75.0 | 95.0 | 45.0 | 50.0 | 50.0 | 63 | 11° | 80 | 8.0 | 1.71 | 18000 |
| | | | | | | *.984* | | *2.244* | *3.740* | *.508* | *2.953* | *3.740* | *1.772* | *1.969* | *1.969* | *2.500* | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 10 | **930-I50-S-20-089** | 20.0 | M24 | 51 | 89.0 | 16.0 | 49.2 | 69.9 | 38.0 | 42.0 | 50.0 | 97 | 7° | 80 | 8.0 | 3.34 | 12000 |
| | | | | | | *.787* | | *2.008* | *3.504* | *.630* | *1.937* | *2.752* | *1.496* | *1.654* | *1.969* | *3.837* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | **930-I50-S-25-095** | 25.0 | M24 | 57 | 95.0 | 12.9 | 73.5 | 95.0 | 45.0 | 50.0 | 50.0 | 97 | 11° | 80 | 8.0 | 3.57 | 12000 |
| | | | | | | *.984* | | *2.244* | *3.740* | *.508* | *2.894* | *3.740* | *1.772* | *1.969* | *1.969* | *3.835* | | *1160* | | | |

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

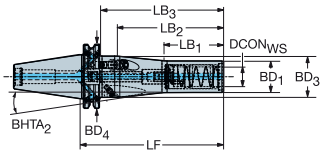
M1 N22 N6 N15 N4

# ISO 7388-1 to CoroChuck™ 930

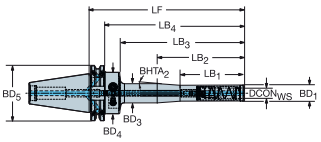
**Machine side interface compatible with DIN 69871-ADB**

**Metric bore**

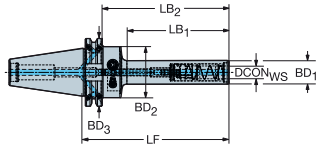
DSGN 11




17




5




**Pencil design**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_2$ | | | | RPMX |
| 40.0 | 8 | 7 | 1 | 5 | **930-I40-P-08-088** | 8.0 | M16 | 37 | 88.0 | 45.8 | 66.5 | 88.0 | 17.5 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.04 | 18000 |
| | | | | | | *.315* | | *1.457* | *3.465* | *1.803* | *2.618* | *3.465* | *.689* | *1.575* | *2.500* | | | *1160* | | | |
| | 10 | 7 | 1 | 5 | **930-I40-P-10-098** | 10.0 | M16 | 41 | 98.0 | 55.8 | 76.5 | 98.0 | 20.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.09 | 18000 |
| | | | | | | *.394* | | *1.614* | *3.858* | *2.197* | *3.012* | *3.858* | *.787* | *1.575* | *2.500* | | | *1160* | | | |
| | 10 | 7 | 1 | 5 | **930-I40-P-10-138** | 10.0 | M16 | 41 | 138.0 | 95.8 | 116.5 | 138.0 | 20.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.18 | 18000 |
| | | | | | | *.394* | | *1.614* | *5.433* | *3.772* | *4.587* | *5.433* | *.787* | *1.575* | *2.500* | | | *1160* | | | |
| | 12 | 7 | 1 | 5 | **930-I40-P-12-103** | 12.0 | M16 | 46 | 103.0 | 60.8 | 83.9 | 103.0 | 22.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.17 | 18000 |
| | | | | | | *.472* | | *1.811* | *4.055* | *2.394* | *3.303* | *4.055* | *.866* | *1.575* | *2.500* | | | *1160* | | | |
| | 12 | 7 | 1 | 5 | **930-I40-P-12-138** | 12.0 | M16 | 46 | 138.0 | 95.8 | 118.9 | 138.0 | 22.0 | 40.0 | 63.5 | | 0° | 80 | 8.0 | 1.27 | 18000 |
| | | | | | | *.472* | | *1.811* | *5.433* | *3.772* | *4.681* | *5.433* | *.866* | *1.575* | *2.500* | | | *1160* | | | |
| | 12 | 7 | 1 | 17 | **930-I40-P-12-188** | 12.0 | M16 | 46 | 188.0 | 50.0 | 75.0 | 145.8 | 22.0 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 1.57 | 18000 |
| | | | | | | *.472* | | *1.811* | *7.402* | *1.969* | *2.953* | *5.740* | *.866* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| | 20 | 7 | 1 | 11 | **930-I40-P-20-145** | 20.0 | M16 | 51 | 145.0 | 60.0 | 108.0 | 125.9 | 32.0 | 32.0 | 42.0 | 63 | 6° | 80 | 8.0 | 1.68 | 18000 |
| | | | | | | *.787* | | *2.008* | *5.709* | *2.362* | *4.252* | *4.957* | *1.260* | *1.260* | *1.654* | *2.500* | | *1160* | | | |

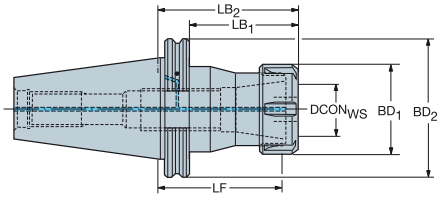
For spare parts, visit www.sandvik.coromant.com

M1 N22 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, inch | | | | | | | BAR PSI | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | | | RPMX |
| 40.0 | ER16 | 7 | 1 | **A1B14-40 16 070** | 17.0 | M16 | 59.7 | 50.9 | 70.0 | 28.0 | 63.5 | 80 | 0.97 | 18000 |
| | | | | | *.669* | | *2.352* | *2.004* | *2.756* | *1.102* | *2.500* | *1160* | | |
| | ER16 | 7 | 1 | **A1B14-40 16 100** | 17.0 | M16 | 89.7 | 80.9 | 100.0 | 28.0 | 63.5 | 80 | 1.12 | 18000 |
| | | | | | *.669* | | *3.533* | *3.185* | *3.937* | *1.102* | *2.500* | *1160* | | |
| | ER20 | 7 | 1 | **A1B14-40 20 070** | 21.0 | M16 | 58.8 | 50.9 | 70.0 | 34.0 | 63.5 | 80 | 1.02 | 18000 |
| | | | | | *.827* | | *2.317* | *2.004* | *2.756* | *1.339* | *2.500* | *1160* | | |
| | ER20 | 7 | 1 | **A1B14-40 20 100** | 21.0 | M16 | 88.8 | 80.9 | 100.0 | 34.0 | 63.5 | 80 | 1.25 | 18000 |
| | | | | | *.827* | | *3.498* | *3.185* | *3.937* | *1.339* | *2.500* | *1160* | | |
| | ER25 | 7 | 1 | **A1B14-40 25 070** | 26.0 | M16 | 58.3 | 50.9 | 70.0 | 42.0 | 63.5 | 80 | 1.13 | 18000 |
| | | | | | *1.024* | | *2.297* | *2.004* | *2.756* | *1.654* | *2.500* | *1160* | | |
| | ER25 | 7 | 1 | **A1B14-40 25 100** | 26.0 | M16 | 88.3 | 80.9 | 100.0 | 42.0 | 63.5 | 80 | 1.44 | 18000 |
| | | | | | *1.024* | | *3.478* | *3.185* | *3.937* | *1.654* | *2.500* | *1160* | | |
| | ER32 | 7 | 1 | **A1B14-40 32 070** | 33.0 | M16 | 57.3 | 50.9 | 70.0 | 50.0 | 63.5 | 80 | 1.18 | 18000 |
| | | | | | *1.299* | | *2.257* | *2.004* | *2.756* | *1.969* | *2.500* | *1160* | | |
| | ER40 | 7 | 1 | **A1B14-40 40 070** | 41.0 | M16 | 55.3 | 50.9 | 70.0 | 63.0 | 63.5 | 80 | 1.25 | 18000 |
| | | | | | *1.614* | | *2.179* | *2.004* | *2.756* | *2.480* | *2.500* | *1160* | | |
| 50.0 | ER20 | 7 | 1 | **A1B14-50 20 070** | 21.0 | M24 | 58.8 | 50.9 | 70.0 | 34.0 | 97.5 | 80 | 2.96 | 12000 |
| | | | | | *.827* | | *2.317* | *2.004* | *2.756* | *1.339* | *3.837* | *1160* | | |
| | ER20 | 7 | 1 | **A1B14-50 20 100** | 21.0 | M24 | 88.8 | 80.9 | 100.0 | 34.0 | 97.5 | 80 | 3.23 | 12000 |
| | | | | | *.827* | | *3.498* | *3.185* | *3.937* | *1.339* | *3.837* | *1160* | | |
| | ER25 | 7 | 1 | **A1B14-50 25 070** | 26.0 | M24 | 58.3 | 50.9 | 70.0 | 42.0 | 97.5 | 80 | 3.02 | 12000 |
| | | | | | *1.024* | | *2.297* | *2.004* | *2.756* | *1.654* | *3.837* | *1160* | | |
| | ER25 | 7 | 1 | **A1B14-50 25 100** | 26.0 | M24 | 88.3 | 80.9 | 100.0 | 42.0 | 97.5 | 80 | 3.45 | 12000 |
| | | | | | *1.024* | | *3.478* | *3.185* | *3.937* | *1.654* | *3.837* | *1160* | | |
| | ER32 | 7 | 1 | **A1B14-50 32 070** | 33.0 | M24 | 57.3 | 50.9 | 70.0 | 50.0 | 97.5 | 80 | 3.08 | 12000 |
| | | | | | *1.299* | | *2.257* | *2.004* | *2.756* | *1.969* | *3.837* | *1160* | | |
| | ER32 | 7 | 1 | **A1B14-50 32 100** | 33.0 | M24 | 87.3 | 80.9 | 100.0 | 50.0 | 97.5 | 80 | 3.58 | 12000 |
| | | | | | *1.299* | | *3.439* | *3.185* | *3.937* | *1.969* | *3.837* | *1160* | | |
| | ER40 | 7 | 1 | **A1B14-50 40 070** | 41.0 | M24 | 55.3 | 50.9 | 70.0 | 63.0 | 97.5 | 80 | 3.20 | 12000 |
| | | | | | *1.614* | | *2.179* | *2.004* | *2.756* | *2.480* | *3.837* | *1160* | | |

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

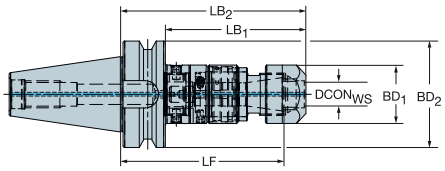
M1 N22 N15

# ISO 7388.1 to CoroChuck™ 970

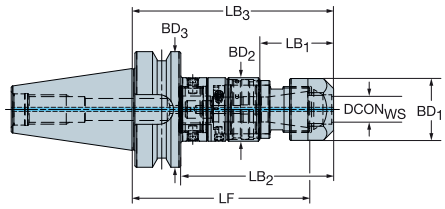
**Machine side interface compatible with DIN 69871-AD**

**Workpiece side interface DIN 6499-B**

DSGN 2




5

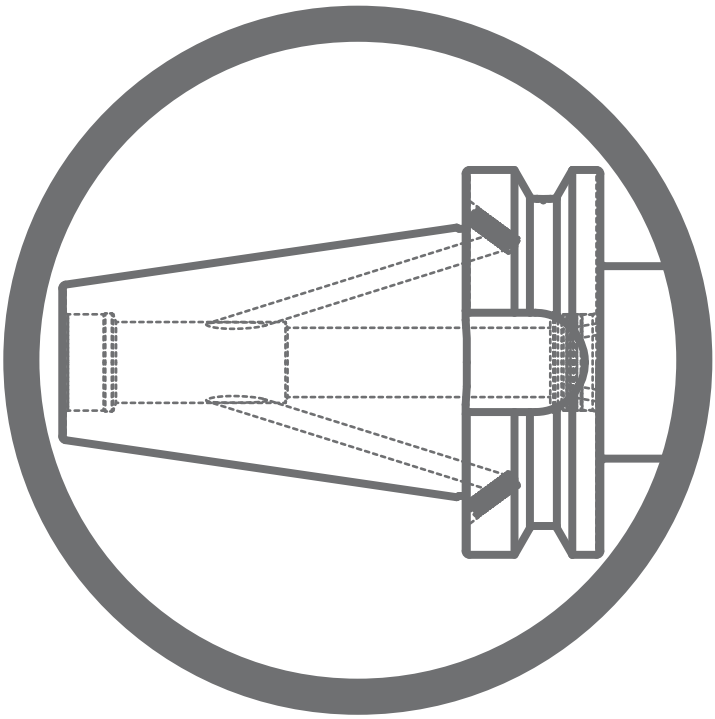



| CZC$_{MS}$ | CZC$_{WS}$ | TRMAX | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | ER20 | M12 | 1 | 1 | 5 | **970-I40-20-102** | 20.8 | M16 | 89.2 | 35.3 | 78.1 | 97.2 | 33.7 | 35.0 | 63.5 | 80 | 1.26 | 8000 |
| | | | | | | | *.819* | | *3.512* | *1.390* | *3.075* | *3.827* | *1.327* | *1.378* | *2.500* | *1160* | | |
| | ER25 | M20 | 1 | 1 | 5 | **970-I40-25-122** | 25.8 | M16 | 108.1 | 37.1 | 97.5 | 116.6 | 42.0 | 44.0 | 63.5 | 80 | 1.63 | 8000 |
| | | | | | | | *1.016* | | *4.256* | *1.461* | *3.839* | *4.591* | *1.654* | *1.732* | *2.500* | *1160* | | |
| | ER32 | M20 | 1 | 1 | 2 | **970-I40-32-125** | 32.8 | M16 | 115.8 | 106.2 | 125.3 | | 50.0 | 63.5 | | 80 | 1.58 | 8000 |
| | | | | | | | *1.291* | | *4.559* | *4.181* | *4.933* | | *1.969* | *2.500* | | *1160* | | |
| 50.0 | ER20 | M12 | 1 | 1 | 5 | **970-I50-20-106** | 20.8 | M24 | 93.2 | 35.3 | 82.1 | 101.2 | 33.7 | 35.0 | 97.5 | 80 | 3.12 | 8000 |
| | | | | | | | *.819* | | *3.669* | *1.390* | *3.232* | *3.984* | *1.327* | *1.378* | *3.839* | *1160* | | |
| | ER25 | M20 | 1 | 1 | 5 | **970-I50-25-126** | 25.8 | M24 | 112.1 | 37.1 | 101.5 | 120.6 | 42.0 | 44.0 | 97.5 | 80 | 3.75 | 8000 |
| | | | | | | | *1.016* | | *4.413* | *1.461* | *3.996* | *4.748* | *1.654* | *1.732* | *3.839* | *1160* | | |
| | ER32 | M20 | 1 | 1 | 2 | **970-I50-32-129** | 32.8 | M24 | 119.8 | 110.2 | 129.3 | | 50.0 | 97.5 | | 80 | 3.36 | 8000 |
| | | | | | | | *1.291* | | *4.717* | *4.339* | *5.091* | | *1.969* | *3.837* | | *1160* | | |
| | ER40 | M30 | 1 | 1 | 2 | **970-I50-40-155** | 40.8 | M24 | 138.2 | 130.6 | 149.6 | | 63.0 | 97.5 | | 80 | 4.94 | 8000 |
| | | | | | | | *1.606* | | *5.441* | *5.142* | *5.890* | | *2.480* | *3.839* | | *1160* | | |

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

M1 N22 N15 N5

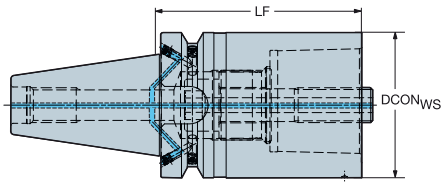
# Machine side interface MAS-BT



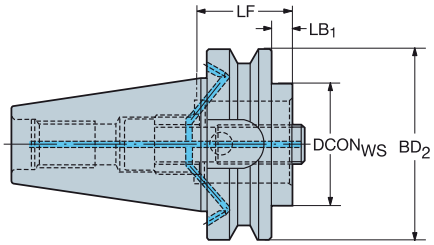
# MAS-BT 403 to Coromant Capto® adapter

**Machine side interface compatible with JIS B 6339**

DSGN 1




2




| | | | | | | Dimensions, mm, inch | | | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $BD_2$ | | | |
| 30.0 | C3 | 1 | 1 | 2 | C3-390.55-30 030 | 32.0 | M12 | 30.0 | 8.0 | 30.0 | 46.0 | 80 | 45.0 | 0.42 |
| | | | | | | *1.260* | | *1.181* | *.315* | *1.181* | *1.811* | *1160* | | |
| | C3 | 1 | 1 | 2 | C3-390.55-30 060 | 32.0 | M12 | 60.0 | 38.0 | 60.0 | 46.0 | 80 | 45.0 | 0.58 |
| | | | | | | *1.260* | | *2.362* | *1.496* | *2.362* | *1.811* | *1160* | | |
| | C4 | 1 | 1 | 2 | C4-390.55-30 060 | 40.0 | M12 | 60.0 | 38.0 | 60.0 | 46.0 | 80 | 55.0 | 0.67 |
| | | | | | | *1.575* | | *2.362* | *1.496* | *2.362* | *1.811* | *1160* | | |
| | C5 | 1 | 1 | 1 | C5-390.55-30 080 | 50.0 | M12 | 80.0 | 80.0 | | | 80 | 95.0 | 1.07 |
| | | | | | | *1.969* | | *3.150* | *3.150* | | | *1160* | | |
| 40.0 | C3 | 7 | 1 | 2 | C3-390B.55-40 030 | 32.0 | M16 | 30.0 | 3.0 | 30.0 | 63.0 | 80 | 45.0 | 0.99 |
| | | | | | | *1.260* | | *1.181* | *.118* | *1.181* | *2.480* | *1160* | | |
| | C3 | 7 | 1 | 2 | C3-390B.55-40 060 | 32.0 | M16 | 60.0 | 33.0 | 60.0 | 63.0 | 80 | 45.0 | 1.14 |
| | | | | | | *1.260* | | *2.362* | *1.299* | *2.362* | *2.480* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.55-40 030 | 40.0 | M16 | 30.0 | 3.0 | 30.0 | 63.0 | 80 | 55.0 | 0.95 |
| | | | | | | *1.575* | | *1.181* | *.118* | *1.181* | *2.480* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.55-40 060 | 40.0 | M16 | 60.0 | 33.0 | 60.0 | 63.0 | 80 | 55.0 | 1.21 |
| | | | | | | *1.575* | | *2.362* | *1.299* | *2.362* | *2.480* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.55-40 050 | 50.0 | M16 | 50.0 | 23.0 | 50.0 | 63.0 | 80 | 95.0 | 1.15 |
| | | | | | | *1.969* | | *1.969* | *.906* | *1.969* | *2.480* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.55-40 090 | 50.0 | M16 | 90.0 | 63.0 | 90.0 | 63.0 | 80 | 95.0 | 1.72 |
| | | | | | | *1.969* | | *3.543* | *2.480* | *3.543* | *2.480* | *1160* | | |
| | C6 | 7 | 1 | 1 | C6-390B.55-40 075 | 63.0 | M16 | 75.0 | 75.0 | | | 80 | 170.0 | 1.74 |
| | | | | | | *2.480* | | *2.953* | *2.953* | | | *1160* | | |
| 50.0 | C3 | 7 | 1 | 2 | C3-390B.58-50 040 | 32.0 | M24 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 45.0 | 3.68 |
| | | | | | | *1.260* | | *1.575* | *.079* | *1.575* | *3.937* | *1160* | | |
| | C3 | 7 | 1 | 2 | C3-390B.58-50 070 | 32.0 | M24 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 45.0 | 3.80 |
| | | | | | | *1.260* | | *2.756* | *1.260* | *2.756* | *3.937* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.58-50 040 | 40.0 | M24 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 55.0 | 3.65 |
| | | | | | | *1.575* | | *1.575* | *.079* | *1.575* | *3.937* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-390B.58-50 070 | 40.0 | M24 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 55.0 | 3.88 |
| | | | | | | *1.575* | | *2.756* | *1.260* | *2.756* | *3.937* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.58-50 040 | 50.0 | M24 | 40.0 | 2.0 | 40.0 | 100.0 | 80 | 95.0 | 3.56 |
| | | | | | | *1.969* | | *1.575* | *.079* | *1.575* | *3.937* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-390B.58-50 080 | 50.0 | M24 | 80.0 | 42.0 | 80.0 | 100.0 | 80 | 95.0 | 4.09 |
| | | | | | | *1.969* | | *3.150* | *1.654* | *3.150* | *3.937* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390B.58-50 050 | 63.0 | M24 | 50.0 | 12.0 | 50.0 | 100.0 | 80 | 170.0 | 3.61 |
| | | | | | | *2.480* | | *1.969* | *.472* | *1.969* | *3.937* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-390B.58-50 100 | 63.0 | M24 | 100.0 | 62.0 | 100.0 | 100.0 | 80 | 170.0 | 4.71 |
| | | | | | | *2.480* | | *3.937* | *2.441* | *3.937* | *3.937* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-390B.58-50 070 | 80.0 | M24 | 70.0 | 32.0 | 70.0 | 100.0 | 80 | 170.0 | 4.12 |
| | | | | | | *3.150* | | *2.756* | *1.260* | *2.756* | *3.937* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-390B.58-50 120 | 80.0 | M24 | 120.0 | 72.0 | 120.0 | 100.0 | 80 | 170.0 | 5.98 |
| | | | | | | *3.150* | | *4.724* | *2.835* | *4.724* | *3.937* | *1160* | | |
| | C10 | 7 | 1 | 1 | C10-390B.58-50 140 | 100.0 | M24 | 140.0 | 140.0 | | | 80 | 380.0 | 8.00 |
| | | | | | | *3.937* | | *5.512* | *5.512* | | | *1160* | | |
| 60.0 | C8 | 1 | 1 | 2 | C8-390.58-60 120 | 80.0 | M30 | 120.0 | 72.0 | 120.0 | 155.0 | 80 | 170.0 | 15.14 |
| | | | | | | *3.150* | | *4.724* | *2.835* | *4.724* | *6.102* | *1160* | | |
| | C10 | 1 | 1 | 2 | C10-390.58-60 080 | 100.0 | M30 | 80.0 | 32.0 | 80.0 | 155.0 | 80 | 380.0 | 13.30 |
| | | | | | | *3.937* | | *3.150* | *1.260* | *3.150* | *6.102* | *1160* | | |

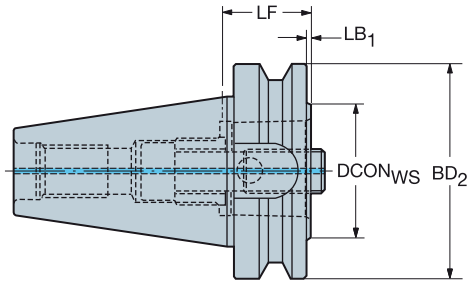
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

## MAS-BT 403 to Coromant Capto® adapter

**90° rotated polygon for precision tool tip control**

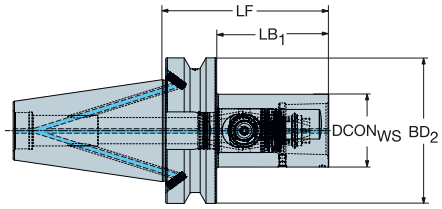
**Designed for Mazak™ e-machine and Mori Seiki NT Series**




| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_2$ | BAR PSI | NM | KG |
| 40.0 | C5 | 1 | 1 | **C5-390.605-40 030** | 50.0 | M16 | 30.0 | 3.0 | 63.0 | 80 | 95.0 | 0.88 |
| | | | | | *1.969* | | *1.181* | *.118* | *2.480* | *1160* | | |
| 50.0 | C6 | 1 | 1 | **C6-390.605-50 040** | 63.0 | M24 | 40.0 | 2.0 | 100.0 | 80 | 170.0 | 3.26 |
| | | | | | *2.480* | | *1.575* | *.079* | *3.937* | *1160* | | |
| | C8 | 1 | 1 | **C8-390.605-50 070** | 80.0 | M24 | 70.0 | 32.0 | 100.0 | 80 | 170.0 | 4.14 |
| | | | | | *3.150* | | *2.756* | *1.260* | *3.937* | *1160* | | |

## MAS-BT 403 to Coromant Capto® adapter with Quick change

**Machine side interface compatible with JIS B 6339**




**Metric bore**

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_2$ | BAR PSI | NM | KG |
| 50.0 | C5 | 7 | 1 | **B50-QC-C5-115** | 50.0 | M24 | 115.0 | 76.0 | 100.0 | 80 | 70.0 | 4.55 |
| | | | | | *1.969* | | *4.528* | *2.992* | *3.937* | *1160* | | |
| | C6 | 7 | 1 | **B50-QC-C6-135** | 63.0 | M24 | 135.0 | 96.0 | 100.0 | 80 | 90.0 | 5.49 |
| | | | | | *2.480* | | *5.315* | *3.780* | *3.937* | *1160* | | |
| | C8 | 7 | 1 | **B50-QC-C8-150** | 80.0 | M24 | 150.0 | 111.0 | 100.0 | 80 | 130.0 | 6.91 |
| | | | | | *3.150* | | *5.906* | *4.370* | *3.937* | *1160* | | |

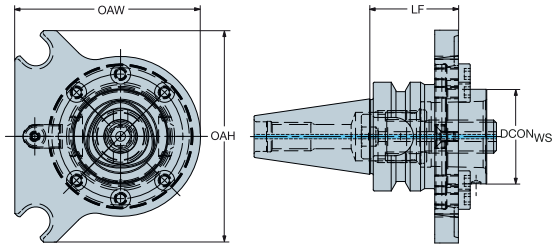
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

# MAS-BT 403 to Coromant Capto® turning adapter

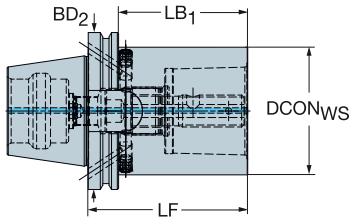
**For Brother Speedio mill-turn**

**Internal coolant supply**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | LF | OAW | OAH | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 30 | C4 | 1 | 1 | C4-390.680-30 050Y | 40 | 50 | 77 | 90 | 80 | 55 | 1.013 |
| | | | | | 1.575 | 1.969 | 3.032 | 3.543 | 1160 | | |

# MAS-BT short cone to Coromant Capto® adapter




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | LF | LB$_1$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | C8 | 6 | 1 | C8-390.670-50 100 | 80.0 | 100.0 | 62.0 | 100.0 | 150 | 170.0 | 4.43 |
| | | | | | *3.150* | *3.937* | *2.441* | *3.937* | *2175* | | |

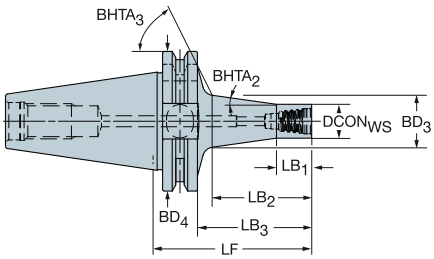
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

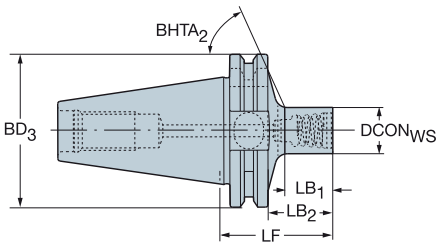
# MAS-BT 403 to Coromant EH adapter

**Machine side interface compatible with JIS B 6339**

DSGN 15




7




## Metric version

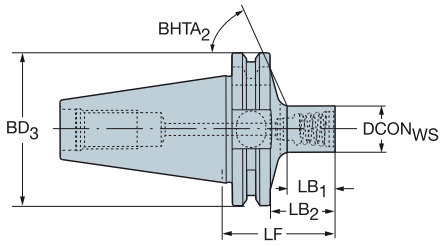
| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_3$ | $BD_4$ | $BHTA_2$ | $BHTA_3$ | BAR PSI | NM | KG | RPMX |
| 30.0 | E10 | 1 | 1 | 7 | **392.55EH-30 10 044** | 9.6 | M12 | 44.0 | 13.3 | 22.0 | 44.0 | 46.0 | | 65° | 0° | 80 | 12.0 | 0.51 | 25000 |
| | | | | | | *.378* | | *1.732* | *.524* | *.866* | *1.732* | *1.811* | | | | *1160* | | | |
| | E10 | 1 | 1 | 15 | **392.55EH-30 10 057** | 9.6 | M12 | 57.0 | 10.0 | 27.6 | 35.0 | 14.6 | 46 | 7° | 65° | 80 | 12.0 | 0.51 | 25000 |
| | | | | | | *.378* | | *2.244* | *.394* | *1.087* | *1.378* | *.575* | *1.811* | | | *1160* | | | |
| | E12 | 1 | 1 | 7 | **392.55EH-30 12 046** | 11.6 | M12 | 46.0 | 15.6 | 24.0 | 46.0 | 46.0 | | 64° | 0° | 80 | 15.0 | 0.52 | 25000 |
| | | | | | | *.457* | | *1.811* | *.614* | *.945* | *1.811* | *1.811* | | | | *1160* | | | |
| | E12 | 1 | 1 | 15 | **392.55EH-30 12 063** | 11.6 | M12 | 63.0 | 12.0 | 34.1 | 41.0 | 17.8 | 46 | 8° | 64° | 80 | 15.0 | 0.54 | 25000 |
| | | | | | | *.457* | | *2.480* | *.472* | *1.343* | *1.614* | *.701* | *1.811* | | | *1160* | | | |
| | E16 | 1 | 1 | 7 | **392.55EH-30 16 041** | 15.4 | M12 | 41.3 | 8.0 | 19.3 | 41.3 | 46.0 | | 49° | 0° | 80 | 30.0 | 0.57 | 25000 |
| | | | | | | *.606* | | *1.626* | *.315* | *.760* | *1.626* | *1.811* | | | | *1160* | | | |
| | E16 | 1 | 1 | 7 | **392.55EH-30 16 052** | 15.4 | M12 | 52.0 | 22.1 | 30.0 | 52.0 | 46.0 | | 63° | 0° | 80 | 30.0 | 0.58 | 25000 |
| | | | | | | *.606* | | *2.047* | *.870* | *1.181* | *2.047* | *1.811* | | | | *1160* | | | |
| | E16 | 1 | 1 | 7 | **392.55EH-30 16 056** | 15.4 | M12 | 56.3 | 16.0 | 34.3 | 56.3 | 46.0 | | 35° | 0° | 80 | 30.0 | 0.61 | 25000 |
| | | | | | | *.606* | | *2.217* | *.630* | *1.350* | *2.217* | *1.811* | | | | *1160* | | | |
| | E16 | 1 | 1 | 15 | **392.55EH-30 16 074** | 15.4 | M12 | 74.0 | 16.0 | 45.9 | 52.0 | 23.8 | 46 | 8° | 61° | 80 | 30.0 | 0.64 | 25000 |
| | | | | | | *.606* | | *2.913* | *.630* | *1.807* | *2.047* | *.937* | *1.811* | | | *1160* | | | |
| | E20 | 1 | 1 | 7 | **392.55EH-30 20 049** | 19.2 | M12 | 49.0 | 19.6 | 27.0 | 49.0 | 46.0 | | 61° | 0° | 80 | 50.0 | 0.59 | 25000 |
| | | | | | | *.756* | | *1.929* | *.772* | *1.063* | *1.929* | *1.811* | | | | *1160* | | | |
| | E20 | 1 | 1 | 7 | **392.55EH-30 20 069** | 19.2 | M12 | 68.7 | 25.0 | 34.7 | 68.7 | 46.0 | | 27° | 0° | 80 | 50.0 | 0.66 | 25000 |
| | | | | | | *.756* | | *2.705* | *.984* | *1.366* | *2.705* | *1.811* | | | | *1160* | | | |
| | E20 | 1 | 1 | 15 | **392.55EH-30 20 086** | 19.2 | M12 | 86.0 | 20.0 | 58.7 | 64.0 | 30.1 | 46 | 8° | 56° | 80 | 50.0 | 0.73 | 25000 |
| | | | | | | *.756* | | *3.386* | *.787* | *2.311* | *2.520* | *1.185* | *1.811* | | | *1160* | | | |
| | E25 | 1 | 1 | 7 | **392.55EH-30 25 054** | 24.1 | M12 | 54.0 | 25.2 | 32.0 | 54.0 | 46.0 | | 58° | 0° | 80 | 65.0 | 0.65 | 25000 |
| | | | | | | *.949* | | *2.126* | *.992* | *1.260* | *2.126* | *1.811* | | | | *1160* | | | |
| | E25 | 1 | 1 | 15 | **392.55EH-30 25 077** | 24.1 | M12 | 77.0 | 25.0 | 49.9 | 55.0 | 31.1 | 46 | 8° | 55° | 80 | 65.0 | 0.75 | 25000 |
| | | | | | | *.949* | | *3.032* | *.984* | *1.965* | *2.165* | *1.224* | *1.811* | | | *1160* | | | |
| 40.0 | E10 | 1 | 1 | 7 | **392.55EH-40 10 051** | 9.6 | M16 | 51.0 | 13.0 | 24.0 | 51.0 | 63.0 | | 67° | 0° | 80 | 12.0 | 1.16 | 18000 |
| | | | | | | *.378* | | *2.008* | *.512* | *.945* | *2.008* | *2.480* | | | | *1160* | | | |
| | E10 | 1 | 1 | 15 | **392.55EH-40 10 065** | 9.6 | M16 | 65.0 | 10.0 | 28.4 | 38.0 | 14.8 | 63 | 8° | 68° | 80 | 12.0 | 1.18 | 18000 |
| | | | | | | *.378* | | *2.559* | *.394* | *1.118* | *1.496* | *.583* | *2.480* | | | *1160* | | | |
| | E12 | 1 | 1 | 7 | **392.55EH-40 12 054** | 11.6 | M16 | 54.0 | 16.3 | 27.0 | 54.0 | 63.0 | | 67° | 0° | 80 | 15.0 | 1.18 | 18000 |
| | | | | | | *.457* | | *2.126* | *.642* | *1.063* | *2.126* | *2.480* | | | | *1160* | | | |
| | E12 | 1 | 1 | 15 | **392.55EH-40 12 070** | 11.6 | M16 | 70.0 | 12.0 | 33.8 | 43.0 | 17.7 | 63 | 8° | 67° | 80 | 15.0 | 1.20 | 18000 |
| | | | | | | *.457* | | *2.756* | *.472* | *1.331* | *1.693* | *.697* | *2.480* | | | *1160* | | | |
| | E16 | 1 | 1 | 7 | **392.55EH-40 16 060** | 15.4 | M16 | 60.0 | 22.8 | 33.0 | 60.0 | 63.0 | | 66° | 0° | 80 | 30.0 | 1.23 | 18000 |
| | | | | | | *.606* | | *2.362* | *.898* | *1.299* | *2.362* | *2.480* | | | | *1160* | | | |
| | E16 | 1 | 1 | 15 | **392.55EH-40 16 081** | 15.4 | M16 | 81.0 | 16.0 | 45.6 | 54.0 | 23.7 | 63 | 8° | 66° | 80 | 30.0 | 1.29 | 18000 |
| | | | | | | *.606* | | *3.189* | *.630* | *1.795* | *2.126* | *.933* | *2.480* | | | *1160* | | | |
| | E20 | 1 | 1 | 7 | **392.55EH-40 20 056** | 19.2 | M16 | 56.0 | 19.3 | 29.0 | 56.0 | 63.0 | | 66° | 0° | 80 | 50.0 | 1.25 | 18000 |
| | | | | | | *.756* | | *2.205* | *.760* | *1.142* | *2.205* | *2.480* | | | | *1160* | | | |
| | E20 | 1 | 1 | 15 | **392.55EH-40 20 094** | 19.2 | M16 | 94.0 | 20.0 | 59.5 | 67.0 | 30.3 | 63 | 8° | 65° | 80 | 50.0 | 1.39 | 18000 |
| | | | | | | *.756* | | *3.701* | *.787* | *2.343* | *2.638* | *1.193* | *2.480* | | | *1160* | | | |
| | E25 | 1 | 1 | 7 | **392.55EH-40 25 062** | 24.1 | M16 | 62.0 | 26.0 | 35.0 | 62.0 | 63.0 | | 65° | 0° | 80 | 65.0 | 1.30 | 18000 |
| | | | | | | *.949* | | *2.441* | *1.024* | *1.378* | *2.441* | *2.480* | | | | *1160* | | | |
| | E25 | 1 | 1 | 15 | **392.55EH-40 25 108** | 24.1 | M16 | 108.0 | 25.0 | 74.5 | 81.0 | 38.0 | 63 | 8° | 62° | 80 | 65.0 | 1.59 | 18000 |
| | | | | | | *.949* | | *4.252* | *.984* | *2.933* | *3.189* | *1.496* | *2.480* | | | *1160* | | | |

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

M1 N22 N6 N15 N3

# MAS-BT 403 to Coromant EH adapter

**Machine side interface compatible with JIS B 6339**



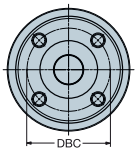

| | | | | | Dimensions, mm, inch | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $BD_3$ | $BHTA_2$ | | | | RPMX |
| 30.0 | E10 | 1 | 1 | **A392.55EH-30 10 044** | 9.2 | M12 | 44.0 | 13.2 | 22.0 | 46.0 | 75° | 80 | 12.0 | 0.50 | 25000 |
| | | | | | .360 | | 1.732 | .520 | .866 | 1.811 | | 1160 | | | |

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

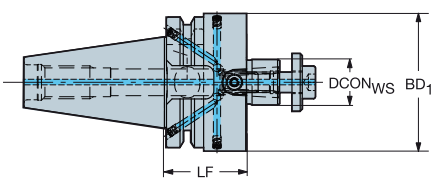
M1 N22 N6 N15 N3

# MAS-BT 403 to arbor adapter

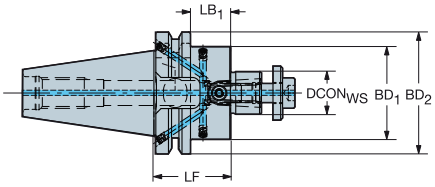
**Machine side interface compatible with JIS B 6339**




DSGN 1




DSGN 2




## Metric pilot

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | DCON$_{WS}$ | DBC | CRKS | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
| 30.0 | 16 | 1 | 1 | 2 | **A205-30 16 035** | 16.0 | | M12 | 35.0 | 13.0 | 35.0 | 36.0 | 46.0 | 80 | 22.0 | 0.54 | 25000 |
| | | | | | | *.630* | | | *1.378* | *.512* | *1.378* | *1.417* | *1.811* | *1160* | | | |
| | 22 | 1 | 1 | 2 | **A205-30 22 035** | 22.0 | | M12 | 35.0 | 11.9 | 35.0 | 42.0 | 46.0 | 80 | 45.0 | 0.63 | 25000 |
| | | | | | | *.866* | | | *1.378* | *.469* | *1.378* | *1.654* | *1.811* | *1160* | | | |
| | 27 | 1 | 1 | 2 | **A205-30 27 035** | 27.0 | | M12 | 35.0 | 13.0 | 35.0 | 42.0 | 46.0 | 80 | 80.0 | 0.67 | 25000 |
| | | | | | | *1.063* | | | *1.378* | *.512* | *1.378* | *1.654* | *1.811* | *1160* | | | |
| | 32 | 1 | 1 | 1 | **A205-30 32 050** | 32.0 | | M12 | 50.0 | 50.0 | | 78.0 | | 80 | 180.0 | 1.40 | 25000 |
| | | | | | | *1.260* | | | *1.969* | *1.969* | | *3.071* | | *1160* | | | |
| 40.0 | 16 | 7 | 1 | 2 | **A2B05-40 16 035** | 16.0 | | M16 | 35.0 | 8.0 | 35.0 | 36.0 | 63.0 | 80 | 22.0 | 0.96 | 18000 |
| | | | | | | *.630* | | | *1.378* | *.315* | *1.378* | *1.417* | *2.480* | *1160* | | | |
| | 16 | 7 | 1 | 2 | **A2B05-40 16 100** | 16.0 | | M16 | 100.0 | 71.0 | 100.0 | 36.0 | 63.0 | 80 | 22.0 | 1.58 | 18000 |
| | | | | | | *.630* | | | *3.937* | *2.795* | *3.937* | *1.417* | *2.480* | *1160* | | | |
| | 22 | 7 | 1 | 2 | **A2B05-40 22 035** | 22.0 | | M16 | 35.0 | 6.0 | 35.0 | 48.0 | 63.0 | 80 | 45.0 | 1.20 | 18000 |
| | | | | | | *.866* | | | *1.378* | *.236* | *1.378* | *1.890* | *2.480* | *1160* | | | |
| | 22 | 7 | 1 | 2 | **A2B05-40 22 100** | 22.0 | | M16 | 100.0 | 71.0 | 100.0 | 48.0 | 63.0 | 80 | 45.0 | 2.07 | 18000 |
| | | | | | | *.866* | | | *3.937* | *2.795* | *3.937* | *1.890* | *2.480* | *1160* | | | |
| | 27 | 7 | 1 | 2 | **A2B05-40 27 035** | 27.0 | | M16 | 35.0 | 6.0 | 35.0 | 48.0 | 63.0 | 80 | 80.0 | 1.26 | 18000 |
| | | | | | | *1.063* | | | *1.378* | *.236* | *1.378* | *1.890* | *2.480* | *1160* | | | |
| | 27 | 7 | 1 | 2 | **A2B05-40 27 100** | 27.0 | | M16 | 100.0 | 71.0 | 100.0 | 59.0 | 63.0 | 80 | 80.0 | 2.66 | 18000 |
| | | | | | | *1.063* | | | *3.937* | *2.795* | *3.937* | *2.323* | *2.480* | *1160* | | | |
| | 32 | 7 | 1 | 1 | **A2B05-40 32 065** | 32.0 | | M16 | 65.0 | 65.0 | | 78.0 | | 80 | 180.0 | 2.35 | 18000 |
| | | | | | | *1.260* | | | *2.559* | *2.559* | | *3.071* | | *1160* | | | |
| | 40S | 7 | 1 | 1 | **A2B05-40 40 070** | 40.0 | 66.7 | M16 | 70.0 | 70.0 | | 87.0 | | 80 | 300.0 | 3.08 | 18000 |
| | | | | | | *1.575* | *2.626* | | *2.756* | *2.756* | | *3.425* | | *1160* | | | |
| 50.0 | 22 | 7 | 4 | 2 | **A2B05-50 22 055** | 22.0 | | M24 | 55.0 | 14.0 | 55.0 | 48.0 | 100.0 | 80 | 45.0 | 4.06 | 12000 |
| | | | | | | *.866* | | | *2.165* | *.551* | *2.165* | *1.890* | *3.937* | *1160* | | | |
| | 22 | 7 | 1 | 2 | **A2B05-50 22 100** | 22.0 | | M24 | 100.0 | 59.0 | 100.0 | 48.0 | 100.0 | 80 | 45.0 | 4.79 | 12000 |
| | | | | | | *.866* | | | *3.937* | *2.323* | *3.937* | *1.890* | *3.937* | *1160* | | | |
| | 27 | 7 | 1 | 2 | **A2B05-50 27 055** | 27.0 | | M24 | 55.0 | 14.0 | 55.0 | 60.0 | 100.0 | 80 | 80.0 | 4.26 | 12000 |
| | | | | | | *1.063* | | | *2.165* | *.551* | *2.165* | *2.362* | *3.937* | *1160* | | | |
| | 27 | 7 | 1 | 2 | **A2B05-50 27 100** | 27.0 | | M24 | 100.0 | 59.0 | 100.0 | 60.0 | 100.0 | 80 | 80.0 | 5.28 | 12000 |
| | | | | | | *1.063* | | | *3.937* | *2.323* | *3.937* | *2.362* | *3.937* | *1160* | | | |
| | 32 | 7 | 1 | 2 | **A2B05-50 32 055** | 32.0 | | M24 | 55.0 | 14.0 | 55.0 | 78.0 | 100.0 | 80 | 180.0 | 4.62 | 12000 |
| | | | | | | *1.260* | | | *2.165* | *.551* | *2.165* | *3.071* | *3.937* | *1160* | | | |
| | 32 | 7 | 1 | 2 | **A2B05-50 32 100** | 32.0 | | M24 | 100.0 | 59.0 | 100.0 | 78.0 | 100.0 | 80 | 180.0 | 6.31 | 12000 |
| | | | | | | *1.260* | | | *3.937* | *2.323* | *3.937* | *3.071* | *3.937* | *1160* | | | |
| | 40S | 7 | 1 | 2 | **A2B05-50 40 055** | 40.0 | 66.7 | M24 | 55.0 | 14.0 | 55.0 | 89.0 | 100.0 | 80 | 300.0 | 5.04 | 12000 |
| | | | | | | *1.575* | *2.626* | | *2.165* | *.551* | *2.165* | *3.504* | *3.937* | *1160* | | | |
| | 60 | 7 | 1 | 1 | **A2F05-50 60 080** | 60.0 | 101.6 | M24 | 80.0 | 80.0 | | 127.0 | | 80 | 180.0 | 7.78 | 12000 |
| | | | | | | *2.362* | *4.000* | | *3.150* | *3.150* | | *5.000* | | *1160* | | | |

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 M12.

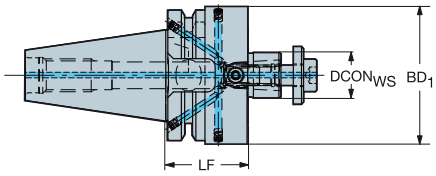
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

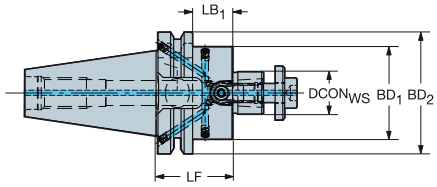
# MAS-BT 403 to arbor adapter

**Machine side interface compatible with JIS B 6339**

DSGN 1




2



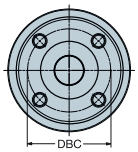

**Inch pilot**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | 3/4 | 1 | 1 | 2 | AA205-30 19 030 | 19.1 | M12 | 30.2 | 8.1 | 30.1 | 44.5 | 46.0 | 80 | 25.0 | 0.58 | 25000 |
| | | | | | | *.750* | | *1.190* | *.322* | *1.187* | *1.750* | *1.811* | *1160* | | | |
| | 1 | 1 | 1 | 1 | AA205-30 25 045 | 25.4 | M12 | 45.0 | 44.9 | | 57.2 | | 80 | 65.0 | 1.00 | 25000 |
| | | | | | | *1.000* | | *1.770* | *1.770* | | *2.250* | | *1160* | | | |
| 40.0 | 3/4 | 7 | 1 | 2 | AA2B05-40 19 051 | 19.1 | M16 | 50.8 | 23.8 | 50.8 | 44.5 | 63.0 | 80 | 25.0 | 1.33 | 18000 |
| | | | | | | *.750* | | *2.000* | *.937* | *2.000* | *1.750* | *2.480* | *1160* | | | |
| | 1 | 7 | 1 | 2 | AA2B05-40 25 051 | 25.4 | M16 | 50.8 | 23.8 | 50.8 | 57.2 | 63.0 | 80 | 65.0 | 1.62 | 18000 |
| | | | | | | *1.000* | | *2.000* | *.937* | *2.000* | *2.252* | *2.480* | *1160* | | | |

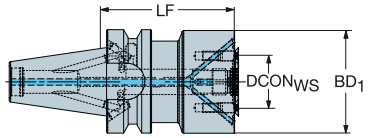
# MAS-BT to arbor with driving screws adapter

**Machine side interface compatible with JIS B 6339**

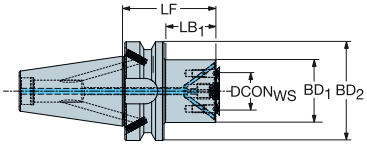
**For CoroMill® QD with internal coolant supply**




DSGN 1




2




**Metric pilot**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | X10 | 1 | 3 | 2 | B30-X10-032-050 | 10.0 | 22.0 | M12 | 2 | 50.0 | 27.0 | 50.0 | 32.0 | 46.0 | 80 | 6.4 | 0.60 | 12000 |
| | | | | | | *.394* | *.866* | | *.094* | *1.969* | *1.063* | *1.969* | *1.260* | *1.811* | *1160* | | | |
| | X22 | 1 | 3 | 2 | B30-X22-040-055 | 22.0 | 32.0 | M12 | 2 | 55.0 | 32.0 | 55.0 | 40.0 | 46.0 | 80 | 3.9 | 0.73 | 11000 |
| | | | | | | *.866* | *1.260* | | *.094* | *2.165* | *1.260* | *2.165* | *1.575* | *1.811* | *1160* | | | |
| 40.0 | X10 | 7 | 3 | 2 | B40-X10-032-055 | 10.0 | 22.0 | M16 | 2 | 55.0 | 27.0 | 55.0 | 32.0 | 63.0 | 80 | 6.4 | 1.18 | 12000 |
| | | | | | | *.394* | *.866* | | *.094* | *2.165* | *1.063* | *2.165* | *1.260* | *2.480* | *1160* | | | |
| | X22 | 7 | 3 | 2 | B40-X22-040-060 | 22.0 | 32.0 | M16 | 2 | 60.0 | 32.0 | 60.0 | 40.0 | 63.0 | 80 | 3.9 | 1.33 | 11000 |
| | | | | | | *.866* | *1.260* | | *.094* | *2.362* | *1.260* | *2.362* | *1.575* | *2.480* | *1160* | | | |
| | X32 | 7 | 3 | 1 | B40-X32-063-080 | 32.0 | 45.0 | M16 | 2 | 80.0 | 80.0 | | 63.0 | | 80 | 6.4 | 2.28 | 10000 |
| | | | | | | *1.260* | *1.772* | | *.094* | *3.150* | *3.150* | | *2.480* | | *1160* | | | |

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 M12.

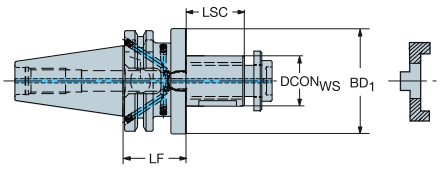
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

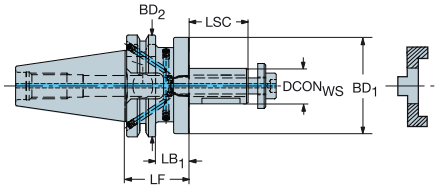
# MAS-BT 403 to side and face-mill arbor adapter

**Machine side interface compatible with JIS B 6339**

DSGN 1




2

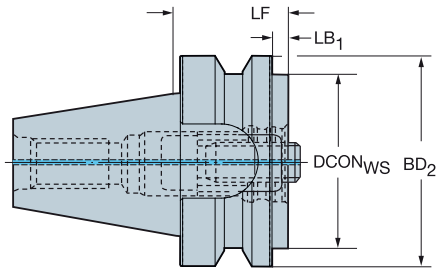



**Metric pilot**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | 22 | 1 | 1 | 2 | A208-30 22 047 | 22.0 | M12 | 31 | 35.0 | 13.0 | 35.0 | 40.0 | 46.0 | 80 | 45.0 | 0.71 | 25000 |
| | | | | | | *.866* | | *1.220* | *1.378* | *.512* | *1.378* | *1.575* | *1.811* | *1160* | | | |
| | 27 | 1 | 1 | 1 | A208-30 27 050 | 27.0 | M12 | 33 | 38.0 | 38.0 | | 48.0 | | 80 | 80.0 | 0.87 | 25000 |
| | | | | | | *1.063* | | *1.299* | *1.496* | *1.496* | | *1.890* | | *1160* | | | |
| 40.0 | 22 | 7 | 1 | 2 | A2B08-40 22 055 | 22.0 | M16 | 31 | 43.0 | 12.0 | 43.0 | 40.0 | 63.0 | 80 | 45.0 | 1.35 | 18000 |
| | | | | | | *.866* | | *1.220* | *1.693* | *.472* | *1.693* | *1.575* | *2.480* | *1160* | | | |
| | 27 | 7 | 1 | 2 | A2B08-40 27 055 | 27.0 | M16 | 33 | 43.0 | 15.0 | 43.0 | 48.0 | 63.0 | 80 | 80.0 | 1.51 | 18000 |
| | | | | | | *1.063* | | *1.299* | *1.693* | *.591* | *1.693* | *1.890* | *2.480* | *1160* | | | |
| | 32 | 7 | 1 | 2 | A2B08-40 32 060 | 32.0 | M16 | 38 | 46.0 | 18.0 | 46.0 | 58.0 | 63.0 | 80 | 180.0 | 1.86 | 18000 |
| | | | | | | *1.260* | | *1.496* | *1.811* | *.709* | *1.811* | *2.283* | *2.480* | *1160* | | | |
| | 40 | 7 | 1 | 1 | A2B08-40 40 070 | 40.0 | M16 | 41 | 56.0 | 56.0 | | 70.0 | | 80 | 300.0 | 2.70 | 18000 |
| | | | | | | *1.575* | | *1.614* | *2.205* | *2.205* | | *2.756* | | *1160* | | | |

# MAS-BT 403 to VL adapter

**Machine side interface compatible with JIS B 6339**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 80 | 1 | 1 | 390.58-50 80 040 | 80.0 | M24 | 40.0 | 2.0 | 100.0 | 20 | 180.0 | 3.63 |
| | | | | | *3.150* | | *1.575* | *.079* | *3.937* | *290* | | |

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

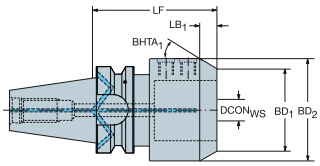
M1 N22 N15

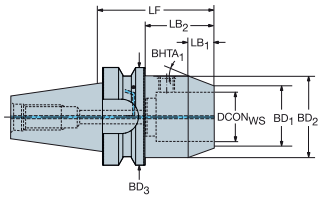
# MAS-BT 403 to Weldon adapter

**Machine side interface compatible with JIS B 6339**

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

DSGN 3 6




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | BAR PSI | NM | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | | | | RPMX |
| 30.0 | 12 | 1 | 1 | 6 | A2B20-30 12 052 | 12.0 | M12 | 52.0 | 12.6 | 28.9 | 52.0 | 27.0 | 41.5 | 46.0 | 30° | 20 | 12.0 | 0.63 | 25000 |
| | | | | | | *.472* | | *2.047* | *.496* | *1.138* | *2.047* | *1.061* | *1.634* | *1.811* | | *290* | | | |
| | 16 | 1 | 1 | 3 | A2B20-30 16 063 | 16.0 | M12 | 63.0 | 12.6 | 63.0 | | 33.0 | 47.5 | | 30° | 20 | 15.0 | 0.83 | 25000 |
| | | | | | | *.630* | | *2.480* | *.496* | *2.480* | | *1.297* | *1.870* | | | *290* | | | |
| | 20 | 1 | 1 | 3 | A2B20-30 20 063 | 20.0 | M12 | 63.0 | 12.6 | 63.0 | | 37.0 | 51.5 | | 30° | 20 | 20.0 | 0.87 | 25000 |
| | | | | | | *.787* | | *2.480* | *.496* | *2.480* | | *1.455* | *2.028* | | | *290* | | | |
| 40.0 | 6 | 7 | 1 | 6 | A2B20-40 06 100 | 6.0 | M16 | 100.0 | 11.0 | 71.0 | 100.0 | 12.3 | 25.0 | 63.0 | 30° | 20 | 3.0 | 1.21 | 18000 |
| | | | | | | *.236* | | *3.937* | *.433* | *2.795* | *3.937* | *.484* | *.984* | *2.480* | | *290* | | | |
| | 8 | 7 | 1 | 6 | A2B20-40 08 100 | 8.0 | M16 | 100.0 | 11.0 | 71.0 | 100.0 | 15.3 | 28.0 | 63.0 | 30° | 20 | 7.0 | 1.27 | 18000 |
| | | | | | | *.315* | | *3.937* | *.433* | *2.795* | *3.937* | *.602* | *1.102* | *2.480* | | *290* | | | |
| | 10 | 7 | 1 | 6 | A2B20-40 10 100 | 10.0 | M16 | 100.0 | 13.0 | 71.0 | 100.0 | 20.0 | 35.0 | 63.0 | 30° | 20 | 10.0 | 1.44 | 18000 |
| | | | | | | *.394* | | *3.937* | *.512* | *2.795* | *3.937* | *.787* | *1.378* | *2.480* | | *290* | | | |
| | 12 | 7 | 1 | 6 | A2B20-40 12 063 | 12.0 | M16 | 63.0 | 13.0 | 34.0 | 63.0 | 27.0 | 42.0 | 63.0 | 30° | 20 | 12.0 | 1.12 | 18000 |
| | | | | | | *.472* | | *2.480* | *.512* | *1.339* | *2.480* | *1.063* | *1.654* | *2.480* | | *290* | | | |
| | 12 | 7 | 1 | 6 | A2B20-40 12 100 | 12.0 | M16 | 100.0 | 13.0 | 71.0 | 100.0 | 27.0 | 42.0 | 63.0 | 30° | 20 | 12.0 | 1.66 | 18000 |
| | | | | | | *.472* | | *3.937* | *.512* | *2.795* | *3.937* | *1.063* | *1.654* | *2.480* | | *290* | | | |
| | 16 | 7 | 1 | 6 | A2B20-40 16 063 | 16.0 | M16 | 63.0 | 13.0 | 34.0 | 63.0 | 33.0 | 48.0 | 63.0 | 30° | 20 | 15.0 | 1.35 | 18000 |
| | | | | | | *.630* | | *2.480* | *.512* | *1.339* | *2.480* | *1.299* | *1.890* | *2.480* | | *290* | | | |
| | 16 | 7 | 1 | 6 | A2B20-40 16 100 | 16.0 | M16 | 100.0 | 13.0 | 71.0 | 100.0 | 33.0 | 48.0 | 63.0 | 30° | 20 | 15.0 | 1.84 | 18000 |
| | | | | | | *.630* | | *3.937* | *.512* | *2.795* | *3.937* | *1.299* | *1.890* | *2.480* | | *290* | | | |
| | 20 | 7 | 1 | 6 | A2B20-40 20 063 | 20.0 | M16 | 63.0 | 13.0 | 34.0 | 63.0 | 37.0 | 52.0 | 63.0 | 30° | 20 | 20.0 | 1.37 | 18000 |
| | | | | | | *.787* | | *2.480* | *.512* | *1.339* | *2.480* | *1.456* | *2.047* | *2.480* | | *290* | | | |
| | 20 | 7 | 1 | 6 | A2B20-40 20 100 | 20.0 | M16 | 100.0 | 13.0 | 71.0 | 100.0 | 37.0 | 52.0 | 63.0 | 30° | 20 | 20.0 | 1.96 | 18000 |
| | | | | | | *.787* | | *3.937* | *.512* | *2.795* | *3.937* | *1.456* | *2.047* | *2.480* | | *290* | | | |
| | 25 | 7 | 1 | 6 | A2B20-40 25 090 | 25.0 | M16 | 90.0 | 13.0 | 61.0 | 90.0 | 44.0 | 59.0 | 63.0 | 30° | 20 | 25.0 | 1.73 | 18000 |
| | | | | | | *.984* | | *3.543* | *.512* | *2.402* | *3.543* | *1.732* | *2.323* | *2.480* | | *290* | | | |
| | 32 | 7 | 1 | 3 | A2B20-40 32 100 | 32.0 | M16 | 100.0 | 13.0 | 100.0 | | 57.0 | 72.0 | | 30° | 20 | 45.0 | 2.40 | 18000 |
| | | | | | | *1.260* | | *3.937* | *.512* | *3.937* | | *2.244* | *2.835* | | | *290* | | | |
| 50.0 | 6 | 7 | 1 | 6 | A2B20-50 06 063 | 6.0 | M24 | 63.0 | 11.0 | 22.0 | 63.0 | 12.3 | 25.0 | 100.0 | 30° | 20 | 3.0 | 3.81 | 12000 |
| | | | | | | *.236* | | *2.480* | *.433* | *.866* | *2.480* | *.484* | *.984* | *3.937* | | *290* | | | |
| | 8 | 7 | 1 | 6 | A2B20-50 08 063 | 8.0 | M24 | 63.0 | 11.0 | 22.0 | 63.0 | 15.3 | 28.0 | 100.0 | 30° | 20 | 7.0 | 3.84 | 12000 |
| | | | | | | *.315* | | *2.480* | *.433* | *.866* | *2.480* | *.602* | *1.102* | *3.937* | | *290* | | | |
| | 10 | 7 | 1 | 6 | A2B20-50 10 070 | 10.0 | M24 | 70.0 | 13.0 | 29.0 | 70.0 | 20.0 | 35.0 | 100.0 | 30° | 20 | 10.0 | 3.90 | 12000 |
| | | | | | | *.394* | | *2.756* | *.512* | *1.142* | *2.756* | *.787* | *1.378* | *3.937* | | *290* | | | |
| | 12 | 7 | 1 | 6 | A2B20-50 12 080 | 12.0 | M24 | 80.0 | 13.0 | 36.0 | 80.0 | 26.8 | 42.0 | 100.0 | 30° | 20 | 12.0 | 4.04 | 12000 |
| | | | | | | *.472* | | *3.150* | *.512* | *1.417* | *3.150* | *1.055* | *1.654* | *3.937* | | *290* | | | |
| | 16 | 7 | 1 | 6 | A2B20-50 16 080 | 16.0 | M24 | 80.0 | 13.0 | 39.0 | 80.0 | 33.0 | 48.0 | 100.0 | 30° | 20 | 15.0 | 4.16 | 12000 |
| | | | | | | *.630* | | *3.150* | *.512* | *1.535* | *3.150* | *1.299* | *1.890* | *3.937* | | *290* | | | |
| | 20 | 7 | 1 | 6 | A2B20-50 20 080 | 20.0 | M24 | 80.0 | 13.0 | 39.0 | 80.0 | 37.0 | 52.0 | 100.0 | 30° | 20 | 20.0 | 4.18 | 12000 |
| | | | | | | *.787* | | *3.150* | *.512* | *1.535* | *3.150* | *1.456* | *2.047* | *3.937* | | *290* | | | |
| | 20 | 7 | 1 | 6 | A2B20-50 20 100 | 20.0 | M24 | 100.0 | 13.0 | 59.0 | 100.0 | 37.0 | 52.0 | 100.0 | 30° | 20 | 20.0 | 4.58 | 12000 |
| | | | | | | *.787* | | *3.937* | *.512* | *2.323* | *3.937* | *1.456* | *2.047* | *3.937* | | *290* | | | |
| | 25 | 7 | 1 | 6 | A2B20-50 25 100 | 25.0 | M24 | 100.0 | 13.0 | 59.0 | 100.0 | 50.0 | 65.0 | 100.0 | 30° | 20 | 25.0 | 4.90 | 12000 |
| | | | | | | *.984* | | *3.937* | *.512* | *2.323* | *3.937* | *1.968* | *2.559* | *3.937* | | *290* | | | |
| | 25 | 7 | 1 | 6 | A2B20-50 25 160 | 25.0 | M24 | 160.0 | 13.0 | 119.0 | 160.0 | 50.0 | 65.0 | 100.0 | 30° | 20 | 25.0 | 6.62 | 12000 |
| | | | | | | *.984* | | *6.299* | *.512* | *4.685* | *6.299* | *1.968* | *2.559* | *3.937* | | *290* | | | |
| | 32 | 7 | 1 | 6 | A2B20-50 32 105 | 32.0 | M24 | 105.0 | 12.0 | 64.0 | 105.0 | 58.1 | 72.0 | 100.0 | 30° | 20 | 45.0 | 5.30 | 12000 |
| | | | | | | *1.260* | | *4.134* | *.472* | *2.520* | *4.134* | *2.289* | *2.835* | *3.937* | | *290* | | | |
| | 32 | 7 | 1 | 6 | A2B20-50 32 160 | 32.0 | M24 | 160.0 | 12.0 | 119.0 | 160.0 | 58.1 | 72.0 | 100.0 | 30° | 20 | 45.0 | 7.20 | 12000 |
| | | | | | | *1.260* | | *6.299* | *.472* | *4.685* | *6.299* | *2.289* | *2.835* | *3.937* | | *290* | | | |
| | 40 | 7 | 1 | 6 | A2B20-50 40 115 | 40.0 | M24 | 115.0 | 15.0 | 74.0 | 115.0 | 60.7 | 78.0 | 100.0 | 30° | 20 | 45.0 | 5.60 | 12000 |
| | | | | | | *1.575* | | *4.528* | *.591* | *2.913* | *4.528* | *2.389* | *3.071* | *3.937* | | *290* | | | |

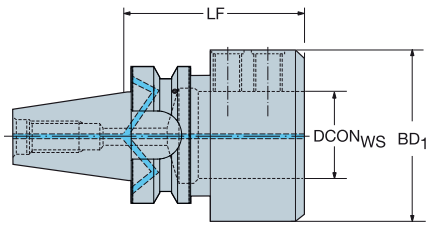
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

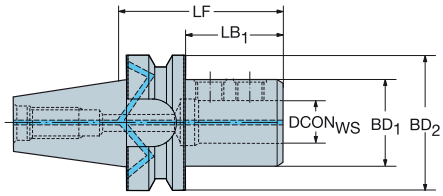
# MAS-BT 403 to ISO 9766 adapter

**Machine side interface compatible with JIS B 6339**

DSGN 1




2

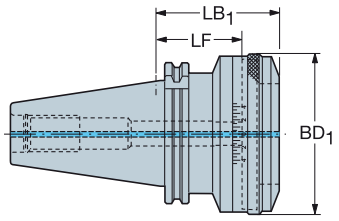



**Metric bore**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | 16 | 1 | 1 | 2 | A227-30 16 080 | 16.0 | M12 | 49 | 80.0 | 58.0 | 80.0 | 36.0 | 46.0 | 20 | 10.0 | 0.76 | 25000 |
| | | | | | | *.630* | | *1.949* | *3.150* | *2.283* | *3.150* | *1.417* | *1.811* | *290* | | | |
| | 20 | 1 | 1 | 2 | A227-30 20 080 | 20.0 | M12 | 51 | 80.0 | 56.9 | 80.0 | 40.0 | 46.0 | 20 | 12.0 | 0.82 | 25000 |
| | | | | | | *.787* | | *2.028* | *3.150* | *2.240* | *3.150* | *1.575* | *1.811* | *290* | | | |
| | 25 | 1 | 1 | 2 | A227-30 25 085 | 25.0 | M12 | 57 | 85.0 | 62.9 | 85.0 | 45.0 | 46.0 | 20 | 20.0 | 0.92 | 25000 |
| | | | | | | *.984* | | *2.264* | *3.346* | *2.476* | *3.346* | *1.772* | *1.811* | *290* | | | |
| | 32 | 1 | 1 | 1 | A227-30 32 090 | 32.0 | M12 | 61 | 90.0 | 90.0 | | 52.0 | | 20 | 30.0 | 1.03 | 25000 |
| | | | | | | *1.260* | | *2.421* | *3.543* | *3.543* | | *2.047* | | *290* | | | |
| 40.0 | 16 | 7 | 1 | 2 | A2B27-40 16 070 | 16.0 | M16 | 49 | 70.0 | 42.0 | 70.0 | 36.0 | 63.0 | 20 | 10.0 | 1.24 | 18000 |
| | | | | | | *.630* | | *1.949* | *2.756* | *1.654* | *2.756* | *1.417* | *2.480* | *290* | | | |
| | 20 | 7 | 1 | 2 | A2B27-40 20 075 | 20.0 | M16 | 51 | 75.0 | 48.0 | 75.0 | 40.0 | 63.0 | 20 | 12.0 | 1.32 | 18000 |
| | | | | | | *.787* | | *2.028* | *2.953* | *1.890* | *2.953* | *1.575* | *2.480* | *290* | | | |
| | 25 | 7 | 1 | 2 | A2B27-40 25 080 | 25.0 | M16 | 57 | 80.0 | 52.0 | 80.0 | 45.0 | 63.0 | 20 | 20.0 | 1.40 | 18000 |
| | | | | | | *.984* | | *2.264* | *3.150* | *2.047* | *3.150* | *1.772* | *2.480* | *290* | | | |
| | 32 | 7 | 1 | 2 | A2B27-40 32 085 | 32.0 | M16 | 61 | 85.0 | 57.0 | 85.0 | 52.0 | 63.0 | 20 | 30.0 | 1.51 | 18000 |
| | | | | | | *1.260* | | *2.421* | *3.346* | *2.244* | *3.346* | *2.047* | *2.480* | *290* | | | |
| 50.0 | 16 | 7 | 1 | 2 | A2B27-50 16 080 | 16.0 | M24 | 49 | 80.0 | 41.5 | 80.0 | 36.0 | 100.0 | 20 | 10.0 | 3.98 | 12000 |
| | | | | | | *.630* | | *1.949* | *3.150* | *1.634* | *3.150* | *1.417* | *3.937* | *290* | | | |
| | 20 | 7 | 1 | 2 | A2B27-50 20 085 | 20.0 | M24 | 51 | 85.0 | 46.0 | 85.0 | 40.0 | 100.0 | 20 | 12.0 | 3.98 | 12000 |
| | | | | | | *.787* | | *2.028* | *3.346* | *1.811* | *3.346* | *1.575* | *3.937* | *290* | | | |
| | 25 | 7 | 1 | 2 | A2B27-50 25 090 | 25.0 | M24 | 57 | 90.0 | 51.0 | 90.0 | 45.0 | 100.0 | 20 | 20.0 | 4.08 | 12000 |
| | | | | | | *.984* | | *2.264* | *3.543* | *2.008* | *3.543* | *1.772* | *3.937* | *290* | | | |
| | 32 | 7 | 1 | 2 | A2B27-50 32 095 | 32.0 | M24 | 61 | 95.0 | 56.0 | 95.0 | 52.0 | 100.0 | 20 | 30.0 | 4.24 | 12000 |
| | | | | | | *1.260* | | *2.421* | *3.740* | *2.205* | *3.740* | *2.047* | *3.937* | *290* | | | |
| | 40 | 7 | 1 | 2 | A2B27-50 40 105 | 40.0 | M24 | 71 | 105.0 | 66.0 | 105.0 | 75.0 | 100.0 | 20 | 40.0 | 5.32 | 12000 |
| | | | | | | *1.575* | | *2.815* | *4.134* | *2.598* | *4.134* | *2.953* | *3.937* | *290* | | | |
| | 50 | 7 | 1 | 2 | A2B27-50 50 113 | 50.0 | M24 | 81 | 113.0 | 74.0 | 113.0 | 75.0 | 100.0 | 20 | 45.0 | 4.96 | 12000 |
| | | | | | | *1.969* | | *3.209* | *4.449* | *2.913* | *4.449* | *2.953* | *3.937* | *290* | | | |

# MAS-BT 403 to ISO 9766 adjustable adapter

**Machine side interface compatible with JIS B 6339**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | BD$_1$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 1 | 1 | 1 | 392.55277-40 01 055A | 78.0 | M16 | 55.0 | 79.6 | 86.0 | 20 | 2.38 | 12000 |
| | | | | | *3.071* | | *2.165* | *3.134* | *3.386* | *290* | | |
| 50.0 | 2 | 1 | 1 | 392.58277-50 02 063A | 98.0 | M24 | 63.0 | 87.6 | 106.0 | 20 | 5.79 | 9000 |
| | | | | | *3.858* | | *2.480* | *3.449* | *4.173* | *290* | | |
| | 3 | 1 | 1 | 392.58277-50 03 080B | 136.0 | M24 | 80.0 | 90.0 | 140.0 | 20 | 7.36 | 6000 |
| | | | | | *5.354* | | *3.150* | *3.543* | *5.512* | *290* | | |

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

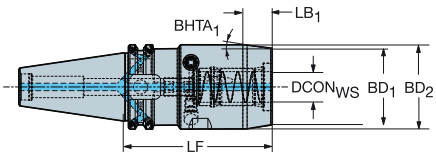
M1 N22 N15

# MAS-BT 403 to CoroChuck™ 930

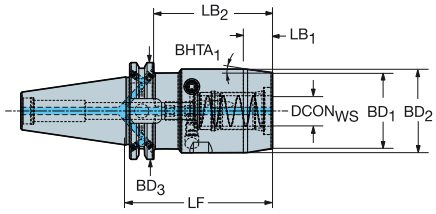
**Machine side interface compatible with JIS B 6339**

**Heavy-duty design**

DSGN 3




DSGN 6

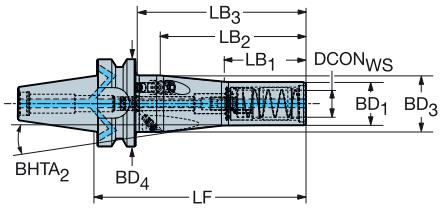



**Metric bore**

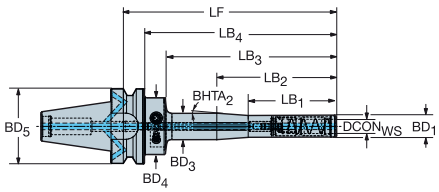
| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 20 | 7 | 1 | 6 | 930-B40-HD-20-088 | 20.0 | M16 | 51 | 88.0 | 17.8 | 61.0 | 88.0 | 50.0 | 55.0 | 63.0 | 8° | 80 | 10.0 | 1.93 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.465* | *.701* | *2.402* | *3.465* | *1.969* | *2.165* | *2.480* | | *1160* | | | |
| | 25 | 7 | 1 | 3 | 930-B40-HD-25-094 | 25.0 | M16 | 57 | 94.0 | 18.8 | 94.0 | | 57.0 | 65.0 | | 12° | 80 | 10.0 | 2.39 | 18000 |
| | | | | | | *.984* | | *2.244* | *3.701* | *.740* | *3.701* | | *2.244* | *2.559* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 6 | 930-B50-HD-20-102 | 20.0 | M24 | 51 | 102.0 | 17.8 | 64.0 | 102.0 | 50.0 | 55.0 | 100.0 | 8° | 80 | 10.0 | 4.68 | 12000 |
| | | | | | | *.787* | | *2.008* | *4.016* | *.701* | *2.520* | *4.016* | *1.969* | *2.165* | *3.937* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | 930-B50-HD-25-106 | 25.0 | M24 | 57 | 106.0 | 18.8 | 68.0 | 106.0 | 57.0 | 65.0 | 100.0 | 12° | 80 | 10.0 | 5.15 | 12000 |
| | | | | | | *.984* | | *2.244* | *4.173* | *.740* | *2.677* | *4.173* | *2.244* | *2.559* | *3.937* | | *1160* | | | |
| | 32 | 7 | 1 | 6 | 930-B50-HD-32-096 | 32.0 | M24 | 61 | 96.0 | 18.8 | 58.0 | 96.0 | 68.0 | 76.0 | 100.0 | 12° | 80 | 10.0 | 5.23 | 12000 |
| | | | | | | *1.260* | | *2.402* | *3.780* | *.740* | *2.283* | *3.780* | *2.677* | *2.992* | *3.937* | | *1160* | | | |
| | 32 | 7 | 1 | 6 | 930-B50-HD-32-185 | 32.0 | M24 | 61 | 185.0 | 18.8 | 147.0 | 185.0 | 68.0 | 76.0 | 100.0 | 12° | 80 | 10.0 | 8.34 | 12000 |
| | | | | | | *1.260* | | *2.402* | *7.283* | *.740* | *5.787* | *7.283* | *2.677* | *2.992* | *3.937* | | *1160* | | | |

**Pencil design**

DSGN 11




DSGN 17




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_3$ | $BD_4$ | $BHTA_2$ | BAR PSI | NM | KG | RPMX |
| 30.0 | 6 | 1 | 1 | 11 | 930-B30-P-06-088 | 6.0 | M12 | 37 | 88.0 | 45.8 | 52.1 | 66.0 | 14.5 | 40.0 | 46 | 0° | 80 | 8.0 | 0.62 | 25000 |
| | | | | | | *.236* | | *1.457* | *3.465* | *1.803* | *2.051* | *2.598* | *.571* | *1.575* | *1.811* | | *1160* | | | |
| | 12 | 1 | 1 | 11 | 930-B30-P-12-103 | 12.0 | M12 | 46 | 103.0 | 60.8 | 66.4 | 81.0 | 22.0 | 40.0 | 46 | 0° | 80 | 8.0 | 0.71 | 25000 |
| | | | | | | *.472* | | *1.811* | *4.055* | *2.394* | *2.614* | *3.189* | *.866* | *1.575* | *1.811* | | *1160* | | | |
| | 12 | 1 | 1 | 11 | 930-B30-P-12-138 | 12.0 | M12 | 46 | 138.0 | 95.8 | 101.4 | 116.0 | 22.0 | 40.0 | 46 | 0° | 80 | 8.0 | 0.81 | 25000 |
| | | | | | | *.472* | | *1.811* | *5.433* | *3.772* | *3.992* | *4.567* | *.866* | *1.575* | *1.811* | | *1160* | | | |
| | 12 | 1 | 1 | 17 | 930-B30-P-12-188 | 12.0 | M12 | 46 | 188.0 | 50.0 | 75.0 | 151.1 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 1.10 | 25000 |
| | | | | | | *.472* | | *1.811* | *7.402* | *1.969* | *2.953* | *5.949* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| 40.0 | 12 | 7 | 1 | 11 | 930-B40-P-12-110 | 12.0 | M16 | 46 | 110.0 | 60.8 | 66.4 | 83.0 | 22.0 | 40.0 | 63 | 0° | 80 | 8.0 | 1.32 | 18000 |
| | | | | | | *.472* | | *1.811* | *4.331* | *2.394* | *2.614* | *3.268* | *.866* | *1.575* | *2.480* | | *1160* | | | |
| | 12 | 7 | 1 | 11 | 930-B40-P-12-145 | 12.0 | M16 | 46 | 145.0 | 95.8 | 101.4 | 118.0 | 22.0 | 40.0 | 63 | 0° | 80 | 8.0 | 1.47 | 18000 |
| | | | | | | *.472* | | *1.811* | *5.709* | *3.772* | *3.992* | *4.646* | *.866* | *1.575* | *2.480* | | *1160* | | | |
| | 12 | 7 | 1 | 17 | 930-B40-P-12-195 | 12.0 | M16 | 46 | 195.0 | 50.0 | 75.0 | 151.1 | 22.0 | 26.0 | 40 | 4° | 80 | 8.0 | 1.72 | 18000 |
| | | | | | | *.472* | | *1.811* | *7.677* | *1.969* | *2.953* | *5.949* | *.866* | *1.024* | *1.575* | | *1160* | | | |
| | 20 | 7 | 1 | 11 | 930-B40-P-20-153 | 20.0 | M16 | 51 | 153.0 | 60.0 | 108.0 | 126.0 | 32.0 | 42.0 | 63 | 6° | 80 | 8.0 | 1.84 | 18000 |
| | | | | | | *.787* | | *2.008* | *6.024* | *2.362* | *4.252* | *4.961* | *1.260* | *1.654* | *2.480* | | *1160* | | | |

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

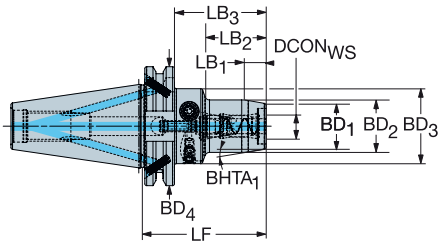
M1 N22 N6 N15 N4

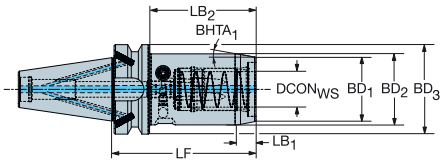
# MAS-BT 403 to CoroChuck™ 930

**Machine side interface compatible with JIS B 6339**

**Metric bore**

DSGN 10 6




**Slender design**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $LB_4$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 30.0 | 6 | 1 | 1 | 6 | 930-B30-S-06-048 | 6.0 | M12 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 22.0 | 26.0 | 46.0 | | 12° | 80 | 8.0 | 0.55 | 25000 |
| | | | | | | *.236* | | *1.457* | *1.890* | *.366* | *.504* | *1.890* | | *.866* | *1.024* | *1.811* | | | *1160* | | | |
| | 8 | 1 | 1 | 6 | 930-B30-S-08-048 | 8.0 | M12 | 37 | 48.0 | 9.3 | 12.8 | 48.0 | | 24.0 | 28.0 | 46.0 | | 12° | 80 | 8.0 | 0.56 | 25000 |
| | | | | | | *.315* | | *1.457* | *1.890* | *.366* | *.504* | *1.890* | | *.945* | *1.102* | *1.811* | | | *1160* | | | |
| | 10 | 1 | 1 | 6 | 930-B30-S-10-048 | 10.0 | M12 | 41 | 48.0 | 9.3 | 13.8 | 48.0 | | 26.0 | 30.0 | 46.0 | | 12° | 80 | 8.0 | 0.55 | 25000 |
| | | | | | | *.394* | | *1.614* | *1.890* | *.366* | *.543* | *1.890* | | *1.024* | *1.181* | *1.811* | | | *1160* | | | |
| | 12 | 1 | 1 | 10 | 930-B30-S-12-082 | 12.0 | M12 | 46 | 82.0 | 11.3 | 38.2 | 60.0 | 82.0 | 28.0 | 32.0 | 40.0 | 46 | 10° | 80 | 8.0 | 0.75 | 25000 |
| | | | | | | *.472* | | *1.811* | *3.228* | *.445* | *1.504* | *2.362* | *3.228* | *1.102* | *1.260* | *1.575* | *1.811* | | *1160* | | | |
| | 20 | 1 | 1 | 6 | 930-B30-S-20-088 | 20.0 | M12 | 51 | 88.0 | 16.0 | 66.0 | 88.0 | | 38.0 | 42.0 | 46.0 | | 7° | 80 | 8.0 | 0.93 | 25000 |
| | | | | | | *.787* | | *2.008* | *3.465* | *.630* | *2.598* | *3.465* | | *1.496* | *1.654* | *1.811* | | | *1160* | | | |
| 40.0 | 6 | 7 | 1 | 10 | 930-B40-S-06-075 | 6.0 | M16 | 37 | 75.0 | 11.3 | 30.2 | 48.0 | 75.0 | 22.0 | 26.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.21 | 18000 |
| | | | | | | *.236* | | *1.457* | *2.953* | *.445* | *1.189* | *1.890* | *2.953* | *.866* | *1.024* | *1.575* | *2.480* | | *1160* | | | |
| | 8 | 7 | 1 | 10 | 930-B40-S-08-075 | 8.0 | M16 | 37 | 75.0 | 11.3 | 30.2 | 48.0 | 75.0 | 24.0 | 28.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.23 | 18000 |
| | | | | | | *.315* | | *1.457* | *2.953* | *.445* | *1.189* | *1.890* | *2.953* | *.945* | *1.102* | *1.575* | *2.480* | | *1160* | | | |
| | 10 | 7 | 1 | 10 | 930-B40-S-10-080 | 10.0 | M16 | 41 | 80.0 | 11.3 | 34.2 | 53.0 | 80.0 | 26.0 | 30.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.27 | 18000 |
| | | | | | | *.394* | | *1.614* | *3.150* | *.445* | *1.346* | *2.087* | *3.150* | *1.024* | *1.181* | *1.575* | *2.480* | | *1160* | | | |
| | 12 | 7 | 1 | 10 | 930-B40-S-12-085 | 12.0 | M16 | 46 | 85.0 | 11.3 | 38.2 | 58.0 | 85.0 | 27.9 | 32.0 | 50.0 | 63 | 10° | 80 | 8.0 | 1.45 | 18000 |
| | | | | | | *.472* | | *1.811* | *3.346* | *.445* | *1.504* | *2.283* | *3.346* | *1.098* | *1.260* | *1.969* | *2.480* | | *1160* | | | |
| | 20 | 7 | 1 | 10 | 930-B40-S-20-094 | 20.0 | M16 | 51 | 94.0 | 16.0 | 49.2 | 67.0 | 94.0 | 37.9 | 42.0 | 50.0 | 63 | 7° | 80 | 8.0 | 1.62 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.701* | *.630* | *1.937* | *2.638* | *3.701* | *1.492* | *1.654* | *1.969* | *2.480* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | 930-B40-S-25-102 | 25.0 | M16 | 57 | 102.0 | 12.9 | 74.0 | 102.0 | | 45.0 | 50.0 | 63 | | 11° | 80 | 8.0 | 1.86 | 18000 |
| | | | | | | *.984* | | *2.244* | *4.016* | *.508* | *2.913* | *4.016* | | *1.772* | *1.969* | *2.480* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 10 | 930-B50-S-20-108 | 20.0 | M24 | 51 | 108.0 | 16.0 | 49.2 | 70.0 | 108.0 | 37.9 | 42.0 | 50.0 | 100 | 7° | 80 | 8.0 | 4.35 | 12000 |
| | | | | | | *.787* | | *2.008* | *4.252* | *.630* | *1.937* | *2.756* | *4.252* | *1.492* | *1.654* | *1.969* | *3.937* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | 930-B50-S-25-114 | 25.0 | M24 | 57 | 114.0 | 12.9 | 73.5 | 114.0 | | 45.0 | 50.0 | 100 | | 11° | 80 | 8.0 | 4.59 | 12000 |
| | | | | | | *.984* | | *2.244* | *4.488* | *.508* | *2.894* | *4.488* | | *1.772* | *1.969* | *3.937* | | | *1160* | | | |

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

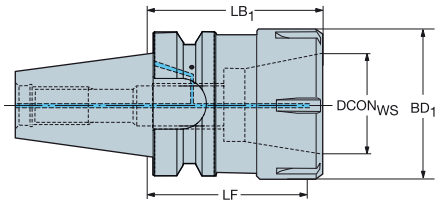
M1 N22 N6 N15 N4

# MAS-BT 403 to ER collet chuck

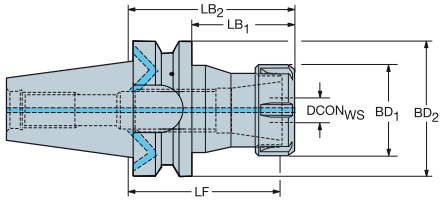
**Machine side interface compatible with JIS B 6339**

**Workpiece side interface DIN 6499-B**

DSGN 1




DSGN 2




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 30.0 | ER11 | 1 | 1 | 2 | A2B14-30 11 050 | 11.4 | M12 | 43.7 | 26.9 | 50.0 | 19.0 | 46.0 | 80 | 0.43 | 25000 |
| | | | | | | *.449* | | *1.720* | *1.059* | *1.969* | *.748* | *1.811* | *1160* | | |
| | ER16 | 1 | 1 | 2 | A214-30 16 080 | 17.0 | M12 | 69.7 | 56.9 | 80.0 | 28.0 | 46.0 | 80 | 0.59 | 25000 |
| | | | | | | *.669* | | *2.746* | *2.240* | *3.150* | *1.102* | *1.811* | *1160* | | |
| | ER16 | 1 | 1 | 2 | A214-30 16 100 | 17.0 | M12 | 89.7 | 76.9 | 100.0 | 28.0 | 46.0 | 80 | 0.68 | 25000 |
| | | | | | | *.669* | | *3.533* | *3.028* | *3.937* | *1.102* | *1.811* | *1160* | | |
| | ER16 | 1 | 1 | 2 | A214-30 16 130 | 17.0 | M12 | 119.7 | 106.9 | 130.0 | 28.0 | 46.0 | 80 | 0.81 | 25000 |
| | | | | | | *.669* | | *4.714* | *4.209* | *5.118* | *1.102* | *1.811* | *1160* | | |
| | ER16 | 1 | 1 | 2 | A2B14-30 16 050 | 17.0 | M12 | 39.7 | 26.9 | 50.0 | 27.7 | 46.0 | 80 | 0.46 | 25000 |
| | | | | | | *.669* | | *1.565* | *1.059* | *1.969* | *1.091* | *1.811* | *1160* | | |
| | ER20 | 1 | 1 | 2 | A214-30 20 090 | 21.0 | M12 | 78.8 | 66.9 | 90.0 | 34.0 | 46.0 | 80 | 0.73 | 25000 |
| | | | | | | *.827* | | *3.104* | *2.634* | *3.543* | *1.339* | *1.811* | *1160* | | |
| | ER20 | 1 | 1 | 2 | A214-30 20 130 | 21.0 | M12 | 118.8 | 106.9 | 130.0 | 34.0 | 46.0 | 80 | 0.99 | 25000 |
| | | | | | | *.827* | | *4.679* | *4.209* | *5.118* | *1.339* | *1.811* | *1160* | | |
| | ER20 | 1 | 1 | 2 | A2B14-30 20 050 | 21.0 | M12 | 38.8 | 26.9 | 50.0 | 34.0 | 46.0 | 80 | 0.48 | 25000 |
| | | | | | | *.827* | | *1.529* | *1.059* | *1.969* | *1.339* | *1.811* | *1160* | | |
| | ER25 | 1 | 1 | 2 | A214-30 25 100 | 26.0 | M12 | 88.3 | 76.9 | 100.0 | 42.0 | 46.0 | 80 | 0.99 | 25000 |
| | | | | | | *1.024* | | *3.478* | *3.028* | *3.937* | *1.654* | *1.811* | *1160* | | |
| | ER25 | 1 | 1 | 2 | A214-30 25 130 | 26.0 | M12 | 118.3 | 108.0 | 130.0 | 42.0 | 46.0 | 80 | 1.30 | 25000 |
| | | | | | | *1.024* | | *4.659* | *4.252* | *5.118* | *1.654* | *1.811* | *1160* | | |
| | ER25 | 1 | 1 | 2 | A2B14-30 25 062 | 26.0 | M12 | 50.3 | 38.9 | 62.0 | 42.0 | 46.0 | 80 | 0.58 | 25000 |
| | | | | | | *1.024* | | *1.982* | *1.532* | *2.441* | *1.654* | *1.811* | *1160* | | |
| | ER32 | 1 | 1 | 1 | A214-30 32 070 | 33.0 | M12 | 57.3 | 70.0 | | 50.0 | | 80 | 0.70 | 25000 |
| | | | | | | *1.299* | | *2.257* | *2.756* | | *1.969* | | *1160* | | |
| | ER32 | 1 | 1 | 1 | A214-30 32 130 | 33.0 | M12 | 117.3 | 130.0 | | 50.0 | | 80 | 1.25 | 25000 |
| | | | | | | *1.299* | | *4.620* | *5.118* | | *1.969* | | *1160* | | |
| 40.0 | ER16 | 7 | 1 | 2 | A2B14-40 16 070 | 17.0 | M16 | 59.7 | 41.0 | 70.0 | 28.0 | 63.0 | 80 | 1.10 | 18000 |
| | | | | | | *.669* | | *2.352* | *1.614* | *2.756* | *1.102* | *2.480* | *1160* | | |
| | ER16 | 7 | 1 | 2 | A2B14-40 16 100 | 17.0 | M16 | 89.7 | 71.0 | 100.0 | 28.0 | 63.0 | 80 | 1.25 | 18000 |
| | | | | | | *.669* | | *3.533* | *2.795* | *3.937* | *1.102* | *2.480* | *1160* | | |
| | ER20 | 7 | 1 | 2 | A2B14-40 20 070 | 21.0 | M16 | 58.8 | 41.0 | 70.0 | 34.0 | 63.0 | 80 | 1.15 | 18000 |
| | | | | | | *.827* | | *2.317* | *1.614* | *2.756* | *1.339* | *2.480* | *1160* | | |
| | ER20 | 7 | 1 | 2 | A2B14-40 20 100 | 21.0 | M16 | 88.8 | 71.0 | 100.0 | 34.0 | 63.0 | 80 | 1.33 | 18000 |
| | | | | | | *.827* | | *3.498* | *2.795* | *3.937* | *1.339* | *2.480* | *1160* | | |
| | ER25 | 7 | 1 | 2 | A2B14-40 25 070 | 26.0 | M16 | 58.3 | 41.0 | 70.0 | 42.0 | 63.0 | 80 | 1.22 | 18000 |
| | | | | | | *1.024* | | *2.297* | *1.614* | *2.756* | *1.654* | *2.480* | *1160* | | |
| | ER25 | 7 | 1 | 2 | A2B14-40 25 100 | 26.0 | M16 | 88.3 | 71.0 | 100.0 | 42.0 | 63.0 | 80 | 1.50 | 18000 |
| | | | | | | *1.024* | | *3.478* | *2.795* | *3.937* | *1.654* | *2.480* | *1160* | | |
| | ER32 | 7 | 1 | 2 | A2B14-40 32 070 | 33.0 | M16 | 57.3 | 41.0 | 70.0 | 50.0 | 63.0 | 80 | 1.24 | 18000 |
| | | | | | | *1.299* | | *2.257* | *1.614* | *2.756* | *1.969* | *2.480* | *1160* | | |
| | ER40 | 7 | 1 | 1 | A2B14-40 40 070 | 41.0 | M16 | 55.3 | 70.0 | | 63.0 | | 80 | 1.35 | 18000 |
| | | | | | | *1.614* | | *2.179* | *2.756* | | *2.480* | | *1160* | | |
| 50.0 | ER20 | 7 | 1 | 2 | A2B14-50 20 070 | 21.0 | M24 | 58.8 | 29.0 | 70.0 | 34.0 | 100.0 | 80 | 3.80 | 12000 |
| | | | | | | *.827* | | *2.317* | *1.142* | *2.756* | *1.339* | *3.937* | *1160* | | |
| | ER20 | 7 | 1 | 2 | A2B14-50 20 100 | 21.0 | M24 | 88.8 | 59.0 | 100.0 | 34.0 | 100.0 | 80 | 4.11 | 12000 |
| | | | | | | *.827* | | *3.498* | *2.323* | *3.937* | *1.339* | *3.937* | *1160* | | |
| | ER25 | 7 | 1 | 2 | A2B14-50 25 070 | 26.0 | M24 | 58.3 | 29.0 | 70.0 | 42.0 | 100.0 | 80 | 3.88 | 12000 |
| | | | | | | *1.024* | | *2.297* | *1.142* | *2.756* | *1.654* | *3.937* | *1160* | | |
| | ER25 | 7 | 1 | 2 | A2B14-50 25 100 | 26.0 | M24 | 88.3 | 59.0 | 100.0 | 42.0 | 100.0 | 80 | 4.26 | 12000 |
| | | | | | | *1.024* | | *3.478* | *2.323* | *3.937* | *1.654* | *3.937* | *1160* | | |
| | ER32 | 7 | 1 | 2 | A2B14-50 32 070 | 33.0 | M24 | 57.3 | 28.6 | 70.0 | 50.0 | 100.0 | 80 | 3.84 | 12000 |
| | | | | | | *1.299* | | *2.257* | *1.128* | *2.756* | *1.969* | *3.937* | *1160* | | |
| | ER32 | 7 | 1 | 2 | A2B14-50 32 100 | 33.0 | M24 | 87.3 | 59.0 | 100.0 | 50.0 | 100.0 | 80 | 4.26 | 12000 |
| | | | | | | *1.299* | | *3.439* | *2.323* | *3.937* | *1.969* | *3.937* | *1160* | | |
| | ER40 | 7 | 1 | 2 | A2B14-50 40 080 | 41.0 | M24 | 65.3 | 39.0 | 80.0 | 63.0 | 100.0 | 80 | 4.04 | 12000 |
| | | | | | | *1.614* | | *2.572* | *1.535* | *3.150* | *2.480* | *3.937* | *1160* | | |

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

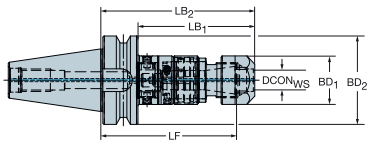
M1 N22 N15

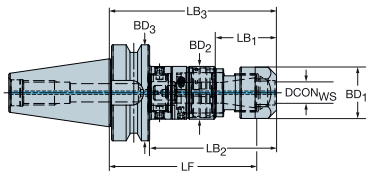
# MAS-BT 403 to CoroChuck™ 970

**Machine side interface compatible with JIS B 6339**

**Workpiece side interface DIN 6499-B**

DSGN 2 5



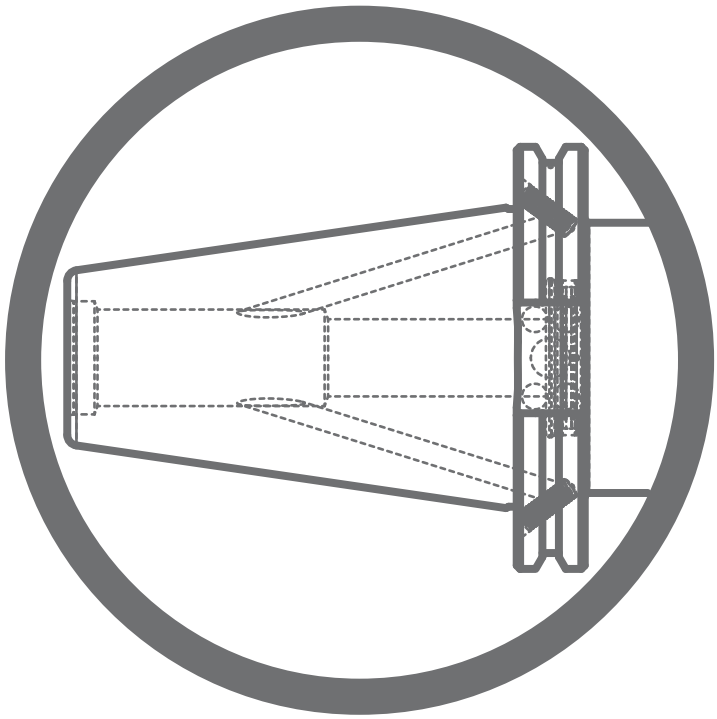




| | | | | | | | Dimensions, mm, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | TRMAX | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | KG | RPMX |
| 30.0 | ER11 | M5 | 1 | 1 | 5 | 970-B30-11-082 | 11.3 | M12 | 78.2 | 24.1 | 60.0 | 82.0 | 18.7 | 23.5 | 46.0 | 80 | 0.55 | 8000 |
| | | | | | | | *.445* | | *3.079* | *.949* | *2.362* | *3.228* | *.736* | *.925* | *1.811* | *1160* | | |
| | ER20 | M12 | 1 | 1 | 5 | 970-B30-20-105 | 20.8 | M12 | 92.2 | 35.3 | 78.1 | 100.2 | 33.7 | 35.0 | 46.0 | 80 | 0.83 | 8000 |
| | | | | | | | *.819* | | *3.630* | *1.390* | *3.075* | *3.945* | *1.327* | *1.378* | *1.811* | *1160* | | |
| | ER25 | M20 | 1 | 1 | 5 | 970-B30-25-125 | 25.8 | M12 | 111.1 | 37.1 | 97.6 | 119.6 | 42.0 | 44.0 | 46.0 | 80 | 1.19 | 8000 |
| | | | | | | | *1.016* | | *4.374* | *1.461* | *3.843* | *4.709* | *1.654* | *1.732* | *1.811* | *1160* | | |
| 40.0 | ER20 | M12 | 1 | 1 | 5 | 970-B40-20-110 | 20.8 | M16 | 97.2 | 35.3 | 78.1 | 105.2 | 33.7 | 35.0 | 63.0 | 80 | 1.42 | 8000 |
| | | | | | | | *.819* | | *3.827* | *1.390* | *3.075* | *4.142* | *1.327* | *1.378* | *2.480* | *1160* | | |
| | ER25 | M20 | 1 | 1 | 5 | 970-B40-25-130 | 25.8 | M16 | 116.1 | 37.1 | 97.6 | 124.6 | 42.0 | 44.0 | 63.0 | 80 | 1.78 | 8000 |
| | | | | | | | *1.016* | | *4.571* | *1.461* | *3.843* | *4.906* | *1.654* | *1.732* | *2.480* | *1160* | | |
| | ER32 | M20 | 1 | 1 | 2 | 970-B40-32-133 | 32.8 | M16 | 123.8 | 106.3 | 133.3 | | 50.0 | 63.0 | | 80 | 1.74 | 8000 |
| | | | | | | | *1.291* | | *4.874* | *4.185* | *5.248* | | *1.969* | *2.480* | | *1160* | | |
| 50.0 | ER20 | M12 | 1 | 1 | 5 | 970-B50-20-125 | 20.8 | M24 | 112.2 | 35.3 | 82.1 | 120.2 | 33.7 | 35.0 | 100.0 | 80 | 4.09 | 8000 |
| | | | | | | | *.819* | | *4.417* | *1.390* | *3.232* | *4.732* | *1.327* | *1.378* | *3.937* | *1160* | | |
| | ER25 | M20 | 1 | 1 | 5 | 970-B50-25-145 | 25.8 | M24 | 131.1 | 37.1 | 101.6 | 139.6 | 42.0 | 44.0 | 100.0 | 80 | 4.47 | 8000 |
| | | | | | | | *1.016* | | *5.161* | *1.461* | *4.000* | *5.496* | *1.654* | *1.732* | *3.937* | *1160* | | |
| | ER32 | M20 | 1 | 1 | 2 | 970-B50-32-148 | 32.8 | M24 | 138.8 | 110.3 | 148.3 | | 50.0 | 100.0 | | 80 | 4.33 | 8000 |
| | | | | | | | *1.291* | | *5.465* | *4.343* | *5.839* | | *1.969* | *3.937* | | *1160* | | |
| | ER40 | M30 | 1 | 1 | 2 | 970-B50-40-174 | 40.8 | M24 | 157.2 | 130.6 | 168.6 | | 63.0 | 100.0 | | 80 | 5.90 | 8000 |
| | | | | | | | *1.606* | | *6.189* | *5.142* | *6.638* | | *2.480* | *3.937* | | *1160* | | |

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

M1 N22 N15 N5

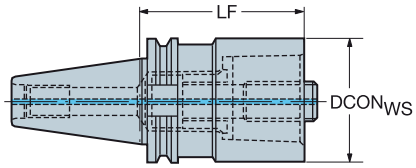
# Machine side interface CAT-V

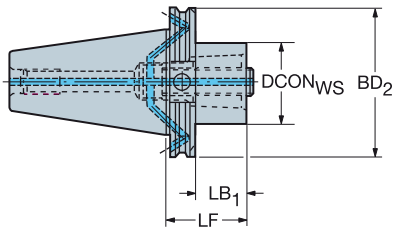


# CAT-V to Coromant Capto® adapter

**Machine side interface ASME B5.50-2009**

DSGN 1 2




| | | | | | | Dimensions, mm, inch | | | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $BD_2$ | | | |
| 40.0 | C3 | 7 | 1 | 2 | C3-A390B.45-40 030 | 32.0 | 5/8"-11 | 30.0 | 10.9 | 30.0 | 63.5 | 80 | 45.0 | 0.88 |
| | | | | | | *1.260* | | *1.181* | *.429* | *1.181* | *2.500* | *1160* | | |
| | C3 | 7 | 1 | 2 | C3-A390B.45-40 060 | 32.0 | 5/8"-11 | 60.0 | 40.9 | 60.0 | 63.5 | 80 | 45.0 | 1.04 |
| | | | | | | *1.260* | | *2.362* | *1.610* | *2.362* | *2.500* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-A390B.45-40 030 | 40.0 | 5/8"-11 | 30.0 | 10.9 | 30.0 | 63.5 | 80 | 55.0 | 0.86 |
| | | | | | | *1.575* | | *1.181* | *.429* | *1.181* | *2.500* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-A390B.45-40 060 | 40.0 | 5/8"-11 | 60.0 | 40.9 | 60.0 | 63.5 | 80 | 55.0 | 1.13 |
| | | | | | | *1.575* | | *2.362* | *1.610* | *2.362* | *2.500* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-A390B.45-40 040 | 50.0 | 5/8"-11 | 40.0 | 20.9 | 40.0 | 63.5 | 80 | 95.0 | 0.96 |
| | | | | | | *1.969* | | *1.575* | *.823* | *1.575* | *2.500* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-A390B.45-40 080 | 50.0 | 5/8"-11 | 80.0 | 60.9 | 80.0 | 63.5 | 80 | 95.0 | 1.53 |
| | | | | | | *1.969* | | *3.150* | *2.398* | *3.150* | *2.500* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-A390B.45-40 085 | 63.0 | 5/8"-11 | 85.0 | 65.9 | 85.0 | 63.5 | 80 | 170.0 | 1.95 |
| | | | | | | *2.480* | | *3.346* | *2.594* | *3.346* | *2.500* | *1160* | | |
| 50.0 | C3 | 7 | 1 | 2 | C3-A390B.45-50 030 | 32.0 | 1"-8 | 30.0 | 10.9 | 30.0 | 98.4 | 80 | 45.0 | 2.72 |
| | | | | | | *1.260* | | *1.181* | *.429* | *1.181* | *3.874* | *1160* | | |
| | C3 | 7 | 1 | 2 | C3-A390B.45-50 060 | 32.0 | 1"-8 | 60.0 | 40.9 | 60.0 | 98.4 | 80 | 45.0 | 2.84 |
| | | | | | | *1.260* | | *2.362* | *1.610* | *2.362* | *3.874* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-A390B.45-50 030 | 40.0 | 1"-8 | 30.0 | 10.9 | 30.0 | 98.4 | 80 | 55.0 | 1.72 |
| | | | | | | *1.575* | | *1.181* | *.429* | *1.181* | *3.874* | *1160* | | |
| | C4 | 7 | 1 | 2 | C4-A390B.45-50 060 | 40.0 | 1"-8 | 60.0 | 40.9 | 60.0 | 98.4 | 80 | 55.0 | 2.95 |
| | | | | | | *1.575* | | *2.362* | *1.610* | *2.362* | *3.874* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-A390B.45-50 030 | 50.0 | 1"-8 | 30.0 | 10.9 | 30.0 | 98.4 | 80 | 95.0 | 2.70 |
| | | | | | | *1.969* | | *1.181* | *.429* | *1.181* | *3.874* | *1160* | | |
| | C5 | 7 | 1 | 2 | C5-A390B.45-50 070 | 50.0 | 1"-8 | 70.0 | 50.9 | 70.0 | 98.4 | 80 | 95.0 | 3.22 |
| | | | | | | *1.969* | | *2.756* | *2.004* | *2.756* | *3.874* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-A390B.45-50 030 | 63.0 | 1"-8 | 30.0 | 10.9 | 30.0 | 98.4 | 80 | 170.0 | 2.61 |
| | | | | | | *2.480* | | *1.181* | *.429* | *1.181* | *3.874* | *1160* | | |
| | C6 | 7 | 1 | 2 | C6-A390B.45-50 080 | 63.0 | 1"-8 | 80.0 | 60.9 | 80.0 | 98.4 | 80 | 170.0 | 3.70 |
| | | | | | | *2.480* | | *3.150* | *2.398* | *3.150* | *3.874* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-A390B.45-50 070 | 80.0 | 1"-8 | 70.0 | 50.9 | 70.0 | 98.4 | 80 | 170.0 | 3.81 |
| | | | | | | *3.150* | | *2.756* | *2.004* | *2.756* | *3.874* | *1160* | | |
| | C8 | 7 | 1 | 2 | C8-A390B.45-50 120 | 80.0 | 1"-8 | 120.0 | 100.9 | 120.0 | 98.4 | 80 | 170.0 | 5.68 |
| | | | | | | *3.150* | | *4.724* | *3.972* | *4.724* | *3.874* | *1160* | | |
| | C10 | 7 | 1 | 1 | C10-A390.44-50 140 | 100.0 | 1"-8 | 140.0 | 140.0 | | | 80 | 380.0 | 7.89 |
| | | | | | | *3.937* | | *5.512* | *5.512* | | | *1160* | | |

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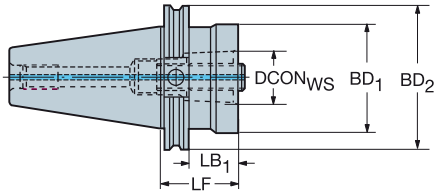
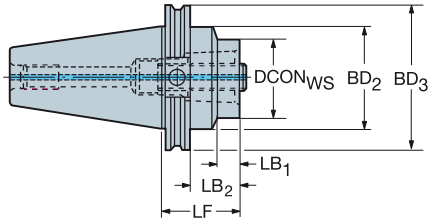
M1 N22 N15

# CAT-V to Coromant Capto® adapter

**Machine side interface ASME B5.50-1985**

DSGN 2 5

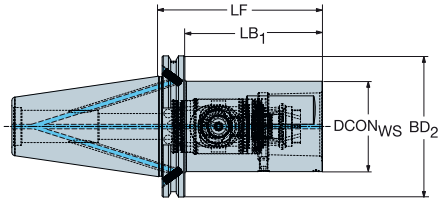



| | | | | | | Dimensions, mm, inch | | | | | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_2$ | $BD_3$ | | | |
| 45.0 | C5 | 1 | 1 | 5 | C5-A390.45-45 040 | 50.0 | 3/4"-10 | 40.0 | 2.8 | 20.9 | 40.0 | 57.4 | 82.6 | 80 | 45.0 | 1.86 |
| | | | | | | *1.969* | | *1.575* | *.110* | *.823* | *1.575* | *2.260* | *3.252* | *1160* | | |
| | C6 | 1 | 1 | 2 | C6-A390.45-45 050 | 63.0 | 3/4"-10 | 50.0 | 30.9 | 50.0 | | 82.5 | | 80 | 65.0 | 1.88 |
| | | | | | | *2.480* | | *1.969* | *1.217* | *1.969* | | *3.248* | | *1160* | | |
| 60.0 | C8 | 1 | 1 | 5 | C8-A390.45-60 050 | 80.0 | 1 1/4"-7 | 50.0 | 3.8 | 30.9 | 50.0 | 108.2 | 139.7 | 80 | 65.0 | 10.14 |
| | | | | | | *3.150* | | *1.969* | *.150* | *1.217* | *1.969* | *4.260* | *5.500* | *1160* | | |
| | C10 | 1 | 1 | 5 | C10-A390.45-60 050 | 100.0 | 1 1/4"-7 | 50.0 | 10.5 | 30.9 | 50.0 | 108.0 | 139.7 | 80 | 90.0 | 9.28 |
| | | | | | | *3.937* | | *1.969* | *.413* | *1.217* | *1.969* | *4.252* | *5.500* | *1160* | | |

# CAT-V to Coromant Capto® adapter with Quick change

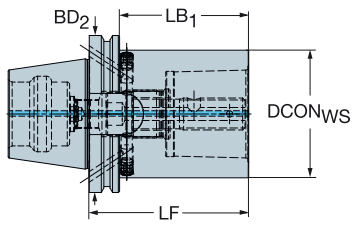
**Machine side interface compatible with ASME B5.50-2009**




**Metric bore**

| | | | | | Dimensions, mm, inch | | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_2$ | | | |
| 50.0 | C5 | 7 | 1 | V50-QC-C5-095 | 50.0 | 1"-8 | 95.0 | 75.0 | 98.4 | 80 | 70.0 | 3.53 |
| | | | | | *1.969* | | *3.740* | *2.953* | *3.874* | *1160* | | |
| | C6 | 7 | 1 | V50-QC-C6-115 | 63.0 | 1"-8 | 115.0 | 95.0 | 98.4 | 80 | 90.0 | 4.43 |
| | | | | | *2.480* | | *4.528* | *3.740* | *3.874* | *1160* | | |
| | C8 | 7 | 1 | V50-QC-C8-150 | 80.0 | 1"-8 | 150.0 | 130.0 | 98.4 | 80 | 130.0 | 6.44 |
| | | | | | *3.150* | | *5.906* | *5.118* | *3.874* | *1160* | | |

# CAT-V short cone to Coromant Capto® adapter




| | | | | | Dimensions, mm, inch | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{WS}$ | LF | $LB_1$ | $BD_2$ | | | |
| 50.0 | C8 | 6 | 1 | C8-390.669-50 100 | 80.0 | 100.0 | 80.0 | 98.4 | 150 | 170.0 | 4.14 |
| | | | | | *3.150* | *3.937* | *3.150* | *3.874* | *2175* | | |

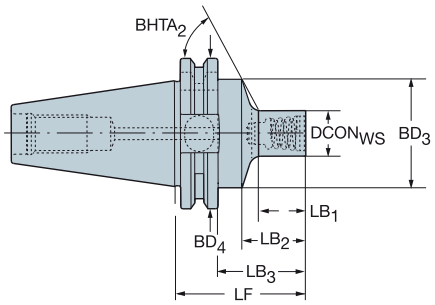
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15

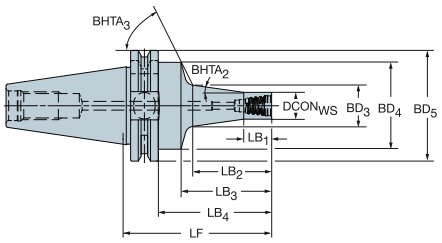
# CAT-V to Coromant EH adapter

**Machine side interface compatible with ASME B5.50-1985**

DSGN 11




18




## Inch version

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_3$ | $BD_4$ | $BHTA_2$ | $BHTA_3$ | BAR PSI | NM | KG | RPMX |
| 40.0 | E10 | 1 | 1 | 11 | **A392.45EH-40 10 056** | 9.2 | 5/8"-11 | 56.0 | 12.0 | 21.0 | 36.9 | 44.5 | 63 | 63° | 0° | 80 | 12.0 | 1.13 | 18000 |
| | | | | | | *.360* | | *2.205* | *.472* | *.827* | *1.453* | *1.752* | *2.500* | | | *1160* | | | |
| | E10 | 1 | 1 | 18 | **A392.45EH-40 10 068** | 9.2 | 5/8"-11 | 68.0 | 9.5 | 25.7 | 33.0 | 13.7 | 44 | 8° | 64° | 80 | 12.0 | 1.16 | 18000 |
| | | | | | | *.360* | | *2.677* | *.374* | *1.012* | *1.299* | *.539* | *1.748* | | | *1160* | | | |
| | E12 | 1 | 1 | 11 | **A392.45EH-40 12 060** | 12.2 | 5/8"-11 | 60.0 | 16.4 | 25.0 | 40.9 | 44.4 | 63 | 62° | 0° | 80 | 65.0 | 1.16 | 18000 |
| | | | | | | *.480* | | *2.362* | *.646* | *.984* | *1.610* | *1.748* | *2.500* | | | *1160* | | | |
| | E12 | 1 | 1 | 18 | **A392.45EH-40 12 078** | 12.2 | 5/8"-11 | 78.0 | 12.7 | 36.4 | 43.0 | 18.9 | 44 | 8° | 62° | 80 | 15.0 | 1.20 | 18000 |
| | | | | | | *.480* | | *3.071* | *.500* | *1.433* | *1.693* | *.744* | *1.748* | | | *1160* | | | |
| | E16 | 1 | 1 | 11 | **A392.45EH-40 16 065** | 15.4 | 5/8"-11 | 65.0 | 21.8 | 30.0 | 45.9 | 44.4 | 63 | 61° | 0° | 80 | 30.0 | 1.21 | 18000 |
| | | | | | | *.606* | | *2.559* | *.858* | *1.181* | *1.807* | *1.748* | *2.500* | | | *1160* | | | |
| | E16 | 1 | 1 | 18 | **A392.45EH-40 16 086** | 15.4 | 5/8"-11 | 86.0 | 15.8 | 45.1 | 51.0 | 23.6 | 44 | 8° | 60° | 80 | 30.0 | 1.28 | 18000 |
| | | | | | | *.606* | | *3.386* | *.622* | *1.776* | *2.008* | *.929* | *1.748* | | | *1160* | | | |
| | E20 | 1 | 1 | 11 | **A392.45EH-40 20 060** | 18.4 | 5/8"-11 | 60.0 | 17.2 | 25.0 | 40.9 | 44.4 | 63 | 60° | 0° | 80 | 50.0 | 1.22 | 18000 |
| | | | | | | *.724* | | *2.362* | *.677* | *.984* | *1.610* | *1.748* | *2.500* | | | *1160* | | | |
| | E20 | 1 | 1 | 18 | **A392.45EH-40 20 096** | 18.4 | 5/8"-11 | 96.0 | 19.0 | 55.7 | 61.0 | 28.7 | 44 | 8° | 55° | 80 | 50.0 | 1.35 | 18000 |
| | | | | | | *.724* | | *3.780* | *.748* | *2.193* | *2.402* | *1.130* | *1.748* | | | *1160* | | | |
| | E25 | 1 | 1 | 11 | **A392.45EH-40 25 068** | 24.4 | 5/8"-11 | 68.0 | 26.0 | 33.0 | 48.9 | 44.4 | 63 | 56° | 0° | 80 | 65.0 | 1.29 | 18000 |
| | | | | | | *.961* | | *2.677* | *1.024* | *1.299* | *1.925* | *1.748* | *2.500* | | | *1160* | | | |
| | E25 | 1 | 1 | 18 | **A392.45EH-40 25 114** | 24.4 | 5/8"-11 | 114.0 | 25.4 | 76.3 | 79.0 | 38.7 | 44 | 8° | 44° | 80 | 65.0 | 1.59 | 18000 |
| | | | | | | *.961* | | *4.488* | *1.000* | *3.004* | *3.110* | *1.524* | *1.748* | | | *1160* | | | |

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

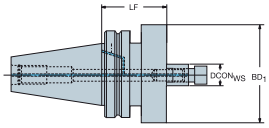
M1 N22 N6 N15 N3

# CAT-V to arbor adapter

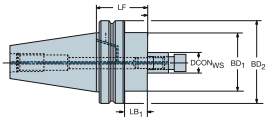
**Machine side interface compatible with ASME B5.50-1985**

DSGN

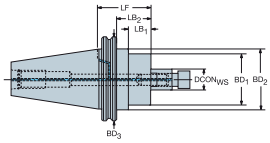
1




2




5




## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 22 | 7 | 1 | 2 | AA3B05-40 22 035 | 22.0 | | 5/8"-11 | 35.0 | 13.9 | 43.5 | 63.6 | 80 | 45.0 | 1.12 | 18000 |
| | | | | | | *.866* | | | *1.378* | *.549* | *1.711* | *2.502* | *1160* | | | |
| | 27 | 7 | 1 | 2 | AA3B05-40 27 050 | 27.0 | | 5/8"-11 | 50.0 | 30.9 | 60.0 | 63.6 | 80 | 80.0 | 1.48 | 18000 |
| | | | | | | *1.063* | | | *1.969* | *1.217* | *2.362* | *2.502* | *1160* | | | |
| 50.0 | 22 | 7 | 1 | 2 | AA3B05-50 22 035 | 22.0 | | 1"-8 | 35.0 | 15.9 | 43.5 | 98.4 | 80 | 45.0 | 3.04 | 12000 |
| | | | | | | *.866* | | | *1.378* | *.626* | *1.711* | *3.875* | *1160* | | | |
| | 27 | 7 | 1 | 2 | AA3B05-50 27 035 | 27.0 | | 1"-8 | 35.0 | 15.9 | 60.0 | 98.4 | 80 | 80.0 | 3.26 | 12000 |
| | | | | | | *1.063* | | | *1.378* | *.626* | *2.362* | *3.875* | *1160* | | | |
| | 32 | 7 | 1 | 2 | AA3B05-50 32 050 | 32.0 | | 1"-8 | 50.0 | 29.9 | 78.0 | 98.4 | 80 | 180.0 | 3.99 | 12000 |
| | | | | | | *1.260* | | | *1.969* | *1.179* | *3.071* | *3.875* | *1160* | | | |
| | 40S | 7 | 1 | 2 | AA3B05-50 40 050 | 40.0 | 66.7 | 1"-8 | 50.0 | 29.9 | 89.0 | 98.4 | 80 | 300.0 | 4.46 | 12000 |
| | | | | | | *1.575* | *2.626* | | *1.969* | *1.179* | *3.504* | *3.875* | *1160* | | | |

## Inch pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 3/4 | 7 | 1 | 2 | AA3B05-40 19 038 | 19.1 | | 5/8"-11 | 38.1 | 15.9 | 38.1 | | 44.5 | 63.6 | | 80 | 25.0 | 1.11 | 18000 |
| | | | | | | *.750* | | | *1.500* | *.626* | *1.500* | | *1.750* | *2.502* | | *1160* | | | |
| | 1 | 7 | 1 | 2 | AA3B05-40 25 051 | 25.4 | | 5/8"-11 | 50.8 | 31.7 | 50.8 | | 57.2 | 63.6 | | 80 | 65.0 | 1.49 | 18000 |
| | | | | | | *1.000* | | | *2.000* | *1.250* | *2.000* | | *2.250* | *2.502* | | *1160* | | | |
| | 1 1/4 | 7 | 1 | 1 | AA3B05-40 32 057 | 31.8 | | 5/8"-11 | 57.2 | 57.1 | | | 69.9 | | | 80 | 180.0 | 2.06 | 18000 |
| | | | | | | *1.250* | | | *2.250* | *2.250* | | | *2.750* | | | *1160* | | | |
| | 1 1/2 | 7 | 1 | 1 | AA3B05-40 38 061 | 38.1 | | 5/8"-11 | 61.0 | 60.9 | | | 95.3 | | | 80 | 220.0 | 2.88 | 18000 |
| | | | | | | *1.500* | | | *2.400* | *2.400* | | | *3.750* | | | *1160* | | | |
| 50.0 | 3/4 | 7 | 1 | 5 | AA3B05-50 19 038 | 19.1 | | 1"-8 | 38.1 | 3.0 | 19.0 | 38.1 | 44.4 | 69.8 | 98.4 | 80 | 25.0 | 3.20 | 12000 |
| | | | | | | *.750* | | | *1.500* | *.118* | *.748* | *1.500* | *1.748* | *2.748* | *3.875* | *1160* | | | |
| | 3/4 | 7 | 1 | 5 | AA3B05-50 19 089 | 19.1 | | 1"-8 | 88.9 | 53.8 | 69.8 | 88.9 | 44.4 | 69.8 | 98.4 | 80 | 25.0 | 3.79 | 12000 |
| | | | | | | *.750* | | | *3.500* | *2.118* | *2.748* | *3.500* | *1.748* | *2.748* | *3.875* | *1160* | | | |
| | 1 | 7 | 1 | 5 | AA3B05-50 25 051 | 25.4 | | 1"-8 | 50.8 | 15.7 | 31.8 | 50.8 | 57.2 | 69.8 | 98.4 | 80 | 65.0 | 3.60 | 12000 |
| | | | | | | *1.000* | | | *2.000* | *.618* | *1.252* | *2.000* | *2.252* | *2.748* | *3.875* | *1160* | | | |
| | 1 | 7 | 1 | 5 | AA3B05-50 25 101 | 25.4 | | 1"-8 | 101.6 | 66.5 | 82.6 | 101.6 | 57.2 | 69.8 | 98.4 | 80 | 65.0 | 4.53 | 12000 |
| | | | | | | *1.000* | | | *4.000* | *2.618* | *3.252* | *4.000* | *2.252* | *2.748* | *3.875* | *1160* | | | |
| | 1 1/4 | 7 | 1 | 2 | AA3B05-50 32 089 | 31.8 | | 1"-8 | 88.9 | 69.8 | 88.9 | | 69.8 | 98.4 | | 80 | 180.0 | 4.88 | 12000 |
| | | | | | | *1.250* | | | *3.500* | *2.748* | *3.500* | | *2.748* | *3.875* | | *1160* | | | |
| | 1 1/2 | 7 | 1 | 2 | AA3B05-50 38 061 | 38.1 | | 1"-8 | 61.0 | 41.9 | 61.0 | | 95.3 | 98.4 | | 80 | 220.0 | 4.85 | 12000 |
| | | | | | | *1.500* | | | *2.400* | *1.650* | *2.402* | | *3.750* | *3.875* | | *1160* | | | |
| | 1 1/2 | 7 | 1 | 2 | AA3B05-50 38 101 | 38.1 | | 1"-8 | 101.6 | 82.6 | 101.6 | | 95.3 | 98.4 | | 80 | 220.0 | 6.49 | 12000 |
| | | | | | | *1.500* | | | *4.000* | *3.252* | *4.000* | | *3.750* | *3.875* | | *1160* | | | |
| | 2 1/2 | 7 | 1 | 1 | AA3B05-50 63 061 | 63.5 | 101.6 | 1"-8 | 61.0 | 60.9 | | | 123.8 | | | 80 | 120.0 | 6.57 | 12000 |
| | | | | | | *2.500* | *4.000* | | *2.400* | *2.400* | | | *4.875* | | | *1160* | | | |

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 M12.

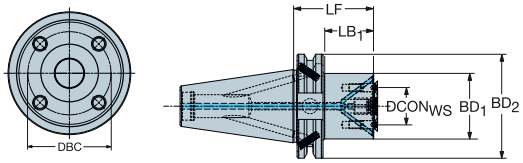
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

# CAT-V to arbor with driving screws adapter

**Machine side interface ASME B5.50-2009**

**For CoroMill® QD with internal coolant supply**




### Metric pilot

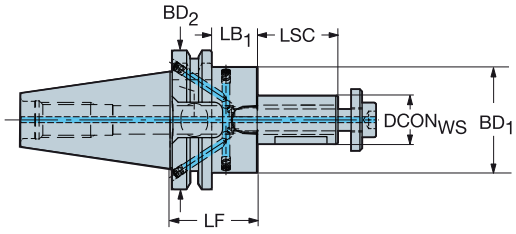
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LSC | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | X10 | 7 | 3 | V40-X10-032-045 | 10.0 | 22.0 | 5/8"-11 | 2 | 45.0 | 24.5 | 32.0 | 63.5 | 80 | 6.4 | 1.02 | 12000 |
| | | | | | *.394* | *.866* | | *.094* | *1.772* | *.965* | *1.260* | *2.500* | *1160* | | | |

### Inch pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | DBC | CRKS | LSC | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | Y25 | 7 | 3 | V40-Y25-050-060 | 25.4 | 36.0 | 5/8"-11 | 2 | 60.0 | 39.5 | 50.0 | 63.5 | 80 | 3.9 | 1.47 | 11000 |
| | | | | | *1.000* | *1.417* | | *.094* | *2.362* | *1.555* | *1.969* | *2.500* | *1160* | | | |
| | Y31 | 7 | 3 | V40-Y31-063-070 | 31.8 | 45.0 | 5/8"-11 | 2 | 70.0 | 50.5 | 63.0 | 63.5 | 80 | 6.4 | 2.10 | 10000 |
| | | | | | *1.250* | *1.772* | | *.094* | *2.756* | *1.988* | *2.480* | *2.500* | *1160* | | | |

# CAT-V to side and face-mill arbor adapter

**Machine side interface compatible with ASME B5.50-1985**




### Inch pilot

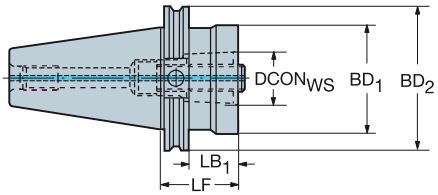
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 1 | 7 | 1 | AA3B10-40 25 055 | 25.4 | 5/8"-11 | 50 | 55.0 | 35.9 | 43.0 | 63.6 | 20 | 65.0 | 1.49 | 18000 |
| | | | | | *1.000* | | *1.969* | *2.165* | *1.413* | *1.693* | *2.502* | *290* | | | |
| | 1 1/4 | 7 | 1 | AA3B10-40 31 060 | 31.8 | 5/8"-11 | 60 | 60.0 | 40.9 | 48.0 | 63.6 | 20 | 120.0 | 1.82 | 18000 |
| | | | | | *1.250* | | *2.362* | *2.362* | *1.610* | *1.890* | *2.502* | *290* | | | |
| | 1 1/2 | 7 | 1 | AA3B10-40 38 060 | 38.1 | 5/8"-11 | 60 | 60.0 | 40.9 | 56.0 | 63.6 | 20 | 220.0 | 2.15 | 18000 |
| | | | | | *1.500* | | *2.362* | *2.362* | *1.610* | *2.205* | *2.502* | *290* | | | |

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

M1 N22 N15

# CAT-V to VL adapter

**Machine side interface compatible with ASME B5.50-1985**

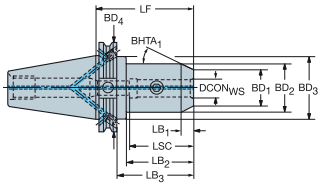



| | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $BD_2$ | BAR PSI | NM | KG |
| 50.0 | 80 | 1 | 1 | A390.45-50 80 050M | 80.0 | 1"-8 | 50.0 | 30.9 | 50.0 | 98.4 | 20 | 180.0 | 3.68 |
| | | | | | *3.150* | | *1.969* | *1.217* | *1.969* | *3.874* | *290* | | |

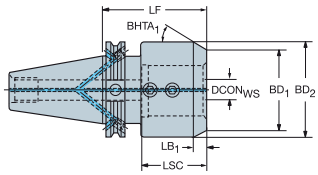
# CAT-V to Weldon adapter

**Machine side interface compatible with ASME B5.50-1985**

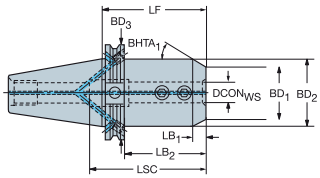
DSGN 10




DSGN 3




DSGN 6




**Metric bore**

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 20 | 7 | 1 | 6 | 392.45520-40 20 089 | 20.0 | 5/8"-11 | 88.9 | 7.6 | 71.4 | 90.4 | 29.2 | 44.4 | 63.5 | | 45° | 20 | 20.0 | 1.49 | 18000 |
| | | | | | | *.787* | | *3.500* | *.299* | *2.811* | *3.559* | *1.150* | *1.748* | *2.500* | | | *290* | | | |
| | 25 | 7 | 1 | 6 | 392.45520-40 25 100 | 25.0 | 5/8"-11 | 101.6 | 7.6 | 82.6 | 101.6 | 35.6 | 50.8 | 63.5 | | 45° | 20 | 25.0 | 1.72 | 18000 |
| | | | | | | *.984* | | *4.000* | *.299* | *3.252* | *4.000* | *1.402* | *2.000* | *2.500* | | | *290* | | | |
| | 32 | 7 | 1 | 3 | 392.45520-40 32 100 | 32.0 | 5/8"-11 | 101.6 | 10.8 | 101.6 | | 41.9 | 63.5 | | | 45° | 20 | 40.0 | 2.13 | 18000 |
| | | | | | | *1.260* | | *4.000* | *.425* | *4.000* | | *1.650* | *2.500* | | | | *290* | | | |
| 50.0 | 20 | 7 | 1 | 10 | 392.45520-50 20 095 | 20.0 | 1"-8 | 95.3 | 7.6 | 60.2 | 76.2 | 29.2 | 44.4 | 69.8 | 98 | 45° | 20 | 20.0 | 3.54 | 12000 |
| | | | | | | *.787* | | *3.750* | *.299* | *2.370* | *3.000* | *1.150* | *1.748* | *2.750* | *3.874* | | *290* | | | |
| | 25 | 7 | 1 | 10 | 392.45520-50 25 100 | 25.0 | 1"-8 | 101.6 | 7.6 | 66.5 | 82.6 | 35.6 | 50.8 | 69.8 | 98 | 45° | 20 | 25.0 | 3.84 | 12000 |
| | | | | | | *.984* | | *4.000* | *.299* | *2.618* | *3.250* | *1.400* | *2.000* | *2.750* | *3.874* | | *290* | | | |
| | 32 | 7 | 1 | 10 | 392.45520-50 32 100 | 32.0 | 1"-8 | 101.6 | 10.8 | 66.5 | 82.6 | 41.9 | 63.5 | 69.8 | 98 | 45° | 20 | 40.0 | 4.25 | 12000 |
| | | | | | | *1.260* | | *4.000* | *.425* | *2.618* | *3.250* | *1.650* | *2.500* | *2.750* | *3.874* | | *290* | | | |
| | 40 | 7 | 1 | 6 | 392.45520-50 40 100 | 40.0 | 1"-8 | 101.6 | 10.8 | 82.5 | 101.6 | 48.2 | 69.8 | 98.4 | | 45° | 20 | 50.0 | 4.26 | 12000 |
| | | | | | | *1.575* | | *4.000* | *.425* | *3.250* | *4.000* | *1.898* | *2.748* | *3.874* | | | *290* | | | |

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

M1 N22 N15

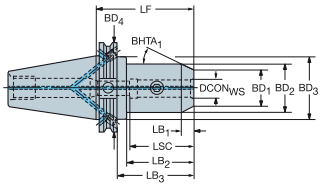
# CAT-V to Weldon adapter

**Machine side interface compatible with ASME B5.50-1985**

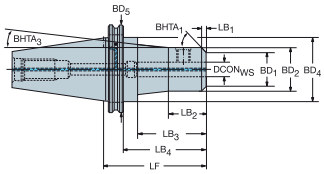
**Workpiece side interface ANSI B94.19**

DSGN

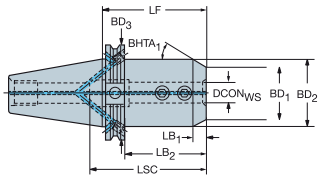
10




20




6




## Inch bore

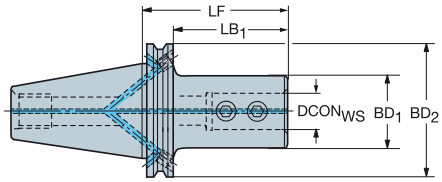
| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | $BHTA_3$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 1/8 | 7 | 1 | 6 | AA3B20-40 03 044 | 3.2 | 5/8"-11 | 44.5 | 2.0 | 25.4 | 44.4 | 13.4 | 17.5 | 63.5 | | 45° | 0° | 20 | 3.0 | 1.08 | 18000 |
| | | | | | | .125 | | 1.750 | .079 | 1.000 | 1.748 | .528 | .689 | 2.500 | | | | 290 | | | |
| | 1/4 | 7 | 1 | 10 | AA3B20-40 06 063 | 6.4 | 5/8"-11 | 63.5 | 2.8 | 28.4 | 44.4 | 16.6 | 22.2 | 44.4 | 63 | 45° | 0° | 20 | 7.0 | 1.09 | 18000 |
| | | | | | | .250 | | 2.500 | .110 | 1.118 | 1.748 | .654 | .874 | 1.748 | 2.500 | | | 290 | | | |
| | 3/8 | 7 | 1 | 6 | AA3B20-40 09 044 | 9.5 | 5/8"-11 | 44.5 | 2.8 | 25.4 | 44.4 | 19.6 | 25.4 | 63.5 | | 45° | 0° | 20 | 10.0 | 0.93 | 18000 |
| | | | | | | .375 | | 1.750 | .110 | 1.000 | 1.748 | .772 | 1.000 | 2.500 | | | | 290 | | | |
| | 3/8 | 7 | 1 | 10 | AA3B20-40 09 063 | 9.5 | 5/8"-11 | 63.5 | 2.8 | 28.4 | 44.4 | 20.0 | 25.4 | 44.4 | 63 | 45° | 0° | 20 | 10.0 | 1.11 | 18000 |
| | | | | | | .375 | | 2.500 | .110 | 1.118 | 1.748 | .787 | 1.000 | 1.748 | 2.500 | | | 290 | | | |
| | 1/2 | 7 | 1 | 6 | AA3B20-40 13 044 | 12.7 | 5/8"-11 | 44.5 | 9.4 | 25.4 | 44.4 | 25.7 | 44.4 | 63.5 | | 45° | 0° | 20 | 12.0 | 0.94 | 18000 |
| | | | | | | .500 | | 1.750 | .370 | 1.000 | 1.748 | 1.012 | 1.748 | 2.500 | | | | 290 | | | |
| | 1/2 | 7 | 1 | 10 | AA3B20-40 13 067 | 12.7 | 5/8"-11 | 66.6 | 4.6 | 31.5 | 47.5 | 22.6 | 31.8 | 44.4 | 63 | 45° | 0° | 20 | 12.0 | 1.17 | 18000 |
| | | | | | | .500 | | 2.620 | .181 | 1.240 | 1.870 | .890 | 1.252 | 1.748 | 2.500 | | | 290 | | | |
| | 5/8 | 7 | 1 | 6 | AA3B20-40 16 044 | 15.9 | 5/8"-11 | 44.5 | 9.4 | 25.4 | 44.4 | 25.7 | 44.4 | 63.5 | | 45° | 0° | 20 | 15.0 | 0.92 | 18000 |
| | | | | | | .625 | | 1.750 | .370 | 1.000 | 1.748 | 1.012 | 1.748 | 2.500 | | | | 290 | | | |
| | 5/8 | 7 | 1 | 10 | AA3B20-40 16 070 | 15.9 | 5/8"-11 | 69.9 | 5.6 | 34.8 | 50.8 | 26.4 | 38.1 | 44.4 | 63 | 45° | 0° | 20 | 15.0 | 1.23 | 18000 |
| | | | | | | .625 | | 2.750 | .220 | 1.370 | 2.000 | 1.039 | 1.500 | 1.748 | 2.500 | | | 290 | | | |
| | 3/4 | 7 | 1 | 6 | AA3B20-40 19 044 | 19.1 | 5/8"-11 | 44.5 | 9.4 | 25.4 | 44.4 | 25.7 | 44.4 | 63.5 | | 45° | 0° | 20 | 20.0 | 1.00 | 18000 |
| | | | | | | .750 | | 1.750 | .370 | 1.000 | 1.748 | 1.012 | 1.748 | 2.500 | | | | 290 | | | |
| | 3/4 | 7 | 1 | 6 | AA3B20-40 19 089 | 19.1 | 5/8"-11 | 88.9 | 7.6 | 69.8 | 88.9 | 29.2 | 44.4 | 63.5 | | 45° | 0° | 20 | 20.0 | 1.45 | 18000 |
| | | | | | | .750 | | 3.500 | .299 | 2.748 | 3.500 | 1.150 | 1.748 | 2.500 | | | | 290 | | | |
| | 1 | 7 | 1 | 6 | AA3B20-40 25 044 | 25.4 | 5/8"-11 | 44.5 | 4.3 | 25.4 | 44.4 | 39.8 | 48.3 | 63.5 | | 45° | 0° | 20 | 25.0 | 0.97 | 18000 |
| | | | | | | 1.000 | | 1.750 | .169 | 1.000 | 1.748 | 1.567 | 1.900 | 2.500 | | | | 290 | | | |
| | 1 | 7 | 1 | 6 | AA3B20-40 25 101 | 25.4 | 5/8"-11 | 101.6 | 7.6 | 82.6 | 101.6 | 35.5 | 50.8 | 63.5 | | 45° | 0° | 20 | 25.0 | 1.59 | 18000 |
| | | | | | | 1.000 | | 4.000 | .299 | 3.252 | 4.000 | 1.398 | 2.000 | 2.500 | | | | 290 | | | |
| | 1 1/4 | 7 | 1 | 3 | AA3B20-40 32 101 | 31.8 | 5/8"-11 | 101.6 | 10.6 | 101.6 | | 42.8 | 63.5 | | | 45° | | 20 | 45.0 | 1.77 | 18000 |
| | | | | | | 1.250 | | 4.000 | .417 | 4.000 | | 1.685 | 2.500 | | | | | 290 | | | |
| | 1 1/2 | 7 | 1 | 3 | AA3B20-40 38 101 | 38.1 | 5/8"-11 | 101.6 | 9.1 | 101.6 | | 48.4 | 66.7 | | | 45° | | 20 | 45.0 | 2.18 | 18000 |
| | | | | | | 1.500 | | 4.000 | .358 | 4.000 | | 1.906 | 2.625 | | | | | 290 | | | |
| 50.0 | 3/8 | 7 | 1 | 10 | AA3B20-50 09 063 | 9.5 | 1"-8 | 63.5 | 2.8 | 28.4 | 44.4 | 19.6 | 25.4 | 69.8 | 98 | 45° | 0° | 20 | 10.0 | 3.12 | 12000 |
| | | | | | | .375 | | 2.500 | .110 | 1.118 | 1.748 | .772 | 1.000 | 2.748 | 3.874 | | | 290 | | | |
| | 3/8 | 7 | 1 | 20 | AA3B20-50 09 165 | 9.5 | 1"-8 | 165.1 | 2.8 | 76.2 | 130.0 | 19.6 | 25.4 | 25.4 | 69 | 45° | 7° | 20 | 10.0 | 3.59 | 12000 |
| | | | | | | .375 | | 6.500 | .110 | 3.000 | 5.118 | .772 | 1.000 | 1.000 | 2.748 | | | 290 | | | |
| | 1/2 | 7 | 1 | 10 | AA3B20-50 13 067 | 12.7 | 1"-8 | 66.7 | 4.6 | 31.6 | 47.6 | 22.4 | 31.8 | 69.8 | 98 | 45° | 0° | 20 | 12.0 | 3.04 | 12000 |
| | | | | | | .500 | | 2.625 | .181 | 1.244 | 1.874 | .882 | 1.252 | 2.748 | 3.874 | | | 290 | | | |
| | 1/2 | 7 | 1 | 20 | AA3B20-50 13 168 | 12.7 | 1"-8 | 168.3 | 4.6 | 79.5 | 133.2 | 22.4 | 31.8 | 31.8 | 69 | 45° | 7° | 20 | 12.0 | 3.89 | 12000 |
| | | | | | | .500 | | 6.625 | .181 | 3.130 | 5.244 | .882 | 1.252 | 1.252 | 2.748 | | | 290 | | | |
| | 5/8 | 7 | 1 | 10 | AA3B20-50 16 095 | 15.9 | 1"-8 | 95.3 | 5.8 | 60.2 | 76.2 | 26.4 | 38.1 | 69.8 | 98 | 45° | 0° | 20 | 15.0 | 3.51 | 12000 |
| | | | | | | .625 | | 3.750 | .228 | 2.370 | 3.000 | 1.039 | 1.500 | 2.748 | 3.874 | | | 290 | | | |
| | 5/8 | 7 | 1 | 20 | AA3B20-50 16 197 | 15.9 | 1"-8 | 196.9 | 5.8 | 108.0 | 161.8 | 26.4 | 38.1 | 38.1 | 69 | 45° | 7° | 20 | 15.0 | 3.58 | 12000 |
| | | | | | | .625 | | 7.750 | .228 | 4.252 | 6.370 | 1.039 | 1.500 | 1.500 | 2.748 | | | 290 | | | |
| | 3/4 | 7 | 1 | 10 | AA3B20-50 19 095 | 19.1 | 1"-8 | 95.3 | 7.6 | 60.2 | 76.2 | 29.2 | 44.4 | 69.8 | 98 | 45° | 0° | 20 | 20.0 | 3.60 | 12000 |
| | | | | | | .750 | | 3.750 | .299 | 2.370 | 3.000 | 1.150 | 1.748 | 2.748 | 3.874 | | | 290 | | | |
| | 3/4 | 7 | 1 | 20 | AA3B20-50 19 197 | 19.1 | 1"-8 | 196.9 | 7.6 | 108.0 | 161.8 | 29.2 | 44.4 | 44.4 | 69 | 45° | 7° | 20 | 20.0 | 4.80 | 12000 |
| | | | | | | .750 | | 7.750 | .299 | 4.252 | 6.370 | 1.150 | 1.748 | 1.748 | 2.748 | | | 290 | | | |
| | 1 | 7 | 1 | 10 | AA3B20-50 25 101 | 25.4 | 1"-8 | 101.6 | 7.6 | 66.5 | 82.6 | 35.5 | 50.8 | 69.8 | 98 | 45° | 0° | 20 | 25.0 | 3.70 | 12000 |
| | | | | | | 1.000 | | 4.000 | .299 | 2.618 | 3.252 | 1.398 | 2.000 | 2.748 | 3.874 | | | 290 | | | |
| | 1 | 7 | 1 | 20 | AA3B20-50 25 203 | 25.4 | 1"-8 | 203.2 | 7.6 | 114.3 | 168.1 | 35.5 | 50.8 | 50.8 | 66 | 45° | 7° | 20 | 25.0 | 5.24 | 12000 |
| | | | | | | 1.000 | | 8.000 | .299 | 4.500 | 6.618 | 1.398 | 2.000 | 2.000 | 2.630 | | | 290 | | | |
| | 1 1/4 | 7 | 1 | 10 | AA3B20-50 32 101 | 31.8 | 1"-8 | 101.6 | 10.7 | 66.5 | 82.6 | 42.2 | 63.5 | 69.8 | 98 | 45° | 0° | 20 | 45.0 | 4.13 | 12000 |
| | | | | | | 1.250 | | 4.000 | .421 | 2.618 | 3.252 | 1.661 | 2.500 | 2.748 | 3.874 | | | 290 | | | |
| | 1 1/4 | 7 | 1 | 10 | AA3B20-50 32 203 | 31.8 | 1"-8 | 203.2 | 10.7 | 168.1 | 184.2 | 42.2 | 63.5 | 69.8 | 98 | 45° | 0° | 20 | 45.0 | 6.49 | 12000 |
| | | | | | | 1.250 | | 8.000 | .421 | 6.618 | 7.252 | 1.661 | 2.500 | 2.748 | 3.874 | | | 290 | | | |
| | 1 1/2 | 7 | 1 | 6 | AA3B20-50 38 101 | 38.1 | 1"-8 | 101.6 | 10.7 | 82.6 | 101.6 | 48.5 | 69.8 | 98.4 | | 45° | 0° | 20 | 45.0 | 4.03 | 12000 |
| | | | | | | 1.500 | | 4.000 | .421 | 3.252 | 4.000 | 1.909 | 2.748 | 3.874 | | | | 290 | | | |
| | 2 | 7 | 1 | 6 | AA3B20-50 51 143 | 50.8 | 1"-8 | 142.9 | 10.7 | 123.8 | 142.9 | 73.9 | 95.2 | 98.4 | | 45° | 0° | 20 | 50.0 | 7.35 | 12000 |
| | | | | | | 2.000 | | 5.625 | .421 | 4.874 | 5.626 | 2.909 | 3.748 | 3.874 | | | | 290 | | | |

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

M1 N22 N15

# CAT-V to ISO 9766 adapter

**Machine side interface compatible with ASME B5.50-1985**




## Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 16 | 7 | 1 | A3B27-40 16 080 | 16.0 | 5/8"-11 | 49 | 80.0 | 60.9 | 36.0 | 63.5 | 20 | 10.0 | 1.24 | 18000 |
| | | | | | *.630* | | *1.949* | *3.150* | *2.400* | *1.417* | *2.500* | *290* | | | |
| | 20 | 7 | 1 | A3B27-40 20 080 | 20.0 | 5/8"-11 | 51 | 80.0 | 60.9 | 40.0 | 63.5 | 20 | 12.0 | 1.22 | 18000 |
| | | | | | *.787* | | *2.028* | *3.150* | *2.400* | *1.575* | *2.500* | *290* | | | |
| | 25 | 7 | 1 | A3B27-40 25 085 | 25.0 | 5/8"-11 | 57 | 85.0 | 65.9 | 44.5 | 63.5 | 20 | 20.0 | 1.41 | 18000 |
| | | | | | *.984* | | *2.264* | *3.346* | *2.596* | *1.750* | *2.500* | *290* | | | |
| | 32 | 7 | 1 | A3B27-40 32 090 | 32.0 | 5/8"-11 | 61 | 90.0 | 70.9 | 52.0 | 63.5 | 20 | 30.0 | 1.53 | 18000 |
| | | | | | *1.260* | | *2.421* | *3.543* | *2.793* | *2.047* | *2.500* | *290* | | | |
| 50.0 | 20 | 7 | 1 | A3B27-50 20 080 | 20.0 | 1"-8 | 51 | 80.0 | 60.9 | 40.0 | 98.4 | 20 | 12.0 | 3.15 | 12000 |
| | | | | | *.787* | | *2.028* | *3.150* | *2.400* | *1.575* | *3.874* | *290* | | | |
| | 25 | 7 | 1 | A3B27-50 25 085 | 25.0 | 1"-8 | 57 | 85.0 | 65.9 | 45.0 | 98.4 | 20 | 20.0 | 3.18 | 12000 |
| | | | | | *.984* | | *2.264* | *3.346* | *2.596* | *1.772* | *3.874* | *290* | | | |
| | 32 | 7 | 1 | A3B27-50 32 090 | 32.0 | 1"-8 | 61 | 90.0 | 70.9 | 52.0 | 98.4 | 20 | 30.0 | 3.37 | 12000 |
| | | | | | *1.260* | | *2.421* | *3.543* | *2.793* | *2.047* | *3.874* | *290* | | | |
| | 40 | 7 | 1 | A3B27-50 40 090 | 40.0 | 1"-8 | 71 | 90.0 | 70.9 | 65.0 | 98.4 | 20 | 40.0 | 3.74 | 12000 |
| | | | | | *1.575* | | *2.815* | *3.543* | *2.793* | *2.559* | *3.874* | *290* | | | |
| | 50 | 7 | 1 | A3B27-50 50 110 | 50.0 | 1"-8 | 81 | 110.0 | 90.9 | 75.0 | 98.4 | 20 | 45.0 | 4.44 | 12000 |
| | | | | | *1.969* | | *3.209* | *4.331* | *3.581* | *2.953* | *3.874* | *290* | | | |

## Inch bore

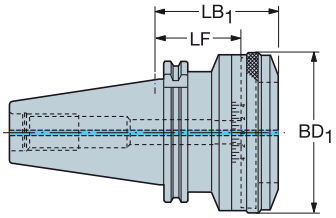
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 5/8 | 7 | 1 | AA3B27-40 15 080 | 15.9 | 5/8"-11 | 49 | 80.0 | 61.0 | 36.0 | 63.5 | 20 | 10.0 | 1.22 | 18000 |
| | | | | | *.625* | | *1.949* | *3.150* | *2.402* | *1.417* | *2.500* | *290* | | | |
| | 3/4 | 7 | 1 | AA3B27-40 19 080 | 19.1 | 5/8"-11 | 54 | 80.0 | 61.0 | 40.0 | 63.5 | 20 | 20.0 | 1.29 | 18000 |
| | | | | | *.750* | | *2.126* | *3.150* | *2.402* | *1.575* | *2.500* | *290* | | | |
| | 1 | 7 | 1 | AA3B27-40 25 085 | 25.4 | 5/8"-11 | 60 | 85.0 | 66.0 | 45.0 | 63.5 | 20 | 25.0 | 1.39 | 18000 |
| | | | | | *1.000* | | *2.382* | *3.346* | *2.598* | *1.772* | *2.500* | *290* | | | |
| | 1 1/4 | 7 | 1 | AA3B27-40 32 090 | 31.8 | 5/8"-11 | 64 | 90.0 | 71.0 | 52.0 | 63.5 | 20 | 45.0 | 1.51 | 18000 |
| | | | | | *1.250* | | *2.520* | *3.543* | *2.795* | *2.047* | *2.500* | *290* | | | |
| 50.0 | 3/4 | 7 | 1 | AA3B27-50 19 080 | 19.1 | 1"-8 | 54 | 80.0 | 61.0 | 40.0 | 98.5 | 20 | 20.0 | 3.14 | 12000 |
| | | | | | *.750* | | *2.126* | *3.150* | *2.402* | *1.575* | *3.878* | *290* | | | |
| | 1 | 7 | 1 | AA3B27-50 25 085 | 25.4 | 1"-8 | 60 | 85.0 | 66.0 | 45.0 | 98.5 | 20 | 25.0 | 3.22 | 12000 |
| | | | | | *1.000* | | *2.382* | *3.346* | *2.598* | *1.772* | *3.878* | *290* | | | |
| | 1 1/4 | 7 | 1 | AA3B27-50 32 090 | 31.8 | 1"-8 | 64 | 90.0 | 71.0 | 52.0 | 98.5 | 20 | 45.0 | 3.41 | 12000 |
| | | | | | *1.250* | | *2.520* | *3.543* | *2.795* | *2.047* | *3.878* | *290* | | | |
| | 1 1/2 | 7 | 1 | AA3B27-50 38 090 | 38.1 | 1"-8 | 71 | 90.0 | 71.0 | 65.0 | 98.5 | 20 | 45.0 | 3.84 | 12000 |
| | | | | | *1.500* | | *2.815* | *3.543* | *2.795* | *2.559* | *3.878* | *290* | | | |
| | 2 | 7 | 1 | AA3B27-50 51 110 | 50.8 | 1"-8 | 81 | 110.0 | 91.0 | 75.0 | 98.5 | 20 | 60.0 | 4.39 | 12000 |
| | | | | | *2.000* | | *3.209* | *4.331* | *3.583* | *2.953* | *3.878* | *290* | | | |

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

M1 N22 N15

# CAT-V to ISO 9766 adjustable adapter

**Machine side interface compatible with ASME B5.50-1985**




| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_1$ | BAR PSI | KG | RPMX |
| 40.0 | 1 | 1 | 1 | **A392.45277-40 01 055A** | 78.0 | 5/8"-11 | 55.0 | 79.6 | 86.0 | 20 | 2.16 | 12000 |
| | | | | | *3.071* | | *2.165* | *3.134* | *3.386* | *290* | | |
| 50.0 | 2 | 1 | 1 | **A392.45277-50 02 055A** | 98.0 | 1"-8 | 55.0 | 76.6 | 106.0 | 20 | 4.78 | 9000 |
| | | | | | *3.858* | | *2.165* | *3.016* | *4.173* | *290* | | |
| | 3 | 1 | 1 | **A392.45277-50 03 075A** | 136.0 | 1"-8 | 75.0 | 85.0 | 140.0 | 20 | 6.82 | 6000 |
| | | | | | *5.354* | | *2.953* | *3.346* | *5.512* | *290* | | |

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

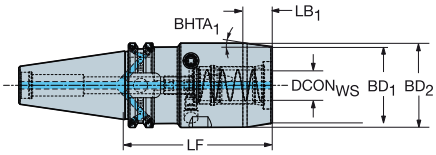
M1 N22 N15

# CAT-V to CoroChuck™ 930

**Heavy-duty design**

**Machine side interface ASME B5.50-2009**

DSGN 3

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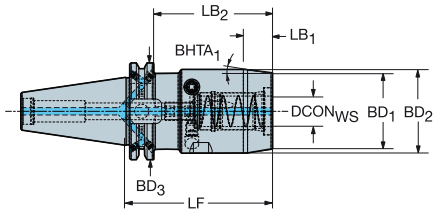
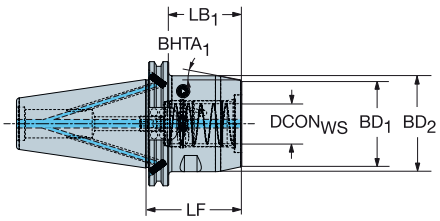



## Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 20 | 7 | 1 | 6 | 930-V40-HD-20-082 | 20.0 | 5/8"-11 | 51 | 82.0 | 17.8 | 62.9 | 82.0 | 50.0 | 55.0 | 63.5 | 8° | 80 | 10.0 | 1.81 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.228* | *.701* | *2.476* | *3.228* | *1.969* | *2.165* | *2.500* | | *1160* | | | |
| | 25 | 7 | 1 | 3 | 930-V40-HD-25-101 | 25.0 | 5/8"-11 | 57 | 101.0 | 18.8 | 101.0 | | 57.0 | 65.0 | | 12° | 80 | 10.0 | 2.48 | 18000 |
| | | | | | | *.984* | | *2.244* | *3.976* | *.740* | *3.976* | | *2.244* | *2.559* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 6 | 930-V50-HD-20-083 | 20.0 | 1"-8 | 51 | 83.0 | 17.8 | 63.9 | 83.0 | 50.0 | 55.0 | 98.4 | 8° | 80 | 10.0 | 3.69 | 12000 |
| | | | | | | *.787* | | *2.008* | *3.268* | *.701* | *2.516* | *3.268* | *1.969* | *2.165* | *3.874* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | 930-V50-HD-25-087 | 25.0 | 1"-8 | 57 | 87.0 | 18.8 | 65.4 | 87.0 | 57.0 | 65.0 | 98.4 | 12° | 80 | 10.0 | 4.13 | 12000 |
| | | | | | | *.984* | | *2.244* | *3.425* | *.740* | *2.575* | *3.425* | *2.244* | *2.559* | *3.874* | | *1160* | | | |
| | 32 | 7 | 1 | 6 | 930-V50-HD-32-077 | 32.0 | 1"-8 | 61 | 77.0 | 18.8 | 57.9 | 77.0 | 68.0 | 76.0 | 98.4 | 12° | 80 | 10.0 | 4.24 | 12000 |
| | | | | | | *1.260* | | *2.402* | *3.032* | *.740* | *2.280* | *3.032* | *2.677* | *2.992* | *3.874* | | *1160* | | | |
| | 32 | 7 | 1 | 6 | 930-V50-HD-32-170 | 32.0 | 1"-8 | 61 | 170.0 | 18.8 | 150.9 | 170.0 | 68.0 | 76.0 | 98.4 | 12° | 80 | 10.0 | 7.43 | 12000 |
| | | | | | | *1.260* | | *2.402* | *6.693* | *.740* | *5.941* | *6.693* | *2.677* | *2.992* | *3.874* | | *1160* | | | |




## Inch bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BD$_3$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50.0 | 1 1/4 | 7 | 1 | 930-V50-HD-A31-077 | 31.8 | 1"-8 | 61 | 77.0 | 18.8 | 57.9 | 68.0 | 76.0 | 98.4 | 12° | 80 | 10.0 | 4.25 | 12000 |
| | | | | | *1.250* | | *2.402* | *3.032* | *.740* | *2.280* | *2.677* | *2.992* | *3.874* | | *1160* | | | |

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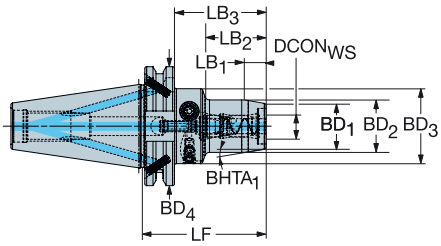
SANDVIK Coromant

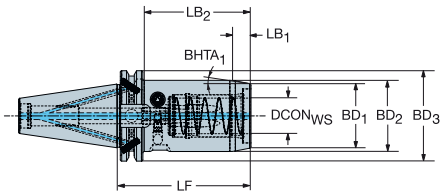
# CAT-V to CoroChuck™ 930

**Slender design**

**Machine side interface ASME B5.50-2009**

DSGN 10 6




## Metric bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | $BD_4$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 6 | 7 | 1 | 10 | **930-V40-S-06-068** | 6.0 | 5/8"-11 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 22.0 | 26.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.06 | 18000 |
| | | | | | | *.236* | | *1.457* | *2.677* | *.445* | *1.189* | *1.925* | *.866* | *1.024* | *1.575* | *2.500* | | *1160* | | | |
| | 8 | 7 | 1 | 10 | **930-V40-S-08-068** | 8.0 | 5/8"-11 | 37 | 68.0 | 11.3 | 30.2 | 48.9 | 24.0 | 28.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.08 | 18000 |
| | | | | | | *.315* | | *1.457* | *2.677* | *.445* | *1.189* | *1.925* | *.945* | *1.102* | *1.575* | *2.500* | | *1160* | | | |
| | 10 | 7 | 1 | 10 | **930-V40-S-10-072** | 10.0 | 5/8"-11 | 41 | 72.0 | 11.3 | 34.2 | 52.9 | 26.0 | 30.0 | 40.0 | 63 | 10° | 80 | 8.0 | 1.11 | 18000 |
| | | | | | | *.394* | | *1.614* | *2.835* | *.445* | *1.346* | *2.083* | *1.024* | *1.181* | *1.575* | *2.500* | | *1160* | | | |
| | 12 | 7 | 1 | 10 | **930-V40-S-12-080** | 12.0 | 5/8"-11 | 46 | 80.0 | 11.3 | 38.2 | 60.9 | 28.0 | 32.0 | 50.0 | 63 | 10° | 80 | 8.0 | 1.33 | 18000 |
| | | | | | | *.472* | | *1.811* | *3.150* | *.445* | *1.504* | *2.398* | *1.102* | *1.260* | *1.969* | *2.500* | | *1160* | | | |
| | 20 | 7 | 1 | 10 | **930-V40-S-20-090** | 20.0 | 5/8"-11 | 51 | 90.0 | 16.0 | 49.2 | 70.9 | 38.0 | 42.0 | 50.0 | 63 | 7° | 80 | 8.0 | 1.50 | 18000 |
| | | | | | | *.787* | | *2.008* | *3.543* | *.630* | *1.937* | *2.791* | *1.496* | *1.654* | *1.969* | *2.500* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | **930-V40-S-25-095** | 25.0 | 5/8"-11 | 57 | 95.0 | 12.9 | 75.0 | 95.0 | 45.0 | 50.0 | 63 | | 11° | 80 | 8.0 | 1.72 | 18000 |
| | | | | | | *.984* | | *2.244* | *3.740* | *.508* | *2.953* | *3.740* | *1.772* | *1.969* | *2.500* | | | *1160* | | | |
| 50.0 | 20 | 7 | 1 | 10 | **930-V50-S-20-089** | 20.0 | 1"-8 | 51 | 89.0 | 16.0 | 49.2 | 69.9 | 38.0 | 42.0 | 50.0 | 98 | 7° | 80 | 8.0 | 3.34 | 12000 |
| | | | | | | *.787* | | *2.008* | *3.504* | *.630* | *1.937* | *2.752* | *1.496* | *1.654* | *1.969* | *3.874* | | *1160* | | | |
| | 25 | 7 | 1 | 6 | **930-V50-S-25-095** | 25.0 | 1"-8 | 57 | 95.0 | 12.9 | 73.5 | 95.0 | 45.0 | 50.0 | 98 | | 11° | 80 | 8.0 | 3.56 | 12000 |
| | | | | | | *.984* | | *2.244* | *3.740* | *.508* | *2.894* | *3.740* | *1.772* | *1.969* | *3.874* | | | *1160* | | | |

## Inch bore

| | | | | | | Dimensions, mm, inch | | | | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | $BD_3$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 40.0 | 1 | 7 | 1 | 6 | **930-V40-S-A25-095** | 25.4 | 5/8"-11 | 57 | 95.0 | 12.9 | 75.0 | 45.0 | 50.0 | 63 | 11° | 80 | 8.0 | 1.71 | 18000 |
| | | | | | | *1.000* | | *2.244* | *3.740* | *.508* | *2.953* | *1.772* | *1.969* | *2.500* | | *1160* | | | |

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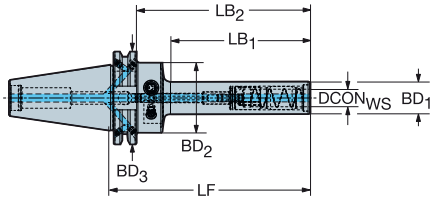
M1 N22 N6 N15 N4

# CAT-V to CoroChuck™ 930

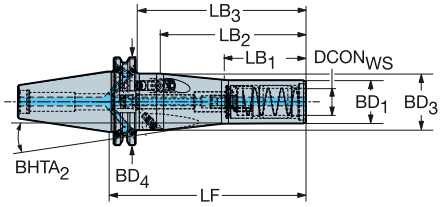
**Pencil design**

**Machine side interface ASME B5.50-2009**



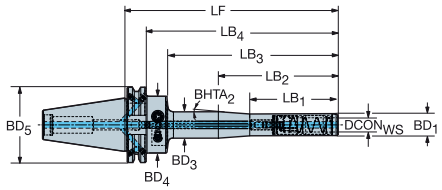

## Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BD$_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 8 | 7 | 1 | 930-V40-P-08-088 | 8.0 | 5/8"-11 | 37 | 88.0 | 45.8 | 66.5 | 17.5 | 40.0 | 63.5 | 80 | 8.0 | 1.05 | 18000 |
| | | | | | *.315* | | *1.457* | *3.465* | *1.803* | *2.618* | *.689* | *1.575* | *2.500* | *1160* | | | |
| | 10 | 7 | 1 | 930-V40-P-10-098 | 10.0 | 5/8"-11 | 41 | 98.0 | 55.8 | 76.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.09 | 18000 |
| | | | | | *.394* | | *1.614* | *3.858* | *2.197* | *3.012* | *.787* | *1.575* | *2.500* | *1160* | | | |
| | 10 | 7 | 1 | 930-V40-P-10-138 | 10.0 | 5/8"-11 | 41 | 138.0 | 95.8 | 116.5 | 20.0 | 40.0 | 63.5 | 80 | 8.0 | 1.19 | 18000 |
| | | | | | *.394* | | *1.614* | *5.433* | *3.772* | *4.587* | *.787* | *1.575* | *2.500* | *1160* | | | |
| | 12 | 7 | 1 | 930-V40-P-12-103 | 12.0 | 5/8"-11 | 46 | 103.0 | 60.8 | 83.9 | 22.0 | 40.0 | 63.5 | 80 | 8.0 | 1.18 | 18000 |
| | | | | | *.472* | | *1.811* | *4.055* | *2.394* | *3.303* | *.866* | *1.575* | *2.500* | *1160* | | | |
| | 12 | 7 | 1 | 930-V40-P-12-138 | 12.0 | 5/8"-11 | 46 | 138.0 | 95.8 | 118.9 | 22.0 | 40.0 | 63.5 | 80 | 8.0 | 1.27 | 18000 |
| | | | | | *.472* | | *1.811* | *5.433* | *3.772* | *4.681* | *.866* | *1.575* | *2.500* | *1160* | | | |




## Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 20 | 7 | 1 | 930-V40-P-20-145 | 20.0 | 5/8"-11 | 51 | 145.0 | 60.0 | 108.0 | 125.9 | 32.0 | 42.0 | 63.5 | 5° | 80 | 8.0 | 1.68 | 18000 |
| | | | | | *.787* | | *2.008* | *5.709* | *2.362* | *4.252* | *4.957* | *1.260* | *1.654* | *2.500* | | *1160* | | | |




## Metric bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | LB$_4$ | BD$_1$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | 12 | 7 | 1 | 930-V40-P-12-188 | 12.0 | 5/8"-11 | 46 | 188.0 | 50.0 | 75.0 | 145.8 | 168.9 | 22.0 | 26.0 | 40.0 | 4° | 80 | 8.0 | 1.46 | 18000 |
| | | | | | *.472* | | *1.811* | *7.402* | *1.969* | *2.953* | *5.740* | *6.650* | *.866* | *1.024* | *1.575* | | *1160* | | | |

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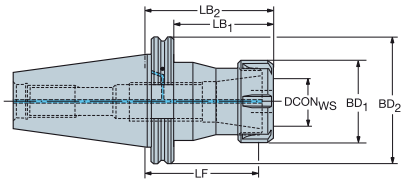
SANDVIK Coromant

# CAT-V to ER collet chuck

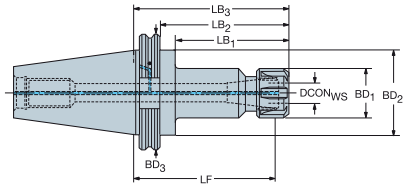
**Machine side interface compatible with ASME B5.50-1985**

**Workpiece side interface DIN 6499-B**

DSGN 2




DSGN 5




| | | | | | | Dimensions, mm, inch | | | | | | | | | BAR PSI | KG | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | | | RPMX |
| 40.0 | ER11 | 7 | 1 | 2 | **AA3B14-40 11 070** | 11.4 | 5/8"-11 | 63.7 | 38.2 | 70.0 | | 19.0 | 63.5 | | 80 | 0.96 | 18000 |
| | | | | | | *.449* | | *2.508* | *1.504* | *2.756* | | *.748* | *2.500* | | *1160* | | |
| | ER16 | 7 | 1 | 2 | **AA3B14-40 16 067** | 17.0 | 5/8"-11 | 53.0 | 47.5 | 66.6 | | 27.7 | 63.6 | | 80 | 1.00 | 18000 |
| | | | | | | *.669* | | *2.087* | *1.872* | *2.622* | | *1.092* | *2.502* | | *1160* | | |
| | ER16 | 7 | 1 | 5 | **AA3B14-40 16 105** | 17.0 | 5/8"-11 | 91.1 | 69.6 | 85.6 | 104.7 | 27.7 | 44.4 | 63.5 | 80 | 1.23 | 18000 |
| | | | | | | *.669* | | *3.587* | *2.740* | *3.370* | *4.120* | *1.092* | *1.748* | *2.502* | *1160* | | |
| | ER20 | 7 | 1 | 2 | **AA3B14-40 20 070** | 21.0 | 5/8"-11 | 58.8 | 48.9 | 70.0 | | 34.0 | 63.5 | | 80 | 1.05 | 18000 |
| | | | | | | *.827* | | *2.317* | *1.927* | *2.756* | | *1.339* | *2.500* | | *1160* | | |
| | ER20 | 7 | 1 | 5 | **AA3B14-40 20 105** | 21.0 | 5/8"-11 | 89.4 | 69.6 | 85.6 | 104.7 | 34.0 | 44.4 | 63.5 | 80 | 1.32 | 18000 |
| | | | | | | *.827* | | *3.520* | *2.740* | *3.370* | *4.120* | *1.340* | *1.748* | *2.502* | *1160* | | |
| | ER20 | 7 | 1 | 5 | **AA3B14-40 20 156** | 21.0 | 5/8"-11 | 140.2 | 120.4 | 136.4 | 155.5 | 34.0 | 44.4 | 63.5 | 80 | 1.50 | 18000 |
| | | | | | | *.827* | | *5.520* | *4.740* | *5.370* | *6.120* | *1.340* | *1.748* | *2.502* | *1160* | | |
| | ER25 | 7 | 1 | 2 | **AA3B14-40 25 070** | 26.0 | 5/8"-11 | 58.3 | 48.9 | 70.0 | | 42.0 | 63.5 | | 80 | 1.14 | 18000 |
| | | | | | | *1.024* | | *2.297* | *1.927* | *2.756* | | *1.654* | *2.500* | | *1160* | | |
| | ER25 | 7 | 1 | 5 | **AA3B14-40 25 105** | 26.0 | 5/8"-11 | 89.3 | 69.6 | 85.6 | 104.7 | 41.7 | 44.4 | 63.5 | 80 | 1.48 | 18000 |
| | | | | | | *1.024* | | *3.516* | *2.740* | *3.370* | *4.120* | *1.643* | *1.748* | *2.502* | *1160* | | |
| | ER25 | 7 | 1 | 5 | **AA3B14-40 25 156** | 26.0 | 5/8"-11 | 140.3 | 120.4 | 136.4 | 155.5 | 41.7 | 44.4 | 63.5 | 80 | 1.93 | 18000 |
| | | | | | | *1.024* | | *5.524* | *4.740* | *5.370* | *6.120* | *1.643* | *1.748* | *2.502* | *1160* | | |
| | ER32 | 7 | 1 | 2 | **AA3B14-40 32 079** | 33.0 | 5/8"-11 | 62.6 | 60.2 | 79.3 | | 49.7 | 63.6 | | 80 | 1.25 | 18000 |
| | | | | | | *1.299* | | *2.465* | *2.372* | *3.122* | | *1.958* | *2.502* | | *1160* | | |
| | ER32 | 7 | 1 | 2 | **AA3B14-40 32 105** | 33.0 | 5/8"-11 | 88.0 | 85.6 | 104.6 | | 49.7 | 63.6 | | 80 | 1.52 | 18000 |
| | | | | | | *1.299* | | *3.465* | *3.370* | *4.120* | | *1.958* | *2.502* | | *1160* | | |
| | ER32 | 7 | 1 | 2 | **AA3B14-40 32 160** | 33.0 | 5/8"-11 | 147.3 | 138.9 | 160.0 | | 50.0 | 63.5 | | 80 | 2.12 | 18000 |
| | | | | | | *1.299* | | *5.801* | *5.470* | *6.299* | | *1.969* | *2.500* | | *1160* | | |
| | ER40 | 7 | 1 | 2 | **AA3B14-40 40 105** | 41.0 | 5/8"-11 | 86.1 | 85.6 | 104.6 | | 62.7 | 63.6 | | 80 | 1.79 | 18000 |
| | | | | | | *1.614* | | *3.390* | *3.370* | *4.120* | | *2.470* | *2.502* | | *1160* | | |
| 50.0 | ER16 | 7 | 1 | 5 | **AA3B14-50 16 105** | 17.0 | 1"-8 | 91.1 | 69.6 | 85.6 | 104.7 | 27.7 | 69.9 | 98.4 | 80 | 3.32 | 12000 |
| | | | | | | *.669* | | *3.587* | *2.740* | *3.370* | *4.120* | *1.092* | *2.750* | *3.875* | *1160* | | |
| | ER20 | 7 | 1 | 5 | **AA3B14-50 20 105** | 21.0 | 1"-8 | 89.4 | 69.9 | 85.6 | 104.7 | 34.0 | 69.9 | 98.4 | 80 | 3.38 | 12000 |
| | | | | | | *.827* | | *3.520* | *2.752* | *3.370* | *4.120* | *1.340* | *2.750* | *3.875* | *1160* | | |
| | ER25 | 7 | 1 | 5 | **AA3B14-50 25 105** | 26.0 | 1"-8 | 89.3 | 69.9 | 85.6 | 104.7 | 41.7 | 69.9 | 98.4 | 80 | 3.60 | 12000 |
| | | | | | | *1.024* | | *3.516* | *2.752* | *3.370* | *4.120* | *1.642* | *2.750* | *3.875* | *1160* | | |
| | ER32 | 7 | 1 | 5 | **AA3B14-50 32 105** | 33.0 | 1"-8 | 88.0 | 69.9 | 85.6 | 104.7 | 49.7 | 69.9 | 98.4 | 80 | 3.74 | 12000 |
| | | | | | | *1.299* | | *3.465* | *2.752* | *3.370* | *4.120* | *1.958* | *2.750* | *3.875* | *1160* | | |
| | ER40 | 7 | 1 | 5 | **AA3B14-50 40 105** | 41.0 | 1"-8 | 86.1 | 69.6 | 85.6 | 104.7 | 62.7 | 69.9 | 98.4 | 80 | 3.93 | 12000 |
| | | | | | | *1.614* | | *3.390* | *2.740* | *3.370* | *4.120* | *2.470* | *2.750* | *3.875* | *1160* | | |
| | ER40 | 7 | 1 | 2 | **AA3B14-50 40 160** | 41.0 | 1"-8 | 145.3 | 137.9 | 160.0 | | 63.0 | 98.4 | | 80 | 5.37 | 12000 |
| | | | | | | *1.614* | | *5.722* | *5.431* | *6.299* | | *2.480* | *3.875* | | *1160* | | |

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M1

N22

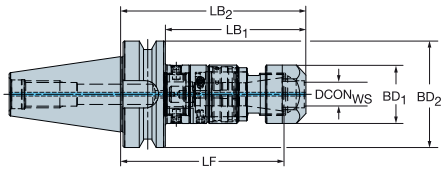
N15

# CAT-V to CoroChuck™ 970

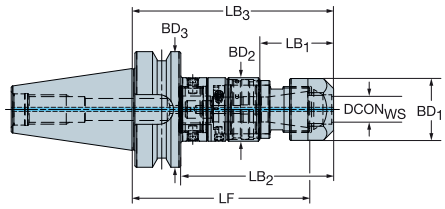
**Machine side interface ASME B5.50-2009**

**Workpiece side interface DIN 6499-B**

DSGN 2




5




| | | | | | | | Dimensions, mm, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | TRMAX | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | $BD_3$ | BAR PSI | KG | RPMX |
| 40.0 | ER20 | M12 | 1 | 1 | 2 | **970-V40-20-102** | 20.8 | 5/8"-11 | 89.2 | 35.3 | 78.2 | 97.2 | 33.7 | 35.0 | 63.5 | 80 | 1.27 | 8000 |
| | | | | | | | *.819* | | *3.512* | *1.390* | *3.079* | *3.827* | *1.327* | *1.378* | *2.500* | *1160* | | |
| | ER25 | M20 | 1 | 1 | 5 | **970-V40-25-122** | 25.8 | 5/8"-11 | 108.1 | 35.1 | 97.5 | 116.6 | 42.0 | 44.0 | 63.5 | 80 | 1.64 | 8000 |
| | | | | | | | *1.016* | | *4.256* | *1.382* | *3.839* | *4.591* | *1.654* | *1.732* | *2.500* | *1160* | | |
| | ER32 | M20 | 1 | 1 | 2 | **970-V40-32-125** | 32.8 | 5/8"-11 | 115.8 | 106.2 | 125.3 | | 50.0 | 63.5 | | 80 | 1.59 | 8000 |
| | | | | | | | *1.291* | | *4.559* | *4.181* | *4.933* | | *1.969* | *2.500* | | *1160* | | |
| 50.0 | ER20 | M12 | 1 | 1 | 5 | **970-V50-20-106** | 20.8 | 1"-8 | 93.2 | 35.3 | 82.1 | 101.2 | 33.7 | 35.0 | 98.4 | 80 | 3.13 | 8000 |
| | | | | | | | *.819* | | *3.669* | *1.390* | *3.232* | *3.984* | *1.327* | *1.378* | *3.874* | *1160* | | |
| | ER25 | M20 | 1 | 1 | 5 | **970-V50-25-126** | 25.8 | 1"-8 | 112.1 | 37.1 | 101.5 | 120.6 | 42.0 | 44.0 | 98.4 | 80 | 3.48 | 8000 |
| | | | | | | | *1.016* | | *4.413* | *1.461* | *3.996* | *4.748* | *1.654* | *1.732* | *3.874* | *1160* | | |
| | ER32 | M20 | 1 | 1 | 2 | **970-V50-32-129** | 32.8 | 1"-8 | 119.8 | 110.2 | 129.3 | | 50.0 | 98.4 | | 80 | 3.41 | 8000 |
| | | | | | | | *1.291* | | *4.717* | *4.339* | *5.091* | | *1.969* | *3.874* | | *1160* | | |
| | ER40 | M30 | 1 | 1 | 2 | **970-V50-40-155** | 40.8 | 1"-8 | 138.2 | 130.6 | 149.6 | | 63.0 | 98.4 | | 80 | 4.93 | 8000 |
| | | | | | | | *1.606* | | *5.441* | *5.142* | *5.890* | | *2.480* | *3.874* | | *1160* | | |

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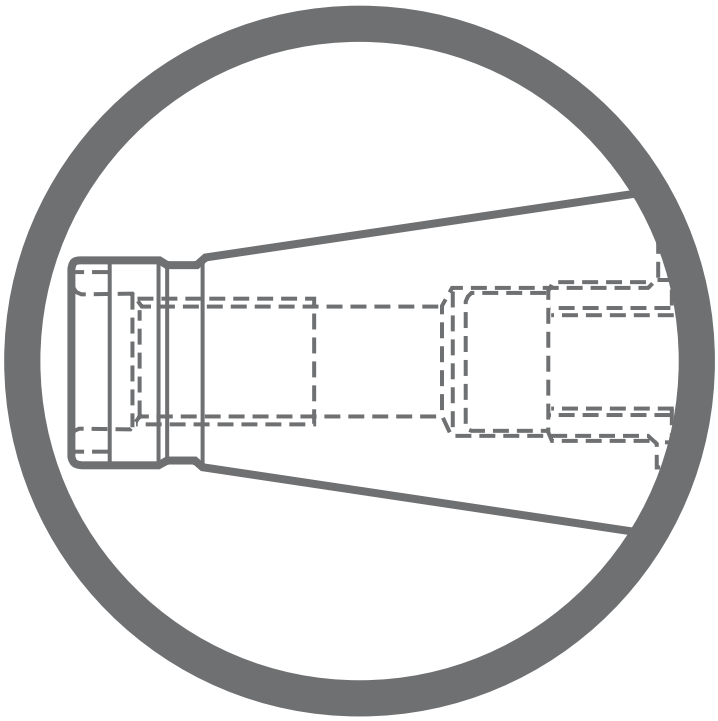
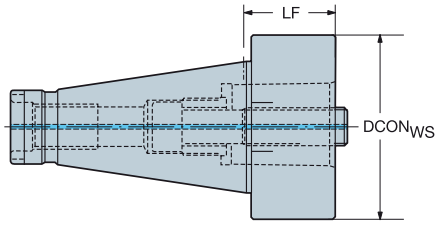
M1 N22 N15 N5

# Machine side interface DIN 2080

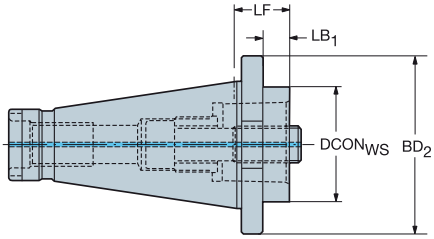


# DIN 2080 to Coromant Capto® adapter

DSGN 1




2

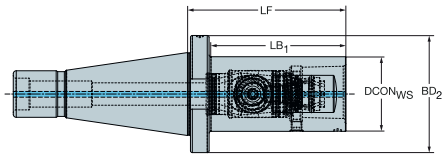



| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{WS}$ | CRKS | LF | LB$_1$ | LB$_2$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | C3 | 1 | 1 | 2 | C3-390.00-40 030 | 32.0 | M16 | 30.0 | 18.4 | 30.0 | 63.0 | 80 | 45.0 | 0.86 |
| | | | | | | *1.260* | | *1.181* | *.724* | *1.181* | *2.480* | *1160* | | |
| | C4 | 1 | 1 | 2 | C4-390.00-40 030 | 40.0 | M16 | 30.0 | 18.4 | 30.0 | 63.0 | 80 | 55.0 | 0.09 |
| | | | | | | *1.575* | | *1.181* | *.724* | *1.181* | *2.480* | *1160* | | |
| | C4 | 1 | 1 | 2 | C4-390.00-40 060 | 40.0 | M16 | 60.0 | 48.4 | 60.0 | 63.0 | 80 | 55.0 | 1.13 |
| | | | | | | *1.575* | | *2.362* | *1.906* | *2.362* | *2.480* | *1160* | | |
| | C5 | 1 | 1 | 2 | C5-390.00-40 030 | 50.0 | M16 | 30.0 | 18.4 | 30.0 | 63.0 | 80 | 95.0 | 0.90 |
| | | | | | | *1.969* | | *1.181* | *.724* | *1.181* | *2.480* | *1160* | | |
| | C6 | 1 | 1 | 1 | C6-390.00-40 075 | 63.0 | M16 | 75.0 | 75.0 | | | 80 | 170.0 | 1.87 |
| | | | | | | *2.480* | | *2.953* | *2.953* | | | *1160* | | |
| 50.0 | C3 | 1 | 1 | 2 | C3-390.00-50 030 | 32.0 | M24 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 45.0 | 2.78 |
| | | | | | | *1.260* | | *1.181* | *.583* | *1.181* | *3.839* | *1160* | | |
| | C3 | 1 | 1 | 2 | C3-390.00-50 060 | 32.0 | M24 | 60.0 | 44.8 | 60.0 | 97.5 | 80 | 45.0 | 2.89 |
| | | | | | | *1.260* | | *2.362* | *1.764* | *2.362* | *3.839* | *1160* | | |
| | C4 | 1 | 1 | 2 | C4-390.00-50 030 | 40.0 | M24 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 55.0 | 2.79 |
| | | | | | | *1.575* | | *1.181* | *.583* | *1.181* | *3.839* | *1160* | | |
| | C4 | 1 | 1 | 2 | C4-390.00-50 060 | 40.0 | M24 | 60.0 | 44.8 | 60.0 | 97.5 | 80 | 55.0 | 3.01 |
| | | | | | | *1.575* | | *2.362* | *1.764* | *2.362* | *3.839* | *1160* | | |
| | C5 | 1 | 1 | 2 | C5-390.00-50 030 | 50.0 | M24 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 95.0 | 2.76 |
| | | | | | | *1.969* | | *1.181* | *.583* | *1.181* | *3.839* | *1160* | | |
| | C5 | 1 | 1 | 2 | C5-390.00-50 070 | 50.0 | M24 | 70.0 | 54.8 | 70.0 | 97.5 | 80 | 95.0 | 3.28 |
| | | | | | | *1.969* | | *2.756* | *2.157* | *2.756* | *3.839* | *1160* | | |
| | C6 | 1 | 1 | 2 | C6-390.00-50 030 | 63.0 | M24 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 170.0 | 2.72 |
| | | | | | | *2.480* | | *1.181* | *.583* | *1.181* | *3.839* | *1160* | | |
| | C6 | 1 | 1 | 2 | C6-390.00-50 080 | 63.0 | M24 | 80.0 | 64.8 | 80.0 | 97.5 | 80 | 170.0 | 3.82 |
| | | | | | | *2.480* | | *3.150* | *2.551* | *3.150* | *3.839* | *1160* | | |
| | C8 | 1 | 1 | 2 | C8-390.00-50 070 | 80.0 | M24 | 70.0 | 54.8 | 70.0 | 97.5 | 80 | 170.0 | 3.98 |
| | | | | | | *3.150* | | *2.756* | *2.157* | *2.756* | *3.839* | *1160* | | |
| | C8 | 1 | 1 | 2 | C8-390.00-50 120 | 80.0 | M24 | 120.0 | 104.8 | 120.0 | 97.5 | 80 | 170.0 | 5.84 |
| | | | | | | *3.150* | | *4.724* | *4.126* | *4.724* | *3.839* | *1160* | | |

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

N22 N15

# DIN 2080 to Coromant Capto® adapter with Quick change

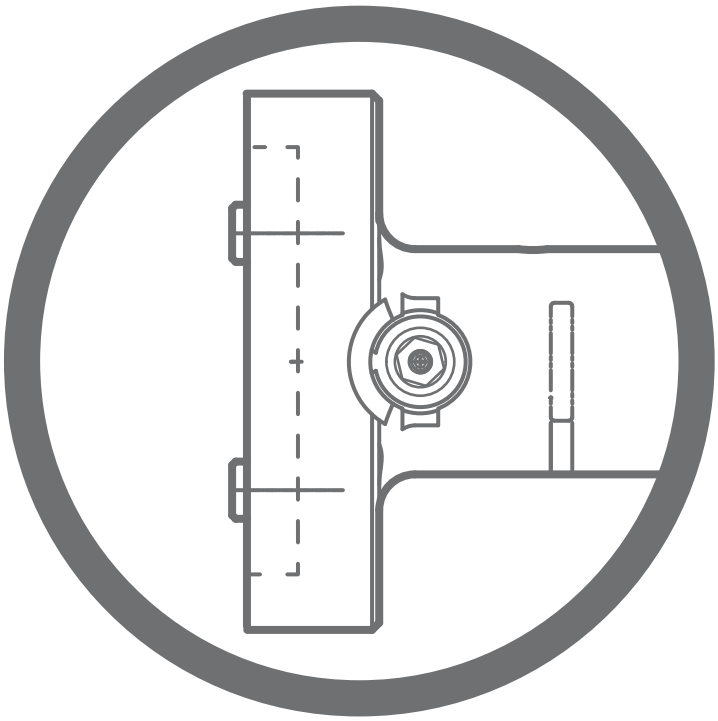



| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $BD_2$ | BAR PSI | NM | KG |
| 40.0 | C5 | 1 | 1 | **DN40-QC-C5-095** | 50.0 | M16 | 95.0 | 83.4 | 62.8 | 80 | 70.0 | 1.70 |
| | | | | | *1.969* | | *3.740* | *3.283* | *2.472* | *1160* | | |
| 50.0 | C8 | 1 | 1 | **DN50-QC-C8-140** | 80.0 | M24 | 140.0 | 124.8 | 97.3 | 80 | 130.0 | 6.30 |
| | | | | | *3.150* | | *5.512* | *4.913* | *3.831* | *1160* | | |

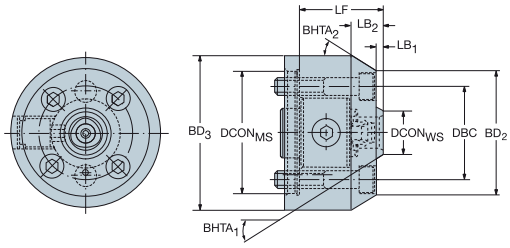
For spare parts, visit www.sandvik.coromant.com

N22 N15

# Machine side interface DIN 2079

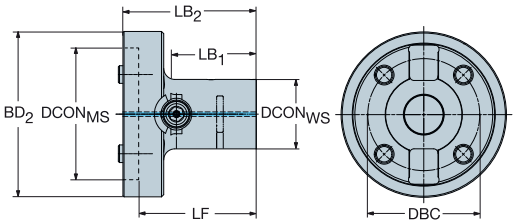


# DIN 2079 to Coromant Capto® adapter




| CZC$_{MS}$ | CZC$_{WS}$ | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LF | LB$_1$ | LB$_2$ | BD$_2$ | BD$_3$ | BHTA$_1$ | BHTA$_2$ | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | C3 | **C3-390.34705-40 060** | 88.9 | 32.0 | 66.7 | 60.0 | 5.0 | 22.3 | 90.0 | 110.0 | 30° | 30° | 35.0 | 3.99 |
| | | | *3.499* | *1.260* | *2.626* | *2.362* | *.197* | *.878* | *3.543* | *4.331* | | | | |
| | C4 | **C4-390.34705-40 070** | 88.9 | 40.0 | 66.7 | 70.0 | 5.0 | 22.3 | 90.0 | 110.0 | 30° | 30° | 15.0 | 5.00 |
| | | | *3.499* | *1.575* | *2.626* | *2.756* | *.197* | *.878* | *3.543* | *4.331* | | | | |

# DIN 2079 to Coromant Capto® adapter with Quick change



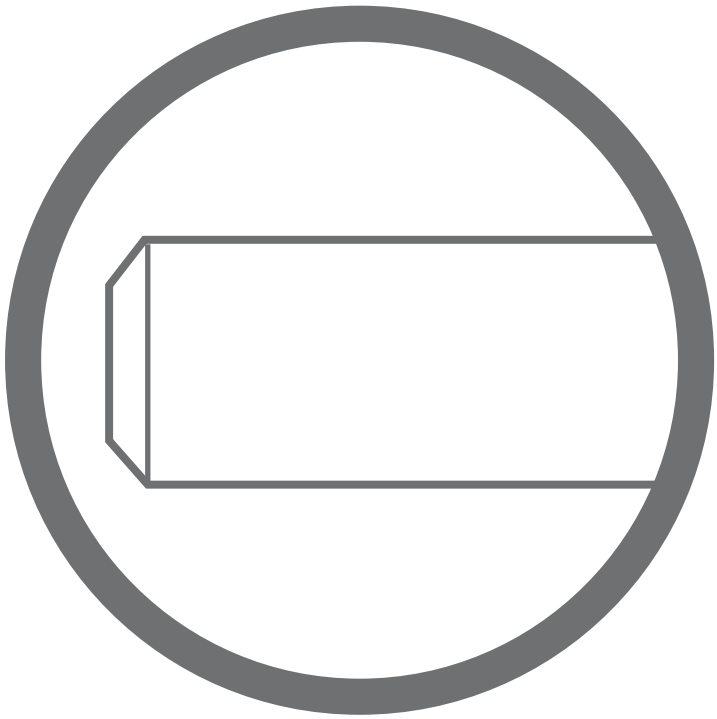

**Metric version**

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LF | LB$_1$ | LB$_2$ | BD$_2$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40.0 | C5 | 1 | 1 | **SI40-QC-C5-090** | 88.9 | 50.0 | 66.7 | 90.0 | 70.0 | 102.0 | 110.0 | 80 | 70.0 | 2.30 |
| | | | | | *3.499* | *1.969* | *2.626* | *3.543* | *2.756* | *4.016* | *4.331* | *1160* | | |
| 50.0 | C6 | 1 | 1 | **SI50-QC-C6-105** | 128.6 | 63.0 | 101.6 | 105.0 | 74.0 | 121.0 | 150.0 | 80 | 90.0 | 5.00 |
| | | | | | *5.062* | *2.480* | *4.000* | *4.134* | *2.913* | *4.764* | *5.906* | *1160* | | |
| | C8 | 3 | 1 | **SI50-QC-C8-135** | 128.6 | 80.0 | 101.6 | 135.0 | 104.0 | 151.0 | 150.0 | 80 | 130.0 | 6.89 |
| | | | | | *5.062* | *3.150* | *4.000* | *5.315* | *4.094* | *5.945* | *5.906* | *1160* | | |

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

N22 N15

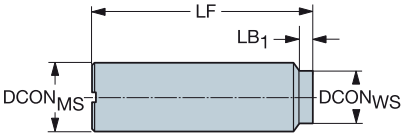
# Machine-side interface cylindrical shank



# Cylindrical shank to Coromant EH adapter

**Straight design**

**Steel shank**




## Metric version

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | BAR PSI | NM | KG | RPMX |
| 10.0 | E10 | 1 | 1 | **E10-A10-SS-075** | 10.0 | 9.6 | 54 | 75.0 | 20.0 | 80 | 12.0 | 0.09 | 40000 |
| | | | | | *.394* | *.378* | *2.126* | *2.953* | *.787* | *1160* | | | |
| 12.0 | E12 | 1 | 1 | **E12-A12-SS-100** | 12.0 | 11.6 | 77 | 100.0 | 22.0 | 80 | 15.0 | 0.14 | 31000 |
| | | | | | *.472* | *.457* | *3.032* | *3.937* | *.866* | *1160* | | | |
| 16.0 | E10 | 1 | 1 | **E10-A16-SS-065** | 16.0 | 9.6 | 57 | 65.0 | 5.0 | 80 | 12.0 | 0.14 | 40000 |
| | | | | | *.630* | *.378* | *2.244* | *2.559* | *.197* | *1160* | | | |
| | E12 | 1 | 1 | **E12-A16-SS-065** | 16.0 | 11.6 | 58 | 65.0 | 5.0 | 80 | 15.0 | 0.15 | 40000 |
| | | | | | *.630* | *.457* | *2.283* | *2.559* | *.197* | *1160* | | | |
| 20.0 | E16 | 1 | 1 | **E16-A20-SS-070** | 20.0 | 15.4 | 63 | 70.0 | 5.0 | 80 | 30.0 | 0.26 | 40000 |
| | | | | | *.787* | *.606* | *2.480* | *2.756* | *.197* | *1160* | | | |
| | E16 | 1 | 1 | **E16-A20-SS-110** | 20.0 | 15.4 | 83 | 110.0 | 25.0 | 80 | 30.0 | 0.33 | 40000 |
| | | | | | *.787* | *.606* | *3.268* | *4.331* | *.984* | *1160* | | | |
| | E20 | 1 | 1 | **E20-A20-SS-120** | 20.0 | 19.2 | 89 | 120.0 | 30.0 | 80 | 50.0 | 0.38 | 34000 |
| | | | | | *.787* | *.756* | *3.504* | *4.724* | *1.181* | *1160* | | | |
| 25.0 | E20 | 1 | 1 | **E20-A25-SS-080** | 25.0 | 19.2 | 73 | 80.0 | 5.0 | 80 | 50.0 | 0.39 | 40000 |
| | | | | | *.984* | *.756* | *2.874* | *3.150* | *.197* | *1160* | | | |
| | E25 | 1 | 1 | **E25-A25-SS-140** | 25.0 | 24.1 | 99 | 140.0 | 40.0 | 80 | 65.0 | 0.63 | 25000 |
| | | | | | *.984* | *.949* | *3.898* | *5.512* | *1.575* | *1160* | | | |
| 32.0 | E25 | 1 | 1 | **E25-A32-SS-080** | 32.0 | 24.1 | 73 | 80.0 | 5.0 | 80 | 65.0 | 0.62 | 40000 |
| | | | | | *1.260* | *.949* | *2.874* | *3.150* | *.197* | *1160* | | | |

## Inch version

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | | | | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $BD_2$ | BAR PSI | NM | KG | RPMX |
| 3/8 | E10 | 1 | 1 | 2 | **AE10-A10-SS-030** | 9.5 | 9.2 | 54 | 76.2 | 21.3 | 9.5 | 80 | 12.0 | 0.09 | 40000 |
| | | | | | | *.375* | *.360* | *2.126* | *3.000* | *.839* | *.375* | *1160* | | | |
| 1/2 | E10 | 1 | 1 | 2 | **AE10-A12-SS-025** | 12.7 | 9.2 | 55 | 63.5 | 6.3 | 12.7 | 80 | 12.0 | 0.10 | 40000 |
| | | | | | | *.500* | *.360* | *2.165* | *2.500* | *.250* | *.500* | *1160* | | | |
| | E10 | 1 | 1 | 2 | **AE10-A12-SS-030** | 12.7 | 9.2 | 48 | 76.2 | 25.4 | 12.7 | 80 | 12.0 | 0.11 | 40000 |
| | | | | | | *.500* | *.360* | *1.890* | *3.000* | *1.000* | *.500* | *1160* | | | |
| | E12 | 1 | 1 | 2 | **AE12-A12-SS-030** | 12.7 | 12.2 | 68 | 76.2 | 6.3 | 12.7 | 80 | 15.0 | 0.12 | 40000 |
| | | | | | | *.500* | *.480* | *2.677* | *3.000* | *.250* | *.500* | *1160* | | | |
| | E12 | 1 | 1 | 2 | **AE12-A12-SS-045** | 12.7 | 12.2 | 87 | 114.3 | 25.4 | 12.7 | 80 | 15.0 | 0.16 | 30000 |
| | | | | | | *.500* | *.480* | *3.425* | *4.500* | *1.000* | *.500* | *1160* | | | |
| 5/8 | E16 | 1 | 1 | 2 | **AE16-A16-SS-030** | 15.9 | 15.4 | 68 | 76.2 | 6.3 | 15.9 | 80 | 30.0 | 0.21 | 40000 |
| | | | | | | *.625* | *.606* | *2.677* | *3.000* | *.250* | *.625* | *1160* | | | |
| | E16 | 1 | 1 | 2 | **AE16-A16-SS-045** | 15.9 | 15.4 | 87 | 114.3 | 25.4 | 15.9 | 80 | 30.0 | 0.26 | 30000 |
| | | | | | | *.625* | *.606* | *3.425* | *4.500* | *1.000* | *.625* | *1160* | | | |
| 3/4 | E20 | 1 | 1 | 2 | **AE20-A19-SS-030** | 19.1 | 18.4 | 68 | 76.2 | 6.3 | 19.1 | 80 | 50.0 | 0.27 | 40000 |
| | | | | | | *.750* | *.724* | *2.677* | *3.000* | *.250* | *.750* | *1160* | | | |
| | E20 | 1 | 1 | 2 | **AE20-A19-SS-045** | 19.1 | 18.4 | 88 | 114.3 | 25.4 | 19.1 | 80 | 50.0 | 0.34 | 40000 |
| | | | | | | *.750* | *.724* | *3.465* | *4.500* | *1.000* | *.750* | *1160* | | | |
| 1.0 | E25 | 1 | 1 | 2 | **AE25-A25-SS-035** | 25.4 | 24.4 | 81 | 88.9 | 6.3 | 25.4 | 80 | 65.0 | 0.46 | 40000 |
| | | | | | | *1.000* | *.961* | *3.189* | *3.500* | *.250* | *1.000* | *1160* | | | |
| | E25 | 1 | 1 | 2 | **AE25-A25-SS-045** | 25.4 | 24.4 | 75 | 114.3 | 38.1 | 25.4 | 80 | 65.0 | 0.55 | 40000 |
| | | | | | | *1.000* | *.961* | *2.953* | *4.500* | *1.500* | *1.000* | *1160* | | | |
| 1 1/4 | E25 | 1 | 1 | 2 | **AE25-A32-SS-065** | 31.8 | 24.4 | 99 | 165.1 | 63.5 | 31.8 | 80 | 65.0 | 0.90 | 23000 |
| | | | | | | *1.250* | *.961* | *3.898* | *6.500* | *2.500* | *1.250* | *1160* | | | |

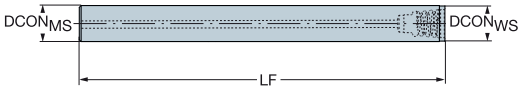
For spare parts, visit www.sandvik.coromant.com

N22 N6 N15 N3

# Cylindrical shank to Coromant EH adapter

**Straight design**

**G-undersized steel shank**




## Metric version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 9.7 | E10 | 1 | 1 | **EH10-A09.7-SS-080** | 9.7 | 9.6 | 78 | 80.0 | 80 | 12.0 | 0.10 | 40000 |
| | | | | | *.382* | *.378* | *3.071* | *3.150* | *1160* | | | |
| 11.7 | E12 | 1 | 1 | **EH12-A11.7-SS-085** | 11.7 | 11.6 | 83 | 85.0 | 80 | 15.0 | 0.12 | 40000 |
| | | | | | *.461* | *.457* | *3.268* | *3.346* | *1160* | | | |
| 15.7 | E16 | 1 | 1 | **EH16-A15.7-SS-100** | 15.7 | 15.4 | 97 | 100.0 | 80 | 30.0 | 0.24 | 40000 |
| | | | | | *.618* | *.606* | *3.819* | *3.937* | *1160* | | | |
| 19.7 | E20 | 1 | 1 | **EH20-A19.7-SS-120** | 19.7 | 19.2 | 117 | 120.0 | 80 | 50.0 | 0.38 | 40000 |
| | | | | | *.776* | *.756* | *4.606* | *4.724* | *1160* | | | |
| 24.7 | E25 | 1 | 1 | **EH25-A24.7-SS-135** | 24.7 | 24.1 | 132 | 135.0 | 80 | 65.0 | 0.56 | 40000 |
| | | | | | *.972* | *.949* | *5.197* | *5.315* | *1160* | | | |

## Inch version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 9.2 | E10 | 1 | 1 | **AEH10-A09.2-SS-080** | 9.2 | 9.2 | 78 | 80.0 | 80 | 12.0 | 0.09 | 40000 |
| | | | | | *.362* | *.360* | *3.071* | *3.150* | *1160* | | | |
| 18.7 | E20 | 1 | 1 | **AEH20-A18.7-SS-110** | 18.7 | 18.4 | 107 | 110.0 | 80 | 50.0 | 0.33 | 40000 |
| | | | | | *.736* | *.724* | *4.213* | *4.331* | *1160* | | | |

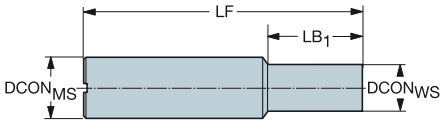
For spare parts, visit www.sandvik.coromant.com

N22 N6 N15 N3

# Cylindrical shank to Coromant EH adapter

**Straight design**

**Cemented carbide shank**




## Metric version

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 10.0 | E10 | 1 | 1 | **E10-A10-SE-100** | 10.0 | 9.6 | 49 | 100.0 | 50.0 | 80 | 12.0 | 0.15 | 35000 |
| | | | | | *.394* | *.378* | *1.929* | *3.937* | *1.969* | *1160* | | | |
| 12.0 | E12 | 1 | 1 | **E12-A12-SE-100** | 12.0 | 11.6 | 51 | 100.0 | 48.0 | 80 | 15.0 | 0.20 | 40000 |
| | | | | | *.472* | *.457* | *2.008* | *3.937* | *1.890* | *1160* | | | |
| 16.0 | E16 | 1 | 1 | **E16-A16-SE-135** | 16.0 | 15.4 | 54 | 135.0 | 80.0 | 80 | 30.0 | 0.44 | 27000 |
| | | | | | *.630* | *.606* | *2.126* | *5.315* | *3.150* | *1160* | | | |
| 20.0 | E20 | 1 | 1 | **E20-A20-SE-095** | 20.0 | 19.2 | 56 | 95.0 | 38.0 | 80 | 50.0 | 0.46 | 40000 |
| | | | | | *.787* | *.756* | *2.205* | *3.740* | *1.496* | *1160* | | | |
| | E20 | 1 | 1 | **E20-A20-SE-180** | 20.0 | 19.2 | 69 | 180.0 | 110.0 | 80 | 50.0 | 0.82 | 20000 |
| | | | | | *.787* | *.756* | *2.717* | *7.087* | *4.331* | *1160* | | | |
| 25.0 | E25 | 1 | 1 | **E25-A25-SE-200** | 25.0 | 24.1 | 79 | 200.0 | 120.0 | 80 | 65.0 | 1.36 | 19000 |
| | | | | | *.984* | *.949* | *3.110* | *7.874* | *4.724* | *1160* | | | |

## Inch version

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1 1/4 | E25 | 1 | 1 | **AE25-A32-SE-065** | 31.8 | 24.4 | 99 | 165.1 | 65.6 | 80 | 65.0 | 1.58 | 37000 |
| | | | | | *1.250* | *.961* | *3.898* | *6.500* | *2.583* | *1160* | | | |

**Note!**

Cemented carbide shank to be used for finishing/semi-finishing only

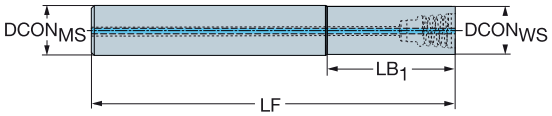
For spare parts, visit www.sandvik.coromant.com

N22 N6 N15 N3

# Cylindrical shank to Coromant EH adapter

**Straight design**

**Heavy metal shank**




## Metric version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 10.0 | E10 | 1 | 1 | **EH10-A10-SH-100** | 10.0 | 9.6 | 79 | 100.0 | 20.0 | 80 | 12.0 | 0.18 | 26000 |
| | | | | | *.394* | *.378* | *3.110* | *3.937* | *.787* | *1160* | | | |
| 12.0 | E12 | 1 | 1 | **EH12-A12-SH-110** | 12.0 | 11.6 | 84 | 110.0 | 25.0 | 80 | 15.0 | 0.26 | 25000 |
| | | | | | *.472* | *.457* | *3.307* | *4.331* | *.984* | *1160* | | | |
| 16.0 | E16 | 1 | 1 | **EH16-A16-SH-130** | 16.0 | 15.4 | 94 | 130.0 | 35.0 | 80 | 30.0 | 0.52 | 22000 |
| | | | | | *.630* | *.606* | *3.701* | *5.118* | *1.378* | *1160* | | | |
| 20.0 | E20 | 1 | 1 | **EH20-A20-SH-160** | 20.0 | 19.2 | 114 | 160.0 | 45.0 | 80 | 50.0 | 0.92 | 17000 |
| | | | | | *.787* | *.756* | *4.488* | *6.299* | *1.772* | *1160* | | | |
| 25.0 | E25 | 1 | 1 | **EH25-A25-SH-185** | 25.0 | 24.1 | 119 | 185.0 | 65.0 | 80 | 65.0 | 1.58 | 16000 |
| | | | | | *.984* | *.949* | *4.685* | *7.283* | *2.559* | *1160* | | | |

## Inch version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 3/8 | E10 | 1 | 1 | **AEH10-A10-SH-100** | 9.5 | 9.2 | 97 | 100.0 | 20.0 | 80 | 12.0 | 0.17 | 23000 |
| | | | | | *.375* | *.360* | *3.819* | *3.937* | *.787* | *1160* | | | |
| 1/2 | E12 | 1 | 1 | **AEH12-A12-SH-120** | 12.7 | 12.2 | 84 | 120.0 | 25.0 | 80 | 15.0 | 0.31 | 25000 |
| | | | | | *.500* | *.480* | *3.307* | *4.724* | *.984* | *1160* | | | |
| 5/8 | E16 | 1 | 1 | **AEH16-A16-SH-130** | 15.9 | 15.4 | 94 | 130.0 | 35.0 | 80 | 30.0 | 0.52 | 22000 |
| | | | | | *.625* | *.606* | *3.701* | *5.118* | *1.378* | *1160* | | | |
| 3/4 | E20 | 1 | 1 | **AEH20-A19-SH-160** | 19.1 | 18.4 | 114 | 160.0 | 45.0 | 80 | 50.0 | 0.85 | 17000 |
| | | | | | *.750* | *.724* | *4.488* | *6.299* | *1.772* | *1160* | | | |
| 1.0 | E25 | 1 | 1 | **AEH25-A25-SH-185** | 25.4 | 24.4 | 119 | 185.0 | 65.0 | 80 | 65.0 | 1.63 | 16000 |
| | | | | | *1.000* | *.961* | *4.685* | *7.283* | *2.559* | *1160* | | | |

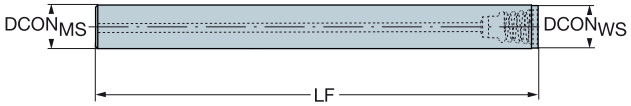
For spare parts, visit www.sandvik.coromant.com

N22 N6 N15 N3

# Cylindrical shank to Coromant EH adapter

**Straight design**

**G-undersized heavy metal shank**




## Metric version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 9.7 | E10 | 1 | 1 | EH10-A09.7-SH-120 | 9.7 | 9.6 | 117 | 120.0 | 80 | 12.0 | 0.20 | 19000 |
| | | | | | *.382* | *.378* | *4.606* | *4.724* | *1160* | | | |
| | E10 | 1 | 1 | EH10-A09.7-SH-100 | 9.7 | 9.6 | 97 | 100.0 | 80 | 12.0 | 0.17 | 23000 |
| | | | | | *.382* | *.378* | *3.819* | *3.937* | *1160* | | | |
| 11.7 | E12 | 1 | 1 | EH12-A11.7-SH-135 | 11.7 | 11.6 | 132 | 135.0 | 80 | 15.0 | 0.29 | 17000 |
| | | | | | *.461* | *.457* | *5.197* | *5.315* | *1160* | | | |
| | E12 | 1 | 1 | EH12-A11.7-SH-110 | 11.7 | 11.6 | 107 | 110.0 | 80 | 15.0 | 0.25 | 23000 |
| | | | | | *.461* | *.457* | *4.213* | *4.331* | *1160* | | | |
| 15.7 | E16 | 1 | 1 | EH16-A15.7-SH-160 | 15.7 | 15.4 | 156 | 160.0 | 80 | 30.0 | 0.61 | 15000 |
| | | | | | *.618* | *.606* | *6.142* | *6.299* | *1160* | | | |
| | E16 | 1 | 1 | EH16-A15.7-SH-130 | 15.7 | 15.4 | 126 | 130.0 | 80 | 30.0 | 0.51 | 19000 |
| | | | | | *.618* | *.606* | *4.961* | *5.118* | *1160* | | | |
| 19.7 | E20 | 1 | 1 | EH20-A19.7-SH-200 | 19.7 | 19.2 | 196 | 200.0 | 80 | 50.0 | 1.15 | 12000 |
| | | | | | *.776* | *.756* | *7.717* | *7.874* | *1160* | | | |
| | E20 | 1 | 1 | EH20-A19.7-SH-160 | 19.7 | 19.2 | 156 | 160.0 | 80 | 50.0 | 0.91 | 19000 |
| | | | | | *.776* | *.756* | *6.142* | *6.299* | *1160* | | | |
| 24.7 | E25 | 1 | 1 | EH25-A24.7-SH-235 | 24.7 | 24.1 | 231 | 235.0 | 80 | 65.0 | 1.99 | 10500 |
| | | | | | *.972* | *.949* | *9.094* | *9.252* | *1160* | | | |
| | E25 | 1 | 1 | EH25-A24.7-SH-185 | 24.7 | 24.1 | 181 | 185.0 | 80 | 65.0 | 1.58 | 14000 |
| | | | | | *.972* | *.949* | *7.126* | *7.283* | *1160* | | | |

## Inch version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 9.2 | E10 | 1 | 1 | AEH10-A09.2-SH-120 | 9.2 | 9.2 | 117 | 120.0 | 80 | 12.0 | 0.19 | 19000 |
| | | | | | *.362* | *.360* | *4.606* | *4.724* | *1160* | | | |
| | E10 | 1 | 1 | AEH10-A09.2-SH-100 | 9.2 | 9.2 | 97 | 100.0 | 80 | 12.0 | 0.16 | 23000 |
| | | | | | *.362* | *.360* | *3.819* | *3.937* | *1160* | | | |
| 18.7 | E20 | 1 | 1 | AEH20-A18.7-SH-190 | 18.7 | 18.4 | 186 | 190.0 | 80 | 50.0 | 0.97 | 12000 |
| | | | | | *.736* | *.724* | *7.323* | *7.480* | *1160* | | | |
| | E20 | 1 | 1 | AEH20-A18.7-SH-150 | 18.7 | 18.4 | 147 | 150.0 | 80 | 50.0 | 0.78 | 19000 |
| | | | | | *.736* | *.724* | *5.787* | *5.906* | *1160* | | | |

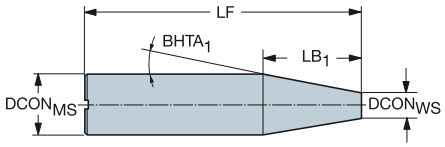
For spare parts, visit www.sandvik.coromant.com

N22 N6 N15 N3

# Cylindrical shank to Coromant EH adapter

**Conical design**

**Inch version**




## Steel shank

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.0 | E16 | 1 | 1 | **AEH16-A25-CS-065** | 25.4 | 15.4 | 107 | 165.1 | 57.2 | 5° | 80 | 30.0 | 0.66 | 31000 |
| | | | | | *1.000* | *.606* | *4.248* | *6.500* | *2.252* | | *1160* | | | |

## Cemented carbide shank

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | BD$_2$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5/8 | E10 | 1 | 1 | **AE10-A16-CE-055** | 15.9 | 9.2 | 101 | 139.7 | 38.5 | 15.9 | 5° | 80 | 12.0 | 0.41 | 28000 |
| | | | | | *.625* | *.360* | *3.976* | *5.500* | *1.516* | *.625* | | *1160* | | | |
| | E10 | 1 | 1 | **AE10-A16-CE-065** | 15.9 | 9.2 | 112 | 165.1 | 53.0 | 15.9 | 1° | 80 | 12.0 | 0.42 | 19000 |
| | | | | | *.625* | *.360* | *4.409* | *6.500* | *2.087* | *.625* | | *1160* | | | |
| | E12 | 1 | 1 | **AE12-A16-CE-065** | 15.9 | 12.2 | 144 | 165.1 | 21.0 | 15.9 | 5° | 80 | 15.0 | 0.55 | 18000 |
| | | | | | *.625* | *.480* | *5.669* | *6.500* | *.827* | *.625* | | *1160* | | | |
| | E12 | 1 | 1 | **AE12-A16-CE-075** | 15.9 | 12.2 | 127 | 190.5 | 63.0 | 15.9 | 1° | 80 | 15.0 | 0.53 | 13000 |
| | | | | | *.625* | *.480* | *5.000* | *7.500* | *2.480* | *.625* | | *1160* | | | |
| 3/4 | E16 | 1 | 1 | **AE16-A19-CE-065** | 19.1 | 15.4 | 144 | 165.1 | 21.0 | 19.1 | 5° | 80 | 30.0 | 0.70 | 25000 |
| | | | | | *.750* | *.606* | *5.669* | *6.500* | *.827* | *.750* | | *1160* | | | |
| | E16 | 1 | 1 | **AE16-A19-CE-075** | 19.1 | 15.4 | 112 | 190.5 | 78.3 | 19.1 | 1° | 80 | 30.0 | 0.76 | 18000 |
| | | | | | *.750* | *.606* | *4.409* | *7.500* | *3.083* | *.750* | | *1160* | | | |
| 1.0 | E20 | 1 | 1 | **AE20-A25-CE-060** | 25.4 | 18.4 | 112 | 152.4 | 40.0 | 25.4 | 5° | 80 | 50.0 | 1.05 | 36000 |
| | | | | | *1.000* | *.724* | *4.409* | *6.000* | *1.575* | *1.000* | | *1160* | | | |
| | E20 | 1 | 1 | **AE20-A25-CE-080** | 25.4 | 18.4 | 120 | 203.2 | 82.6 | 25.4 | 1° | 80 | 50.0 | 1.30 | 19000 |
| | | | | | *1.000* | *.724* | *4.724* | *8.000* | *3.252* | *1.000* | | *1160* | | | |
| 1 1/4 | E25 | 1 | 1 | **AE25-A32-CE-085** | 31.8 | 24.4 | 173 | 215.9 | 42.0 | 31.8 | 5° | 80 | 65.0 | 2.38 | 18000 |
| | | | | | *1.250* | *.961* | *6.811* | *8.500* | *1.654* | *1.250* | | *1160* | | | |

**Note!**

Cemented carbide shank to be used for finishing/semi-finishing only

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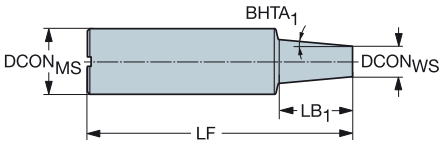
N22 N6 N15 N3

# Cylindrical shank to Coromant EH adapter

## Conical design

### Metric version




### Steel shank

| | | | | | Dimensions, mm, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 16.0 | E10 | 1 | 1 | E10-A16-CS-140 | 16.0 | 9.6 | 103 | 140.0 | 36.6 | 5° | 80 | 12.0 | 0.24 | 16000 |
| | | | | | *.630* | *.378* | *4.055* | *5.512* | *1.441* | | *1160* | | | |
| | E10 | 1 | 1 | E10-A16-CS-160 | 16.0 | 9.6 | 108 | 160.0 | 50.0 | 1° | 80 | 12.0 | 0.24 | 12000 |
| | | | | | *.630* | *.378* | *4.252* | *6.299* | *1.969* | | *1160* | | | |
| | E12 | 1 | 1 | E12-A16-CS-140 | 16.0 | 11.6 | 115 | 140.0 | 25.1 | 5° | 80 | 15.0 | 0.25 | 16000 |
| | | | | | *.630* | *.457* | *4.528* | *5.512* | *.988* | | *1160* | | | |
| | E12 | 1 | 1 | E12-A16-CS-170 | 16.0 | 11.6 | 108 | 170.0 | 60.0 | 1° | 80 | 15.0 | 0.30 | 12000 |
| | | | | | *.630* | *.457* | *4.252* | *6.693* | *2.362* | | *1160* | | | |
| 20.0 | E16 | 1 | 1 | E16-A20-CS-190 | 20.0 | 15.4 | 112 | 190.0 | 75.0 | 1° | 80 | 30.0 | 0.49 | 13000 |
| | | | | | *.787* | *.606* | *4.409* | *7.480* | *2.953* | | *1160* | | | |
| | E16 | 1 | 1 | EH16-A20-CS-165 | 20.0 | 15.4 | 138 | 165.0 | 26.3 | 5° | 80 | | 0.44 | 27000 |
| | | | | | *.787* | *.606* | *5.461* | *6.496* | *1.035* | | *1160* | | | |
| 25.0 | E16 | 1 | 1 | E16-A25-CS-170 | 25.0 | 15.4 | 115 | 170.0 | 54.9 | 5° | 80 | 30.0 | 0.66 | 18000 |
| | | | | | *.984* | *.606* | *4.528* | *6.693* | *2.161* | | *1160* | | | |
| | E20 | 1 | 1 | EH20-A25-CS-200 | 25.0 | 19.2 | 120 | 200.0 | 80.0 | 1° | 80 | | 0.70 | 19000 |
| | | | | | *.984* | *.756* | *4.724* | *7.874* | *3.150* | | *1160* | | | |
| 32.0 | E10 | 1 | 1 | E10-A32-CS-250 | 32.0 | 9.6 | 186 | 250.0 | 63.5 | 10° | 80 | 12.0 | 1.39 | 10000 |
| | | | | | *1.260* | *.378* | *7.323* | *9.843* | *2.500* | | *1160* | | | |
| | E12 | 1 | 1 | E12-A32-CS-250 | 32.0 | 11.6 | 192 | 250.0 | 57.8 | 10° | 80 | 15.0 | 1.50 | 10000 |
| | | | | | *1.260* | *.457* | *7.559* | *9.843* | *2.276* | | *1160* | | | |
| | E20 | 1 | 1 | E20-A32-CS-180 | 32.0 | 19.2 | 107 | 180.0 | 73.2 | 5° | 80 | 50.0 | 1.06 | 20000 |
| | | | | | *1.260* | *.756* | *4.213* | *7.087* | *2.882* | | *1160* | | | |
| | E25 | 1 | 1 | E25-A32-CS-200 | 32.0 | 24.1 | 154 | 200.0 | 45.1 | 5° | 80 | 65.0 | 1.29 | 15000 |
| | | | | | *1.260* | *.949* | *6.063* | *7.874* | *1.776* | | *1160* | | | |

### Cemented carbide shank

| | | | | | Dimensions, mm, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $BHTA_1$ | BAR PSI | NM | KG | RPMX |
| 16.0 | E10 | 1 | 1 | EH10-A16-CE-140 | 16.0 | 9.6 | 103 | 140.0 | 36.6 | 5° | 80 | | 0.41 | 36000 |
| | | | | | *.630* | *.378* | *4.071* | *5.512* | *1.441* | | *1160* | | | |
| | E12 | 1 | 1 | EH12-A16-CE-165 | 16.0 | 11.6 | 139 | 165.0 | 25.1 | 5° | 80 | | 0.50 | 23000 |
| | | | | | *.630* | *.457* | *5.508* | *6.496* | *.988* | | *1160* | | | |
| | E10 | 1 | 1 | E10-A16-CE-155 | 16.0 | 9.6 | 52 | 155.0 | 100.0 | 1° | 80 | 12.0 | 0.34 | 22000 |
| | | | | | *.630* | *.378* | *2.047* | *6.102* | *3.937* | | *1160* | | | |
| | E12 | 1 | 1 | E12-A16-CE-150 | 16.0 | 11.6 | 58 | 150.0 | 90.0 | 1° | 80 | 15.0 | 0.39 | 23000 |
| | | | | | *.630* | *.457* | *2.283* | *5.906* | *3.543* | | *1160* | | | |
| 20.0 | E16 | 1 | 1 | EH16-A20-CE-165 | 20.0 | 15.4 | 138 | 165.0 | 26.3 | 5° | 80 | | 0.78 | 27000 |
| | | | | | *.787* | *.606* | *5.461* | *6.496* | *1.035* | | *1160* | | | |
| | E16 | 1 | 1 | E16-A20-CE-175 | 20.0 | 15.4 | 55 | 175.0 | 118.0 | 1° | 80 | 30.0 | 0.72 | 22000 |
| | | | | | *.787* | *.606* | *2.165* | *6.890* | *4.646* | | *1160* | | | |
| 25.0 | E20 | 1 | 1 | EH20-A25-CE-150 | 25.0 | 19.2 | 116 | 150.0 | 33.1 | 5° | 80 | 50.0 | 1.05 | 23000 |
| | | | | | *.984* | *.756* | *4.567* | *5.906* | *1.303* | | *1160* | | | |
| | E20 | 1 | 1 | EH20-A25-CE-200 | 25.0 | 19.2 | 117 | 200.0 | 83.0 | 2° | 80 | 50.0 | 1.08 | 19000 |
| | | | | | *.984* | *.756* | *4.606* | *7.874* | *3.268* | | *1160* | | | |
| 32.0 | E20 | 1 | 1 | EH20-A32-CE-175 | 32.0 | 19.2 | 101 | 175.0 | 73.2 | 5° | 80 | 50.0 | 1.78 | 21000 |
| | | | | | *1.260* | *.756* | *3.976* | *6.890* | *2.882* | | *1160* | | | |
| | E25 | 1 | 1 | EH25-A32-CE-190 | 32.0 | 24.1 | 144 | 190.0 | 45.1 | 5° | 80 | 65.0 | 2.07 | 20000 |
| | | | | | *1.260* | *.949* | *5.669* | *7.480* | *1.776* | | *1160* | | | |
| | E25 | 1 | 1 | EH25-A32-CE-215 | 32.0 | 24.1 | 169 | 215.0 | 45.1 | 5° | 80 | 65.0 | 2.41 | 18000 |
| | | | | | *1.260* | *.949* | *6.654* | *8.465* | *1.776* | | *1160* | | | |

**Note!**

Cemented carbide shank to be used for finishing/semi-finishing only

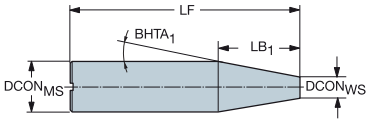
For spare parts, visit www.sandvik.coromant.com

N22 N6 N15 N3

# Cylindrical shank to Coromant EH adapter

**Conical design**

**Inch version**



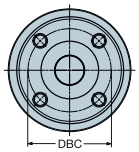

**Steel shank**

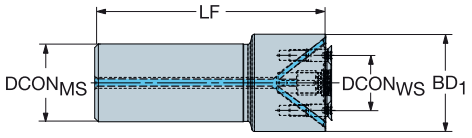
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | BD$_2$ | BHTA$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 5/8 | E10 | 1 | 1 | **AE10-A16-CS-055** | 15.9 | 9.2 | 101 | 139.7 | 38.5 | 15.9 | 5° | 80 | 12.0 | 0.23 | 17000 |
| | | | | | *.625* | *.360* | *3.976* | *5.500* | *1.516* | *.625* | | *1160* | | | |
| | E10 | 1 | 1 | **AE10-A16-CS-065** | 15.9 | 9.2 | 112 | 165.1 | 51.0 | 15.9 | 1° | 80 | 12.0 | 0.25 | 12000 |
| | | | | | *.625* | *.360* | *4.409* | *6.500* | *2.008* | *.625* | | *1160* | | | |
| | E12 | 1 | 1 | **AE12-A16-CS-065** | 15.9 | 12.2 | 144 | 165.1 | 21.0 | 15.9 | 5° | 80 | 15.0 | 0.29 | 12000 |
| | | | | | *.625* | *.480* | *5.669* | *6.500* | *.827* | *.625* | | *1160* | | | |
| | E12 | 1 | 1 | **AE12-A16-CS-075** | 15.9 | 12.2 | 127 | 190.5 | 61.0 | 15.9 | 1° | 80 | 15.0 | 0.30 | 10000 |
| | | | | | *.625* | *.480* | *5.000* | *7.500* | *2.402* | *.625* | | *1160* | | | |
| 3/4 | E16 | 1 | 1 | **AE16-A19-CS-065** | 19.1 | 15.4 | 144 | 165.1 | 21.0 | 19.1 | 5° | 80 | 30.0 | 0.44 | 16000 |
| | | | | | *.750* | *.606* | *5.669* | *6.500* | *.827* | *.750* | | *1160* | | | |
| | E16 | 1 | 1 | **AE16-A19-CS-075** | 19.1 | 15.4 | 112 | 190.5 | 76.2 | 19.1 | 1° | 80 | 30.0 | 0.47 | 12000 |
| | | | | | *.750* | *.606* | *4.409* | *7.500* | *3.000* | *.750* | | *1160* | | | |
| 1.0 | E20 | 1 | 1 | **AE20-A25-CS-060** | 25.4 | 18.4 | 112 | 152.4 | 40.0 | 25.4 | 5° | 80 | 50.0 | 0.65 | 23000 |
| | | | | | *1.000* | *.724* | *4.409* | *6.000* | *1.575* | *1.000* | | *1160* | | | |
| | E20 | 1 | 1 | **AE20-A25-CS-080** | 25.4 | 18.4 | 120 | 203.2 | 80.0 | 25.4 | 1° | 80 | 50.0 | 0.80 | 12000 |
| | | | | | *1.000* | *.724* | *4.724* | *8.000* | *3.150* | *1.000* | | *1160* | | | |
| 1 1/4 | E25 | 1 | 1 | **AE25-A32-CS-075** | 31.8 | 24.4 | 148 | 190.5 | 42.0 | 31.8 | 5° | 80 | 65.0 | 1.12 | 17000 |
| | | | | | *1.250* | *.961* | *5.827* | *7.500* | *1.654* | *1.250* | | *1160* | | | |

N22 N6 N15 N3

# Cylindrical shank to arbor with driving screws adapter

**For CoroMill® QD with internal coolant supply**




## Metric version

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $DCON_{WS}$ | DBC | LSC | LF | $BD_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 25.0 | X10 | 1 | 3 | **CY25-X10-032-090** | 25.0 | 10.0 | 22.0 | 57 | 90.0 | 32.0 | 80 | 6.4 | 0.42 | 12000 |
| | | | | | *.984* | *.394* | *.866* | *2.244* | *3.543* | *1.260* | *1160* | | | |
| | X22 | 1 | 3 | **CY25-X22-040-090** | 25.0 | 22.0 | 32.0 | 57 | 90.0 | 40.0 | 80 | 3.9 | 0.53 | 11000 |
| | | | | | *.984* | *.866* | *1.260* | *2.244* | *3.543* | *1.575* | *1160* | | | |
| 32.0 | X22 | 1 | 3 | **CY32-X22-040-095** | 32.0 | 22.0 | 32.0 | 61 | 95.0 | 40.0 | 80 | 3.9 | 0.71 | 11000 |
| | | | | | *1.260* | *.866* | *1.260* | *2.402* | *3.740* | *1.575* | *1160* | | | |

## Inch version

| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch $DCON_{MS}$ | $DCON_{WS}$ | DBC | LSC | LF | $BD_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.0 | X10 | 1 | 3 | **CY25A-X10-032-090** | 25.4 | 10.0 | 22.0 | 57 | 90.0 | 32.0 | 80 | 6.4 | 0.25 | 12000 |
| | | | | | *1.000* | *.394* | *.866* | *2.281* | *3.543* | *1.260* | *1160* | | | |
| | Y25 | 1 | 3 | **CY25A-Y25-050-100** | 25.4 | 25.4 | 36.0 | 57 | 100.0 | 50.0 | 80 | 3.9 | 0.83 | 11000 |
| | | | | | *1.000* | *1.000* | *1.417* | *2.281* | *3.937* | *1.969* | *1160* | | | |

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

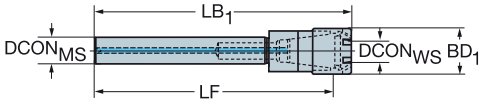
M1

N22

N15

# Cylindrical shank to ER collet chuck

**Workpiece side interface DIN 6499-B**




## Metric version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | BD$_1$ | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 8.0 | ER11 | 1 | 1 | 393.14-08 11 056 | 8.0 | 11.4 | 52 | 75.0 | 82.5 | 16.0 | 20 | 0.05 |
| | | | | | *.315* | *.449* | *2.047* | *2.953* | *3.248* | *.630* | *290* | |
| 12.0 | ER16 | 1 | 1 | 393.14-12 16 080 | 12.0 | 17.0 | 77 | 107.0 | 118.5 | 22.0 | 20 | 0.13 |
| | | | | | *.472* | *.669* | *3.032* | *4.213* | *4.665* | *.866* | *290* | |
| 16.0 | ER11 | 1 | 1 | 393.14-16 11 150 | 16.0 | 11.4 | 149 | 163.5 | 171.0 | 16.0 | 20 | 0.21 |
| | | | | | *.630* | *.449* | *5.866* | *6.437* | *6.732* | *.630* | *290* | |
| 20.0 | ER16 | 1 | 1 | 393.14-20 16 155 | 20.0 | 17.0 | 155 | 170.0 | 181.5 | 22.0 | 20 | 0.31 |
| | | | | | *.787* | *.669* | *6.102* | *6.693* | *7.146* | *.866* | *290* | |
| 25.0 | ER20 | 1 | 1 | 393.14-25 20 170A | 25.0 | 21.0 | 141 | 170.5 | 182.0 | 28.0 | 20 | 0.51 |
| | | | | | *.984* | *.827* | *5.551* | *6.713* | *7.165* | *1.102* | *290* | |

## Inch version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | BD$_1$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1/2 | ER16 | 1 | 1 | A393.14-13 16 182 | 12.7 | 17.0 | 136 | 165.5 | 177.0 | 22.0 | 20 | 1.8 | 0.17 |
| | | | | | *.500* | *.669* | *5.354* | *6.516* | *6.969* | *.866* | *290* | | |
| 3/4 | ER16 | 1 | 1 | A393.14-19 16 182 | 19.1 | 17.0 | 142 | 170.0 | 181.5 | 22.0 | 20 | 1.8 | 0.28 |
| | | | | | *.750* | *.669* | *5.591* | *6.693* | *7.146* | *.866* | *290* | | |
| | ER20 | 1 | 1 | A393.14-19 20 187 | 19.1 | 21.0 | 146 | 175.5 | 187.0 | 28.0 | 20 | 4.3 | 0.33 |
| | | | | | *.750* | *.827* | *5.748* | *6.909* | *7.362* | *1.102* | *290* | | |
| | ER25 | 1 | 1 | A393.14-19 25 203 | 19.1 | 26.0 | 152 | 191.7 | 203.0 | 41.7 | 20 | 4.3 | 0.59 |
| | | | | | *.750* | *1.024* | *5.984* | *7.547* | *7.992* | *1.642* | *290* | | |
| 1.0 | ER20 | 1 | 1 | A393.14-26 20 203 | 25.4 | 21.0 | 161 | 191.0 | 203.2 | 28.0 | 20 | 4.3 | 0.52 |
| | | | | | *1.000* | *.827* | *6.339* | *7.520* | *8.000* | *1.102* | *290* | | |
| | ER25 | 1 | 1 | A393.14-26 25 203 | 25.4 | 26.0 | 152 | 191.0 | 203.0 | 41.7 | 20 | 4.3 | 0.61 |
| | | | | | *1.000* | *1.024* | *5.984* | *7.520* | *7.992* | *1.642* | *290* | | |
| | ER32 | 1 | 1 | A393.14-26 32 203 | 25.4 | 33.0 | 146 | 190.0 | 203.0 | 49.7 | 20 | 6.5 | 0.73 |
| | | | | | *1.000* | *1.299* | *5.748* | *7.480* | *7.992* | *1.957* | *290* | | |

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

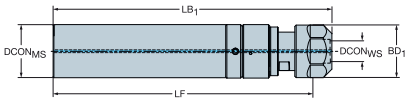
M1 N22 N15

# Cylindrical shank to CoroChuck™ 970

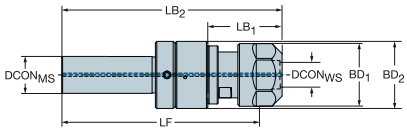
**For synchronized tapping operations**

**Workpiece side interface DIN 6499-B**

DSGN 1




2




## Metric version

| | | | | | | | Dimensions, mm, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | TRMAX | CNSC | CXSC | DSGN | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BD_2$ | BAR PSI | KG | RPMX |
| 12.0 | ER8 | M3 | 1 | 1 | 1 | **970-CY12-8-052** | 12.0 | 8.5 | 70 | 94.0 | 100.0 | | 12.0 | | 60 | 0.12 | 8000 |
| | | | | | | | *.472* | *.335* | *2.756* | *3.701* | *3.937* | | *.472* | | *870* | | |
| 16.0 | 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 |
| | | | | | | | *.630* | *.445* | *1.752* | *3.602* | *.992* | *3.795* | *.736* | *.925* | *1160* | | |
| 20.0 | 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 |
| | | | | | | | *.787* | *.819* | *2.000* | *4.193* | *1.583* | *4.705* | *1.339* | *1.362* | *1160* | | |

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

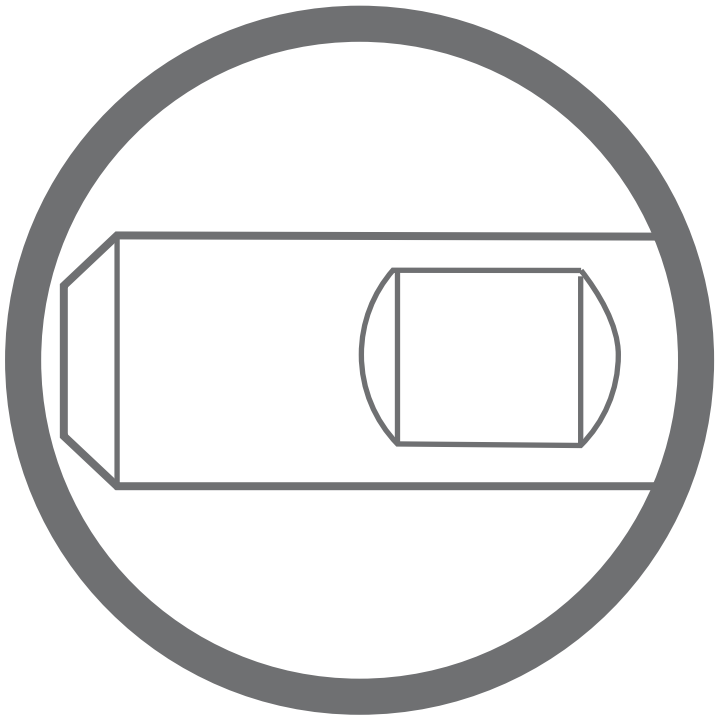
M1

N22

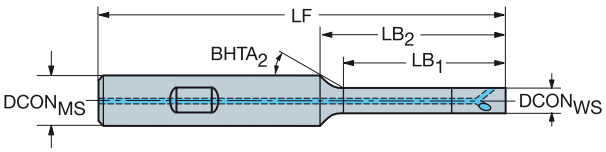
N15

N5

# Machine side interface Weldon shank



# Weldon to CoroMill® 327 adapter




## Metric version

| | | | | | Dimensions, mm, inch | | | | | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $BD_1$ | $BHTA_2$ | | | |
| 12.0 | 06 | 1 | 1 | **327-12B15SC-06** | 12.0 | 6.0 | 46 | 70.5 | 11.5 | 17.2 | 6.0 | 30° | 20 | 1.8 | 0.07 |
| | | | | | *.472* | *.236* | *1.811* | *2.776* | *.453* | *.678* | *.236* | | *290* | | |
| | 06 | 1 | 1 | **327-12B21EC-06** | 12.0 | 6.0 | 46 | 76.5 | 17.5 | 23.2 | 6.0 | 30° | 20 | 1.8 | 0.13 |
| | | | | | *.472* | *.236* | *1.811* | *3.012* | *.689* | *.915* | *.236* | | *290* | | |
| | 06 | 1 | 1 | **327-12B30EC-06** | 12.0 | 6.0 | 46 | 86.5 | 26.5 | 32.2 | 6.0 | 30° | 20 | 1.8 | 0.13 |
| | | | | | *.472* | *.236* | *1.811* | *3.406* | *1.043* | *1.269* | *.236* | | *290* | | |
| | 06 | 1 | 1 | **327-12B42EC-06** | 12.0 | 6.0 | 46 | 96.5 | 38.5 | 44.2 | 6.0 | 30° | 20 | 1.8 | 0.13 |
| | | | | | *.472* | *.236* | *1.811* | *3.799* | *1.516* | *1.741* | *.236* | | *290* | | |
| 16.0 | 09 | 1 | 1 | **327-16B18SC-09** | 16.0 | 9.0 | 49 | 74.3 | 12.2 | 18.8 | 9.0 | 30° | 20 | 4.3 | 0.19 |
| | | | | | *.630* | *.354* | *1.929* | *2.923* | *.482* | *.742* | *.354* | | *290* | | |
| | 12 | 1 | 1 | **327-16B24SC-12** | 16.0 | 12.0 | 49 | 74.3 | 18.3 | 22.3 | 12.0 | 30° | 20 | 6.5 | 0.10 |
| | | | | | *.630* | *.472* | *1.929* | *2.925* | *.720* | *.878* | *.472* | | *290* | | |
| | 09 | 1 | 1 | **327-16B32EC-09** | 16.0 | 9.0 | 49 | 94.3 | 26.2 | 32.8 | 9.0 | 30° | 20 | 4.3 | 0.27 |
| | | | | | *.630* | *.354* | *1.929* | *3.711* | *1.033* | *1.293* | *.354* | | *290* | | |
| | 09 | 1 | 1 | **327-16B45EC-09** | 16.0 | 9.0 | 49 | 104.3 | 39.2 | 45.8 | 9.0 | 30° | 20 | 4.3 | 0.20 |
| | | | | | *.630* | *.354* | *1.929* | *4.104* | *1.545* | *1.805* | *.354* | | *290* | | |
| | 09 | 1 | 1 | **327-16B64EC-09** | 16.0 | 9.0 | 49 | 124.3 | 58.2 | 64.8 | 9.0 | 30° | 20 | 4.3 | 0.30 |
| | | | | | *.630* | *.354* | *1.929* | *4.892* | *2.293* | *2.553* | *.354* | | *290* | | |
| | 12 | 1 | 1 | **327-16B42EC-12** | 16.0 | 12.0 | 49 | 94.3 | 36.3 | 40.3 | 12.0 | 30° | 20 | 6.5 | 0.28 |
| | | | | | *.630* | *.472* | *1.929* | *3.713* | *1.429* | *1.587* | *.472* | | *290* | | |
| | 12 | 1 | 1 | **327-16B60EC-12** | 16.0 | 12.0 | 49 | 124.3 | 54.3 | 58.3 | 12.0 | 30° | 20 | 6.5 | 0.34 |
| | | | | | *.630* | *.472* | *1.929* | *4.894* | *2.138* | *2.295* | *.472* | | *290* | | |
| | 12 | 1 | 1 | **327-16B85EC-12** | 16.0 | 12.0 | 49 | 154.3 | 79.3 | 83.3 | 12.0 | 30° | 20 | 6.5 | 0.39 |
| | | | | | *.630* | *.472* | *1.929* | *6.075* | *3.122* | *3.280* | *.472* | | *290* | | |
| | 14 | 1 | 1 | **327-16B42EC-14** | 16.0 | 14.3 | 49 | 93.5 | 35.5 | 37.5 | 14.3 | 30° | 20 | 6.5 | 0.30 |
| | | | | | *.630* | *.563* | *1.929* | *3.681* | *1.398* | *1.477* | *.563* | | *290* | | |
| | 14 | 1 | 1 | **327-16B60EC-14** | 16.0 | 14.3 | 49 | 123.5 | 53.5 | 55.5 | 14.3 | 30° | 20 | 6.5 | 0.37 |
| | | | | | *.630* | *.563* | *1.929* | *4.862* | *2.106* | *2.185* | *.563* | | *290* | | |
| | 14 | 1 | 1 | **327-16B85EC-14** | 16.0 | 14.3 | 49 | 153.5 | 78.5 | 80.5 | 14.3 | 30° | 20 | 6.5 | 0.47 |
| | | | | | *.630* | *.563* | *1.929* | *6.043* | *3.091* | *3.170* | *.563* | | *290* | | |
| 20.0 | 14 | 1 | 1 | **327-20B35SC-14** | 20.0 | 14.3 | 51 | 93.5 | 28.5 | 33.2 | 14.0 | 30° | 20 | 6.5 | 0.28 |
| | | | | | *.787* | *.563* | *2.008* | *3.681* | *1.122* | *1.307* | *.551* | | *290* | | |

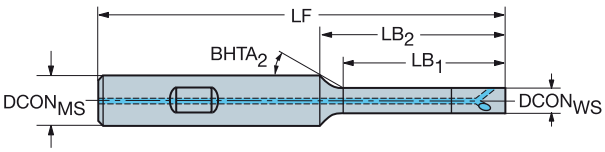
S = Steel shank

E = Cemented carbide shank

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

N22 N15

# Weldon to CoroMill® 327 adapter




## Inch version

| | | | | | Dimensions, mm, inch | | | | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $LB_1$ | $LB_2$ | $BHTA_2$ | | | |
| 1/2 | 06 | 1 | 1 | A327-13B21EC-06 | 12.7 | 6.0 | 45 | 76.5 | 17.5 | 23.8 | 30° | 20 | 1.8 | 0.14 |
| | | | | | *.500* | *.236* | *1.781* | *3.012* | *.689* | *.939* | | *290* | | |
| | 06 | 1 | 1 | A327-13B30EC-06 | 12.7 | 6.0 | 45 | 86.5 | 26.5 | 32.8 | 30° | 20 | 1.8 | 0.15 |
| | | | | | *.500* | *.236* | *1.781* | *3.405* | *1.043* | *1.293* | | *290* | | |
| | 06 | 1 | 1 | A327-13B42EC-06 | 12.7 | 6.0 | 45 | 96.5 | 38.5 | 44.8 | 30° | 20 | 1.8 | 0.14 |
| | | | | | *.500* | *.236* | *1.781* | *3.799* | *1.516* | *1.766* | | *290* | | |
| 5/8 | 12 | 1 | 1 | A327-16B24SC-12 | 15.9 | 12.0 | 52 | 74.2 | 18.3 | 22.1 | 30° | 20 | 6.5 | 0.20 |
| | | | | | *.625* | *.472* | *2.051* | *2.923* | *.720* | *.871* | | *290* | | |
| | 09 | 1 | 1 | A327-16B18SC-09 | 15.9 | 9.0 | 52 | 74.3 | 12.2 | 18.7 | 30° | 20 | 4.3 | 0.19 |
| | | | | | *.625* | *.354* | *2.075* | *2.923* | *.482* | *.738* | | *290* | | |
| | 09 | 1 | 1 | A327-16B32EC-09 | 15.9 | 9.0 | 52 | 94.3 | 26.2 | 32.7 | 30° | 20 | 4.3 | 0.21 |
| | | | | | *.625* | *.354* | *2.075* | *3.711* | *1.033* | *1.289* | | *290* | | |
| | 09 | 1 | 1 | A327-16B45EC-09 | 15.9 | 9.0 | 52 | 104.3 | 39.2 | 45.7 | 30° | 20 | 4.3 | 0.21 |
| | | | | | *.625* | *.354* | *2.075* | *4.105* | *1.545* | *1.801* | | *290* | | |
| | 09 | 1 | 1 | A327-16B64EC-09 | 15.9 | 9.0 | 52 | 124.3 | 58.2 | 64.7 | 30° | 20 | 4.3 | 0.30 |
| | | | | | *.625* | *.354* | *2.075* | *4.892* | *2.293* | *2.549* | | *290* | | |
| | 12 | 1 | 1 | A327-16B42EC-12 | 15.9 | 12.0 | 52 | 94.3 | 36.3 | 40.2 | 30° | 20 | 6.5 | 0.28 |
| | | | | | *.625* | *.472* | *2.075* | *3.713* | *1.429* | *1.583* | | *290* | | |
| | 12 | 1 | 1 | A327-16B60EC-12 | 15.9 | 12.0 | 52 | 124.3 | 54.3 | 58.1 | 30° | 20 | 6.5 | 0.33 |
| | | | | | *.625* | *.472* | *2.075* | *4.894* | *2.138* | *2.288* | | *290* | | |
| | 12 | 1 | 1 | A327-16B85EC-12 | 15.9 | 12.0 | 52 | 154.3 | 79.3 | 83.1 | 30° | 20 | 6.5 | 0.37 |
| | | | | | *.625* | *.472* | *2.075* | *6.075* | *3.122* | *3.272* | | *290* | | |
| | 14 | 1 | 1 | A327-16B42EC-14 | 15.9 | 14.3 | 52 | 93.5 | 35.5 | 37.4 | 30° | 20 | 6.5 | 0.25 |
| | | | | | *.625* | *.563* | *2.075* | *3.681* | *1.398* | *1.473* | | *290* | | |
| | 14 | 1 | 1 | A327-16B60EC-14 | 15.9 | 14.3 | 52 | 123.5 | 53.4 | 55.3 | 30° | 20 | 6.5 | 0.39 |
| | | | | | *.625* | *.563* | *2.075* | *4.862* | *2.106* | *2.181* | | *290* | | |
| | 14 | 1 | 1 | A327-16B85EC-14 | 15.9 | 14.3 | 52 | 153.5 | 78.4 | 80.3 | 30° | 20 | 6.5 | 0.42 |
| | | | | | *.625* | *.563* | *2.075* | *6.043* | *3.090* | *3.165* | | *290* | | |

S = Steel shank

E = Cemented carbide shank

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

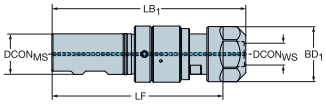
N22 N15

# Weldon to CoroChuck™ 970

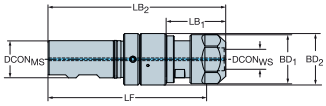
**For synchronized tapping operations**

**Workpiece side interface DIN 6499-B**

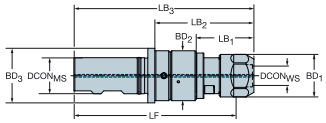
DSGN 1




DSGN 2




DSGN 5




## Metric version

| CZC$_{MS}$ | CZC$_{WS}$ | TRMAX | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 16.0 | 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 |
| | | | | | | | *.630* | *.445* | *1.752* | *3.602* | *.992* | *3.795* | | *.736* | *.925* | | *1160* | | |
| 20.0 | 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 |
| | | | | | | | *.787* | *.445* | *2.000* | *3.850* | *.992* | *1.913* | *4.043* | *.736* | *.925* | *1.122* | *1160* | | |
| | 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 |
| | | | | | | | *.787* | *.819* | *2.000* | *4.193* | *1.587* | *4.705* | | *1.327* | *1.362* | | *1160* | | |
| 25.0 | 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 |
| | | | | | | | *.984* | *.445* | *2.000* | *3.850* | *.992* | *1.913* | *4.043* | *.736* | *.925* | *1.122* | *1160* | | |
| | 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 |
| | | | | | | | *.984* | *.819* | *2.000* | *4.193* | *1.579* | *4.705* | | *1.327* | *1.362* | | *1160* | | |
| | 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 |
| | | | | | | | *.984* | *1.016* | *2.000* | *4.937* | *1.661* | *5.469* | | *1.642* | *1.732* | | *1160* | | |
| | ER40 | M30 | 1 | 1 | 1 | **970-WE25-40-117** | 25.0 | 40.8 | 50 | 151.4 | 167.9 | | | 63.0 | | | 80 | 2.10 | 8000 |
| | | | | | | | *.984* | *1.606* | *2.000* | *5.961* | *6.610* | | | *2.480* | | | *1160* | | |
| 40.0 | 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 |
| | | | | | | | *1.575* | *2.047* | *2.756* | *8.339* | *3.091* | *5.307* | *9.224* | *3.071* | *3.150* | *3.386* | *1160* | | |

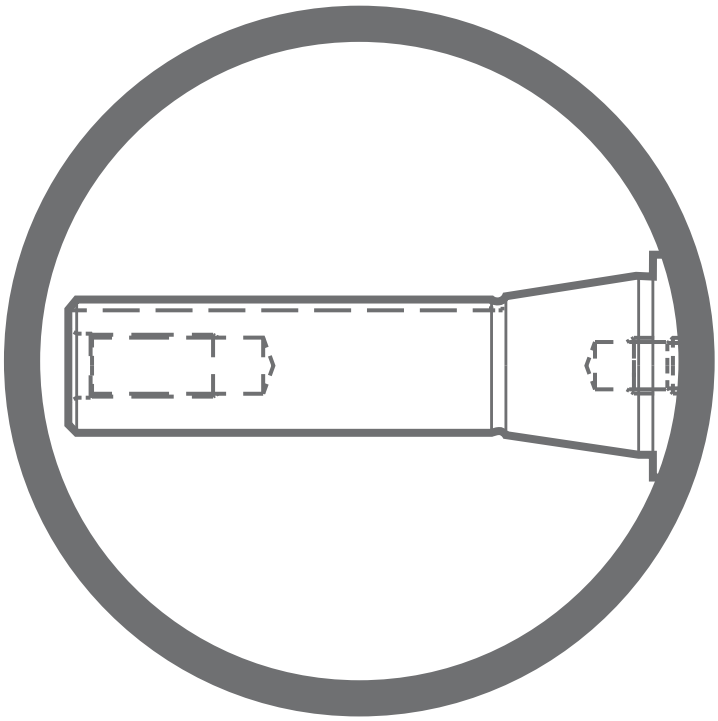
## Inch version

| CZC$_{MS}$ | CZC$_{WS}$ | TRMAX | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BAR PSI | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.0 | ER11 | M5 | 1 | 1 | 5 | **970-WE25A-11-052** | 25.4 | 11.3 | 50 | 97.8 | 25.2 | 48.6 | 102.7 | 18.7 | 23.5 | 28.5 | 80 | 0.27 | 8000 |
| | | | | | | | *1.000* | *.445* | *2.000* | *3.850* | *.992* | *1.913* | *4.043* | *.736* | *.925* | *1.122* | *1160* | | |
| | ER20 | M12 | 1 | 1 | 2 | **970-WE25A-20-069** | 25.4 | 20.8 | 50 | 106.5 | 40.1 | 119.5 | | 33.7 | 34.6 | | 80 | 0.47 | 8000 |
| | | | | | | | *1.000* | *.819* | *2.000* | *4.193* | *1.579* | *4.705* | | *1.327* | *1.362* | | *1160* | | |
| | ER25 | M20 | 1 | 1 | 2 | **970-WE25A-25-088** | 25.4 | 25.8 | 50 | 125.4 | 42.2 | 138.9 | | 41.7 | 44.0 | | 80 | 0.85 | 8000 |
| | | | | | | | *1.000* | *1.016* | *2.000* | *4.937* | *1.661* | *5.469* | | *1.642* | *1.732* | | *1160* | | |

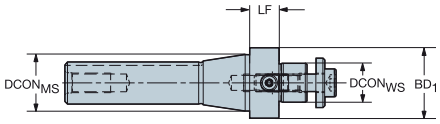
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15 N5

# Machine side interface Bridgeport



# R8 (Bridgeport) to arbor adapter




## Metric pilot

| $CZC_{MS}$ | $CZC_{WS}$ | Ordering code | Dimensions, mm, inch $DCON_{WS}$ | LF | $BD_1$ | NM | KG |
|---|---|---|---|---|---|---|---|
| R8 | 22 | 392.R8.05-22 020 | 22.0 | 20.0 | 40.0 | 45.0 | 0.67 |
| | | | *.866* | *.787* | *1.575* | | |

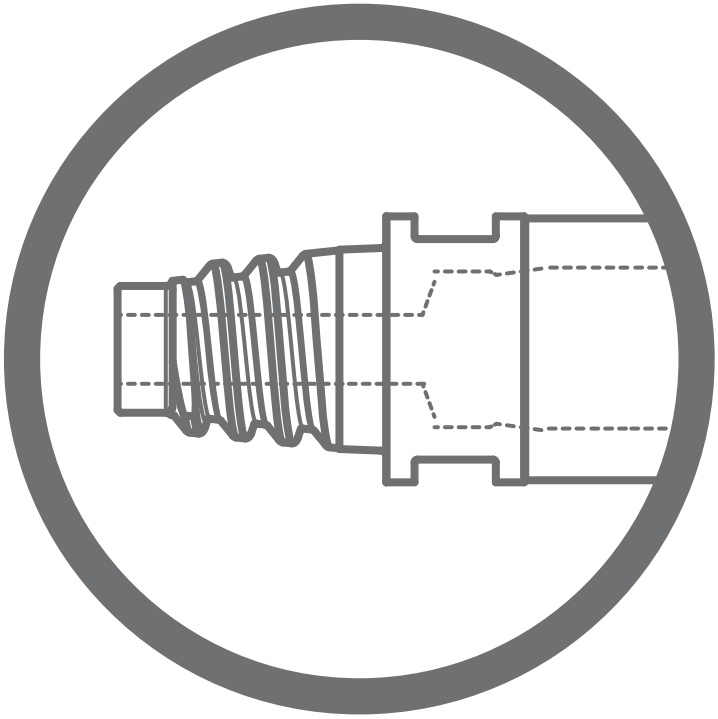
## Inch pilot

| $CZC_{MS}$ | $CZC_{WS}$ | Ordering code | Dimensions, mm, inch $DCON_{WS}$ | LF | $BD_1$ | NM | KG |
|---|---|---|---|---|---|---|---|
| R8 | 3/4 | A392.R8.05-19 020 | 19.1 | 20.0 | 40.0 | 25.0 | 0.67 |
| | | | *.750* | *.787* | *1.575* | | |
| | 1 | A392.R8.05-25 020 | 25.4 | 20.0 | 50.0 | 65.0 | 0.86 |
| | | | *1.000* | *.787* | *1.969* | | |

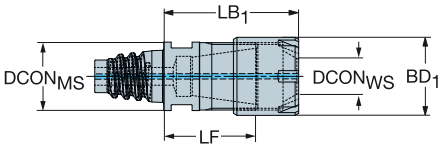
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

# Machine side interface Coromant EH

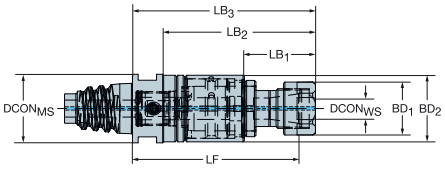


## Coromant EH to ER adapter



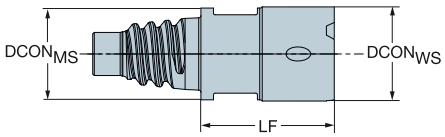

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $BD_1$ | BAR PSI | KG | RPMX |
| E12 | ER8 | 1 | 1 | **ER-EH12-08-024** | 11.7 | 8.5 | 18.0 | 24.0 | 12.0 | 80 | 0.03 | 40000 |
| | | | | | *.461* | *.335* | *.709* | *.945* | *.472* | *1160* | | |
| E16 | ER11 | 1 | 1 | **ER-EH16-11-028** | 15.5 | 11.4 | 20.5 | 28.0 | 16.0 | 80 | 0.04 | 40000 |
| | | | | | *.610* | *.449* | *.807* | *1.102* | *.630* | *1160* | | |
| E20 | ER16 | 1 | 1 | **ER-EH20-16-038** | 19.3 | 17.0 | 26.5 | 38.0 | 22.0 | 80 | 0.08 | 40000 |
| | | | | | *.760* | *.669* | *1.043* | *1.496* | *.866* | *1160* | | |
| E25 | ER20 | 1 | 1 | **ER-EH25-20-042** | 24.2 | 21.0 | 30.5 | 42.0 | 28.0 | 80 | 0.12 | 32000 |
| | | | | | *.953* | *.827* | *1.201* | *1.654* | *1.102* | *1160* | | |

## Coromant EH to CoroChuck™ 970




| | | | | | | Dimensions, mm, inch | | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | TRMAX | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $LB_2$ | $LB_3$ | $BD_1$ | $BD_2$ | BAR PSI | 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 |
| | | | | | | *.953* | *.445* | *2.354* | *.988* | *2.110* | *2.543* | *.736* | *.925* | *1160* | | |

## Coromant EH to CoroMill® 327 adapter

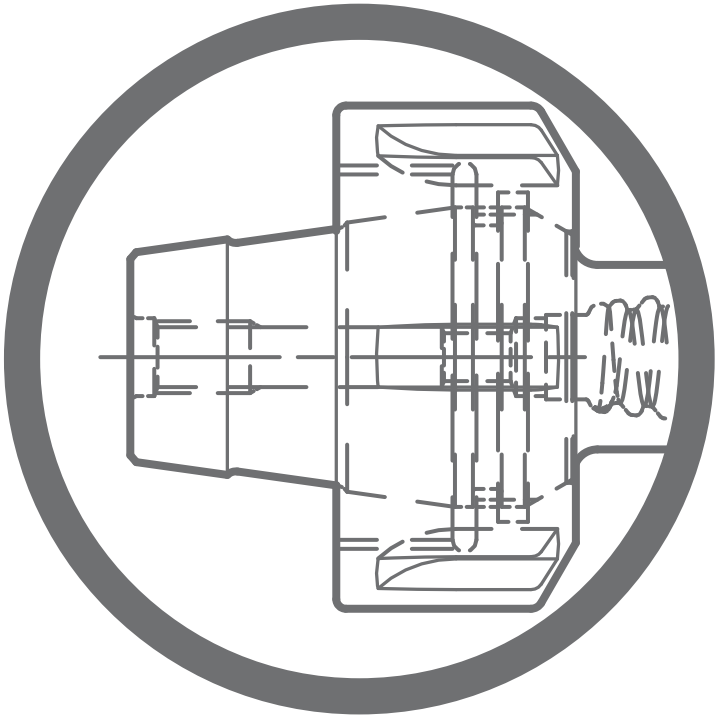



| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LF | $BD_1$ | BAR PSI | NM | KG | RPMX |
| E10 | 09 | 1 | 3 | **327-EH10-09-015** | 9.7 | 9.0 | 15.0 | 10.0 | 20 | 4.3 | 0.02 | 40000 |
| | | | | | *.382* | *.354* | *.591* | *.394* | *290* | | | |
| E12 | 12 | 1 | 3 | **327-EH12-12-017** | 11.7 | 12.0 | 17.0 | 12.0 | 20 | 6.5 | 0.02 | 40000 |
| | | | | | *.461* | *.472* | *.669* | *.472* | *290* | | | |
| | 14 | 1 | 3 | **327-EH12-14-017** | 11.7 | 14.3 | 17.0 | 14.3 | 20 | 6.5 | 0.01 | 40000 |
| | | | | | *.461* | *.563* | *.669* | *.563* | *290* | | | |

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

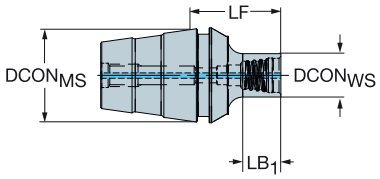
N22 N15 N6 N3

# Machine side interface ER



# ER to Coromant EH adapter

**Machine side interface DIN 6499-B**




## Metric version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| ER16 | E10 | 1 | 1 | EH-ER16-10-008 | 17.0 | 9.6 | 14.9 | 7.2 | 80 | 12.0 | 0.09 | 40000 |
| | | | | | *.669* | *.378* | *.587* | *.283* | *1160* | | | |
| ER20 | E10 | 1 | 1 | EH-ER20-10-008 | 21.0 | 9.6 | 15.8 | 7.2 | 80 | 12.0 | 0.11 | 40000 |
| | | | | | *.827* | *.378* | *.622* | *.283* | *1160* | | | |
| | E12 | 1 | 1 | EH-ER20-12-010 | 21.0 | 11.6 | 17.8 | 9.2 | 80 | 15.0 | 0.13 | 40000 |
| | | | | | *.827* | *.457* | *.701* | *.362* | *1160* | | | |
| ER25 | E10 | 1 | 1 | EH-ER25-10-012 | 26.0 | 9.6 | 20.3 | 7.2 | 80 | 12.0 | 0.16 | 32000 |
| | | | | | *1.024* | *.378* | *.799* | *.283* | *1160* | | | |
| | E12 | 1 | 1 | EH-ER25-12-014 | 26.0 | 11.6 | 22.3 | 10.2 | 80 | 15.0 | 0.17 | 32000 |
| | | | | | *1.024* | *.457* | *.878* | *.402* | *1160* | | | |
| | E16 | 1 | 1 | EH-ER25-16-016 | 26.0 | 15.4 | 24.3 | 14.2 | 80 | 30.0 | 0.22 | 32000 |
| | | | | | *1.024* | *.606* | *.957* | *.559* | *1160* | | | |
| ER32 | E10 | 1 | 1 | EH-ER32-10-012 | 33.0 | 9.6 | 21.5 | 7.4 | 80 | 12.0 | 0.25 | 25000 |
| | | | | | *1.299* | *.378* | *.846* | *.291* | *1160* | | | |
| | E12 | 1 | 1 | EH-ER32-12-014 | 33.0 | 11.6 | 23.5 | 9.4 | 80 | 15.0 | 0.27 | 25000 |
| | | | | | *1.299* | *.457* | *.925* | *.370* | *1160* | | | |
| | E16 | 1 | 1 | EH-ER32-16-018 | 33.0 | 15.4 | 27.5 | 13.4 | 80 | 30.0 | 0.35 | 25000 |
| | | | | | *1.299* | *.606* | *1.083* | *.528* | *1160* | | | |
| | E20 | 1 | 1 | EH-ER32-20-022 | 33.0 | 19.2 | 31.5 | 18.9 | 80 | 50.0 | 0.34 | 25000 |
| | | | | | *1.299* | *.756* | *1.240* | *.744* | *1160* | | | |
| | E25 | 1 | 1 | EH-ER32-25-025 | 33.0 | 24.1 | 34.5 | 25.0 | 80 | 65.0 | 0.41 | 25000 |
| | | | | | *1.299* | *.949* | *1.358* | *.984* | *1160* | | | |
| ER40 | E16 | 1 | 1 | EH-ER40-16-022 | 41.0 | 15.4 | 33.1 | 15.0 | 20 | | 0.51 | 20000 |
| | | | | | *1.614* | *.606* | *1.303* | *.591* | *290* | | | |
| | E20 | 1 | 1 | EH-ER40-20-025 | 41.0 | 19.2 | 36.1 | 19.0 | 20 | | 0.53 | 20000 |
| | | | | | *1.614* | *.756* | *1.421* | *.748* | *290* | | | |
| | E25 | 1 | 1 | EH-ER40-25-028 | 41.0 | 24.1 | 39.1 | 24.0 | 20 | | 0.58 | 20000 |
| | | | | | *1.614* | *.949* | *1.539* | *.945* | *290* | | | |

## Inch version

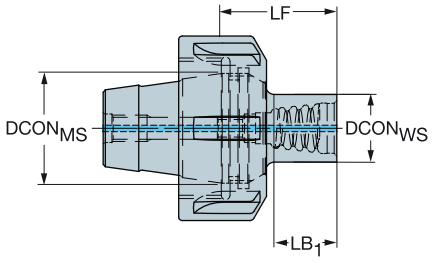
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BD$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| ER16 | E10 | 1 | 1 | EH-ER16-A10-007 | 17.0 | 9.2 | 13.9 | 6.2 | 9.2 | 80 | 12.0 | 0.09 | 40000 |
| | | | | | *.669* | *.360* | *.547* | *.244* | *.362* | *1160* | | | |
| ER20 | E10 | 1 | 1 | EH-ER20-A10-007 | 21.0 | 9.2 | 14.8 | 6.2 | 9.2 | 80 | 12.0 | 0.11 | 40000 |
| | | | | | *.827* | *.360* | *.583* | *.244* | *.362* | *1160* | | | |
| ER25 | E10 | 1 | 1 | EH-ER25-A10-011 | 26.0 | 9.2 | 19.3 | 6.2 | 9.2 | 80 | 12.0 | 0.15 | 32000 |
| | | | | | *1.024* | *.360* | *.760* | *.244* | *.362* | *1160* | | | |
| ER32 | E10 | 1 | 1 | EH-ER32-A10-011 | 33.0 | 9.2 | 20.5 | 6.4 | 9.2 | 80 | 12.0 | 0.26 | 25000 |
| | | | | | *1.299* | *.360* | *.807* | *.252* | *.362* | *1160* | | | |

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

M1 N22 N6 N15 N3

# ER to Coromant EH adapter

**Machine side interface DIN 6499-B**




**Metric version**

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BAR PSI | NM | KG | RPMX |
| ER11 | E10 | 1 | 1 | **392.EREH-11 10 008** | 11.4 | 9.6 | 16.8 | 8.0 | 80 | 12.0 | 0.09 | 40000 |
| | | | | | *.449* | *.378* | *.661* | *.315* | *1160* | | | |
| ER16 | E12 | 1 | 1 | **392.EREH-16 12 010** | 17.0 | 11.6 | 20.5 | 10.0 | 80 | 15.0 | 0.16 | 40000 |
| | | | | | *.669* | *.457* | *.807* | *.394* | *1160* | | | |
| ER20 | E16 | 1 | 1 | **392.EREH-20 16 014** | 21.0 | 15.4 | 24.1 | 14.0 | 80 | 30.0 | 0.27 | 40000 |
| | | | | | *.827* | *.606* | *.949* | *.551* | *1160* | | | |
| ER25 | E20 | 1 | 1 | **392.EREH-25 20 019** | 26.0 | 19.2 | 29.1 | 19.0 | 80 | 50.0 | 0.36 | 40000 |
| | | | | | *1.024* | *.756* | *1.146* | *.748* | *1160* | | | |

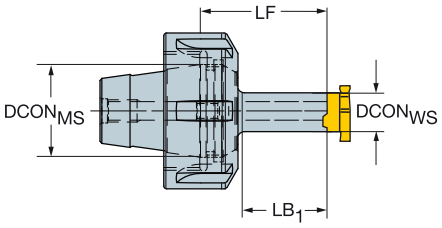
Note! The nut is not a standard ER nut and therefore is not exchangeable with the spare part series 5533 050-0X. The nut is always included in the package!

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

M1 N22 N6 N15 N3

# ER to CoroMill® 327 adapter

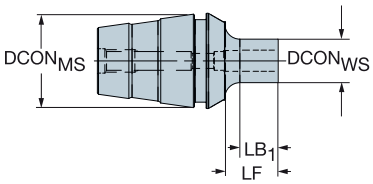
**Machine side interface DIN 6499-B**




| | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | 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 | 4.3 | 0.07 | 40000 |
| | | | *.449* | *.354* | *.983* | *.632* | *.354* | | | |
| ER16 | 09 | 392.ER327-16 09 022 | 17.0 | 9.0 | 26.8 | 16.2 | 9.0 | 4.3 | 0.15 | 40000 |
| | | | *.669* | *.354* | *1.054* | *.640* | *.354* | | | |
| | 12 | 392.ER327-16 12 030 | 17.0 | 12.0 | 34.8 | 24.3 | 12.0 | 6.5 | 0.22 | 40000 |
| | | | *.669* | *.472* | *1.371* | *.957* | *.472* | | | |
| ER20 | 12 | 392.ER327-20 12 030 | 21.0 | 12.0 | 34.7 | 24.8 | 12.0 | 6.5 | 0.25 | 40000 |
| | | | *.827* | *.472* | *1.364* | *.976* | *.472* | | | |
| | 14 | 392.ER327-20 14 035 | 21.0 | 14.3 | 38.9 | 28.8 | 14.0 | 6.5 | 0.27 | 40000 |
| | | | *.827* | *.563* | *1.530* | *1.134* | *.551* | | | |
| ER32 | 14 | 392.ER327-32 14 035 | 33.0 | 14.3 | 41.3 | 28.8 | 14.0 | 6.5 | 0.50 | 25000 |
| | | | *1.299* | *.563* | *1.624* | *1.134* | *.551* | | | |

**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!

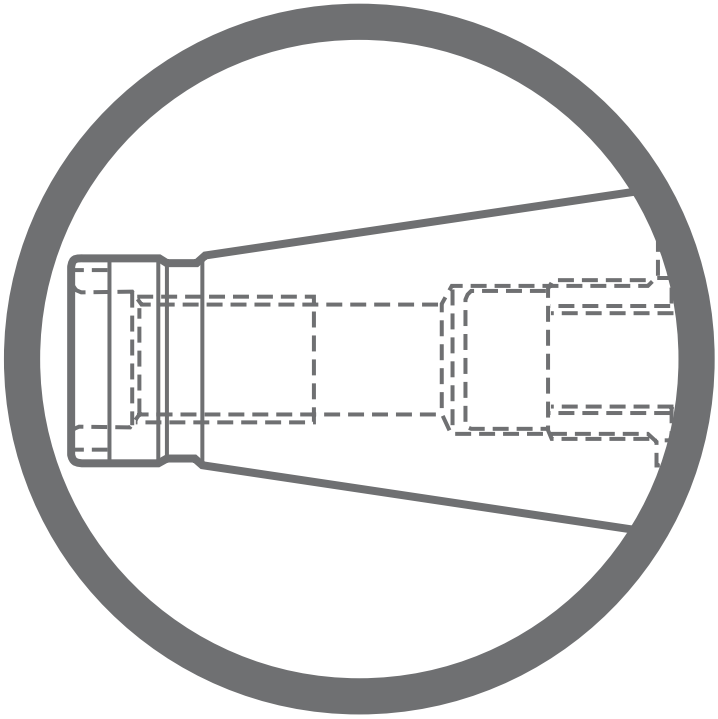



| | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | LF | $LB_1$ | $BD_1$ | NM | KG | RPMX |
| ER11 | 06 | 327-ER11-06-016 | 11.4 | 6.0 | 17.5 | 12.8 | 6.0 | 1.8 | 0.03 | 40000 |
| | | | *.449* | *.236* | *.689* | *.504* | *.236* | | | |
| ER20 | 09 | 327-ER20-09-022 | 21.0 | 9.0 | 24.7 | 16.5 | 9.0 | 4.3 | 0.09 | 40000 |
| | | | *.827* | *.354* | *.970* | *.652* | *.354* | | | |
| ER25 | 09 | 327-ER25-09-022 | 26.0 | 9.0 | 25.2 | 16.5 | 9.0 | 4.3 | 0.13 | 32000 |
| | | | *1.024* | *.354* | *.990* | *.652* | *.354* | | | |
| | 12 | 327-ER25-12-030 | 26.0 | 12.0 | 33.2 | 24.6 | 12.0 | 6.5 | 0.22 | 32000 |
| | | | *1.024* | *.472* | *1.307* | *.969* | *.472* | | | |
| | 14 | 327-ER25-14-019 | 26.0 | 14.3 | 22.9 | 14.3 | 14.0 | 6.5 | 0.21 | 32000 |
| | | | *1.024* | *.563* | *.902* | *.563* | *.551* | | | |
| | 14 | 327-ER25-14-035 | 26.0 | 14.3 | 37.4 | 28.8 | 14.0 | 6.5 | 0.23 | 32000 |
| | | | *1.024* | *.563* | *1.472* | *1.134* | *.551* | | | |
| ER32 | 12 | 327-ER32-12-030 | 33.0 | 12.0 | 34.2 | 24.6 | 12.0 | 6.5 | 0.31 | 25000 |
| | | | *1.299* | *.472* | *1.346* | *.969* | *.472* | | | |
| | 14 | 327-ER32-14-019 | 33.0 | 14.3 | 23.9 | 14.3 | 14.0 | 6.5 | 0.30 | 25000 |
| | | | *1.299* | *.563* | *.941* | *.563* | *.551* | | | |

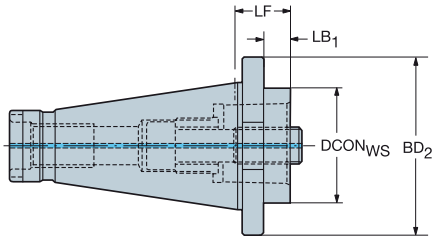
For spare parts, visit www.sandvik.coromant.com

M1 N22

# Machine side interface NMTB



# NMTB to Coromant Capto® adapter



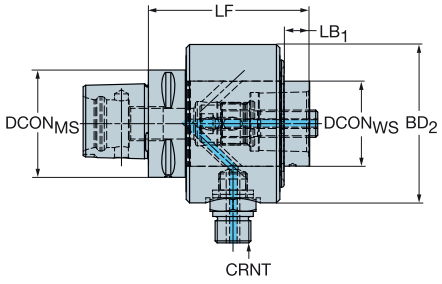

| | | | | | Dimensions, mm, inch | | | | | | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{WS}$ | CRKS | LF | $LB_1$ | $LB_2$ | $BD_2$ | | | |
| 40.0 | C5 | 1 | 1 | **C5-A390.00-40 030** | 50.0 | 5/8"-11 | 30.0 | 20.5 | 30.0 | 63.7 | 80 | 45.0 | 0.87 |
| | | | | | *1.969* | | *1.181* | *.807* | *1.181* | *2.508* | *1160* | | |
| 50.0 | C5 | 1 | 1 | **C5-A390.00-50 030** | 50.0 | 1"-8 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 45.0 | 2.76 |
| | | | | | *1.969* | | *1.181* | *.583* | *1.181* | *3.839* | *1160* | | |
| | C5 | 1 | 1 | **C5-A390.00-50 070** | 50.0 | 1"-8 | 70.0 | 54.8 | 70.0 | 97.5 | 80 | 45.0 | 3.30 |
| | | | | | *1.969* | | *2.756* | *2.157* | *2.756* | *3.839* | *1160* | | |
| | C6 | 1 | 1 | **C6-A390.00-50 030** | 63.0 | 1"-8 | 30.0 | 14.8 | 30.0 | 97.5 | 80 | 65.0 | 2.71 |
| | | | | | *2.480* | | *1.181* | *.583* | *1.181* | *3.839* | *1160* | | |
| | C8 | 1 | 1 | **C8-A390.00-50 070** | 80.0 | 1"-8 | 70.0 | 54.8 | 70.0 | 97.5 | 80 | 65.0 | 3.98 |
| | | | | | *3.150* | | *2.756* | *2.157* | *2.756* | *3.839* | *1160* | | |

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

N22 N15

# Coromant Capto® reduction adapter

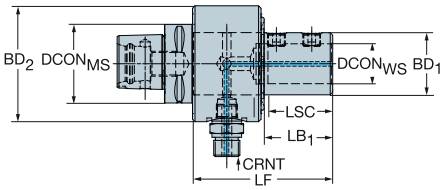
**Coolant inducer**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BD$_2$ | CRNT | BAR PSI | 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 | 55.0 | 1.96 | 6300 |
| | | | | | *1.969* | *1.575* | *3.543* | *.650* | *3.071* | | *261* | | | |
| C6 | C5 | 2 | 1 | C6-391.02CCH-50 095 | 63.0 | 50.0 | 95.0 | 15.0 | 93.0 | G 1/2" | 18 | 95.0 | 1.60 | 4300 |
| | | | | | *2.480* | *1.969* | *3.740* | *.591* | *3.661* | | *261* | | | |
| C8 | C6 | 2 | 1 | C8-391.02CCH-63 110 | 80.0 | 63.0 | 110.0 | 15.0 | 108.0 | G 1/2" | 18 | 170.0 | 4.77 | 3300 |
| | | | | | *3.150* | *2.480* | *4.331* | *.591* | *4.252* | | *261* | | | |

# Coromant Capto® to ISO 9766 adapter

**Coolant inducer**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | BD$_1$ | BD$_2$ | CRNT | BAR PSI | 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 | 12.0 | 2.27 | 6300 |
| | | | | | *1.969* | *.787* | *2.028* | *4.724* | *1.831* | *1.575* | *3.071* | | *261* | | | |
| | 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 | | 3.16 | 5300 |
| | | | | | *1.969* | *.984* | *2.264* | *5.315* | *1.957* | *1.772* | *3.661* | | *261* | | | |
| 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 | | 3.41 | 5300 |
| | | | | | *2.480* | *1.260* | *2.421* | *5.315* | *2.165* | *1.969* | *3.661* | | *261* | | | |
| 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 | | 5.75 | 4000 |
| | | | | | *3.150* | *1.575* | *2.815* | *6.102* | *2.500* | *2.559* | *4.252* | | *261* | | | |

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

M1 N22 N15

# Silent Tools®

## Adapters 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 adapters 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, 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

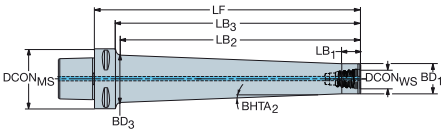
In many machining centers, the components and machine tools require long tool assemblies to reach down in large components. Vibration risk is high, and the typical remedy is either slow machining or damped tools. With Silent Tools™ milling adapters, chatter and vibrations are eliminated, allowing the machining rate to be increased and improving process security. Silent Tools™ for milling are productivity boosters.

www.sandvik.coromant.com/silenttools

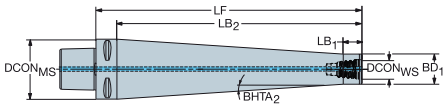
The dampening system consists of a heavy mass supported on rubber spring elements

# Coromant Capto® to Coromant EH damped adapter

DSGN 12




7




SilentTools®

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_3$ | BD$_4$ | BHTA$_2$ | BHTA$_3$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C4 | E16 | 3 | 1 | 12 | **C4-EH16D-175** | 40.0 | 15.4 | 175.0 | 3.0 | 150.0 | 155.0 | 19.5 | 29.7 | 40 | 2° | 45° | 70 | 30.0 | 1.05 | 15000 |
| | | | | | | *1.575* | *.606* | *6.890* | *.118* | *5.906* | *6.102* | *.768* | *1.169* | *1.575* | | | *1015* | | | |
| C5 | E20 | 3 | 1 | 12 | **C5-EH20D-185** | 50.0 | 19.2 | 185.0 | 3.0 | 159.0 | 165.0 | 24.0 | 33.8 | 50 | 1° | 53° | 70 | 50.0 | 1.53 | 15000 |
| | | | | | | *1.969* | *.756* | *7.283* | *.118* | *6.260* | *6.496* | *.945* | *1.331* | *1.969* | | | *1015* | | | |
| | 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 | 65.0 | 5.29 | 10000 |
| | | | | | | *1.969* | *.949* | *11.024* | *.787* | *10.236* | *11.024* | *1.248* | *1.969* | | | | *1015* | | | |
| C6 | E25 | 3 | 1 | 12 | **C6-EH25D-280** | 63.0 | 24.1 | 280.0 | 20.0 | 252.0 | 258.0 | 31.7 | 49.7 | 63 | 2° | 67° | 70 | 65.0 | 5.68 | 10000 |
| | | | | | | *2.480* | *.949* | *11.024* | *.787* | *9.921* | *10.158* | *1.248* | *1.957* | *2.480* | | | *1015* | | | |
| | E25 | 3 | 1 | 12 | **C6-EH25D-340** | 63.0 | 24.1 | 340.0 | 20.0 | 313.0 | 317.8 | 31.7 | 54.7 | 63 | 2° | 61° | 70 | 65.0 | 7.00 | 8000 |
| | | | | | | *2.480* | *.949* | *13.386* | *.787* | *12.323* | *12.512* | *1.248* | *2.154* | *2.480* | | | *1015* | | | |
| C8 | E25 | 3 | 1 | 12 | **C8-EH25D-420** | 80.0 | 24.1 | 420.0 | 8.0 | 384.0 | 390.0 | 31.7 | 61.7 | 80 | 2° | 71° | 70 | 65.0 | 10.61 | 6000 |
| | | | | | | *3.150* | *.949* | *16.535* | *.315* | *15.118* | *15.354* | *1.248* | *2.429* | *3.150* | | | *1015* | | | |

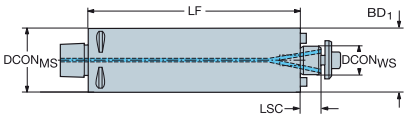
For spare parts, visit www.sandvik.coromant.com

N22 N6 N15 N3

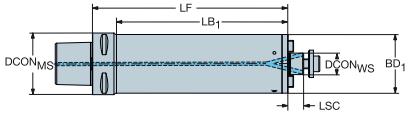
# Coromant Capto® to arbor damped adapter

DSGN

1




2




SilentTools®

## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | 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 | 22.0 | 1.62 | 16000 |
| | | | | | | *1.575* | *.630* | *.433* | *5.118* | *4.244* | *5.118* | *1.496* | *1.575* | *1015* | | | |
| | 16 | 3 | 4 | 2 | C4-Q16D-038-200 | 40.0 | 16.0 | 11 | 200.0 | 177.8 | 200.0 | 38.0 | 40.0 | 70 | 22.0 | 2.32 | 8000 |
| | | | | | | *1.575* | *.630* | *.433* | *7.874* | *7.000* | *7.874* | *1.496* | *1.575* | *1015* | | | |
| 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 | 45.0 | 3.22 | 14000 |
| | | | | | | *1.969* | *.866* | *.630* | *7.087* | *6.205* | *7.087* | *1.870* | *1.969* | *1015* | | | |
| | 22 | 3 | 4 | 2 | C5-Q22D-048-220 | 50.0 | 22.0 | 16 | 220.0 | 197.6 | 220.0 | 47.5 | 50.0 | 70 | 45.0 | 6.04 | 11000 |
| | | | | | | *1.969* | *.866* | *.630* | *8.661* | *7.780* | *8.661* | *1.870* | *1.969* | *1015* | | | |
| | 22 | 3 | 4 | 2 | C5-Q22D-048-270 | 50.0 | 22.0 | 16 | 270.0 | 247.6 | 270.0 | 47.5 | 50.0 | 70 | 45.0 | 6.85 | 7000 |
| | | | | | | *1.969* | *.866* | *.630* | *10.630* | *9.748* | *10.630* | *1.870* | *1.969* | *1015* | | | |
| 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 | 45.0 | 8.05 | 15000 |
| | | | | | | *2.480* | *.866* | *.630* | *7.874* | *6.906* | *7.874* | *2.362* | *2.480* | *1015* | | | |
| | 22 | 3 | 4 | 2 | C6-Q22D-060-260 | 63.0 | 22.0 | 16 | 260.0 | 235.4 | 260.0 | 60.0 | 63.0 | 70 | 45.0 | 9.29 | 11000 |
| | | | | | | *2.480* | *.866* | *.630* | *10.236* | *9.268* | *10.236* | *2.362* | *2.480* | *1015* | | | |
| | 22 | 3 | 4 | 2 | C6-Q22D-060-310 | 63.0 | 22.0 | 16 | 310.0 | 285.4 | 310.0 | 60.0 | 63.0 | 70 | 45.0 | 10.86 | 6000 |
| | | | | | | *2.480* | *.866* | *.630* | *12.205* | *11.236* | *12.205* | *2.362* | *2.480* | *1015* | | | |
| | 27 | 3 | 4 | 1 | C6-Q27D-063-200 | 63.0 | 27.0 | 18 | 200.0 | 200.0 | | 63.0 | | 70 | 80.0 | 8.54 | 11000 |
| | | | | | | *2.480* | *1.063* | *.709* | *7.874* | *7.874* | | *2.480* | | *1015* | | | |
| | 27 | 3 | 4 | 1 | C6-Q27D-063-260 | 63.0 | 27.0 | 18 | 260.0 | 260.0 | | 63.0 | | 70 | 80.0 | 9.88 | 8000 |
| | | | | | | *2.480* | *1.063* | *.709* | *10.236* | *10.236* | | *2.480* | | *1015* | | | |
| | 27 | 3 | 4 | 1 | C6-Q27D-063-310 | 63.0 | 27.0 | 18 | 310.0 | 310.0 | | 63.0 | | 70 | 80.0 | 11.57 | 5000 |
| | | | | | | *2.480* | *1.063* | *.709* | *12.205* | *12.205* | | *2.480* | | *1015* | | | |
| 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 | 80.0 | 12.92 | 12000 |
| | | | | | | *3.150* | *1.063* | *.709* | *8.661* | *7.370* | *8.661* | *2.992* | *3.150* | *1015* | | | |
| | 27 | 3 | 4 | 2 | C8-Q27D-076-320 | 80.0 | 27.0 | 18 | 320.0 | 287.2 | 320.0 | 76.0 | 80.0 | 70 | 80.0 | 13.40 | 8000 |
| | | | | | | *3.150* | *1.063* | *.709* | *12.598* | *11.307* | *12.598* | *2.992* | *3.150* | *1015* | | | |
| | 27 | 3 | 4 | 2 | C8-Q27D-076-360 | 80.0 | 27.0 | 18 | 360.0 | 327.2 | 360.0 | 76.0 | 80.0 | 70 | 80.0 | 18.20 | 6000 |
| | | | | | | *3.150* | *1.063* | *.709* | *14.173* | *12.882* | *14.173* | *2.992* | *3.150* | *1015* | | | |
| | 32 | 3 | 4 | 1 | C8-Q32D-080-220 | 80.0 | 32.0 | 20 | 220.0 | 220.0 | | 80.0 | | 70 | 180.0 | 13.73 | 10000 |
| | | | | | | *3.150* | *1.260* | *.787* | *8.661* | *8.661* | | *3.150* | | *1015* | | | |
| | 32 | 3 | 4 | 1 | C8-Q32D-080-320 | 80.0 | 32.0 | 20 | 320.0 | 320.0 | | 80.0 | | 70 | 180.0 | 18.00 | 6000 |
| | | | | | | *3.150* | *1.260* | *.787* | *12.598* | *12.598* | | *3.150* | | *1015* | | | |
| | 32 | 3 | 4 | 1 | C8-Q32D-080-360 | 80.0 | 32.0 | 20 | 360.0 | 360.0 | | 80.0 | | 70 | 180.0 | 19.60 | 4000 |
| | | | | | | *3.150* | *1.260* | *.787* | *14.173* | *14.173* | | *3.150* | | *1015* | | | |
| 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 | 180.0 | 30.00 | 5000 |
| | | | | | | *3.937* | *1.260* | *.787* | *15.748* | *14.213* | *15.748* | *3.740* | *3.937* | *1015* | | | |
| | 40 | 3 | 4 | 1 | C10-Q40D-100-400 | 100.0 | 40.0 | 23 | 400.0 | 400.0 | | 100.0 | | 70 | 300.0 | 28.30 | 5000 |
| | | | | | | *3.937* | *1.575* | *.906* | *15.748* | *15.748* | | *3.937* | | *1015* | | | |

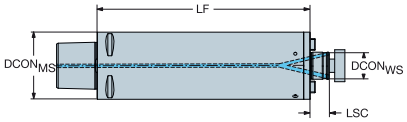
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

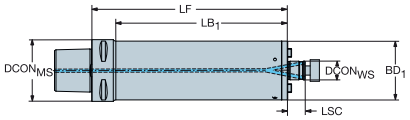
# Coromant Capto® to arbor damped adapter

DSGN

1




2




SilentTools®

## Inch pilot

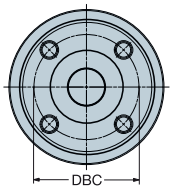
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | DSGN | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | LB$_2$ | BD$_1$ | BD$_2$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C5 | 3/4 | 3 | 4 | 2 | C5-R19D-048-180 | 50.0 | 19.1 | 18 | 180.0 | 157.6 | 180.0 | 47.5 | 50.0 | 70 | 25.0 | 3.40 | 14000 |
| | | | | | | *1.969* | *.750* | *.709* | *7.087* | *6.205* | *7.087* | *1.870* | *1.969* | *1015* | | | |
| | 3/4 | 3 | 4 | 2 | C5-R19D-048-220 | 50.0 | 19.1 | 18 | 220.0 | 197.6 | 220.0 | 47.5 | 50.0 | 70 | 25.0 | 5.94 | 11000 |
| | | | | | | *1.969* | *.750* | *.709* | *8.661* | *7.780* | *8.661* | *1.870* | *1.969* | *1015* | | | |
| | 3/4 | 3 | 4 | 2 | C5-R19D-048-270 | 50.0 | 19.1 | 18 | 270.0 | 247.6 | 270.0 | 47.5 | 50.0 | 70 | 25.0 | 6.83 | 7000 |
| | | | | | | *1.969* | *.750* | *.709* | *10.630* | *9.748* | *10.630* | *1.870* | *1.969* | *1015* | | | |
| C6 | 3/4 | 3 | 4 | 2 | C6-R19D-060-200 | 63.0 | 19.1 | 18 | 200.0 | 175.4 | 200.0 | 60.0 | 63.0 | 70 | 25.0 | 8.05 | 15000 |
| | | | | | | *2.480* | *.750* | *.709* | *7.874* | *6.906* | *7.874* | *2.362* | *2.480* | *1015* | | | |
| | 3/4 | 3 | 4 | 2 | C6-R19D-060-260 | 63.0 | 19.1 | 18 | 260.0 | 235.4 | 260.0 | 60.0 | 63.0 | 70 | 25.0 | 9.27 | 11000 |
| | | | | | | *2.480* | *.750* | *.709* | *10.236* | *9.268* | *10.236* | *2.362* | *2.480* | *1015* | | | |
| | 3/4 | 3 | 4 | 2 | C6-R19D-060-310 | 63.0 | 19.1 | 18 | 310.0 | 285.4 | 310.0 | 60.0 | 63.0 | 70 | 25.0 | 8.20 | 6000 |
| | | | | | | *2.480* | *.750* | *.709* | *12.205* | *11.236* | *12.205* | *2.362* | *2.480* | *1015* | | | |
| | 1 | 3 | 4 | 1 | C6-R25D-063-200 | 63.0 | 25.4 | 18 | 200.0 | 200.0 | | 63.0 | | 70 | 65.0 | 8.54 | 11000 |
| | | | | | | *2.480* | *1.000* | *.709* | *7.874* | *7.874* | | *2.480* | | *1015* | | | |
| | 1 | 3 | 4 | 1 | C6-R25D-063-260 | 63.0 | 25.4 | 18 | 260.0 | 260.0 | | 63.0 | | 70 | 65.0 | 9.93 | 8000 |
| | | | | | | *2.480* | *1.000* | *.709* | *10.236* | *10.236* | | *2.480* | | *1015* | | | |
| | 1 | 3 | 4 | 1 | C6-R25D-063-310 | 63.0 | 25.4 | 18 | 310.0 | 310.0 | | 63.0 | | 70 | 65.0 | 11.60 | 5000 |
| | | | | | | *2.480* | *1.000* | *.709* | *12.205* | *12.205* | | *2.480* | | *1015* | | | |
| C8 | 1 1/2 | 3 | 4 | 1 | C8-R38D-080-220 | 80.0 | 38.1 | 23 | 220.0 | 220.0 | | 80.0 | | 70 | 180.0 | 13.93 | 10000 |
| | | | | | | *3.150* | *1.500* | *.906* | *8.661* | *8.661* | | *3.150* | | *1015* | | | |
| | 1 1/2 | 3 | 4 | 1 | C8-R38D-080-320 | 80.0 | 38.1 | 23 | 320.0 | 320.0 | | 80.0 | | 70 | 180.0 | 18.26 | 6000 |
| | | | | | | *3.150* | *1.500* | *.906* | *12.598* | *12.598* | | *3.150* | | *1015* | | | |
| | 1 1/2 | 3 | 4 | 1 | C8-R38D-080-360 | 80.0 | 38.1 | 23 | 360.0 | 360.0 | | 80.0 | | 70 | 180.0 | 19.94 | 4000 |
| | | | | | | *3.150* | *1.500* | *.906* | *14.173* | *14.173* | | *3.150* | | *1015* | | | |
| C10 | 1 1/2 | 3 | 4 | 2 | C10-R38D-095-400 | 100.0 | 38.1 | 23 | 400.0 | 361.0 | 400.0 | 95.0 | 100.0 | 70 | 180.0 | 30.48 | 5000 |
| | | | | | | *3.937* | *1.500* | *.906* | *15.748* | *14.213* | *15.748* | *3.740* | *3.937* | *1015* | | | |

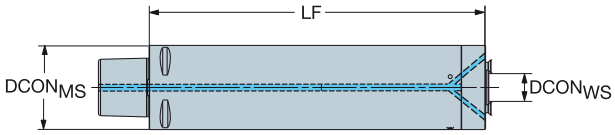
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

# Coromant Capto® to arbor with driving screws damped adapter

**For CoroMill® QD with internal coolant supply**




SilentTools®

## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LSC | LF | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C3 | X10 | 3 | 4 | C3-X10D-032-128 | 32.0 | 10.0 | 22.0 | 2 | 128.0 | 70 | 6.4 | 1.10 | 15000 |
| | | | | | *1.260* | *.394* | *.866* | *.094* | *5.039* | *1015* | | | |
| C4 | X22 | 3 | 3 | C4-X22D-040-160 | 40.0 | 22.0 | 32.0 | 2 | 160.0 | 70 | 3.9 | 1.92 | 15000 |
| | | | | | *1.575* | *.866* | *1.260* | *.094* | *6.299* | *1015* | | | |
| C6 | X32 | 3 | 3 | C6-X32D-063-252 | 63.0 | 32.0 | 45.0 | 2 | 252.0 | 70 | 6.4 | 9.30 | 10000 |
| | | | | | *2.480* | *1.260* | *1.772* | *.094* | *9.921* | *1015* | | | |
| C8 | X40 | 3 | 3 | C8-X40D-080-320 | 80.0 | 40.0 | 63.0 | 2 | 320.0 | 70 | 70.0 | 17.45 | 6000 |
| | | | | | *3.150* | *1.575* | *2.480* | *.094* | *12.598* | *1015* | | | |

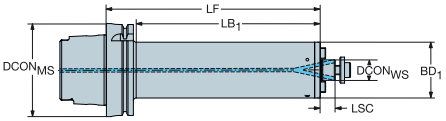
## Inch pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | DBC | LSC | LF | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| C5 | Y25 | 3 | 3 | C5-Y25D-050-200 | 50.0 | 25.4 | 36.0 | 2 | 200.0 | 70 | 3.9 | 3.67 | 12000 |
| | | | | | *1.969* | *1.000* | *1.417* | *.094* | *7.874* | *1015* | | | |
| C6 | Y31 | 3 | 3 | C6-Y31D-063-252 | 63.0 | 31.8 | 45.0 | 2 | 252.0 | 70 | 6.4 | 9.27 | 10000 |
| | | | | | *2.480* | *1.250* | *1.772* | *.094* | *9.921* | *1015* | | | |
| C8 | Y38 | 3 | 3 | C8-Y38D-080-320 | 80.0 | 38.1 | 63.0 | 2 | 320.0 | 70 | 70.0 | 17.42 | 6000 |
| | | | | | *3.150* | *1.500* | *2.480* | *.094* | *12.598* | *1015* | | | |

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

M1 N22 N15

# HSK to damped arbor adapter




SilentTools®

## Metric pilot

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | LF | LB$_1$ | BD$_1$ | BAR PSI | NM | KG | RPMX |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 63.0 | 16 | 1 | 4 | HA06-Q16D-038-160 | 63.0 | 16.0 | 11 | 160.0 | 131.0 | 38.0 | 70 | 22.0 | 4.35 | 16000 |
| | | | | | *2.480* | *.630* | *.433* | *6.299* | *5.157* | *1.496* | *1015* | | | |
| | 16 | 1 | 4 | HA06-Q16D-038-230 | 63.0 | 16.0 | 11 | 230.0 | 201.0 | 38.0 | 70 | 22.0 | 5.06 | 8000 |
| | | | | | *2.480* | *.630* | *.433* | *9.055* | *7.913* | *1.496* | *1015* | | | |
| | 22 | 1 | 4 | HA06-Q22D-048-210 | 63.0 | 22.0 | 16 | 210.0 | 181.0 | 47.5 | 70 | 45.0 | 6.10 | 8000 |
| | | | | | *2.480* | *.866* | *.630* | *8.268* | *7.126* | *1.870* | *1015* | | | |
| | 22 | 1 | 4 | HA06-Q22D-048-260 | 63.0 | 22.0 | 16 | 260.0 | 231.0 | 47.5 | 70 | 45.0 | 6.89 | 5000 |
| | | | | | *2.480* | *.866* | *.630* | *10.236* | *9.094* | *1.870* | *1015* | | | |
| 100.0 | 22 | 1 | 4 | HA10-Q22D-048-213 | 100.0 | 22.0 | 16 | 213.0 | 181.0 | 47.5 | 70 | 45.0 | 7.68 | 14000 |
| | | | | | *3.937* | *.866* | *.630* | *8.386* | *7.126* | *1.870* | *1015* | | | |
| | 22 | 1 | 4 | HA10-Q22D-048-263 | 100.0 | 22.0 | 16 | 263.0 | 231.0 | 47.5 | 70 | 45.0 | 8.55 | 9000 |
| | | | | | *3.937* | *.866* | *.630* | *10.354* | *9.094* | *1.870* | *1015* | | | |
| | 22 | 1 | 4 | HA10-Q22D-060-230 | 100.0 | 22.0 | 16 | 230.0 | 198.0 | 60.0 | 70 | 45.0 | 9.78 | 14000 |
| | | | | | *3.937* | *.866* | *.630* | *9.055* | *7.795* | *2.362* | *1015* | | | |
| | 22 | 1 | 4 | HA10-Q22D-060-340 | 100.0 | 22.0 | 16 | 340.0 | 308.0 | 60.0 | 70 | 45.0 | 12.96 | 7000 |
| | | | | | *3.937* | *.866* | *.630* | *13.386* | *12.126* | *2.362* | *1015* | | | |
| | 27 | 1 | 4 | HA10-Q27D-076-250 | 100.0 | 27.0 | 18 | 250.0 | 218.0 | 76.0 | 70 | 80.0 | 14.13 | 10000 |
| | | | | | *3.937* | *1.063* | *.709* | *9.843* | *8.583* | *2.992* | *1015* | | | |
| | 27 | 1 | 4 | HA10-Q27D-076-390 | 100.0 | 27.0 | 18 | 390.0 | 358.0 | 76.0 | 70 | 80.0 | 20.00 | 5000 |
| | | | | | *3.937* | *1.063* | *.709* | *15.354* | *14.095* | *2.992* | *1015* | | | |
| | 32 | 1 | 4 | HA10-Q32D-080-250 | 100.0 | 32.0 | 20 | 250.0 | 218.0 | 80.0 | 70 | 180.0 | 15.30 | 10000 |
| | | | | | *3.937* | *1.260* | *.787* | *9.843* | *8.583* | *3.150* | *1015* | | | |
| | 32 | 1 | 4 | HA10-Q32D-080-390 | 100.0 | 32.0 | 20 | 390.0 | 358.0 | 80.0 | 70 | 180.0 | 21.07 | 5000 |
| | | | | | *3.937* | *1.260* | *.787* | *15.354* | *14.095* | *3.150* | *1015* | | | |

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

M1 N22 N15

# Accessories


## Coromant Capto® M2

Assembly fixture M3
Tool cart for Coromant Capto M4
Cassettes (polygon seating) M5
Locking mechanism for cassettes M6
Assembly item M7-M9

## HSK

Assembly item M3

## Accessory item for CoroBore®

CoroBore® XL pre-measuring unit M11
Shim set M11

## Arbor

Arbor mounting screws with coolant hole M12
Spacing collars M14

## Sleeves and collets

Cylindrical sleeves M15-M18
Extractor for cylindrical sleeves M18
Cylindrical sleeve with mechanical locking interface M22
Eccentric sleeve for metric drills M23
ER collet M24
ER Collet for tap shank M32
ER Collet sealing discs M36
Sleeve for fine boring head M37
Assembly item M38

## Adapters

Slide to adjustable drill adapter M39
VL M40

## Keys and torque wrenches

Assembly tools M41-M43
Torx Plus® torque wrench M44

## Pull studs M45-M48

# 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 centers
- Vertical lathes

Coromant Capto clamping units and driven tool holders reduce setup and tool change time for high machine utilization.

### Integrated spindle

- Multi-task machines
- Vertical lathes
- Machining centers with turning option

Coromant Capto integrated in the spindle adds stability and versatility.

### Modular system

- Machining centers
- Multi-task machines
- Vertical lathes

Coromant Capto machine interface adapters in combination with extension and reduction adapters enable assembling of tools with different lengths and design regardless of the machine interface.

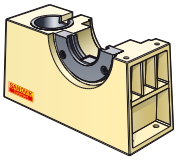
### Coromant Capto® range

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

# Assembly fixture

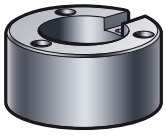
**Fixture body**
**Ordering code:**

**391.500**



**Fixture body for sleeves**
**Ordering code:**

**391.501**



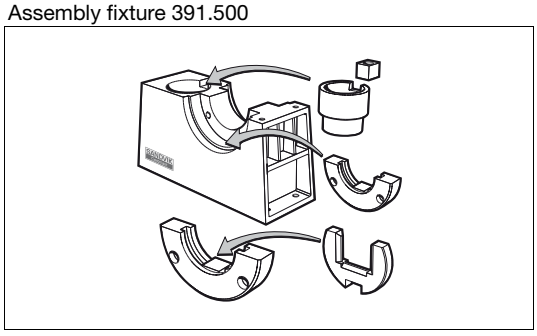
| Ordering code | |
|---|---|
| | |
| **Sleeve** | **For holder type, size** |
| **391.540-C3** | Coromant Capto Size C3 |
| **391.540-C4** | Coromant Capto Size C4 |
| **391.540-C5** | Coromant Capto Size C5 |
| **391.540-C6** | Coromant Capto Size C6 |
| **391.540-C8** | Coromant Capto Size C8 |
| **391.540-C10** | Coromant Capto Size C10 |
| **391.540-HA04** | HSK 40 Form A/C |
| **391.540-HA05** | HSK 50 Form A/C |
| **391.540-HA06** | HSK 63 Form A/C |
| **391.540-HA08** | HSK 80 Form A/C |
| **391.540-HA10** | HSK 100 Form A/C |
| **391.540-30** | MAS-BT/CAT/ISO 30 |
| **391.540-40** | MAS-BT/CAT/ISO 40 |
| **391.540-50** | MAS-BT/CAT/ISO 50 |

| Ordering code | | |
|---|---|---|
| | | |
| **Flange** | **Collar** | **For holder type, size** |
| **391.510-140 50** | **391.530-C3** | Coromant Capto Size C3 |
| **391.510-140 50** | **391.530-C4** | Coromant Capto Size C4 |
| **391.510-140 50** | **391.530-C5** | Coromant Capto Size C5 |
| **391.510-140 50** | **391.530-C6** | Coromant Capto Size C6 |
| **391.510-140 50** | **391.530-C8** | Coromant Capto Size C8 |
| | **391.530-C10*** | Coromant Capto Size C10 |
| **391.510-HA04** | | HSK 40 Form A |
| **391.510-HA05** | | HSK 50 Form A |
| **391.510-HA06** | | HSK 63 Form A |
| **391.510-HA08** | | HSK 80 Form A |
| **391.510-HA10** | | HSK 100 Form A |
| **391.510-HA12** | | HSK 125 Form A |
| **391.510-55 30** | | MAS-BT 30 |
| **391.510-55 40** | | MAS-BT 40 |
| **391.510-55 50** | | MAS-BT 50 |
| **391.510-562-40** | | BIG-PLUS, MAS-BT 40 |
| **391.510-562-50** | | BIG-PLUS, MAS-BT 50 |
| **391.510-140 40** | | DIN 69871/40, ANSIB 5.50-40. ISO7388/1-40, CAT 40 |
| **391.510-140 50** | | DIN 69871/50, ANSIB 5.50-40. ISO7388/1-50, CAT 50 |
| **391.510-540 40** | | BIG-PLUS DIN69871/1-40, BIG-PLUS 7388/1-40, CAT 40 |
| **391.510-540 50** | | BIG-PLUS DIN69871/1-50, BIG-PLUS 7388/1-50, CAT 50 |
| **391.510-00 40** | | DIN 2080-40/NMTB 40 |
| **391.510-00 50** | | DIN 2080-50/NMTB 50 |
| **A391.510-45 40** | | ANSIB 5.50-2009, CAT-V 40-2009 |
| **A391.510-45 50** | | ANSIB 5.50-2009, CAT-V 50-2009 |
| **A391.510-545 40** | | BIG-PLUS ANSIB 5.50-2009, CAT-V 40-2009 |
| **A391.510-545 50** | | BIG-PLUS ANSIB 5.50-2009, CAT-V 50-2009 |
| **391.510-140 50** | **391.530-970-11** | CoroChuck 970, ER11 |
| **391.510-140 50** | **391.530-970-20** | CoroChuck 970, ER20 |
| **391.510-140 50** | **391.530-970-25** | CoroChuck 970, ER25 |
| **391.510-140 50** | **391.530-970-32** | CoroChuck 970, ER32 |
| **391.510-140 50** | **391.530-970-40** | CoroChuck 970, ER40 |

Note: Key is delivered with the sleeve.

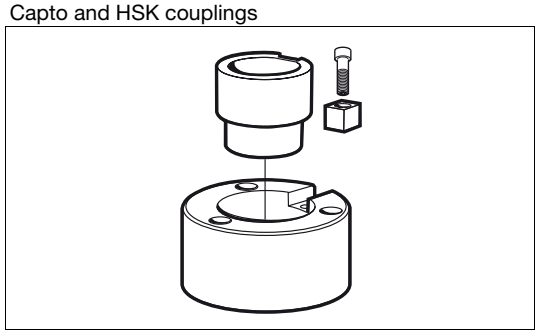
* Combined collar and flange

Assembly fixture 391.500



Choose flange, collar and sleeve to suit tool to be assembled.

Fixture 391.501 for maintenance of tools with Coromant Capto and HSK couplings



Choose sleeve to suit coupling.
The fixture should be fastened to the bench with three socket head screws (not delivered with fixture).

# Tool cart for Coromant Capto

**Quick change tooling**

1. Cradle carrier
2. Tool cradles
3. Molded tool holders (to be ordered separately)

| Ordering code | Kit consists of: | | |
|---|---|---|---|
| CCW-KIT | TC-0 | 4 pieces | Tool cradles |
| | TCC-2 | 4 pair | Frame carriers for tool cradle |

To order a complete cart 1 pcs CCW-KIT + toolholders

Tool cradles and cradle carriers can be purchased extra as accessories.

# Bench stand

| Ordering code |
|---|
| BS-KIT |

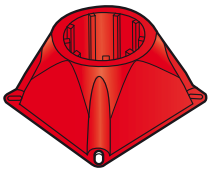
No accessory codes for bench stand.

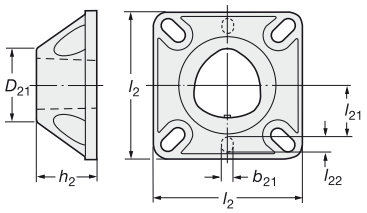
# Molded tool holders - to be ordered separately

| Ordering code | Width (B) | Max. number of coupling sizes |
|---|---|---|
| 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)

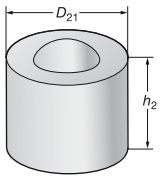
**Coromant Capto®**



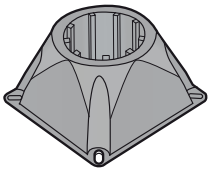


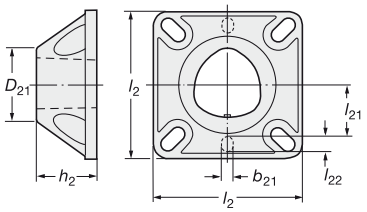

**-4000**
Plastic storage cassettes (red)

**-6000-B**




**Aluminum cassette blanks**



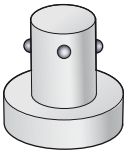


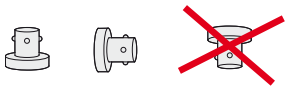

**-5000**
High grade plastic in-machine tool storage (black)

| Coupling size | Ordering code | Dimensions, mm, inch $b_{21}$ | $D_{21}$ | $h_2$ | $l_2$ | $l_{21}$ | All plastic cassettes conforming to hole pattern 17 mm, 20 mm, 25 mm and 1''. |
|---|---|---|---|---|---|---|---|
| C3 | **C3-C-4000** | - | 32 | 26 | 65 | - | - | High grade plastic. Red color. To be used: – alone for upright storage – with mechanism type PL-01 for horizontal or upright position. |
| | | - | *1.260* | *1.024* | *2.559* | - | - | |
| C4 | **C4-C-4000** | 6 | 50 | 39 | 74 | 26 | 8 | |
| | | *.236* | *1.969* | *1.535* | *2.913* | *1.024* | *.315* | |
| C5 | **C5-C-4000** | 6 | 50 | 39 | 74 | 26 | 8 | |
| | | *.236* | *1.969* | *1.535* | *2.913* | *1.024* | *.315* | |
| C6 | **C6-C-4000** | 8 | 80 | 63 | 116 | 41 | 10 | |
| | | *.315* | *3.150* | *2.480* | *4.567* | *1.614* | *.394* | |
| C8 | **C8-C-4000** | 8 | 80 | 63 | 116 | 41 | 10 | |
| | | *.315* | *3.150* | *2.480* | *4.567* | *1.614* | *.394* | |
| C4 | **C4-C-5000** | 6 | 50 | 39 | 74 | 26 | 8 | High grade reinforced black plastic. For in-machine tool storage with mechanism AL-01. |
| | | *.236* | *1.969* | *1.535* | *2.913* | *1.024* | *.315* | |
| C5 | **C5-C-5000** | 6 | 50 | 39 | 74 | 26 | 8 | |
| | | *.236* | *1.969* | *1.535* | *2.913* | *1.024* | *.315* | |
| C6 | **C6-C-5000** | 8 | 80 | 63 | 116 | 41 | 10 | |
| | | *.315* | *3.150* | *2.480* | *4.567* | *1.614* | *.394* | |
| C8 | **C8-C-5000** | 8 | 80 | 63 | 116 | 41 | 10 | |
| | | *.315* | *3.150* | *2.480* | *4.567* | *1.614* | *.394* | |
| C10 | **C10-C-5000** | 8 | 100 | 80 | 150 | 60 | 68 | |
| | | *.315* | *3.940* | *3.150* | *5.910* | *2.360* | *2.630* | |
| C6 | **C6-C-6000-B** | - | 120 | 63 | - | - | - | Aluminum cassette blanks for individual adaptation. To be used with AL-01. |
| | | | *4.724* | *2.480* | | | | |
| C8 | **C8-C-6000-B** | | 120 | 63 | - | - | - | |
| | | | *4.724* | *2.480* | | | | |
| C10 | **C10-C-6000-B** | | 138 | 80 | - | - | - | |
| | | | *5.433* | *3.150* | | | | |

# Locking mechanism for cassettes

**-PL**

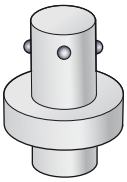


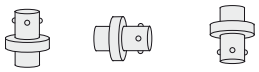


**Passive locking mechanism**

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

**-AL**





**Active locking mechanism**

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

| CZC | **Ordering code** | Pull action force, N | Pull action force, lbf | |
|---|---|---|---|---|
| C4 | **C4-PL-01** | 55 | 12.36 | Central passive locking mechanism. Spring loaded clamping. Fits directly into all cassettes type 4000. |
| C5 | **C5-PL-01** | 120 | 26.98 | |
| C6 | **C6-PL-01** | 150 | 33.72 | |
| C8 | **C8-PL-01** | 240 | 53.95 | |

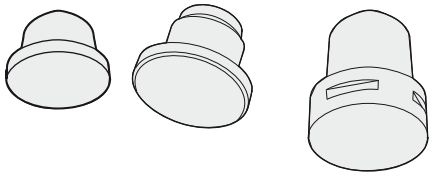
| CZC | **Ordering code** | Rec. max. tool weight, Kg | Rec. max. tool weight lbs | |
|---|---|---|---|---|
| C4 | **C4-AL-01** | 40 | 88 | Active locking mechanism – mechanical push action. Fits directly into all cassettes type 5000/6000. |
| C5 | **C5-AL-01** | 60 | 132 | |
| C6 | **C6-AL-01** | 75 | 165 | |
| C8 | **C8-AL-01** | 110 | 243 | |
| C10 | **C10-AL-01** | 150 | 330.7 | |

| CZC | **Ordering code** | Rec. max. tool weight, Kg | Rec. max. tool weight lbs | |
|---|---|---|---|---|
| C6 | **C6-AL-02** | 75 | 165 | Active locking mechanism – mechanical push action. Fits directly into all cassettes type 5000/6000. |
| C8 | **C8-AL-02** | 110 | 243 | |
| | | | | |
| | | | | |

# Assembly item

## Cover plug

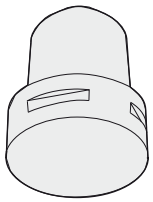
CP-11 CP-01 CPA-01



| 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



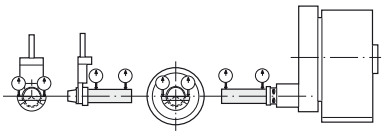
| Coupling size | **Ordering code** |
|---|---|
| C3 | **C3 - BAT - 01** |
| C4 | **C4 - BAT - 01** |
| C5 | **C5 - BAT - 01** |
| C6 | **C6 - BAT - 01** |
| C8 | **C8 - BAT - 01** |
| C10 | **C10 - BAT - 01** |

# Assembly item

## Master setting gauges

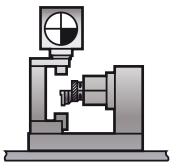
Checking position for grippers

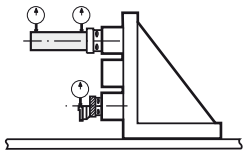
Spindle orientation



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 center height master setting gauges for the various coupling sizes, which are strongly recommended for setting important parameters such as:

Tool post center line





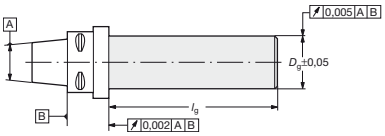
- The centerline of the tool post Spindle orientation The position of the tool for grippers Tool center height and cutting edge position (f1 and l1 dimensions). Gauges can be used in a pre-measuring fixture. Component fixtures

Tool presetting

Component fixture geometric control

### Axial gauge

#### Master setting gauges MAS-11

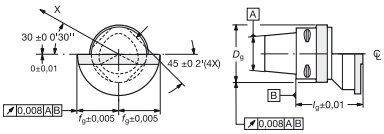



| Coupling size | Ordering code | Dimensions, mm (inch) $D_g$ | $l_g$ |
|---|---|---|---|
| C3 | **C3-MAS-11** | 25 (.98) | 160 (6.30) |
| C4 | **C4-MAS-11** | 25 (.98) | 160 (6.30) |
| C5 | **C5-MAS-11** | 32 (1.26) | 210 (8.27) |
| C6 | **C6-MAS-11** | 40 (1.57) | 315 (12.40) |
| C8 | **C8-MAS-11** | 40 (1.57) | 315 (12.40) |
| C10 | **C10-MAS-11** | 60 (2.362) | 420 (16.535) |

### Center height gauge

#### Master setting gauges MAS-01

(Polygon) Gripper groove



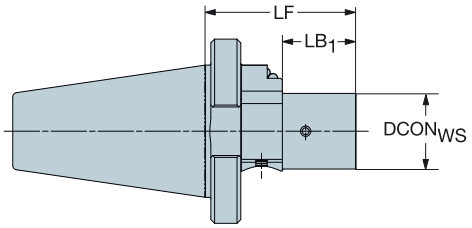

| Coupling size | Ordering code | Dimensions, mm (inch) $f_g$ | $l_g$ | $D_g$ |
|---|---|---|---|---|
| C3 | **C3-MAS-01** | 22 (.87) | 40 (1.57) | 34 (1.34) |
| C4 | **C4-MAS-01** | 27 (1.06) | 50 (1.97) | 42 (1.65) |
| C5 | **C5-MAS-01** | 35 (1.38) | 60 (2.36) | 52 (2.05) |
| C6 | **C6-MAS-01** | 45 (1.77) | 65 (2.56) | 65 (2.56) |
| C8 | **C8-MAS-01** | 55 (2.17) | 80 (3.15) | 82 (3.23) |
| C10 | **C10-MAS-01** | 65 (2.559) | 100 (3.937) | 102 (4.016) |

### Center height gauge

| Coupling size | Ordering code | Dimensions, mm (inch) $l_g$ | $D_g$ |
|---|---|---|---|
| C4 | **C4-MAS-25 140** | 140 (5.512) | 25 (.984) |
| C5 | **C5-MAS-32 145** | 145 (5.709) | 32 (1.260) |
| C6 | **C6-MAS-40 180** | 180 (7.087) | 40 (1.575) |
| C8 | **C8-MAS-40 240** | 240 (9.449) | 40 (1.575) |

# Assembly item

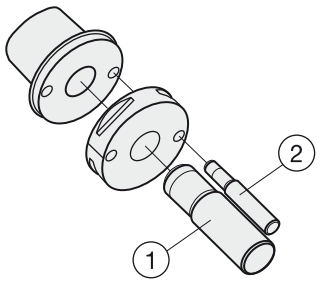
**Pre-measuring unit**




| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | **Ordering code** | Dimensions, mm, inch DCON$_{WS}$ | LF | LB$_1$ |
|---|---|---|---|---|---|---|---|
| 50 | C3 | 0 | 0 | **C3-PMU-I50** | 32 | 75 | 36 |
| | | | | | 1.260 | 2.953 | 1.417 |
| | C4 | 0 | 0 | **C4-PMU-I50** | 40 | 80 | 39 |
| | | | | | 1.575 | 3.150 | 1.535 |
| | C5 | 0 | 0 | **C5-PMU-I50** | 50 | 90 | 45 |
| | | | | | 1.969 | 3.543 | 1.772 |
| | C6 | 0 | 0 | **C6-PMU-I50** | 63 | 107 | 56 |
| | | | | | 2.480 | 4.213 | 2.205 |
| | C8 | 0 | 0 | **C8-PMU-I50** | 80 | 127 | 60 |
| | | | | | 3.150 | 5.000 | 2.362 |

# Alignment tool

This tool is used to check the Automatic Tool Change positioning tolerance between the gripper arm and magazine and the clamping unit/spindle. If the tolerance is not achieved, the result can be abnormal wear on cutting tool or Coromant Capto interface, wrong clamping, dropped tools, personal injuries etc. Instructions and tolerances are available in the box together with the tool.




| Coupling size | **Ordering code** **Tool** | Spare parts 1 Gauge pin | 2 Gauge pin |
|---|---|---|---|
| C4 | **C4-AMT-01** | 5552 069-03 | 5552 069-01 |
| C5 | **C5-AMT-01** | 5552 069-04 | 5552 069-01 |
| C6 | **C6-AMT-01** | 5552 069-05 | 5552 069-02 |
| C8 | **C8-AMT-01** | 5552 069-05 | 5552 069-02 |
| C10 | **C10-AMT-01** | 5552 069-09 | 5552 069-08 |

# Assembly item

**Coolant tube for solid HSK assortment**

| HSK size | Ordering code | Dimensions 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

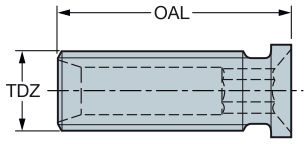
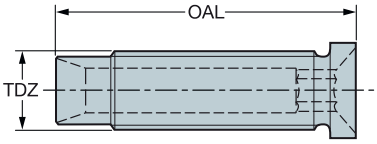



Fig. 2




| Ordering code | Shaft 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

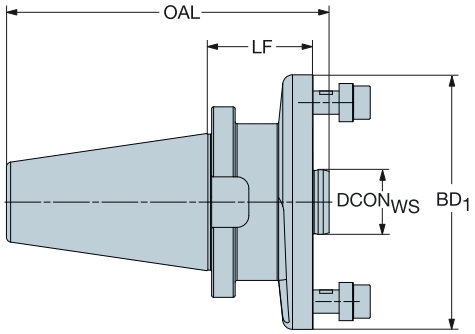
| Ordering code |
|---|
| 5514 100-01 |

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

Taps with external center

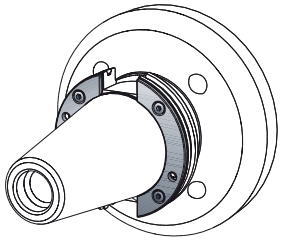
| Tap shank diameter, mm | ER20 | ER25 |
|---|---|---|
| 6, 7 | 5692 037-01 | |
| 8, 9 | 5692 037-02 | 5692 037-04 |
| 10 | 5692 037-03 | 5692 037-03 |
| 11-16 | | 5692 037-05 |

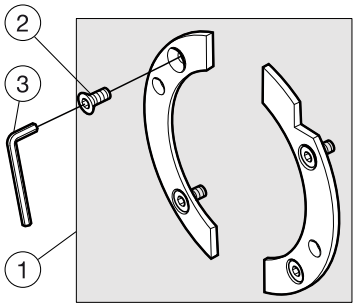
# CoroBore® XL pre-measuring unit




| | | | | Dimensions, mm, inch | | | | |
|---|---|---|---|---|---|---|---|---|
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | Ordering code | OAL | DCON | LF | BD$_1$ | KG |
| 50 | 33 | 0 | I50-PMU-A33 | 178.30 | 33 | 50.0 | 130.0 | 5.59 |
| | | | | *7.019* | *1.299* | *1.969* | *5.118* | |

## 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**

**Metric**

| 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) |

**Inch**

| Arbor size | Screw | | Key |
|---|---|---|---|
| .750 | 5512 074-01 | (3/8"-24 UNF) | 3021 011-516 (5/16) |
| .750 | 5512 074-03 | (3/8"-24 UNF) | 3021 011-516 (5/16) |
| 1.000 | 5512 074-02 | (1/2"-20 UNF) | 3021 011-380 (3/8) |
| 1.250 | 5512 074-04 | (5/8"-18 UNF) | - (1/2) |
| 1.500 | 5512 074-05 | (3/4"-16 UNF) | - (5/8) |

**Metric**

| 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) |

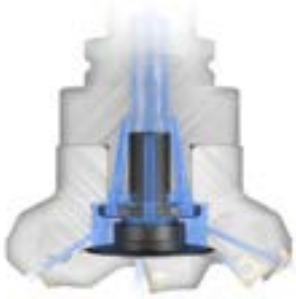
**Inch**

| Arbor size | Screw | | Key |
|---|---|---|---|
| .750 | 5512 088-01 | (3/8"-24 UNF) | 5680 043-17 (30IP) |
| 1.000 | 5512 088-02 | (1/2"-20 UNF) | 5680 043-18 (50IP) |
| 1.000 | 5512 099-06* | (1/2"-20 UNF) | 5680 043-13 (15IP) |
| | | | 5680 043-18 (50IP) |
| 1.500 | 5512 088-03 | (3/4"-16 UNF) | 5680 043-19 (55IP) |

* Screw set has an adjustable cap

# Arbor mounting screws with coolant hole

## ISO B



### Metric

| Arbor size | Screw | | Key |
|---|---|---|---|
| 32 | 5512 098-03 | (M16) | 3021 010-060 (6.0)<br>3021 010-120 (12.0) |
| 40 | 5512 098-03 | (M20) | 3021 010-060 (6.0)<br>3021 010-120 (12.0) |

### Inch

| Arbor size | Screw | | Key |
|---|---|---|---|
| 1.250 | 5512 099-05 | (5/8"-18UNF) | 3021 010-060 (6mm)<br>3021 011-916 (9/16") |
| 1.500 | 5512 099-03 | (3/4"-16UNF) | 3021 011-140 (1/4")<br>3021 011-916 (9/16") |

## Coolant screw and washer to CoroMill® 331

Metric

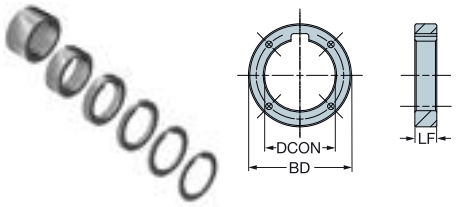
| Set code | Screw | Washer code | Arbor size |
|---|---|---|---|
| 5512 076-101 | 5512 076-01 | 5549 210-01 | 27 |
| 5512 076-102 | 5512 076-02 | 5549 210-02 | 32 |
| 5512 076-103 | 5512 076-03 | 5549 210-03 | 40 |

Inch

| Set code | Screw | Washer code | Arbor size |
|---|---|---|---|
| 5512 077-101 | 5512 077-01 | 5549 211-01 | 25 |
| 5512 077-103 | 5512 077-03 | 5549 210-02 | 32 |
| 5512 077-102 | 5512 077-02 | 5549 211-02 | 38 |

# Spacing collars

## Spacing rings with holes



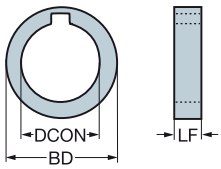

| Metric, mm | LF | 0.5 | 1 | 1.5 | 2 | 3 | 4 | 5 | 6 | 10 | 20 | 30 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Set code | DCON | BD | BD | BD | BD | BD | BD | BD | BD | BD | BD | BD |
| 5549 091-032 | 27 | 39 | 39 | 39 | 41 | 41 | 41 | 41 | 41 | 41 | 41 | 41 |
| 5549 091-042 | 32 | 45 | 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 |

| Inch | LF | 1/32 | 1/16 | 1/4 | 3/8 | 1/2 | 3/4 | 1 |
|---|---|---|---|---|---|---|---|---|
| Set code | DCON | BD | BD | BD | BD | BD | BD | BD |
| 5549 091-512 | 1 | 1.461 | 1.461 | 1.500 | 1.500 | 1.500 | 1.500 | 1.500 |
| 5549 091-522 | 1.25 | 1.77 | 1.77 | 1.85 | 1.85 | 1.85 | 1.85 | 1.85 |
| 5549 091-532 | 1.5 | 2.075 | 2.075 | 2.125 | 2.125 | 2.125 | 2.125 | 2.125 |

For coolant screw and washer, see page [ref-1]

**Set without hole**

**For milling adapter 391.10**
**ISO 839/2 1977**



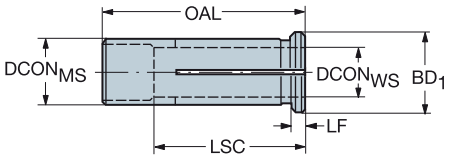

| Metric, mm | LF | 0.5 | 1.0 | 1.5 | 2.0 | 3.0 | 4.0 | 5.0 | 6.0 | 10.0 | 20.0 | 30.0 |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| Set code | DCON | BD | BD | BD | BD | BD | BD | BD | BD | BD | BD | BD |
| 5549 091-011 | 16 | 25 | 25 | 25 | 27 | 27 | 27 | 27 | 27 | 27 | 27 | • |
| 5549 091-021 | 22 | 33 | 33 | 33 | 34 | 34 | 34 | 34 | 34 | 34 | 34 | 34 |
| 5549 091-061 | 50 | 67 | 67 | • | 68 | 68 | 68 | 68 | 68 | 68 | 68 | 68 |
| 5549 091-071 | 60 | 84 | 84 | • | 84 | 84 | 84 | 84 | 84 | 84 | 84 | 84 |

**Set without hole**

| Inch | LF | 1/32 | 1/16 | 1/4 | 3/8 | 1/2 | 3/4 | 1 |
|---|---|---|---|---|---|---|---|---|
| Set code | DCON | BD | BD | BD | BD | BD | BD | BD |
| 5549 091-541 | 2 | 2.711 | 2.711 | 2.75 | 2.75 | 2.75 | 2.75 | 2.75 |
| 5549 091-551 | 2.5 | 3.211 | 3.211 | 3.25 | 3.25 | 3.25 | 3.25 | 3.25 |

# Cylindrical sleeves

**Metallic sealed for coolant through tool**




## Metric bore

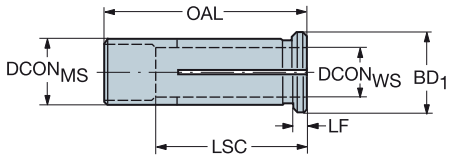
| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| 6 | 3 | 1 | 1 | 393.CGS-06 03 27 | 6 | 3 | 9 | 27.0 | 30 | 3 | 80 | 0.012 |
| | | | | | .236 | .118 | .354 | 1.063 | 1.181 | .118 | 1160 | |
| 12 | 3 | 1 | 1 | 393.CGS-12 03 40 | 12 | 3 | 16 | 40.0 | 44 | 4 | 80 | 0.036 |
| | | | | | .472 | .118 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 4 | 1 | 1 | 393.CGS-12 04 40 | 12 | 4 | 16 | 40.0 | 44 | 4 | 80 | 0.035 |
| | | | | | .472 | .157 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 5 | 1 | 1 | 393.CGS-12 05 40 | 12 | 5 | 16 | 40.0 | 44 | 4 | 80 | 0.030 |
| | | | | | .472 | .197 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 6 | 1 | 1 | 393.CGS-12 06 40 | 12 | 6 | 16 | 40.0 | 44 | 4 | 80 | 0.035 |
| | | | | | .472 | .236 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 7 | 1 | 1 | 393.CGS-12 07 40 | 12 | 7 | 16 | 40.0 | 44 | 4 | 80 | 0.032 |
| | | | | | .472 | .276 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 8 | 1 | 1 | 393.CGS-12 08 40 | 12 | 8 | 16 | 40.0 | 44 | 4 | 80 | 0.029 |
| | | | | | .472 | .315 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 9 | 1 | 1 | 393.CGS-12 09 40 | 12 | 9 | 16 | 40.0 | 44 | 4 | 80 | 0.024 |
| | | | | | .472 | .354 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 10 | 1 | 1 | 393.CGS-12 10 40 | 12 | 10 | 16 | 40.0 | 44 | 4 | 80 | 0.020 |
| | | | | | .472 | .394 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| 20 | 3 | 1 | 1 | 393.CGS-20 03 52 | 20 | 3 | 25 | 50.0 | 54 | 4 | 80 | 0.118 |
| | | | | | .787 | .118 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 4 | 1 | 1 | 393.CGS-20 04 52 | 20 | 4 | 25 | 50.0 | 54 | 4 | 80 | 0.104 |
| | | | | | .787 | .157 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 5 | 1 | 1 | 393.CGS-20 05 52 | 20 | 5 | 25 | 50.0 | 54 | 4 | 80 | 0.100 |
| | | | | | .787 | .197 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 6 | 1 | 1 | 393.CGS-20 06 52 | 20 | 6 | 25 | 50.0 | 54 | 4 | 80 | 0.110 |
| | | | | | .787 | .236 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 7 | 1 | 1 | 393.CGS-20 07 52 | 20 | 7 | 25 | 50.0 | 54 | 4 | 80 | 0.110 |
| | | | | | .787 | .276 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 8 | 1 | 1 | 393.CGS-20 08 52 | 20 | 8 | 25 | 50.0 | 54 | 4 | 80 | 0.108 |
| | | | | | .787 | .315 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 9 | 1 | 1 | 393.CGS-20 09 52 | 20 | 9 | 25 | 50.0 | 54 | 4 | 80 | 0.106 |
| | | | | | .787 | .354 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 9.7 | 1 | 1 | 393.CGS-20 09.7 50 | 20 | 9 | 25 | 50.0 | 54 | 4 | 80 | 0.102 |
| | | | | | .787 | .382 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 10 | 1 | 1 | 393.CGS-20 10 52 | 20 | 10 | 25 | 50.0 | 54 | 4 | 80 | 0.102 |
| | | | | | .787 | .394 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 11.7 | 1 | 1 | 393.CGS-20 11.7 50 | 20 | 11 | 25 | 50.0 | 54 | 4 | 80 | 0.094 |
| | | | | | .787 | .461 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 12 | 1 | 1 | 393.CGS-20 12 52 | 20 | 12 | 25 | 50.0 | 54 | 4 | 80 | 0.094 |
| | | | | | .787 | .472 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 14 | 1 | 1 | 393.CGS-20 14 52 | 20 | 14 | 25 | 50.0 | 54 | 4 | 80 | 0.081 |
| | | | | | .787 | .551 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 15.7 | 1 | 1 | 393.CGS-20 15.7 50 | 20 | 15 | 25 | 50.0 | 54 | 4 | 80 | 0.067 |
| | | | | | .787 | .618 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 16 | 1 | 1 | 393.CGS-20 16 52 | 20 | 16 | 25 | 50.0 | 54 | 4 | 80 | 0.065 |
| | | | | | .787 | .630 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 18 | 1 | 1 | 393.CGS-20 18 52 | 20 | 18 | 25 | 50.0 | 54 | 4 | 80 | 0.045 |
| | | | | | .787 | .709 | .984 | 1.969 | 2.126 | .157 | 1160 | |

LSC Clamping length required to achieve sealing effect.
For extractors for cylindrical collets, see page M21.

N22 N15

# Cylindrical sleeves

**Metallic sealed for coolant through tool**




## Metric bore

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| 25 | 3 | 1 | 1 | 393.CGS-25 03 56 | 25 | 3 | 30 | 56.0 | 60 | 4 | 80 | 0.212 |
| | | | | | .984 | .118 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 4 | 1 | 1 | 393.CGS-25 04 56 | 25 | 4 | 30 | 56.0 | 60 | 4 | 80 | 0.191 |
| | | | | | .984 | .157 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 5 | 1 | 1 | 393.CGS-25 05 56 | 25 | 5 | 30 | 56.0 | 60 | 4 | 80 | 0.208 |
| | | | | | .984 | .197 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 6 | 1 | 1 | 393.CGS-25 06 56 | 25 | 6 | 30 | 56.0 | 60 | 4 | 80 | 0.192 |
| | | | | | .984 | .236 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 7 | 1 | 1 | 393.CGS-25 07 56 | 25 | 7 | 30 | 56.0 | 60 | 4 | 80 | 0.204 |
| | | | | | .984 | .276 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 8 | 1 | 1 | 393.CGS-25 08 56 | 25 | 8 | 30 | 56.0 | 60 | 4 | 80 | 0.200 |
| | | | | | .984 | .315 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 9 | 1 | 1 | 393.CGS-25 09 56 | 25 | 9 | 30 | 56.0 | 60 | 4 | 80 | 0.197 |
| | | | | | .984 | .354 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 9.7 | 1 | 1 | 393.CGS-25 09.7 56 | 25 | 9 | 30 | 56.0 | 60 | 4 | 80 | 0.185 |
| | | | | | .984 | .382 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 10 | 1 | 1 | 393.CGS-25 10 56 | 25 | 10 | 30 | 56.0 | 60 | 4 | 80 | 0.186 |
| | | | | | .984 | .394 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 11.7 | 1 | 1 | 393.CGS-25 11.7 56 | 25 | 11 | 30 | 56.0 | 60 | 4 | 80 | 0.161 |
| | | | | | .984 | .461 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 12 | 1 | 1 | 393.CGS-25 12 56 | 25 | 12 | 30 | 56.0 | 60 | 4 | 80 | 0.167 |
| | | | | | .984 | .472 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 14 | 1 | 1 | 393.CGS-25 14 56 | 25 | 14 | 30 | 56.0 | 60 | 4 | 80 | 0.156 |
| | | | | | .984 | .551 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 15.7 | 1 | 1 | 393.CGS-25 15.7 56 | 25 | 15 | 30 | 56.0 | 60 | 4 | 80 | 0.151 |
| | | | | | .984 | .618 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 16 | 1 | 1 | 393.CGS-25 16 56 | 25 | 16 | 30 | 56.0 | 60 | 4 | 80 | 0.150 |
| | | | | | .984 | .630 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 18 | 1 | 1 | 393.CGS-25 18 56 | 25 | 18 | 30 | 56.0 | 60 | 4 | 80 | 0.121 |
| | | | | | .984 | .709 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 19.7 | 1 | 1 | 393.CGS-25 19.7 56 | 25 | 19 | 30 | 56.0 | 60 | 4 | 80 | 0.102 |
| | | | | | .984 | .776 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 20 | 1 | 1 | 393.CGS-25 20 56 | 25 | 20 | 30 | 56.0 | 60 | 4 | 80 | 0.100 |
| | | | | | .984 | .787 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| 32 | 8 | 1 | 1 | 393.CGS-32 08 60 | 32 | 8 | 36 | 60.0 | 64 | 4 | 80 | 0.329 |
| | | | | | 1.260 | .315 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 10 | 1 | 1 | 393.CGS-32 10 60 | 32 | 10 | 36 | 60.0 | 64 | 4 | 80 | 0.300 |
| | | | | | 1.260 | .394 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 12 | 1 | 1 | 393.CGS-32 12 60 | 32 | 12 | 36 | 60.0 | 64 | 4 | 80 | 0.312 |
| | | | | | 1.260 | .472 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 14 | 1 | 1 | 393.CGS-32 14 60 | 32 | 14 | 36 | 60.0 | 64 | 4 | 80 | 0.300 |
| | | | | | 1.260 | .551 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 15.7 | 1 | 1 | 393.CGS-32 15.7 60 | 32 | 15 | 36 | 60.0 | 64 | 4 | 80 | 0.287 |
| | | | | | 1.260 | .618 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 16 | 1 | 1 | 393.CGS-32 16 60 | 32 | 16 | 36 | 60.0 | 64 | 4 | 80 | 0.288 |
| | | | | | 1.260 | .630 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 18 | 1 | 1 | 393.CGS-32 18 60 | 32 | 18 | 36 | 60.0 | 64 | 4 | 80 | 0.268 |
| | | | | | 1.260 | .709 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 19.7 | 1 | 1 | 393.CGS-32 19.7 60 | 32 | 19 | 36 | 60.0 | 64 | 4 | 80 | 0.248 |
| | | | | | 1.260 | .776 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 20 | 1 | 1 | 393.CGS-32 20 60 | 32 | 20 | 36 | 60.0 | 64 | 4 | 80 | 0.248 |
| | | | | | 1.260 | .787 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 24.7 | 1 | 1 | 393.CGS-32 24.7 60 | 32 | 24 | 36 | 60.0 | 64 | 4 | 80 | 0.184 |
| | | | | | 1.260 | .972 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 25 | 1 | 1 | 393.CGS-32 25 60 | 32 | 25 | 36 | 60.0 | 64 | 4 | 80 | 0.181 |
| | | | | | 1.260 | .984 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |

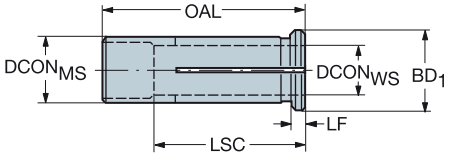
LSC Clamping length required to achieve sealing effect.

For extractors for cylindrical collets, see page M21.

N22 N15

# Cylindrical sleeves

**Metallic sealed for coolant through tool**




## Inch bore

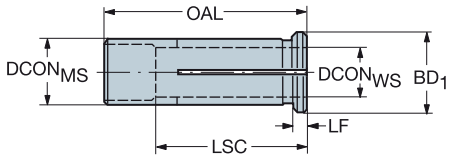
| | | | | | Dimensions, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | BD | LSC | OAL | LF | PSI | LBS |
| 12 | 1/8 | 1 | 1 | A393.CGS-12 02 40 | .472 | .125 | .630 | 1.575 | 1.732 | .157 | 1160 | .079 |
| | 3/16 | 1 | 1 | A393.CGS-12 03 40 | .472 | .188 | .630 | 1.575 | 1.732 | .157 | 1160 | .066 |
| | 1/4 | 1 | 1 | A393.CGS-12 04 40 | .472 | .250 | .630 | 1.575 | 1.732 | .157 | 1160 | .066 |
| | 5/16 | 1 | 1 | A393.CGS-12 05 40 | .472 | .313 | .630 | 1.575 | 1.732 | .157 | 1160 | .066 |
| | 3/8 | 1 | 1 | A393.CGS-12 06 40 | .472 | .375 | .630 | 1.575 | 1.732 | .157 | 1160 | .049 |
| 20 | 1/8 | 1 | 1 | A393.CGS-20 02 52 | .787 | .125 | .984 | 1.969 | 2.126 | .157 | 1160 | .256 |
| | 3/16 | 1 | 1 | A393.CGS-20 03 52 | .787 | .188 | .984 | 1.969 | 2.126 | .157 | 1160 | .251 |
| | 1/4 | 1 | 1 | A393.CGS-20 04 52 | .787 | .250 | .984 | 1.969 | 2.126 | .157 | 1160 | .245 |
| | 5/16 | 1 | 1 | A393.CGS-20 05 52 | .787 | .313 | .984 | 1.969 | 2.126 | .157 | 1160 | .240 |
| | 3/8 | 1 | 1 | A393.CGS-20 06 52 | .787 | .375 | .984 | 1.969 | 2.126 | .157 | 1160 | .229 |
| | 7/16 | 1 | 1 | A393.CGS-20 07 52 | .787 | .438 | .984 | 1.969 | 2.126 | .157 | 1160 | .132 |
| | 1/2 | 1 | 1 | A393.CGS-20 08 52 | .787 | .500 | .984 | 1.969 | 2.126 | .157 | 1160 | .196 |
| | 9 | 1 | 1 | A393.CGS-20 09.2 50 | .787 | .362 | .984 | 1.969 | 2.126 | .157 | 1160 | .227 |
| | 9/16 | 1 | 1 | A393.CGS-20 09 52 | .787 | .563 | .984 | 1.969 | 2.126 | .157 | 1160 | .172 |
| | 5/8 | 1 | 1 | A393.CGS-20 10 52 | .787 | .625 | .984 | 1.969 | 2.126 | .157 | 1160 | .146 |
| 25 | 1/8 | 1 | 1 | A393.CGS-25 02 56 | .984 | .125 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .434 |
| | 3/16 | 1 | 1 | A393.CGS-25 03 56 | .984 | .188 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .459 |
| | 1/4 | 1 | 1 | A393.CGS-25 04 56 | .984 | .250 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .454 |
| | 5/16 | 1 | 1 | A393.CGS-25 05 56 | .984 | .313 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .442 |
| | 3/8 | 1 | 1 | A393.CGS-25 06 56 | .984 | .375 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .441 |
| | 7/16 | 1 | 1 | A393.CGS-25 07 56 | .984 | .438 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .397 |
| | 1/2 | 1 | 1 | A393.CGS-25 08 56 | .984 | .500 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .386 |
| | 9 | 1 | 1 | A393.CGS-25 09.2 56 | .984 | .362 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .406 |
| | 9/16 | 1 | 1 | A393.CGS-25 09 56 | .984 | .563 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .362 |
| | 5/8 | 1 | 1 | A393.CGS-25 10 56 | .984 | .625 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .333 |
| | 3/4 | 1 | 1 | A393.CGS-25 12 56 | .984 | .750 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .243 |
| | 18 | 1 | 1 | A393.CGS-25 18.7 56 | .984 | .736 | 1.181 | 2.205 | 2.362 | .157 | 1160 | .262 |
| 32 | 1/4 | 1 | 1 | A393.CGS-32 04 60 | 1.260 | .250 | 1.417 | 2.362 | 2.520 | .157 | 1160 | .736 |
| | 3/8 | 1 | 1 | A393.CGS-32 06 60 | 1.260 | .375 | 1.417 | 2.362 | 2.520 | .157 | 1160 | .705 |
| | 1/2 | 1 | 1 | A393.CGS-32 08 60 | 1.260 | .500 | 1.417 | 2.362 | 2.520 | .157 | 1160 | .617 |
| | 5/8 | 1 | 1 | A393.CGS-32 10 60 | 1.260 | .625 | 1.417 | 2.362 | 2.520 | .157 | 1160 | .593 |
| | 3/4 | 1 | 1 | A393.CGS-32 12 60 | 1.260 | .750 | 1.417 | 2.362 | 2.520 | .157 | 1160 | .573 |
| | 7/8 | 1 | 1 | A393.CGS-32 14 60 | 1.260 | .875 | 1.417 | 2.362 | 2.520 | .157 | 1160 | .397 |
| | 18 | 1 | 1 | A393.CGS-32 18.7 60 | 1.260 | .736 | 1.417 | 2.362 | 2.520 | .157 | 1160 | .593 |
| | 1 | 1 | 1 | A393.CGS-32 16 60 | 1.260 | 1.000 | 1.417 | 2.362 | 2.520 | .157 | 1160 | .386 |

For extractors for cylindrical collets, see page M21.

N22 N15

# Cylindrical sleeves

**Precision coolant supply**




## Metric version

| | | | | | Dimensions | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | 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 | 40.00 | 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 | 40.00 | 44.00 | 4 | 80 | 0.03 |
| | 5.00 | 1 | 4 | **393.CF-12 05 40** | 12.00 | 5.00 | 40.00 | 44.00 | 4 | 80 | 0.03 |
| | 5.80 | 1 | 4 | **393.CF-12 05.8 40** | 12.00 | 5.80 | 40.00 | 44.00 | 4 | 80 | 0.03 |
| | 6.00 | 1 | 4 | **393.CF-12 06 40** | 12.00 | 6.00 | 40.00 | 44.00 | 4 | 80 | 0.03 |
| | 7.80 | 1 | 4 | **393.CF-12 07.8 40** | 12.00 | 7.80 | 40.00 | 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 | 10.00 | 1 | 4 | **393.CF-20 10 50** | 20.00 | 10.00 | 50.00 | 54.00 | 4 | 80 | 0.09 |
| | 11.70 | 1 | 4 | **393.CF-20 11.7 50** | 20.00 | 11.70 | 50.00 | 54.00 | 4 | 80 | 0.09 |
| | 12.00 | 1 | 4 | **393.CF-20 12 50** | 20.00 | 12.00 | 50.00 | 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 | 50.00 | 54.00 | 4 | 80 | 0.06 |
| | 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 | 50.00 | 54.00 | 4 | 80 | 0.10 |
| | 9.70 | 1 | 4 | **393.CF-20 09.7 50** | 20.00 | 9.70 | 50.00 | 54.00 | 4 | 80 | 0.10 |
| 25 | 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 | 56.00 | 60.00 | 4 | 80 | 0.16 |
| | 12.00 | 1 | 4 | **393.CF-25 12 56** | 25.00 | 12.00 | 56.00 | 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 | 56.00 | 60.00 | 4 | 80 | 0.10 |
| | 9.70 | 1 | 4 | **393.CF-25 09.7 56** | 25.00 | 9.70 | 56.00 | 60.00 | 4 | 80 | 0.18 |
| 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 | 60.00 | 64.00 | 4 | 80 | 0.18 |
| | 25.00 | 1 | 4 | **393.CF-32 25 60** | 32.00 | 25.00 | 60.00 | 64.00 | 4 | 80 | 0.18 |

## Inch version

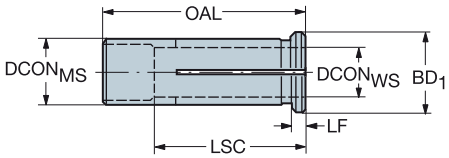
| | | | | | Dimensions, inch | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | OAL | LF | PSI | LBS |
| 12 | 1/4 | 1 | 4 | **A393.CF-12 04 40** | .472 | .250 | 1.574 | 1.732 | .157 | 1160 | .070 |
| | 1/8 | 1 | 4 | **A393.CF-12 02 40** | .472 | .125 | 1.574 | 1.732 | .157 | 1160 | .000 |
| | 3/16 | 1 | 4 | **A393.CF-12 03 40** | .472 | .187 | 1.574 | 1.732 | .157 | 1160 | .000 |
| 20 | 1/2 | 1 | 4 | **A393.CF-20 08 52** | .787 | .500 | 1.968 | 2.125 | .157 | 1160 | .189 |
| | 3/8 | 1 | 4 | **A393.CF-20 06 52** | .787 | .375 | 1.968 | 2.125 | .157 | 1160 | .216 |
| | 5/8 | 1 | 4 | **A393.CF-20 10 52** | .787 | .625 | 1.968 | 2.125 | .157 | 1160 | .134 |
| | 9.200 | 1 | 4 | **A393.CF-20 09.2 50** | .787 | .362 | 1.968 | 2.125 | .157 | 1160 | .224 |
| 25 | 18.700 | 1 | 4 | **A393.CF-25 18.7 56** | .984 | .736 | 2.204 | 2.362 | .157 | 1160 | .266 |
| 32 | 18.700 | 1 | 4 | **A393.CF-32 18.7 60** | 1.259 | .736 | 2.362 | 2.519 | .157 | 1160 | .564 |

For extractors for cylindrical collets, see page M21.

N22 N15

# Cylindrical sleeves

## Coolant through sleeve




### Metric bore

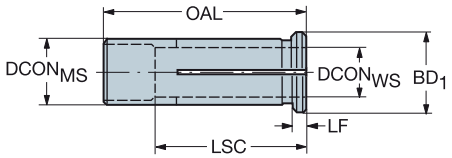
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 12 | 6 | 1 | 4 | 393.CG-12 06 40 | 12 | 6 | 16 | 40.0 | 44 | 4 | 80 | 0.034 |
| | | | | | .472 | .236 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 7 | 1 | 4 | 393.CG-12 07 40 | 12 | 7 | 16 | 40.0 | 44 | 4 | 80 | 0.030 |
| | | | | | .472 | .276 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 8 | 1 | 4 | 393.CG-12 08 40 | 12 | 8 | 16 | 40.0 | 44 | 4 | 80 | 0.029 |
| | | | | | .472 | .315 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 9 | 1 | 4 | 393.CG-12 09 40 | 12 | 9 | 16 | 40.0 | 44 | 4 | 80 | 0.025 |
| | | | | | .472 | .354 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| | 10 | 1 | 4 | 393.CG-12 10 40 | 12 | 10 | 16 | 40.0 | 44 | 4 | 80 | 0.020 |
| | | | | | .472 | .394 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| 20 | 3 | 1 | 4 | 393.CG-20 03 52 | 20 | 3 | 25 | 50.0 | 54 | 4 | 80 | 0.120 |
| | | | | | .787 | .118 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 4 | 1 | 4 | 393.CG-20 04 52 | 20 | 4 | 25 | 50.0 | 54 | 4 | 80 | 0.114 |
| | | | | | .787 | .157 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 5 | 1 | 4 | 393.CG-20 05 52 | 20 | 5 | 25 | 50.0 | 54 | 4 | 80 | 0.100 |
| | | | | | .787 | .197 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 6 | 1 | 4 | 393.CG-20 06 52 | 20 | 6 | 25 | 50.0 | 54 | 4 | 80 | 0.113 |
| | | | | | .787 | .236 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 7 | 1 | 4 | 393.CG-20 07 52 | 20 | 7 | 25 | 50.0 | 54 | 4 | 80 | 0.100 |
| | | | | | .787 | .276 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 8 | 1 | 4 | 393.CG-20 08 52 | 20 | 8 | 25 | 50.0 | 54 | 4 | 80 | 0.109 |
| | | | | | .787 | .315 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 9 | 1 | 4 | 393.CG-20 09 52 | 20 | 9 | 25 | 50.0 | 54 | 4 | 80 | 0.103 |
| | | | | | .787 | .354 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 10 | 1 | 4 | 393.CG-20 10 52 | 20 | 10 | 25 | 50.0 | 54 | 4 | 80 | 0.101 |
| | | | | | .787 | .394 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 12 | 1 | 4 | 393.CG-20 12 52 | 20 | 12 | 25 | 50.0 | 54 | 4 | 80 | 0.095 |
| | | | | | .787 | .472 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 14 | 1 | 4 | 393.CG-20 14 52 | 20 | 14 | 25 | 50.0 | 54 | 4 | 80 | 0.080 |
| | | | | | .787 | .551 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| | 16 | 1 | 4 | 393.CG-20 16 52 | 20 | 16 | 25 | 50.0 | 54 | 4 | 80 | 0.064 |
| | | | | | .787 | .630 | .984 | 1.969 | 2.126 | .157 | 1160 | |
| 25 | 6 | 1 | 4 | 393.CG-25 06 56 | 25 | 6 | 30 | 56.0 | 60 | 4 | 80 | 0.192 |
| | | | | | .984 | .236 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 8 | 1 | 4 | 393.CG-25 08 56 | 25 | 8 | 30 | 56.0 | 60 | 4 | 80 | 0.200 |
| | | | | | .984 | .315 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 10 | 1 | 4 | 393.CG-25 10 56 | 25 | 10 | 30 | 56.0 | 60 | 4 | 80 | 0.171 |
| | | | | | .984 | .394 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 12 | 1 | 4 | 393.CG-25 12 56 | 25 | 12 | 30 | 56.0 | 60 | 4 | 80 | 0.168 |
| | | | | | .984 | .472 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 14 | 1 | 4 | 393.CG-25 14 56 | 25 | 14 | 30 | 56.0 | 60 | 4 | 80 | 0.154 |
| | | | | | .984 | .551 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 16 | 1 | 4 | 393.CG-25 16 56 | 25 | 16 | 30 | 56.0 | 60 | 4 | 80 | 0.139 |
| | | | | | .984 | .630 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 18 | 1 | 4 | 393.CG-25 18 56 | 25 | 18 | 30 | 56.0 | 60 | 4 | 80 | 0.120 |
| | | | | | .984 | .709 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 20 | 1 | 4 | 393.CG-25 20 56 | 25 | 20 | 30 | 56.0 | 60 | 4 | 80 | 0.100 |
| | | | | | .984 | .787 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| 32 | 6 | 1 | 4 | 393.CG-32 06 60 | 32 | 6 | 36 | 60.0 | 64 | 4 | 80 | 0.306 |
| | | | | | 1.260 | .236 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 8 | 1 | 4 | 393.CG-32 08 60 | 32 | 8 | 36 | 60.0 | 64 | 4 | 80 | 0.328 |
| | | | | | 1.260 | .315 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 10 | 1 | 4 | 393.CG-32 10 60 | 32 | 10 | 36 | 60.0 | 64 | 4 | 80 | 0.324 |
| | | | | | 1.260 | .394 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 12 | 1 | 4 | 393.CG-32 12 60 | 32 | 12 | 36 | 60.0 | 64 | 4 | 80 | 0.314 |
| | | | | | 1.260 | .472 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 14 | 1 | 4 | 393.CG-32 14 60 | 32 | 14 | 36 | 60.0 | 64 | 4 | 80 | 0.300 |
| | | | | | 1.260 | .551 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 16 | 1 | 4 | 393.CG-32 16 60 | 32 | 16 | 36 | 60.0 | 64 | 4 | 80 | 0.282 |
| | | | | | 1.260 | .630 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 18 | 1 | 4 | 393.CG-32 18 60 | 32 | 18 | 36 | 60.0 | 64 | 4 | 80 | 0.267 |
| | | | | | 1.260 | .709 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 20 | 1 | 4 | 393.CG-32 20 60 | 32 | 20 | 36 | 60.0 | 64 | 4 | 80 | 0.246 |
| | | | | | 1.260 | .787 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 25 | 1 | 4 | 393.CG-32 25 60 | 32 | 25 | 36 | 60.0 | 64 | 4 | 80 | 0.181 |
| | | | | | 1.260 | .984 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |

For extractors for cylindrical collets, see page M21.

N22 N15

# Cylindrical sleeves

## Coolant through sleeve




## Inch bore

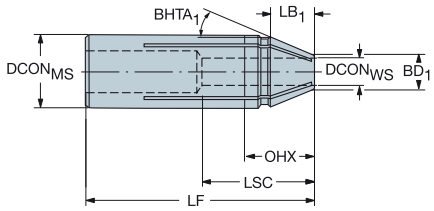
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 12 | 3/8 | 1 | 4 | A393.CG-12 06 40 | 12 | 9 | 16 | 40.0 | 44 | 4 | 80 | 0.022 |
| | | | | | .472 | .375 | .630 | 1.575 | 1.732 | .157 | 1160 | |
| 20 | 1/4 | 1 | 4 | A393.CG-20 04 52 | 20 | 6 | 25 | 50.0 | 56 | 4 | 80 | 0.113 |
| | | | | | .787 | .250 | .984 | 1.969 | 2.205 | .157 | 1160 | |
| | 9 | 1 | 1 | A393.CG-20 09.2 50 | 20 | 9 | 25 | 50.0 | 54 | 4 | 10 | 0.106 |
| | | | | | .787 | .362 | .984 | 1.969 | 2.126 | .157 | 145 | |
| 25 | 1/4 | 1 | 4 | A393.CG-25 04 56 | 25 | 6 | 30 | 56.0 | 60 | 4 | 80 | 0.191 |
| | | | | | .984 | .250 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 3/8 | 1 | 4 | A393.CG-25 06 56 | 25 | 9 | 30 | 56.0 | 60 | 4 | 80 | 0.182 |
| | | | | | .984 | .375 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 1/2 | 1 | 4 | A393.CG-25 08 56 | 25 | 12 | 30 | 56.0 | 60 | 4 | 80 | 0.163 |
| | | | | | .984 | .500 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 9 | 1 | 1 | A393.CG-25 09.2 56 | 25 | 9 | 30 | 56.0 | 60 | 4 | 10 | 0.180 |
| | | | | | .984 | .362 | 1.181 | 2.205 | 2.362 | .157 | 145 | |
| | 5/8 | 1 | 4 | A393.CG-25 10 56 | 25 | 15 | 30 | 56.0 | 60 | 4 | 80 | 0.149 |
| | | | | | .984 | .625 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 3/4 | 1 | 4 | A393.CG-25 12 56 | 25 | 19 | 30 | 56.0 | 60 | 4 | 80 | 0.112 |
| | | | | | .984 | .750 | 1.181 | 2.205 | 2.362 | .157 | 1160 | |
| | 18 | 1 | 1 | A393.CG-25 18.7 56 | 25 | 18 | 30 | 56.0 | 60 | 4 | 10 | 0.119 |
| | | | | | .984 | .736 | 1.181 | 2.205 | 2.362 | .157 | 145 | |
| 32 | 3/8 | 1 | 4 | A393.CG-32 06 60 | 32 | 9 | 36 | 60.0 | 64 | 4 | 80 | 0.326 |
| | | | | | 1.260 | .375 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 1/2 | 1 | 4 | A393.CG-32 08 60 | 32 | 12 | 36 | 60.0 | 64 | 4 | 80 | 0.306 |
| | | | | | 1.260 | .500 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 5/8 | 1 | 4 | A393.CG-32 10 60 | 32 | 15 | 36 | 60.0 | 64 | 4 | 80 | 0.285 |
| | | | | | 1.260 | .625 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 3/4 | 1 | 4 | A393.CG-32 12 60 | 32 | 19 | 36 | 60.0 | 64 | 4 | 80 | 0.254 |
| | | | | | 1.260 | .750 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |
| | 18 | 1 | 1 | A393.CG-32 18.7 60 | 32 | 18 | 36 | 60.0 | 64 | 4 | 10 | 0.258 |
| | | | | | 1.260 | .736 | 1.417 | 2.362 | 2.520 | .157 | 145 | |
| | 1 | 1 | 4 | A393.CG-32 16 60 | 32 | 25 | 36 | 60.0 | 64 | 4 | 80 | 0.173 |
| | | | | | 1.260 | 1.000 | 1.417 | 2.362 | 2.520 | .157 | 1160 | |

For extractors for cylindrical collets, see page M21.

N22 N15

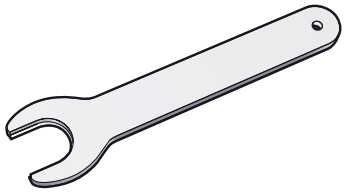
# Cylindrical sleeves

**Pencil type**




| | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | BD | LB | BHTA | LSC | LF | BAR PSI | KG |
| 20 | 3 | 1 | 4 | **393.CGP-20 03 72** | 20 | 3 | 7 | 14 | 20° | 55.0 | 72 | 80 | 0.134 |
| | | | | | .787 | .118 | .276 | .555 | 20° | 2.165 | 2.835 | 1160 | |
| | 6 | 1 | 4 | **393.CGP-20 06 72** | 20 | 6 | 9 | 14 | 20° | 55.0 | 72 | 80 | 0.139 |
| | | | | | .787 | .236 | .354 | .555 | 20° | 2.165 | 2.835 | 1160 | |
| | 8 | 1 | 4 | **393.CGP-20 08 72** | 20 | 8 | 11 | 13 | 17° | 55.0 | 72 | 80 | 0.127 |
| | | | | | .787 | .315 | .433 | .547 | 17° | 2.165 | 2.835 | 1160 | |
| | 10 | 1 | 4 | **393.CGP-20 10 72** | 20 | 10 | 13 | 13 | 15° | 55.0 | 72 | 80 | 0.123 |
| | | | | | .787 | .394 | .512 | .535 | 15° | 2.165 | 2.835 | 1160 | |
| | 12 | 1 | 4 | **393.CGP-20 12 72** | 20 | 12 | 15 | 13 | 13° | 55.0 | 72 | 80 | 0.112 |
| | | | | | .787 | .472 | .591 | .520 | 13° | 2.165 | 2.835 | 1160 | |

# Extractor for cylindrical sleeves

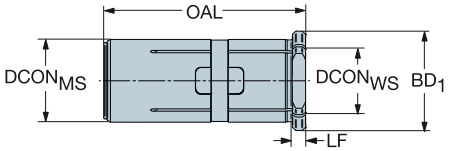


| | For collet size | |
|---|---|---|
| Ordering code | Metric | Inch |
| 5680 061-01 | 12 | 13 (1/2") |
| 5680 061-02 | 16 | 15 (5/8") |
| 5680 061-03 | 20 | 19 (3/4") |
| 5680 061-04 | 25 | 26 (1") |
| 5680 061-05 | 32 | 31 (1 1/4") |

N22 N15

# Collet with mechanical locking interface

393.CLF
A393.CLF




## Metric bore

| Application | Ordering code | Dimensions, mm | | | | | Accessories | |
|---|---|---|---|---|---|---|---|---|
| | | $DCON_{WS}$ | $DCON_{MS}$ | $BD_1$ | LF | OAL | Anchor screw | Assembly tool |
| CoroChuck™ 930 HD32 | 393.CLF-321660 | 16 | 32 | 36 | 4 | 65 | 5519 140-02 | 5680 140-02 |
| | 393.CLF-322060 | 20 | 32 | 36 | 4 | 65 | | |
| | 393.CLF-322560 | 25 | 32 | 36 | 4 | 65 | | |
| CoroChuck™ 930 HD/S25 | 393.CLF-251256 | 12 | 25 | 30 | 4 | 61 | 5519 140-02 | 5680 140-02 |
| | 393.CLF-251656 | 16 | 25 | 30 | 4 | 61 | | |
| | 393.CLF-252056 | 20 | 25 | 30 | 4 | 61 | | |
| CoroChuck™ 930 HD/S20 | 393.CLF-201052 | 10 | 20 | 25 | 4 | 55 | 5519 140-01 | 5680 140-01 |
| | 393.CLF-201252 | 12 | 20 | 25 | 4 | 55 | | |
| | 393.CLF-201652 | 16 | 20 | 25 | 4 | 55 | | |

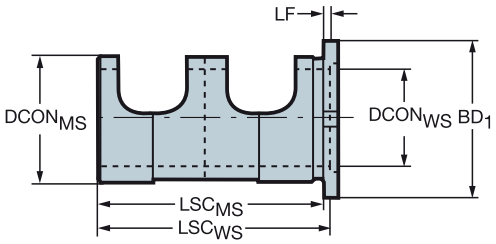
## Inch bore

| Application | Ordering code | Dimensions, inch | | | | | Accessories | |
|---|---|---|---|---|---|---|---|---|
| | | $DCON_{WS}$ | $DCON_{MS}$ | $BD_1$ | LF | OAL | Anchor screw | Assembly tool |
| CoroChuck™ 930 HD32 | A393.CLF-321060 | 5/8 | 1.260 | 1.417 | .157 | 2.559 | 5519 140-02 | 5680 140-02 |
| | A393.CLF-321260 | 3/4 | 1.260 | 1.417 | .157 | 2.559 | | |
| | A393.CLF-321660 | 1 | 1.260 | 1.417 | .157 | 2.559 | | |
| CoroChuck™ 930 HD/S25 | A393.CLF-250856 | 1/2 | .984 | 1.181 | .157 | 2.401 | 5519 140-02 | 5680 140-02 |
| | A393.CLF-251056 | 5/8 | .984 | 1.181 | .157 | 2.401 | | |
| | A393.CLF-251256 | 3/4 | .984 | 1.181 | .157 | 2.401 | | |
| CoroChuck™ 930 HD/S20 | A393.CLF-200652 | 3/8 | .787 | .984 | .157 | 2.165 | 5519 140-01 | 5680 140-01 |
| | A393.CLF-200852 | 1/2 | .787 | .984 | .157 | 2.165 | | |
| | A393.CLF-201052 | 5/8 | .787 | .984 | .157 | 2.165 | | |

Anchor screw and assembly tool to be ordered separately.
For assembly instructions, see www.sandvik.coromant.com/corochuck930/instructions

# Eccentric sleeve for metric drills

**For CoroDrill® 880**




## Metric version

| CZC$_{MS}$ | CZC$_{WS}$ | ADJLN | ADJLX | Ordering code | Dimensions, mm DCON$_{MS}$ | DCON$_{WS}$ | BD | H | LB | LSC | OAL | LF | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 25 | 20 | -0.30 | 0.30 | **416.2-L20-25** | 25 | 20 | 33 | 23 | 5 | 56.0 | 60 | 2 | 0.084 |
| 32 | 25 | -0.30 | 0.30 | **416.2-L25-32** | 32 | 25 | 40 | 30 | 5 | 60.0 | 65 | 3 | 0.153 |
| 40 | 32 | -0.30 | 0.30 | **416.2-L32-40** | 40 | 32 | 50 | 38 | 5 | 70.0 | 75 | 2 | 0.238 |
| 50 | 40 | -0.30 | 0.30 | **416.2-L40-50** | 50 | 40 | 60 | 47 | 5 | 80.0 | 85 | 2 | 0.419 |

## Inch version

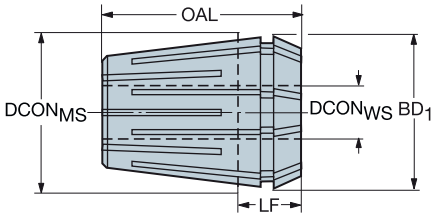
| CZC$_{MS}$ | CZC$_{WS}$ | ADJLN | ADJLX | CNSC | CXSC | Ordering code | Dimensions, inch DCON$_{MS}$ | DCON$_{WS}$ | BD | H | LB | LSC | OAL | LF | PSI | LBS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1 | 3/4 | -.012 | .012 | 1 | 1 | **A416.2-LX19-25** | 1.000 | .750 | 1.299 | .921 | .197 | 2.205 | 2.362 | .098 | 1160 | .220 |
| 1 1/4 | 1 | -.012 | .012 | 1 | 1 | **A416.2-LX25-32** | 1.250 | 1.000 | 1.575 | 1.173 | .197 | 2.362 | 2.559 | .098 | 1160 | .331 |
| 1 1/2 | 1 1/4 | -.012 | .012 | 1 | 1 | **A416.2-LX31-38** | 1.500 | 1.250 | 1.969 | 1.421 | .197 | 2.756 | 2.953 | .138 | 1160 | .434 |
| 2 | 1 1/2 | -.012 | .012 | 1 | 1 | **A416.2-LX38-51** | 2.000 | 1.500 | 2.362 | 1.913 | .197 | 3.150 | 3.346 | .098 | 1160 | 1.129 |

N22 N15

# ER collet

**Metallic sealed for coolant through tool**

**Compatible with DIN 6499-B**




**Metric bore**

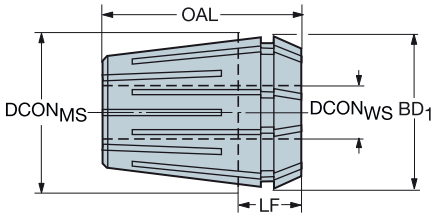
| | | | | | Dimensions, mm, inch | | | | | | | | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | $DCONN_{WS}$ | $DCONX_{WS}$ | BD | LSC | OAL | LF | | |
| ER16 | 3 (h9) | 1 | 1 | **393.15-16 03** | 17 | 3 | | | 17 | 27.5 | 27 | 10 | 300 | 0.026 |
| | | | | | *.669* | *.118* | | | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 4 (h9) | 1 | 1 | **393.15-16 04** | 17 | 4 | | | 17 | 27.5 | 27 | 10 | 300 | 0.025 |
| | | | | | *.669* | *.157* | | | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 5.0 - 4.5 | 1 | 1 | **393.15-16 05** | 17 | | 4.5 | 5.0 | 17 | 27.5 | 27 | 10 | 300 | 0.026 |
| | | | | | *.669* | | *.177* | *.197* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 6.0 - 5.5 | 1 | 1 | **393.15-16 06** | 17 | | 5.5 | 6.0 | 17 | 27.5 | 27 | 10 | 300 | 0.024 |
| | | | | | *.669* | | *.217* | *.236* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 8.0 - 7.5 | 1 | 1 | **393.15-16 08** | 17 | | 7.5 | 8.0 | 17 | 27.5 | 27 | 10 | 300 | 0.021 |
| | | | | | *.669* | | *.295* | *.315* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 10.0 - 9.5 | 1 | 1 | **393.15-16 10** | 17 | | 9.5 | 10.0 | 17 | 27.5 | 27 | 10 | 300 | 0.017 |
| | | | | | *.669* | | *.374* | *.394* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| ER20 | 3 (h9) | 1 | 1 | **393.15-20 03** | 21 | 3 | | | 21 | 31.5 | 31 | 11 | 300 | 0.047 |
| | | | | | *.827* | *.118* | | | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 4 (h9) | 1 | 1 | **393.15-20 04** | 21 | 4 | | | 21 | 31.5 | 31 | 11 | 300 | 0.046 |
| | | | | | *.827* | *.157* | | | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 5 (h9) | 1 | 1 | **393.15-20 05** | 21 | 5 | | | 21 | 31.5 | 31 | 11 | 300 | 0.045 |
| | | | | | *.827* | *.197* | | | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 6 (h9) | 1 | 1 | **393.15-20 06** | 21 | 6 | | | 21 | 31.5 | 31 | 11 | 300 | 0.044 |
| | | | | | *.827* | *.236* | | | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 8.0 - 7.5 | 1 | 1 | **393.15-20 08** | 21 | | 7.5 | 8.0 | 21 | 31.5 | 31 | 11 | 300 | 0.041 |
| | | | | | *.827* | | *.295* | *.315* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 10.0 - 9.5 | 1 | 1 | **393.15-20 10** | 21 | | 9.5 | 10.0 | 21 | 31.5 | 31 | 11 | 300 | 0.036 |
| | | | | | *.827* | | *.374* | *.394* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 12.0 - 11.5 | 1 | 1 | **393.15-20 12** | 21 | | 11.5 | 12.0 | 21 | 31.5 | 31 | 11 | 300 | 0.030 |
| | | | | | *.827* | | *.453* | *.472* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| ER25 | 6 (h9) | 1 | 1 | **393.15-25 06** | 26 | 6 | | | 26 | 34.0 | 34 | 11 | 300 | 0.080 |
| | | | | | *1.024* | *.236* | | | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 8.0 - 7.5 | 1 | 1 | **393.15-25 08** | 26 | | 7.5 | 8.0 | 26 | 34.0 | 34 | 11 | 300 | 0.078 |
| | | | | | *1.024* | | *.295* | *.315* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 10.0 - 9.5 | 1 | 1 | **393.15-25 10** | 26 | | 9.5 | 10.0 | 26 | 34.0 | 34 | 11 | 300 | 0.074 |
| | | | | | *1.024* | | *.374* | *.394* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 12.0 - 11.5 | 1 | 1 | **393.15-25 12** | 26 | | 11.5 | 12.0 | 26 | 34.0 | 34 | 11 | 300 | 0.066 |
| | | | | | *1.024* | | *.453* | *.472* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 14.0 - 13.5 | 1 | 1 | **393.15-25 14** | 26 | | 13.5 | 14.0 | 26 | 34.0 | 34 | 11 | 300 | 0.060 |
| | | | | | *1.024* | | *.531* | *.551* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 16.0 - 15.5 | 1 | 1 | **393.15-25 16** | 26 | | 15.5 | 16.0 | 26 | 34.0 | 34 | 11 | 300 | 0.049 |
| | | | | | *1.024* | | *.610* | *.630* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| ER32 | 6 (h9) | 1 | 1 | **393.15-32 06** | 33 | 6 | | | 33 | 40.0 | 40 | 12 | 300 | 0.163 |
| | | | | | *1.299* | *.236* | | | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 8.0 - 7.5 | 1 | 1 | **393.15-32 08** | 33 | | 7.5 | 8.0 | 33 | 40.0 | 40 | 12 | 300 | 0.167 |
| | | | | | *1.299* | | *.295* | *.315* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 10.0 - 9.5 | 1 | 1 | **393.15-32 10** | 33 | | 9.5 | 10.0 | 33 | 40.0 | 40 | 12 | 300 | 0.158 |
| | | | | | *1.299* | | *.374* | *.394* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 12.0 - 11.5 | 1 | 1 | **393.15-32 12** | 33 | | 11.5 | 12.0 | 33 | 40.0 | 40 | 12 | 300 | 0.100 |
| | | | | | *1.299* | | *.453* | *.472* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 14.0 - 13.5 | 1 | 1 | **393.15-32 14** | 33 | | 13.5 | 14.0 | 33 | 40.0 | 40 | 12 | 300 | 0.135 |
| | | | | | *1.299* | | *.531* | *.551* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 16.0 - 15.5 | 1 | 1 | **393.15-32 16** | 33 | | 15.5 | 16.0 | 33 | 40.0 | 40 | 12 | 300 | 0.124 |
| | | | | | *1.299* | | *.610* | *.630* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 18.0 - 17.5 | 1 | 1 | **393.15-32 18** | 33 | | 17.5 | 18.0 | 33 | 40.0 | 40 | 12 | 300 | 0.112 |
| | | | | | *1.299* | | *.689* | *.709* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 20.0 - 19.5 | 1 | 1 | **393.15-32 20** | 33 | | 19.5 | 20.0 | 33 | 40.0 | 40 | 12 | 300 | 0.098 |
| | | | | | *1.299* | | *.768* | *.787* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |

N22 N15

# ER collet

**Metallic sealed for coolant through tool**

**Compatible with DIN 6499-B**




**Metric bore**

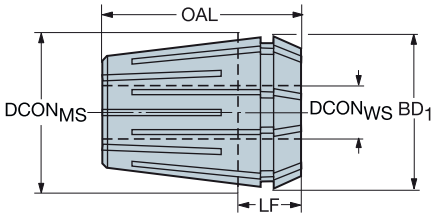
| | | | | | Dimensions, mm, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | $DCONN_{WS}$ | $DCONX_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| ER40 | 6 (h9) | 1 | 1 | **393.15-40 06** | 41 | 6 | | | 41 | 46.0 | 46 | 14 | 300 | 0.291 |
| | | | | | *1.614* | *.236* | | | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 8 (h9) | 1 | 1 | **393.15-40 08** | 41 | 8 | | | 41 | 46.0 | 46 | 14 | 300 | 0.289 |
| | | | | | *1.614* | *.315* | | | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 10.0 - 9.5 | 1 | 1 | **393.15-40 10** | 41 | | 9.5 | 10.0 | 41 | 46.0 | 46 | 14 | 300 | 0.293 |
| | | | | | *1.614* | | *.374* | *.394* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 12.0 - 11.5 | 1 | 1 | **393.15-40 12** | 41 | | 11.5 | 12.0 | 41 | 46.0 | 46 | 14 | 300 | 0.286 |
| | | | | | *1.614* | | *.453* | *.472* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 14.0 - 13.5 | 1 | 1 | **393.15-40 14** | 41 | | 13.5 | 14.0 | 41 | 46.0 | 46 | 14 | 300 | 0.276 |
| | | | | | *1.614* | | *.531* | *.551* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 16.0 - 15.5 | 1 | 1 | **393.15-40 16** | 41 | | 15.5 | 16.0 | 41 | 46.0 | 46 | 14 | 300 | 0.265 |
| | | | | | *1.614* | | *.610* | *.630* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 18.0 - 17.5 | 1 | 1 | **393.15-40 18** | 41 | | 17.5 | 18.0 | 41 | 46.0 | 46 | 14 | 300 | 0.250 |
| | | | | | *1.614* | | *.689* | *.709* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 20.0 - 19.5 | 1 | 1 | **393.15-40 20** | 41 | | 19.5 | 20.0 | 41 | 46.0 | 46 | 14 | 300 | 0.232 |
| | | | | | *1.614* | | *.768* | *.787* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 25.0 - 24.5 | 1 | 1 | **393.15-40 25** | 41 | | 24.5 | 25.0 | 41 | 46.0 | 46 | 14 | 300 | 0.181 |
| | | | | | *1.614* | | *.965* | *.984* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |

N22 N15

# ER collet

**Metallic sealed for coolant through tool**

**Compatible with DIN 6499-B**




**Inch bore**

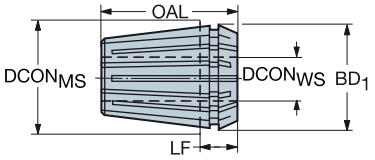
| | | | | | Dimensions, inch | | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | $DCONN_{WS}$ | $DCONX_{WS}$ | BD | LSC | OAL | LF | PSI | LBS |
| ER16 | 1/8 (h9) | 1 | 1 | **A393.15-16 1/8** | .669 | .250 | | | .669 | 1.083 | 1.083 | .404 | 1160 | .055 |
| | 5/32 (h9) | 1 | 1 | **A393.15-16 5/32** | .669 | .156 | | | .669 | 1.083 | 1.083 | .404 | 1160 | .055 |
| | 3/16 (h9) | 1 | 1 | **A393.15-16 3/16** | .669 | .188 | | | .669 | 1.083 | 1.083 | .404 | 1160 | .053 |
| | .2500 - .2303 | 1 | 1 | **A393.15-16 1/4** | .669 | | .230 | .250 | .669 | 1.083 | 1.083 | .404 | 4351 | .052 |
| | .3125 - .2929 | 1 | 1 | **A393.15-16 5/16** | .669 | | .293 | .313 | .669 | 1.083 | 1.083 | .404 | 4351 | .047 |
| | .3750 - .3556 | 1 | 1 | **A393.15-16 3/8** | .669 | | .356 | .375 | .669 | 1.083 | 1.083 | .404 | 4351 | .040 |
| ER20 | 1/8 (h9) | 1 | 1 | **A393.15-20 1/8** | .827 | .250 | | | .827 | 1.240 | 1.240 | .439 | 1160 | .104 |
| | 5/32 (h9) | 1 | 1 | **A393.15-20 5/32** | .827 | .156 | | | .827 | 1.240 | 1.240 | .439 | 1160 | .101 |
| | 3/16 (h9) | 1 | 1 | **A393.15-20 3/16** | .827 | .188 | | | .827 | 1.240 | 1.240 | .439 | 1160 | .099 |
| | 1/4 (h9) | 1 | 1 | **A393.15-20 1/4** | .827 | .250 | | | .827 | 1.240 | 1.240 | .439 | 4351 | .097 |
| | .3125 - .2929 | 1 | 1 | **A393.15-20 5/16** | .827 | | .293 | .313 | .827 | 1.240 | 1.240 | .439 | 4351 | .090 |
| | .3750 - .3556 | 1 | 1 | **A393.15-20 3/8** | .827 | | .356 | .375 | .827 | 1.240 | 1.240 | .439 | 4351 | .082 |
| | .5000 - .4803 | 1 | 1 | **A393.15-20 1/2** | .827 | | .480 | .500 | .827 | 1.240 | 1.240 | .439 | 4351 | .060 |
| ER25 | 1/4 (h9) | 1 | 1 | **A393.15-25 1/4** | 1.024 | .250 | | | 1.024 | 1.339 | 1.339 | .459 | 4351 | .176 |
| | .3125 - .2929 | 1 | 1 | **A393.15-25 5/16** | 1.024 | | .293 | .313 | 1.024 | 1.339 | 1.339 | .459 | 4351 | .176 |
| | .3750 - .3556 | 1 | 1 | **A393.15-25 3/8** | 1.024 | | .356 | .375 | 1.024 | 1.339 | 1.339 | .459 | 4351 | .165 |
| | .5000 - .4803 | 1 | 1 | **A393.15-25 1/2** | 1.024 | | .480 | .500 | 1.024 | 1.339 | 1.339 | .459 | 4351 | .146 |
| | .6250 - .6055 | 1 | 1 | **A393.15-25 5/8** | 1.024 | | .606 | .625 | 1.024 | 1.339 | 1.339 | .459 | 4351 | .109 |
| ER32 | 1/4 (h9) | 1 | 1 | **A393.15-32 1/4** | 1.299 | .250 | | | 1.299 | 1.575 | 1.575 | .498 | 4351 | .357 |
| | .3125 - .2929 | 1 | 1 | **A393.15-32 5/16** | 1.299 | | .293 | .313 | 1.299 | 1.575 | 1.575 | .498 | 4351 | .364 |
| | .3750 - .3556 | 1 | 1 | **A393.15-32 3/8** | 1.299 | | .356 | .375 | 1.299 | 1.575 | 1.575 | .498 | 4351 | .354 |
| | .5000 - .4803 | 1 | 1 | **A393.15-32 1/2** | 1.299 | | .480 | .500 | 1.299 | 1.575 | 1.575 | .498 | 4351 | .311 |
| | .6250 - .6055 | 1 | 1 | **A393.15-32 5/8** | 1.299 | | .606 | .625 | 1.299 | 1.575 | 1.575 | .498 | 4351 | .278 |
| | .7500 - .7303 | 1 | 1 | **A393.15-32 3/4** | 1.299 | | .730 | .750 | 1.299 | 1.575 | 1.575 | .498 | 4351 | .232 |
| ER40 | 1/4 (h9) | 1 | 1 | **A393.15-40 1/4** | 1.614 | .250 | | | 1.614 | 1.811 | 1.811 | .577 | 4351 | .642 |
| | 5/16 (h9) | 1 | 1 | **A393.15-40 5/16** | 1.614 | .313 | | | 1.614 | 1.811 | 1.811 | .577 | 4351 | .635 |
| | .3750 - .3556 | 1 | 1 | **A393.15-40 3/8** | 1.614 | | .356 | .375 | 1.614 | 1.811 | 1.811 | .577 | 4351 | .648 |
| | .5000 - .4803 | 1 | 1 | **A393.15-40 1/2** | 1.614 | | .480 | .500 | 1.614 | 1.811 | 1.811 | .577 | 4351 | .062 |
| | .6250 - .6055 | 1 | 1 | **A393.15-40 5/8** | 1.614 | | .606 | .625 | 1.614 | 1.811 | 1.811 | .577 | 4351 | .582 |
| | .7500 - .7303 | 1 | 1 | **A393.15-40 3/4** | 1.614 | | .730 | .750 | 1.614 | 1.811 | 1.811 | .577 | 4351 | .531 |
| | 1.0000 - .9646 | 1 | 1 | **A393.15-40 1** | 1.614 | | .965 | 1.000 | 1.614 | 1.811 | 1.811 | .577 | 4351 | .387 |

N22 N15

# ER collet

**Coolant through collet**

**Compatible with DIN 6499-B**



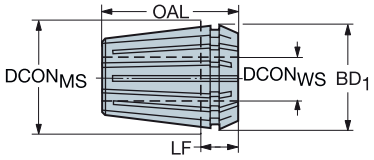

| | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCONN_{WS}$ | $DCONX_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| ER8 | 3.00 - 2.50 | 1 | 4 | **393.14-08 0300** | 8 | 2.5 | 3.0 | 8 | 13.6 | 13 | 4 | 300 | 0.005 |
| | | | | | *.335* | *.098* | *.118* | *.335* | *.535* | *.535* | *.179* | *4351* | |
| | 3.50 - 3.00 | 1 | 4 | **393.14-08 0350** | 8 | 3.0 | 3.5 | 8 | 13.6 | 13 | 4 | 300 | 0.005 |
| | | | | | *.335* | *.118* | *.138* | *.335* | *.535* | *.535* | *.179* | *4351* | |
| | 4.00 - 3.50 | 1 | 4 | **393.14-08 0400** | 8 | 3.5 | 4.0 | 8 | 13.6 | 13 | 4 | 300 | 0.005 |
| | | | | | *.335* | *.138* | *.157* | *.335* | *.535* | *.535* | *.179* | *4351* | |
| ER11 | 1.00 - 0.75 | 1 | 4 | **393.14-11 0100** | 11 | 0.8 | 1.0 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.030* | *.039* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 1.25 - 1.00 | 1 | 4 | **393.14-11 0125** | 11 | 1.0 | 1.3 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.039* | *.049* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 1.50 - 1.25 | 1 | 4 | **393.14-11 0150** | 11 | 1.3 | 1.5 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.049* | *.059* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 1.75 - 1.50 | 1 | 4 | **393.14-11 0175** | 11 | 1.5 | 1.8 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.059* | *.069* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 2.00 - 1.75 | 1 | 4 | **393.14-11 0200** | 11 | 1.8 | 2.0 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.069* | *.079* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 2.25 - 2.00 | 1 | 4 | **393.14-11 0225** | 11 | 2.0 | 2.3 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.079* | *.089* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 2.50 - 2.25 | 1 | 4 | **393.14-11 0250** | 11 | 2.3 | 2.5 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.089* | *.098* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 3.00 - 2.50 | 1 | 4 | **393.14-11 0300** | 11 | 2.5 | 3.0 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.098* | *.118* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 3.50 - 3.00 | 1 | 4 | **393.14-11 0350** | 11 | 3.0 | 3.5 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.118* | *.138* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 4.00 - 3.50 | 1 | 4 | **393.14-11 0400** | 11 | 3.5 | 4.0 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.138* | *.157* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 4.50 - 4.00 | 1 | 4 | **393.14-11 0450** | 11 | 4.0 | 4.5 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.157* | *.177* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 5.00 - 4.50 | 1 | 4 | **393.14-11 0500** | 11 | 4.5 | 5.0 | 11 | 18.0 | 18 | 6 | 300 | 0.009 |
| | | | | | *.449* | *.177* | *.197* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 5.50 - 5.00 | 1 | 4 | **393.14-11 0550** | 11 | 5.0 | 5.5 | 11 | 18.0 | 18 | 6 | 300 | 0.008 |
| | | | | | *.449* | *.197* | *.217* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 6.00 - 5.50 | 1 | 4 | **393.14-11 0600** | 11 | 5.5 | 6.0 | 11 | 18.0 | 18 | 6 | 300 | 0.007 |
| | | | | | *.449* | *.217* | *.236* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 6.50 - 6.00 | 1 | 4 | **393.14-11 0650** | 11 | 6.0 | 6.5 | 11 | 18.0 | 18 | 6 | 300 | 0.007 |
| | | | | | *.449* | *.236* | *.256* | *.449* | *.709* | *.709* | *.248* | *4351* | |
| | 7.00 - 6.50 | 1 | 4 | **393.14-11 0700** | 11 | 6.5 | 7.0 | 11 | 18.0 | 18 | 6 | 300 | 0.006 |
| | | | | | *.449* | *.256* | *.276* | *.449* | *.709* | *.709* | *.248* | *4351* | |

N22 N15

# ER collet

**Coolant through collet**

**Compatible with DIN 6499-B**



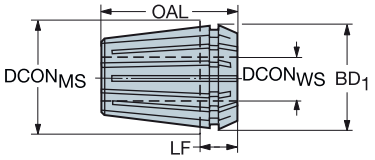

| | | | | | Dimensions, mm, inch | | | | | | | BAR PSI | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCONN_{WS}$ | $DCONX_{WS}$ | BD | LSC | OAL | LF | | |
| ER16 | 1.0 - 0.5 | 1 | 4 | **393.14-16 0100** | 17 | 0.5 | 1.0 | 17 | 27.5 | 27 | 10 | 300 | 0.027 |
| | | | | | *.669* | *.020* | *.039* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 1.5 - 1.0 | 1 | 4 | **393.14-16 0150** | 17 | 1.0 | 1.5 | 17 | 27.5 | 27 | 10 | 300 | 0.027 |
| | | | | | *.669* | *.039* | *.059* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 2.0 - 1.0 | 1 | 4 | **393.14-16 0200** | 17 | 1.0 | 2.0 | 17 | 27.5 | 27 | 10 | 300 | 0.027 |
| | | | | | *.669* | *.039* | *.079* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 2.5 - 1.5 | 1 | 4 | **393.14-16 0250** | 17 | 1.5 | 2.5 | 17 | 27.5 | 27 | 10 | 300 | 0.027 |
| | | | | | *.669* | *.059* | *.098* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 3.0 - 2.0 | 1 | 4 | **393.14-16 0300** | 17 | 2.0 | 3.0 | 17 | 27.5 | 27 | 10 | 300 | 0.024 |
| | | | | | *.669* | *.079* | *.118* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 4.0 - 3.0 | 1 | 4 | **393.14-16 0400** | 17 | 3.0 | 4.0 | 17 | 27.5 | 27 | 10 | 300 | 0.003 |
| | | | | | *.669* | *.118* | *.157* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 5.0 - 4.0 | 1 | 4 | **393.14-16 0500** | 17 | 4.0 | 5.0 | 17 | 27.5 | 27 | 10 | 300 | 0.025 |
| | | | | | *.669* | *.157* | *.197* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 6.0 - 5.0 | 1 | 4 | **393.14-16 0600** | 17 | 5.0 | 6.0 | 17 | 27.5 | 27 | 10 | 300 | 0.023 |
| | | | | | *.669* | *.197* | *.236* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 7.0 - 6.0 | 1 | 4 | **393.14-16 0700** | 17 | 6.0 | 7.0 | 17 | 27.5 | 27 | 10 | 300 | 0.021 |
| | | | | | *.669* | *.236* | *.276* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 8.0 - 7.0 | 1 | 4 | **393.14-16 0800** | 17 | 7.0 | 8.0 | 17 | 27.5 | 27 | 10 | 300 | 0.020 |
| | | | | | *.669* | *.276* | *.315* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 9.0 - 8.0 | 1 | 4 | **393.14-16 0900** | 17 | 8.0 | 9.0 | 17 | 27.5 | 27 | 10 | 300 | 0.018 |
| | | | | | *.669* | *.315* | *.354* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| | 10.0 - 9.0 | 1 | 4 | **393.14-16 1000** | 17 | 9.0 | 10.0 | 17 | 27.5 | 27 | 10 | 300 | 0.016 |
| | | | | | *.669* | *.354* | *.394* | *.669* | *1.083* | *1.083* | *.404* | *4351* | |
| ER20 | 1.5 - 1.0 | 1 | 4 | **393.14-20 015** | 21 | 1.0 | 1.5 | 21 | 31.5 | 31 | 11 | 300 | 0.047 |
| | | | | | *.827* | *.039* | *.059* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 2.0 - 1.5 | 1 | 4 | **393.14-20 020** | 21 | 1.5 | 2.0 | 21 | 31.5 | 31 | 11 | 300 | 0.049 |
| | | | | | *.827* | *.059* | *.079* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 2.5 - 2.0 | 1 | 4 | **393.14-20 025** | 21 | 2.0 | 2.5 | 21 | 31.5 | 31 | 11 | 300 | 0.048 |
| | | | | | *.827* | *.079* | *.098* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 3.0 - 2.5 | 1 | 4 | **393.14-20 030** | 21 | 2.5 | 3.0 | 21 | 31.5 | 31 | 11 | 300 | 0.046 |
| | | | | | *.827* | *.098* | *.118* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 4.0 - 3.0 | 1 | 4 | **393.14-20 040** | 21 | 3.0 | 4.0 | 21 | 31.5 | 31 | 11 | 300 | 0.045 |
| | | | | | *.827* | *.118* | *.157* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 5.0 - 4.0 | 1 | 4 | **393.14-20 050** | 21 | 4.0 | 5.0 | 21 | 31.5 | 31 | 11 | 300 | 0.044 |
| | | | | | *.827* | *.157* | *.197* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 6.0 - 5.0 | 1 | 4 | **393.14-20 060** | 21 | 5.0 | 6.0 | 21 | 31.5 | 31 | 11 | 300 | 0.043 |
| | | | | | *.827* | *.197* | *.236* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 7.0 - 6.0 | 1 | 4 | **393.14-20 070** | 21 | 6.0 | 7.0 | 21 | 31.5 | 31 | 11 | 300 | 0.041 |
| | | | | | *.827* | *.236* | *.276* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 8.0 - 7.0 | 1 | 4 | **393.14-20 080** | 21 | 7.0 | 8.0 | 21 | 31.5 | 31 | 11 | 300 | 0.037 |
| | | | | | *.827* | *.276* | *.315* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 9.0 - 8.0 | 1 | 4 | **393.14-20 090** | 21 | 8.0 | 9.0 | 21 | 31.5 | 31 | 11 | 300 | 0.037 |
| | | | | | *.827* | *.315* | *.354* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 10.0 - 9.0 | 1 | 4 | **393.14-20 100** | 21 | 9.0 | 10.0 | 21 | 31.5 | 31 | 11 | 300 | 0.034 |
| | | | | | *.827* | *.354* | *.394* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 11.0 - 10.0 | 1 | 4 | **393.14-20 110** | 21 | 10.0 | 11.0 | 21 | 31.5 | 31 | 11 | 300 | 0.033 |
| | | | | | *.827* | *.394* | *.433* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 12.0 - 11.0 | 1 | 4 | **393.14-20 120** | 21 | 11.0 | 12.0 | 21 | 31.5 | 31 | 11 | 300 | 0.031 |
| | | | | | *.827* | *.433* | *.472* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |
| | 13.0 - 12.0 | 1 | 4 | **393.14-20 130** | 21 | 12.0 | 13.0 | 21 | 31.5 | 31 | 11 | 300 | 0.026 |
| | | | | | *.827* | *.472* | *.512* | *.827* | *1.240* | *1.240* | *.439* | *4351* | |

N22 N15

# ER collet

**Coolant through collet**

**Compatible with DIN 6499-B**




| | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCONN_{WS}$ | $DCONX_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| ER25 | 2.0 - 1.5 | 1 | 4 | 393.14-25 020 | 26 | 1.5 | 2.0 | 26 | 34.0 | 34 | 11 | 300 | 0.079 |
| | | | | | *1.024* | *.059* | *.079* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 2.5 - 2.0 | 1 | 4 | 393.14-25 025 | 26 | 2.0 | 2.5 | 26 | 34.0 | 34 | 11 | 300 | 0.079 |
| | | | | | *1.024* | *.079* | *.098* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 3.0 - 2.5 | 1 | 4 | 393.14-25 030 | 26 | 2.5 | 3.0 | 26 | 34.0 | 34 | 11 | 300 | 0.078 |
| | | | | | *1.024* | *.098* | *.118* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 4.0 - 3.0 | 1 | 4 | 393.14-25 040 | 26 | 3.0 | 4.0 | 26 | 34.0 | 34 | 11 | 300 | 0.079 |
| | | | | | *1.024* | *.118* | *.157* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 5.0 - 4.0 | 1 | 4 | 393.14-25 050 | 26 | 4.0 | 5.0 | 26 | 34.0 | 34 | 11 | 300 | 0.078 |
| | | | | | *1.024* | *.157* | *.197* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 6.0 - 5.0 | 1 | 4 | 393.14-25 060 | 26 | 5.0 | 6.0 | 26 | 34.0 | 34 | 11 | 300 | 0.076 |
| | | | | | *1.024* | *.197* | *.236* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 7.0 - 6.0 | 1 | 4 | 393.14-25 070 | 26 | 6.0 | 7.0 | 26 | 34.0 | 34 | 11 | 300 | 0.076 |
| | | | | | *1.024* | *.236* | *.276* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 8.0 - 7.0 | 1 | 4 | 393.14-25 080 | 26 | 7.0 | 8.0 | 26 | 34.0 | 34 | 11 | 300 | 0.073 |
| | | | | | *1.024* | *.276* | *.315* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 9.0 - 8.0 | 1 | 4 | 393.14-25 090 | 26 | 8.0 | 9.0 | 26 | 34.0 | 34 | 11 | 300 | 0.078 |
| | | | | | *1.024* | *.315* | *.354* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 10.0 - 9.0 | 1 | 4 | 393.14-25 100 | 26 | 9.0 | 10.0 | 26 | 34.0 | 34 | 11 | 300 | 0.070 |
| | | | | | *1.024* | *.354* | *.394* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 11.0 - 10.0 | 1 | 4 | 393.14-25 110 | 26 | 10.0 | 11.0 | 26 | 34.0 | 34 | 11 | 300 | 0.067 |
| | | | | | *1.024* | *.394* | *.433* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 12.0 - 11.0 | 1 | 4 | 393.14-25 120 | 26 | 11.0 | 12.0 | 26 | 34.0 | 34 | 11 | 300 | 0.064 |
| | | | | | *1.024* | *.433* | *.472* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 13.0 - 12.0 | 1 | 4 | 393.14-25 130 | 26 | 12.0 | 13.0 | 26 | 34.0 | 34 | 11 | 300 | 0.063 |
| | | | | | *1.024* | *.472* | *.512* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 14.0 - 13.0 | 1 | 4 | 393.14-25 140 | 26 | 13.0 | 14.0 | 26 | 34.0 | 34 | 11 | 300 | 0.057 |
| | | | | | *1.024* | *.512* | *.551* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 15.0 - 14.0 | 1 | 4 | 393.14-25 150 | 26 | 14.0 | 15.0 | 26 | 34.0 | 34 | 11 | 300 | 0.054 |
| | | | | | *1.024* | *.551* | *.591* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| | 16.0 - 15.0 | 1 | 4 | 393.14-25 160 | 26 | 15.0 | 16.0 | 26 | 34.0 | 34 | 11 | 300 | 0.047 |
| | | | | | *1.024* | *.591* | *.630* | *1.024* | *1.339* | *1.339* | *.459* | *4351* | |
| ER32 | 2.5 - 2.0 | 1 | 4 | 393.14-32 025 | 33 | 2.0 | 2.5 | 33 | 40.0 | 40 | 12 | 300 | 0.155 |
| | | | | | *1.299* | *.079* | *.098* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 3.0 - 2.5 | 1 | 4 | 393.14-32 030 | 33 | 2.5 | 3.0 | 33 | 40.0 | 40 | 12 | 300 | 0.161 |
| | | | | | *1.299* | *.098* | *.118* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 4.0 - 3.0 | 1 | 4 | 393.14-32 040 | 33 | 3.0 | 4.0 | 33 | 40.0 | 40 | 12 | 300 | 0.154 |
| | | | | | *1.299* | *.118* | *.157* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 5.0 - 4.0 | 1 | 4 | 393.14-32 050 | 33 | 4.0 | 5.0 | 33 | 40.0 | 40 | 12 | 300 | 0.151 |
| | | | | | *1.299* | *.157* | *.197* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 6.0 - 5.0 | 1 | 4 | 393.14-32 060 | 33 | 5.0 | 6.0 | 33 | 40.0 | 40 | 12 | 300 | 0.157 |
| | | | | | *1.299* | *.197* | *.236* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 7.0 - 6.0 | 1 | 4 | 393.14-32 070 | 33 | 6.0 | 7.0 | 33 | 40.0 | 40 | 12 | 300 | 0.152 |
| | | | | | *1.299* | *.236* | *.276* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 8.0 - 7.0 | 1 | 4 | 393.14-32 080 | 33 | 7.0 | 8.0 | 33 | 40.0 | 40 | 12 | 300 | 0.158 |
| | | | | | *1.299* | *.276* | *.315* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 9.0 - 8.0 | 1 | 4 | 393.14-32 090 | 33 | 8.0 | 9.0 | 33 | 40.0 | 40 | 12 | 300 | 0.157 |
| | | | | | *1.299* | *.315* | *.354* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 10.0 - 9.0 | 1 | 4 | 393.14-32 100 | 33 | 9.0 | 10.0 | 33 | 40.0 | 40 | 12 | 300 | 0.144 |
| | | | | | *1.299* | *.354* | *.394* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 11.0 - 10.0 | 1 | 4 | 393.14-32 110 | 33 | 10.0 | 11.0 | 33 | 40.0 | 40 | 12 | 300 | 0.151 |
| | | | | | *1.299* | *.394* | *.433* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 12.0 - 11.0 | 1 | 4 | 393.14-32 120 | 33 | 11.0 | 12.0 | 33 | 40.0 | 40 | 12 | 300 | 0.147 |
| | | | | | *1.299* | *.433* | *.472* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 13.0 - 12.0 | 1 | 4 | 393.14-32 130 | 33 | 12.0 | 13.0 | 33 | 40.0 | 40 | 12 | 300 | 0.135 |
| | | | | | *1.299* | *.472* | *.512* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 14.0 - 13.0 | 1 | 4 | 393.14-32 140 | 33 | 13.0 | 14.0 | 33 | 40.0 | 40 | 12 | 300 | 0.142 |
| | | | | | *1.299* | *.512* | *.551* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |

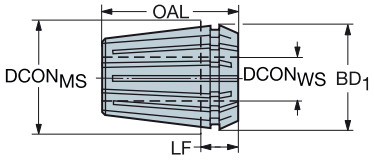
N22

N15

# ER collet

**Coolant through collet**

**Compatible with DIN 6499-B**



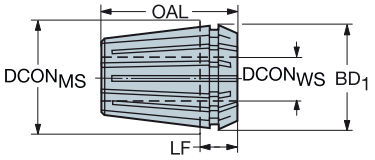

| | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCONN_{WS}$ | $DCONX_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| ER32 | 15.0 - 14.0 | 1 | 4 | 393.14-32 150 | 33 | 14.0 | 15.0 | 33 | 40.0 | 40 | 12 | 300 | 0.124 |
| | | | | | *1.299* | *.551* | *.591* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 16.0 - 15.0 | 1 | 4 | 393.14-32 160 | 33 | 15.0 | 16.0 | 33 | 40.0 | 40 | 12 | 300 | 0.126 |
| | | | | | *1.299* | *.591* | *.630* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 17.0 - 16.0 | 1 | 4 | 393.14-32 170 | 33 | 16.0 | 17.0 | 33 | 40.0 | 40 | 12 | 300 | 0.114 |
| | | | | | *1.299* | *.630* | *.669* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 18.0 - 17.0 | 1 | 4 | 393.14-32 180 | 33 | 17.0 | 18.0 | 33 | 40.0 | 40 | 12 | 300 | 0.108 |
| | | | | | *1.299* | *.669* | *.709* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 19.0 - 18.0 | 1 | 4 | 393.14-32 190 | 33 | 18.0 | 19.0 | 33 | 40.0 | 40 | 12 | 300 | 0.109 |
| | | | | | *1.299* | *.709* | *.748* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| | 20.0 - 19.0 | 1 | 4 | 393.14-32 200 | 33 | 19.0 | 20.0 | 33 | 40.0 | 40 | 12 | 300 | 0.095 |
| | | | | | *1.299* | *.748* | *.787* | *1.299* | *1.575* | *1.575* | *.498* | *4351* | |
| ER40 | 4.0 - 3.0 | 1 | 4 | 393.14-40 040 | 41 | 3.0 | 4.0 | 41 | 46.0 | 46 | 14 | 300 | 0.302 |
| | | | | | *1.614* | *.118* | *.157* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 5.0 - 4.0 | 1 | 4 | 393.14-40 050 | 41 | 4.0 | 5.0 | 41 | 46.0 | 46 | 14 | 300 | 0.316 |
| | | | | | *1.614* | *.157* | *.197* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 6.0 - 5.0 | 1 | 4 | 393.14-40 060 | 41 | 5.0 | 6.0 | 41 | 46.0 | 46 | 14 | 300 | 0.304 |
| | | | | | *1.614* | *.197* | *.236* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 7.0 - 6.0 | 1 | 4 | 393.14-40 070 | 41 | 6.0 | 7.0 | 41 | 46.0 | 46 | 14 | 300 | 0.282 |
| | | | | | *1.614* | *.236* | *.276* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 8.0 - 7.0 | 1 | 4 | 393.14-40 080 | 41 | 7.0 | 8.0 | 41 | 46.0 | 46 | 14 | 300 | 0.305 |
| | | | | | *1.614* | *.276* | *.315* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 9.0 - 8.0 | 1 | 4 | 393.14-40 090 | 41 | 8.0 | 9.0 | 41 | 46.0 | 46 | 14 | 300 | 0.302 |
| | | | | | *1.614* | *.315* | *.354* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 10.0 - 9.0 | 1 | 4 | 393.14-40 100 | 41 | 9.0 | 10.0 | 41 | 46.0 | 46 | 14 | 300 | 0.299 |
| | | | | | *1.614* | *.354* | *.394* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 11.0 - 10.0 | 1 | 4 | 393.14-40 110 | 41 | 10.0 | 11.0 | 41 | 46.0 | 46 | 14 | 300 | 0.295 |
| | | | | | *1.614* | *.394* | *.433* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 12.0 - 11.0 | 1 | 4 | 393.14-40 120 | 41 | 11.0 | 12.0 | 41 | 46.0 | 46 | 14 | 300 | 0.292 |
| | | | | | *1.614* | *.433* | *.472* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 13.0 - 12.0 | 1 | 4 | 393.14-40 130 | 41 | 12.0 | 13.0 | 41 | 46.0 | 46 | 14 | 300 | 0.273 |
| | | | | | *1.614* | *.472* | *.512* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 14.0 - 13.0 | 1 | 4 | 393.14-40 140 | 41 | 13.0 | 14.0 | 41 | 46.0 | 46 | 14 | 300 | 0.281 |
| | | | | | *1.614* | *.512* | *.551* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 15.0 - 14.0 | 1 | 4 | 393.14-40 150 | 41 | 14.0 | 15.0 | 41 | 46.0 | 46 | 14 | 300 | 0.275 |
| | | | | | *1.614* | *.551* | *.591* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 16.0 - 15.0 | 1 | 4 | 393.14-40 160 | 41 | 15.0 | 16.0 | 41 | 46.0 | 46 | 14 | 300 | 0.269 |
| | | | | | *1.614* | *.591* | *.630* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 17.0 - 16.0 | 1 | 4 | 393.14-40 170 | 41 | 16.0 | 17.0 | 41 | 46.0 | 46 | 14 | 300 | 0.261 |
| | | | | | *1.614* | *.630* | *.669* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 18.0 - 17.0 | 1 | 4 | 393.14-40 180 | 41 | 17.0 | 18.0 | 41 | 46.0 | 46 | 14 | 300 | 0.243 |
| | | | | | *1.614* | *.669* | *.709* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 19.0 - 18.0 | 1 | 4 | 393.14-40 190 | 41 | 18.0 | 19.0 | 41 | 46.0 | 46 | 14 | 300 | 0.250 |
| | | | | | *1.614* | *.709* | *.748* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 20.0 - 19.0 | 1 | 4 | 393.14-40 200 | 41 | 19.0 | 20.0 | 41 | 46.0 | 46 | 14 | 300 | 0.228 |
| | | | | | *1.614* | *.748* | *.787* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 21.0 - 20.0 | 1 | 4 | 393.14-40 210 | 41 | 20.0 | 21.0 | 41 | 46.0 | 46 | 14 | 300 | 0.217 |
| | | | | | *1.614* | *.787* | *.827* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 22.0 - 21.0 | 1 | 4 | 393.14-40 220 | 41 | 21.0 | 22.0 | 41 | 46.0 | 46 | 14 | 300 | 0.220 |
| | | | | | *1.614* | *.827* | *.866* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 23.0 - 22.0 | 1 | 4 | 393.14-40 230 | 41 | 22.0 | 23.0 | 41 | 46.0 | 46 | 14 | 300 | 0.210 |
| | | | | | *1.614* | *.866* | *.906* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 24.0 - 23.0 | 1 | 4 | 393.14-40 240 | 41 | 23.0 | 24.0 | 41 | 46.0 | 46 | 14 | 300 | 0.198 |
| | | | | | *1.614* | *.906* | *.945* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 25.0 - 24.0 | 1 | 4 | 393.14-40 250 | 41 | 24.0 | 25.0 | 41 | 46.0 | 46 | 14 | 300 | 0.187 |
| | | | | | *1.614* | *.945* | *.984* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |
| | 26.0 - 25.0 | 1 | 4 | 393.14-40 260 | 41 | 25.0 | 26.0 | 41 | 46.0 | 46 | 14 | 300 | 0.174 |
| | | | | | *1.614* | *.984* | *1.024* | *1.614* | *1.811* | *1.811* | *.577* | *4351* | |

N22 N15

# ER collet

**Coolant through collet**

**Compatible with DIN 6499-B**

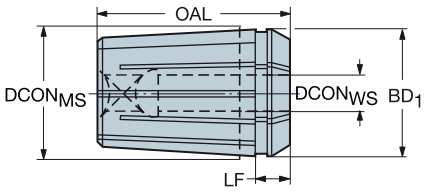



| | | | | | Dimensions, mm, inch | | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCONN_{WS}$ | $DCONX_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| ER50 | 26.0 - 24.0 | 1 | 4 | **393.14-50 260** | 52 | 24.0 | 26.0 | 52 | 60.0 | 60 | 21 | 300 | 0.478 |
| | | | | | *2.047* | *.945* | *1.024* | *2.047* | *2.362* | *2.362* | *.830* | *4351* | |
| | 28.0 - 26.0 | 1 | 4 | **393.14-50 280** | 52 | 26.0 | 28.0 | 52 | 60.0 | 60 | 21 | 300 | 0.461 |
| | | | | | *2.047* | *1.024* | *1.102* | *2.047* | *2.362* | *2.362* | *.830* | *4351* | |
| | 30.0 - 28.0 | 1 | 4 | **393.14-50 300** | 52 | 28.0 | 30.0 | 52 | 60.0 | 60 | 21 | 300 | 0.413 |
| | | | | | *2.047* | *1.102* | *1.181* | *2.047* | *2.362* | *2.362* | *.830* | *4351* | |
| | 32.0 - 30.0 | 1 | 4 | **393.14-50 320** | 52 | 30.0 | 32.0 | 52 | 60.0 | 60 | 21 | 300 | 0.371 |
| | | | | | *2.047* | *1.181* | *1.260* | *2.047* | *2.362* | *2.362* | *.830* | *4351* | |
| | 34.0 - 32.0 | 1 | 4 | **393.14-50 340** | 52 | 32.0 | 34.0 | 52 | 60.0 | 60 | 21 | 300 | 0.332 |
| | | | | | *2.047* | *1.260* | *1.339* | *2.047* | *2.362* | *2.362* | *.830* | *4351* | |
| | 36.0 - 34.0 | 1 | 4 | **393.14-50 360** | 52 | 34.0 | 36.0 | 52 | 60.0 | 60 | 21 | 300 | 0.279 |
| | | | | | *2.047* | *1.339* | *1.417* | *2.047* | *2.362* | *2.362* | *.830* | *4351* | |

N22 N15

# ER Collet for tap shank

**Compatible with DIN 6499-B**

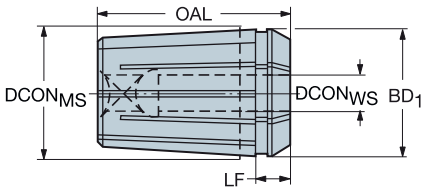



| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| ER11 | 4.00 x 3.15 | 1 | 4 | 393.14-11 D040X0315 | 11 | 4 | 11 | 14.0 | 18 | 4 | 300 | 0.009 |
| | | | | | *.445* | *.157* | *.449* | *.551* | *.709* | *.177* | *4351* | |
| | 2.50 x 2.00 | 1 | 4 | 393.14-11 D025X021 | 11 | 2 | 11 | 12.0 | 18 | 4 | 300 | 0.009 |
| | | | | | *.445* | *.098* | *.449* | *.472* | *.709* | *.177* | *4351* | |
| | 2.80 x 2.10 | 1 | 4 | 393.14-11 D028X021 | 11 | 2 | 11 | 12.0 | 18 | 4 | 300 | 0.010 |
| | | | | | *.445* | *.110* | *.449* | *.472* | *.709* | *.177* | *4351* | |
| | 5.00 x 4.00 | 1 | 4 | 393.14-11 D050X040 | 11 | 5 | 11 | 14.0 | 18 | 4 | 300 | 0.008 |
| | | | | | *.445* | *.197* | *.449* | *.551* | *.709* | *.177* | *4351* | |
| | 3.50 x 2.70 | 1 | 4 | 393.14-11 D035X027 | 11 | 3 | 11 | 14.0 | 18 | 4 | 300 | 0.010 |
| | | | | | *.445* | *.138* | *.449* | *.551* | *.709* | *.177* | *4351* | |
| | 4.00 x 3.00 | 1 | 4 | 393.14-11 D040X030 | 11 | 4 | 11 | 14.0 | 18 | 4 | 300 | 0.009 |
| | | | | | *.445* | *.157* | *.449* | *.551* | *.709* | *.177* | *4351* | |
| | 4.50 x 3.40 | 1 | 4 | 393.14-11 D045X034 | 11 | 4 | 11 | 14.0 | 18 | 4 | 300 | 0.008 |
| | | | | | *.445* | *.177* | *.449* | *.551* | *.709* | *.177* | *4351* | |
| | 6.00 x 4.90 | 1 | 4 | 393.14-11 D060X049 | 11 | 6 | 11 | 14.0 | 18 | 4 | 300 | 0.007 |
| | | | | | *.445* | *.236* | *.449* | *.551* | *.709* | *.177* | *4351* | |
| ER20 | 4.00 x 3.15 | 1 | 4 | 393.14-20 D040X0315 | 20 | 4 | 21 | 18.0 | 31 | 7 | 300 | 0.047 |
| | | | | | *.819* | *.157* | *.827* | *.709* | *1.240* | *.299* | *4351* | |
| | 5.00 x 4.00 | 1 | 4 | 393.14-20 D050X040 | 20 | 5 | 21 | 18.0 | 31 | 7 | 300 | 0.044 |
| | | | | | *.819* | *.197* | *.827* | *.709* | *1.240* | *.299* | *4351* | |
| | 3.50 x 2.70 | 1 | 4 | 393.14-20 D035X027 | 20 | 3 | 21 | 18.0 | 31 | 7 | 300 | 0.045 |
| | | | | | *.819* | *.138* | *.827* | *.709* | *1.240* | *.299* | *4351* | |
| | 6.30 x 5.00 | 1 | 4 | 393.14-20 D063X050 | 20 | 6 | 21 | 18.0 | 31 | 7 | 300 | 0.042 |
| | | | | | *.819* | *.248* | *.827* | *.709* | *1.240* | *.299* | *4351* | |
| | 4.50 x 3.40 | 1 | 4 | 393.14-20 D045X034 | 20 | 4 | 21 | 18.0 | 31 | 7 | 300 | 0.043 |
| | | | | | *.819* | *.177* | *.827* | *.709* | *1.240* | *.299* | *4351* | |
| | 8.00 x 6.30 | 1 | 4 | 393.14-20 D080X063 | 20 | 8 | 21 | 22.0 | 31 | 7 | 300 | 0.039 |
| | | | | | *.819* | *.315* | *.827* | *.866* | *1.240* | *.299* | *4351* | |
| | 5.50 x 4.30 | 1 | 4 | 393.14-20 D055X043 | 20 | 5 | 21 | 18.0 | 31 | 7 | 300 | 0.043 |
| | | | | | *.819* | *.217* | *.827* | *.709* | *1.240* | *.299* | *4351* | |
| | 9.00 x 7.10 | 1 | 4 | 393.14-20 D090X071 | 20 | 9 | 21 | 22.0 | 31 | 7 | 300 | 0.039 |
| | | | | | *.819* | *.354* | *.827* | *.866* | *1.240* | *.299* | *4351* | |
| | 6.00 x 4.90 | 1 | 4 | 393.14-20 D060X049 | 20 | 6 | 21 | 18.0 | 31 | 7 | 300 | 0.042 |
| | | | | | *.819* | *.236* | *.827* | *.709* | *1.240* | *.299* | *4351* | |
| | 10.00 x 8.00 | 1 | 4 | 393.14-20 D100X080 | 20 | 10 | 21 | 25.0 | 31 | 7 | 300 | 0.035 |
| | | | | | *.819* | *.394* | *.827* | *.984* | *1.240* | *.299* | *4351* | |
| | 7.00 x 5.50 | 1 | 4 | 393.14-20 D070X055 | 20 | 7 | 21 | 18.0 | 31 | 7 | 300 | 0.041 |
| | | | | | *.819* | *.276* | *.827* | *.709* | *1.240* | *.299* | *4351* | |

N22 N15

# ER Collet for tap shank

**Compatible with DIN 6499-B**



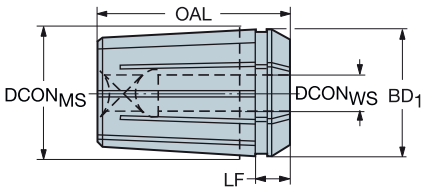

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| ER25 | 8.00 x 6.30 | 1 | 4 | 393.14-25 D080X063 | 25 | 8 | 26 | 22.0 | 34 | 8 | 300 | 0.077 |
| | | | | | *1.016* | *.315* | *1.024* | *.866* | *1.339* | *.319* | *4351* | |
| | 9.00 x 7.10 | 1 | 4 | 393.14-25 D090X071 | 25 | 9 | 26 | 22.0 | 34 | 8 | 300 | 0.077 |
| | | | | | *1.016* | *.354* | *1.024* | *.866* | *1.339* | *.319* | *4351* | |
| | 6.00 x 4.90 | 1 | 4 | 393.14-25 D060X049 | 25 | 6 | 26 | 22.0 | 34 | 8 | 300 | 0.077 |
| | | | | | *1.016* | *.236* | *1.024* | *.866* | *1.339* | *.319* | *4351* | |
| | 10.00 x 8.00 | 1 | 4 | 393.14-25 D100X080 | 25 | 10 | 26 | 25.0 | 34 | 8 | 300 | 0.074 |
| | | | | | *1.016* | *.394* | *1.024* | *.984* | *1.339* | *.319* | *4351* | |
| | 7.00 x 5.50 | 1 | 4 | 393.14-25 D070X055 | 25 | 7 | 26 | 22.0 | 34 | 8 | 300 | 0.076 |
| | | | | | *1.016* | *.276* | *1.024* | *.866* | *1.339* | *.319* | *4351* | |
| | 11.20 x 9.00 | 1 | 4 | 393.14-25 D112X090 | 25 | 11 | 26 | 25.0 | 34 | 8 | 300 | 0.071 |
| | | | | | *1.016* | *.441* | *1.024* | *.984* | *1.339* | *.319* | *4351* | |
| | 12.50 x 10.00 | 1 | 4 | 393.14-25 D125X100 | 25 | 12 | 26 | 25.0 | 34 | 8 | 300 | 0.065 |
| | | | | | *1.016* | *.492* | *1.024* | *.984* | *1.339* | *.319* | *4351* | |
| | 14.00 x 11.20 | 1 | 4 | 393.14-25 D140X112 | 25 | 14 | 26 | 25.0 | 34 | 8 | 300 | 0.057 |
| | | | | | *1.016* | *.551* | *1.024* | *.984* | *1.339* | *.319* | *4351* | |
| | 11.00 x 9.00 | 1 | 4 | 393.14-25 D110X090 | 25 | 11 | 26 | 25.0 | 34 | 8 | 300 | 0.071 |
| | | | | | *1.016* | *.433* | *1.024* | *.984* | *1.339* | *.319* | *4351* | |
| | 12.00 x 9.00 | 1 | 4 | 393.14-25 D120X090 | 25 | 12 | 26 | 25.0 | 34 | 8 | 300 | 0.067 |
| | | | | | *1.016* | *.472* | *1.024* | *.984* | *1.339* | *.319* | *4351* | |
| | 16.00 x 12.00 | 1 | 4 | 393.14-25 D160X120 | 25 | 16 | 26 | 25.0 | 34 | 8 | 300 | 0.047 |
| | | | | | *1.016* | *.630* | *1.024* | *.984* | *1.339* | *.319* | *4351* | |
| ER32 | 10.00 x 8.00 | 1 | 1 | 393.14-32 D100X080 | 32 | 10 | 33 | | 40 | 9 | 80 | 0.148 |
| | | | | | *1.291* | *.394* | *1.299* | | *1.575* | *.358* | *1160* | |
| | 11.00 x 9.00 | 1 | 1 | 393.14-32 D110X090 | 32 | 11 | 33 | | 40 | 9 | 80 | 0.149 |
| | | | | | *1.291* | *.433* | *1.299* | | *1.575* | *.358* | *1160* | |
| | 12.00 x 9.00 | 1 | 1 | 393.14-32 D120X090 | 32 | 12 | 33 | | 40 | 9 | 80 | 0.140 |
| | | | | | *1.291* | *.472* | *1.299* | | *1.575* | *.358* | *1160* | |
| | 14.00 x 11.00 | 1 | 1 | 393.14-32 D140X110 | 32 | 14 | 33 | | 40 | 9 | 80 | 0.135 |
| | | | | | *1.291* | *.551* | *1.299* | | *1.575* | *.358* | *1160* | |
| | 16.00 x 12.00 | 1 | 1 | 393.14-32 D160X120 | 32 | 16 | 33 | | 40 | 9 | 80 | 0.125 |
| | | | | | *1.291* | *.630* | *1.299* | | *1.575* | *.358* | *1160* | |
| | 18.00 x 14.50 | 1 | 1 | 393.14-32 D180X145 | 32 | 18 | 33 | | 40 | 9 | 80 | 0.109 |
| | | | | | *1.291* | *.709* | *1.299* | | *1.575* | *.358* | *1160* | |
| | 20.00 x 16.00 | 1 | 1 | 393.14-32 D200X160 | 32 | 20 | 33 | | 40 | 9 | 80 | 0.093 |
| | | | | | *1.291* | *.787* | *1.299* | | *1.575* | *.358* | *1160* | |
| ER40 | 12.50 x 10.00 | 1 | 4 | 393.14-40 D125X100 | 40 | 12 | 41 | 25.0 | 46 | 11 | 300 | 0.283 |
| | | | | | *1.606* | *.492* | *1.614* | *.984* | *1.811* | *.437* | *4351* | |
| | 14.00 x 11.20 | 1 | 4 | 393.14-40 D140X112 | 40 | 14 | 41 | 25.0 | 46 | 11 | 300 | 0.275 |
| | | | | | *1.606* | *.551* | *1.614* | *.984* | *1.811* | *.437* | *4351* | |
| | 16.00 x 12.50 | 1 | 4 | 393.14-40 D160X125 | 40 | 16 | 41 | 25.0 | 46 | 11 | 300 | 0.265 |
| | | | | | *1.606* | *.630* | *1.614* | *.984* | *1.811* | *.437* | *4351* | |
| | 12.00 x 9.00 | 1 | 4 | 393.14-40 D120X090 | 40 | 12 | 41 | 25.0 | 46 | 11 | 300 | 0.281 |
| | | | | | *1.606* | *.472* | *1.614* | *.984* | *1.811* | *.437* | *4351* | |
| | 18.00 x 14.50 | 1 | 4 | 393.14-40 D180X145 | 40 | 18 | 41 | 25.0 | 46 | 11 | 300 | 0.248 |
| | | | | | *1.606* | *.709* | *1.614* | *.984* | *1.811* | *.437* | *4351* | |
| | 20.00 x 16.00 | 1 | 4 | 393.14-40 D200X160 | 40 | 20 | 41 | 28.0 | 46 | 11 | 300 | 0.234 |
| | | | | | *1.606* | *.787* | *1.614* | *1.102* | *1.811* | *.437* | *4351* | |
| | 22.00 x 18.00 | 1 | 4 | 393.14-40 D220X180 | 40 | 22 | 41 | 28.0 | 46 | 11 | 300 | 0.213 |
| | | | | | *1.606* | *.866* | *1.614* | *1.102* | *1.811* | *.437* | *4351* | |
| ER50 | 22.00 x 18.00 | 1 | 4 | 393.14-50 D220X180 | 52 | 22 | 52 | 60.0 | 60 | 17 | 300 | 0.543 |
| | | | | | *2.047* | *.866* | *2.047* | *2.362* | *2.362* | *.689* | *4351* | |
| | 25.00 x 20.00 | 1 | 4 | 393.14-50 D250X200 | 52 | 25 | 52 | 60.0 | 60 | 17 | 300 | 0.500 |
| | | | | | *2.047* | *.984* | *2.047* | *2.362* | *2.362* | *.689* | *4351* | |
| | 28.00 x 22.00 | 1 | 4 | 393.14-50 D280X220 | 52 | 28 | 52 | 60.0 | 60 | 17 | 300 | 0.449 |
| | | | | | *2.047* | *1.102* | *2.047* | *2.362* | *2.362* | *.689* | *4351* | |
| | 32.00 x 24.00 | 1 | 4 | 393.14-50 D320X240 | 52 | 32 | 52 | 60.0 | 60 | 17 | 300 | 0.380 |
| | | | | | *2.047* | *1.260* | *2.047* | *2.362* | *2.362* | *.689* | *4351* | |

N22 N15

# ER Collet for tap shank

**For inch standard taps**

**Compatible with DIN 6499-B**



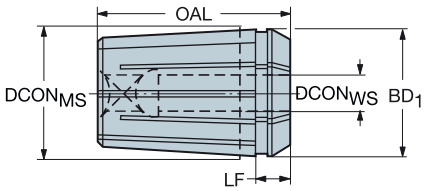

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | Ordering code | $DCON_{MS}$ | $DCON_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| ER11 | .141 x .110 | 1 | 4 | A393.14-11-0-6 NO | 11 | 3 | 11 | 14.0 | 18 | 4 | 300 | 0.009 |
| | | | | | .445 | .141 | .449 | .551 | .709 | .177 | 4351 | |
| | .168 x .131 | 1 | 4 | A393.14-11-8 NO | 11 | 4 | 11 | 14.0 | 18 | 4 | 300 | 0.009 |
| | | | | | .445 | .168 | .449 | .551 | .709 | .177 | 4351 | |
| | .194 x .152 | 1 | 4 | A393.14-11-10 NO | 11 | 4 | 11 | 14.0 | 18 | 4 | 300 | 0.008 |
| | | | | | .445 | .194 | .449 | .551 | .709 | .177 | 4351 | |
| ER20 | .168 x .131 | 1 | 4 | A393.14-20-8 NO | 20 | 4 | 21 | 18.0 | 31 | 7 | 300 | 0.044 |
| | | | | | .819 | .168 | .827 | .709 | 1.240 | .299 | 4351 | |
| | .194 x .152 | 1 | 4 | A393.14-20-10 NO | 20 | 4 | 21 | 18.0 | 31 | 7 | 300 | 0.043 |
| | | | | | .819 | .194 | .827 | .709 | 1.240 | .299 | 4351 | |
| | .220 x .165 | 1 | 4 | A393.14-20-12 NO | 20 | 5 | 21 | 18.0 | 31 | 7 | 300 | 0.043 |
| | | | | | .819 | .220 | .827 | .709 | 1.240 | .299 | 4351 | |
| | .255 x .191 | 1 | 4 | A393.14-20-1/4 | 20 | 6 | 21 | 18.0 | 31 | 7 | 300 | 0.042 |
| | | | | | .819 | .255 | .827 | .709 | 1.240 | .299 | 4351 | |
| | .318 x .238 | 1 | 4 | A393.14-20-5/16 | 20 | 8 | 21 | 22.0 | 31 | 7 | 300 | 0.040 |
| | | | | | .819 | .318 | .827 | .866 | 1.240 | .299 | 4351 | |
| | .323 x .242 | 1 | 4 | A393.14-20-7/16 | 20 | 8 | 21 | 18.0 | 31 | 7 | 300 | 0.043 |
| | | | | | .819 | .323 | .827 | .709 | 1.240 | .299 | 4351 | |
| | .367 x .275 | 1 | 4 | A393.14-20-1/2 | 20 | 9 | 21 | 18.0 | 31 | 7 | 300 | 0.036 |
| | | | | | .819 | .367 | .827 | .709 | 1.240 | .299 | 4351 | |
| | .381 x .286 | 1 | 4 | A393.14-20-3/8 | 20 | 9 | 21 | 22.0 | 31 | 7 | 300 | 0.036 |
| | | | | | .819 | .381 | .827 | .866 | 1.240 | .299 | 4351 | |
| ER25 | .255 x .191 | 1 | 4 | A393.14-25-1/4 | 25 | 6 | 26 | 18.0 | 34 | 8 | 300 | 0.079 |
| | | | | | 1.016 | .255 | 1.024 | .709 | 1.339 | .319 | 4351 | |
| | .318 x .238 | 1 | 4 | A393.14-25-5/16 | 25 | 8 | 26 | 22.0 | 34 | 8 | 300 | 0.078 |
| | | | | | 1.016 | .318 | 1.024 | .866 | 1.339 | .319 | 4351 | |
| | .323 x .242 | 1 | 4 | A393.14-25-7/16 | 25 | 8 | 26 | 22.0 | 34 | 8 | 300 | 0.075 |
| | | | | | 1.016 | .323 | 1.024 | .866 | 1.339 | .319 | 4351 | |
| | .367 x .275 | 1 | 4 | A393.14-25-1/2 | 25 | 9 | 26 | 22.0 | 34 | 8 | 300 | 0.074 |
| | | | | | 1.016 | .367 | 1.024 | .866 | 1.339 | .319 | 4351 | |
| | .381 x .286 | 1 | 4 | A393.14-25-3/8 | 25 | 9 | 26 | 22.0 | 34 | 8 | 300 | 0.078 |
| | | | | | 1.016 | .381 | 1.024 | .866 | 1.339 | .319 | 4351 | |
| | .429 x .322 | 1 | 4 | A393.14-25-9/16 | 25 | 10 | 26 | 25.0 | 34 | 8 | 300 | 0.071 |
| | | | | | 1.016 | .429 | 1.024 | .984 | 1.339 | .319 | 4351 | |
| | .437 x .328 | 1 | 4 | A393.14-25-1/8P | 25 | 11 | 26 | 22.0 | 34 | 8 | 300 | 0.074 |
| | | | | | 1.016 | .437 | 1.024 | .866 | 1.339 | .319 | 4351 | |
| | .480 x .360 | 1 | 4 | A393.14-25-5/8 | 25 | 12 | 26 | 25.0 | 34 | 8 | 300 | 0.066 |
| | | | | | 1.016 | .480 | 1.024 | .984 | 1.339 | .319 | 4351 | |
| | .590 x .442 | 1 | 4 | A393.14-25-3/4 | 25 | 14 | 26 | 25.0 | 34 | 8 | 300 | 0.053 |
| | | | | | 1.016 | .590 | 1.024 | .984 | 1.339 | .319 | 4351 | |
| ER32 | .318 x .238 | 1 | 1 | A393.14-32-5/16 | 32 | 8 | 33 | | 40 | 9 | 80 | 0.200 |
| | | | | | 1.291 | .318 | 1.299 | | 1.575 | .358 | 1160 | |
| | .323 x .242 | 1 | 1 | A393.14-32-7/16 | 32 | 8 | 33 | | 40 | 9 | 80 | 0.200 |
| | | | | | 1.291 | .323 | 1.299 | | 1.575 | .358 | 1160 | |
| | .367 x .275 | 1 | 1 | A393.14-32-1/2 | 32 | 9 | 33 | | 40 | 9 | 80 | 0.144 |
| | | | | | 1.291 | .367 | 1.299 | | 1.575 | .358 | 1160 | |
| | .381 x .286 | 1 | 1 | A393.14-32-3/8 | 32 | 9 | 33 | | 40 | 9 | 80 | 0.200 |
| | | | | | 1.291 | .381 | 1.299 | | 1.575 | .358 | 1160 | |
| | .480 x .360 | 1 | 1 | A393.14-32-5/8 | 32 | 12 | 33 | | 40 | 9 | 80 | 0.200 |
| | | | | | 1.291 | .480 | 1.299 | | 1.575 | .358 | 1160 | |
| | .590 x .442 | 1 | 1 | A393.14-32-3/4 | 32 | 14 | 33 | | 40 | 9 | 80 | 0.132 |
| | | | | | 1.291 | .590 | 1.299 | | 1.575 | .358 | 1160 | |
| | .697 x .523 | 1 | 1 | A393.14-32-7/8 | 32 | 17 | 33 | | 40 | 9 | 80 | 0.112 |
| | | | | | 1.291 | .697 | 1.299 | | 1.575 | .358 | 1160 | |

N22 N15

# ER Collet for tap shank

**For inch standard taps**

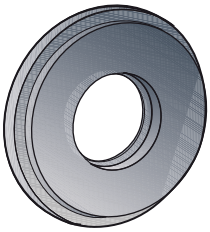
**Compatible with DIN 6499-B**

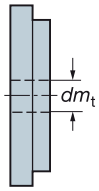



| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| ER40 | .480 x .360 | 1 | 4 | **A393.14-40-5/8** | 40 | 12 | 41 | 25.0 | 46 | 11 | 300 | 0.280 |
| | | | | | 1.606 | .480 | 1.614 | .984 | 1.811 | .437 | 4351 | |
| | .542 x .406 | 1 | 4 | **A393.14-40-M18** | 40 | 13 | 41 | 25.0 | 46 | 11 | 300 | 0.275 |
| | | | | | 1.606 | .542 | 1.614 | .984 | 1.811 | .437 | 4351 | |
| | .562 x .421 | 1 | 4 | **A393.14-40-1/8P** | 40 | 14 | 41 | 25.0 | 46 | 11 | 300 | 0.275 |
| | | | | | 1.606 | .562 | 1.614 | .984 | 1.811 | .437 | 4351 | |
| | .590 x .442 | 1 | 4 | **A393.14-40-3/4** | 40 | 14 | 41 | 25.0 | 46 | 11 | 300 | 0.269 |
| | | | | | 1.606 | .590 | 1.614 | .984 | 1.811 | .437 | 4351 | |
| | .652 x .489 | 1 | 4 | **A393.14-40-M20** | 40 | 16 | 41 | 25.0 | 46 | 11 | 300 | 0.275 |
| | | | | | 1.606 | .652 | 1.614 | .984 | 1.811 | .437 | 4351 | |
| | .687 x .515 | 1 | 4 | **A393.14-40-1/2P** | 40 | 17 | 41 | 25.0 | 46 | 11 | 300 | 0.275 |
| | | | | | 1.606 | .687 | 1.614 | .984 | 1.811 | .437 | 4351 | |
| | .697 x .523 | 1 | 4 | **A393.14-40-7/8** | 40 | 17 | 41 | 25.0 | 46 | 11 | 300 | 0.253 |
| | | | | | 1.606 | .697 | 1.614 | .984 | 1.811 | .437 | 4351 | |
| | .700 x .531 | 1 | 4 | **A393.14-40-3/8P** | 40 | 17 | 41 | 25.0 | 46 | 11 | 300 | 0.275 |
| | | | | | 1.606 | .700 | 1.614 | .984 | 1.811 | .437 | 4351 | |
| | .760 x .570 | 1 | 4 | **A393.14-40-M24** | 40 | 19 | 41 | 25.0 | 46 | 11 | 300 | 0.240 |
| | | | | | 1.606 | .760 | 1.614 | .984 | 1.811 | .437 | 4351 | |
| | .800 x .600 | 1 | 4 | **A393.14-40-1** | 40 | 20 | 41 | 28.0 | 46 | 11 | 300 | 0.233 |
| | | | | | 1.606 | .800 | 1.614 | 1.102 | 1.811 | .437 | 4351 | |

N22 N15

# ER Collet sealing discs

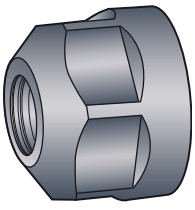


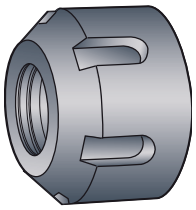



| Size 16 | | | Size 25 | | | Size 32 | | | Size 40 | | |
|---|---|---|---|---|---|---|---|---|---|---|---|
| Range, mm (inch) $dm_t$ | | Ordering code | Range, mm (inch) $dm_t$ | | Ordering code | Range, mm (inch) $dm_t$ | | Ordering code | Range, mm (inch) $dm_t$ | | Ordering code |
| 3.0-2.5 | (.118-.098) | 3916.00300 | 6.0-5.5 | (.236-.217) | 3925.00600 | 3.0-2.5 | (.118-.098) | 3932.00300 | 6.0-5.5 | (.236-.217) | 3940.00600 |
| 4.0-3.5 | (.157-.138) | 3916.00400 | 7.0-6.5 | (.276-.256) | 3925.00700 | 4.0-3.5 | (.157-.138) | 3932.00400 | 7.0-6.5 | (.276-.256) | 3940.00700 |
| 5.0-4.5 | (.197-.177) | 3916.00500 | 8.0-7.5 | (.315-.295) | 3925.00800 | 5.0-4.5 | (.197-.177) | 3932.00500 | 8.0-7.5 | (.315-.295) | 3940.00800 |
| 6.0-5.5 | (.236-.217) | 3916.00600 | 9.0-8.5 | (.354-.335) | 3925.00900 | 6.0-5.5 | (.236-.217) | 3932.00600 | 9.0-8.5 | (.354-.335) | 3940.00900 |
| 7.0-6.5 | (.276-.256) | 3916.00700 | 10.0-9.5 | (.394-.374) | 3925.01000 | 7.0-6.5 | (.276-.256) | 3932.00700 | 10.0-9.5 | (.394-.374) | 3940.01000 |
| 8.0-7.5 | (.315-.295) | 3916.00800 | 11.0-10.5 | (.433-.413) | 3925.01100 | 8.0-7.5 | (.315-.295) | 3932.00800 | 11.0-10.5 | (.433-.413) | 3940.01100 |
| 9.0-8.5 | (.354-.335) | 3916.00900 | 12.0-11.5 | (.472-.453) | 3925.01200 | 9.0-8.5 | (.354-.335) | 3932.00900 | 12.0-11.5 | (.472-.453) | 3940.01200 |
| 10.0-9.5 | (.394-.374) | 3916.01000 | 13.0-12.5 | (.512-.492) | 3925.01300 | 10.0-9.5 | (.394-.374) | 3932.01000 | 13.0-12.5 | (.512-.492) | 3940.01300 |
| | | | 14.0-13.5 | (.551-.531) | 3925.01400 | 11.0-10.5 | (.433-.413) | 3932.01100 | 14.0-13.5 | (.551-.531) | 3940.01400 |
| | | | 15.0-14.5 | (.591-.571) | 3925.01500 | 12.0-11.5 | (.472-.453) | 3932.01200 | 15.0-14.5 | (.591-.571) | 3940.01500 |
| | | | 16.0-15.5 | (.630-.610) | 3925.01600 | 13.0-12.5 | (.512-.492) | 3932.01300 | 16.0-15.5 | (.630-.610) | 3940.01600 |
| | | | | | | 14.0-13.5 | (.551-.531) | 3932.01400 | 17.0-16.5 | (.669-.650) | 3940.01700 |
| | | | | | | 15.0-14.5 | (.591-.571) | 3932.01500 | 18.0-17.5 | (.709-.689) | 3940.01800 |
| | | | | | | 16.0-15.5 | (.630-.610) | 3932.01600 | 19.0-18.5 | (.748-.728) | 3940.01900 |
| | | | | | | 17.0-16.5 | (.669-.650) | 3932.01700 | 20.0-19.5 | (.787-.768) | 3940.02000 |
| | | | | | | 18.0-17.5 | (.709-.689) | 3932.01800 | 21.0-20.5 | (.827-.807) | 3940.02100 |
| | | | | | | 19.0-18.5 | (.748-.728) | 3932.01900 | 22.0-21.5 | (.866-.846) | 3940.02200 |
| Size 20 | | | | | | 20.0-19.5 | (.787-.768) | 3932.02000 | 25.0-24.5 | (.984-.965) | 3940.02500 |
| Range, mm (inch) $dm_t$ | | Ordering code | | | | | | | | | |
| 3.0-2.5 | (.118-.098) | 3920.00300 | | | | | | | | | |
| 4.0-3.5 | (.157-.138) | 3920.00400 | | | | | | | | | |
| 5.0-4.5 | (.197-.177) | 3920.00500 | | | | | | | | | |
| 6.0-5.5 | (.236-.217) | 3920.00600 | | | | | | | | | |
| 7.0-6.5 | (.276-.256) | 3920.00700 | | | | | | | | | |
| 8.0-7.5 | (.315-.295) | 3920.00800 | | | | | | | | | |
| 9.0-8.5 | (.354-.335) | 3920.00900 | | | | | | | | | |
| 10.0-9.5 | (.394-.374) | 3920.01000 | | | | | | | | | |
| 11.0-10.5 | (433-.413) | 3920.01100 | | | | | | | | | |
| 12.0-11.5 | (.472-.453) | 3920.01200 | | | | | | | | | |
| 13.0-12.5 | (.512-.492) | 3920.01300 | | | | | | | | | |

0.5 mm (.020 inch) capacity per disc. Max 150 bar (2000 psi) coolant pressure.

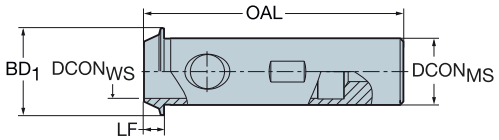
# ER collet nuts for through coolant with sealing disc





| 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



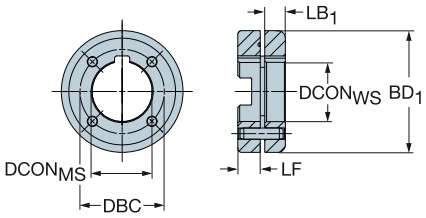

| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | BD | LSC | OAL | LF | BAR PSI | KG |
| 20 | 16 | 1 | 1 | **393.37A-20 16 072** | 20 | 16 | 26 | 72.0 | 78 | 6 | 20 | 0.114 |
| | | | | | *.787* | *.630* | *1.024* | *2.835* | *3.071* | *.236* | *290* | |

To be used with R429U/R429.90 boring bars

L2 N22 N15

# Assembly item

## Driving collar for CoroMill® QD

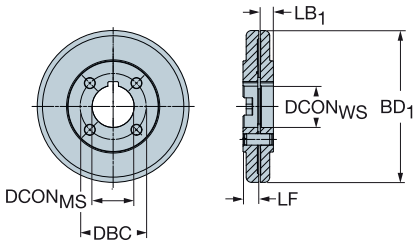



### Metric version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions 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 |

### Inch version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | OAL | LF | LB$_1$ | BD$_1$ | PSI | LBS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1 1/2 | Y38 | 4 | 4 | 5549 201-111 | 1.500 | 1.500 | .094 | 1.141 | .591 | .456 | 3.425 | 1160 | 2.220 |
| 1 1/4 | Y31 | 4 | 4 | 5549 201-101 | 1.250 | 1.250 | .094 | 1.000 | .472 | .433 | 2.559 | 1160 | 1.029 |




### Metric version

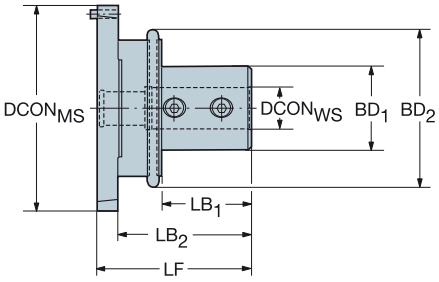
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions DCON$_{MS}$ | DCON$_{WS}$ | LSC | OAL | LF | LB$_1$ | BD$_1$ | BAR | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40 | X40 | 4 | 4 | 5549 201-041 | 40.00 | 40.00 | 2.40 | 29.00 | 15 | 12.50 | 145.00 | 80 | 2.75 |
| | X40 | 4 | 4 | 5549 201-081 | 40.00 | 40.00 | 2.40 | 29.00 | 15 | 11.60 | 185.00 | 80 | 4.62 |

### Inch version

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, inch DCON$_{MS}$ | DCON$_{WS}$ | LSC | OAL | LF | LB$_1$ | BD$_1$ | PSI | LBS |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1 1/2 | Y38 | 4 | 4 | 5549 201-131 | 1.500 | 1.500 | .094 | 1.141 | .591 | .492 | 5.709 | 1160 | 6.122 |
| | Y38 | 4 | 4 | 5549 201-171 | 1.500 | 1.500 | .094 | 1.141 | .591 | .456 | 7.283 | 1160 | 10.141 |

N22 N15

# Slide to adjustable drill adapter




## Metric bore

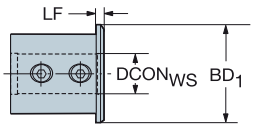
| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | LB$_2$ | LB$_3$ | BD$_1$ | BD$_2$ | BD$_3$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 1.0 | 20 | 1 | 1 | 393.277-20 01 075A | 78.0 | 20.0 | 75.0 | 44.0 | 65.0 | 75.0 | 40.0 | 55.2 | 78.0 | 20 | 12.0 | 0.85 |
| | | | | | *3.071* | *.787* | *2.953* | *1.732* | *2.559* | *2.953* | *1.575* | *2.173* | *3.071* | *290* | | |
| | 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 | 20.0 | 0.94 |
| | | | | | *3.071* | *.984* | *3.150* | *1.969* | *2.756* | *3.150* | *1.772* | *2.173* | *3.071* | *290* | | |
| 2.0 | 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 | 12.0 | 1.26 |
| | | | | | *3.858* | *.787* | *2.953* | *1.732* | *2.559* | *2.953* | *1.575* | *2.961* | *3.858* | *290* | | |
| | 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 | 20.0 | 1.39 |
| | | | | | *3.858* | *.984* | *3.346* | *2.126* | *2.953* | *3.346* | *1.772* | *2.961* | *3.858* | *290* | | |
| | 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 | 30.0 | 1.47 |
| | | | | | *3.858* | *1.260* | *3.346* | *2.126* | *2.953* | *3.346* | *2.047* | *2.961* | *3.858* | *290* | | |
| 3.0 | 40 | 1 | 1 | 393.277-40 03 090A | 136.0 | 40.0 | 90.0 | 65.0 | 90.0 | | 65.0 | 136.0 | | 20 | 40.0 | 3.52 |
| | | | | | *5.354* | *1.575* | *3.543* | *2.559* | *3.543* | | *2.559* | *5.354* | | *290* | | |
| | 50 | 1 | 1 | 393.277-50 03 100A | 136.0 | 50.0 | 100.0 | 75.0 | 110.0 | | 75.0 | 163.0 | | 20 | 45.0 | 3.90 |
| | | | | | *5.354* | *1.969* | *3.937* | *2.953* | *4.331* | | *2.953* | *6.417* | | *290* | | |

## Inch bore

| CZC$_{MS}$ | CZC$_{WS}$ | CNSC | CXSC | Ordering code | Dimensions, mm, inch DCON$_{MS}$ | DCON$_{WS}$ | LF | LB$_1$ | BAR PSI | NM | KG |
|---|---|---|---|---|---|---|---|---|---|---|---|
| 2.0 | 1 | 1 | 1 | A393.277-100 02 085A | 98.0 | 25.4 | 85.0 | 85.0 | 20 | 20.0 | 1.32 |
| | | | | | *3.858* | *1.000* | *3.346* | *3.346* | *290* | | |
| | 1 1/4 | 1 | 1 | A393.277-125 02 085A | 98.0 | 31.8 | 85.0 | 85.0 | 20 | 30.0 | 1.41 |
| | | | | | *3.858* | *1.250* | *3.346* | *3.346* | *290* | | |

N22 N15

## Sleeve

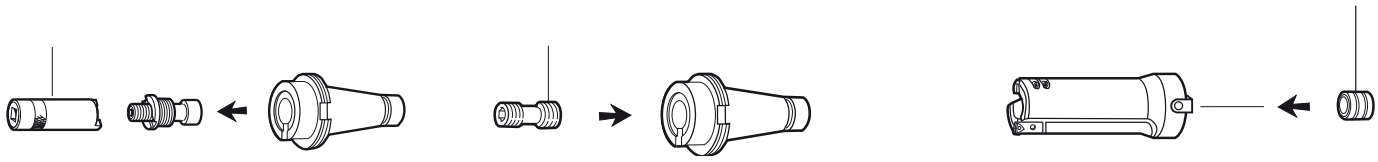



| | | | | | Dimensions, mm, inch | | | | | | | |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| $CZC_{MS}$ | $CZC_{WS}$ | CNSC | CXSC | **Ordering code** | $DCON_{MS}$ | $DCON_{WS}$ | LSC | LF | $BD_1$ | BAR PSI | NM | KG |
| 40.0 | 32 | 1 | 1 | **393.277-40 32 074A** | 40.0 | 32.0 | 70 | 4.0 | 48.0 | 80 | 30.0 | 0.30 |
| | | | | | *1.575* | *1.260* | *2.756* | *.157* | *1.890* | *1160* | | |

## VL

**Trepanning tool**

**1.** **2.** **3.**



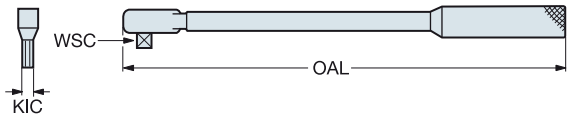
| **1.** | **2.** | **3.** |
|---|---|---|
| **Ordering code** | **Ordering code** | **Ordering code** |
| **Key** | **Screw** | **Centering sleeve** |
| 5680 065-02 | 5516 030-01 | 5638 030-01 |

N22 N15

# Assembly tools

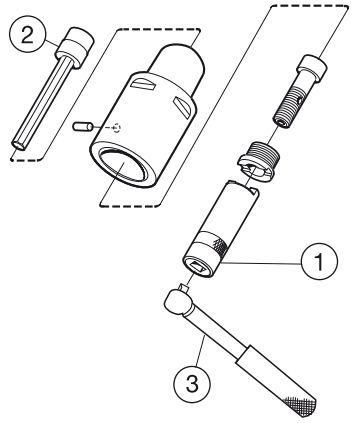
**Coromant Capto®**

## Torque wrench for manual clamping units, quick change




| Coupling size | **Torque wrench** **Ordering code** | Dimensions, mm, inch Torque range, Nm, ft-lbs | WSC | OAL | **Key adapter** **Ordering code** | KIC |
|---|---|---|---|---|---|---|
| C3 | **C-TK-01M** | 20-100 | 1/2" | 345 | **5680 035-14** | 8 |
| | | *15-74* | | *13.583* | | *.315* |
| C4 | **C-TK-01M** | 20-100 | 1/2" | 345 | **5680 035-06** | 10 |
| | | *15-74* | | *13.583* | | *.394* |
| C5 | **C-TK-01M** | 20-100 | 1/2" | 345 | **5680 035-07** | 12 |
| | | *15-74* | | *13.583* | | *.472* |
| C6 | **C-TK-01M** | 20-100 | 1/2" | 345 | **5680 035-07** | 12 |
| | | *15-74* | | *13.583* | | *.472* |
| C8 | **C-TK-02** | 40-200 | 1/2" | 440 | **5680 035-07** | 12 |
| | | *30-148* | | *17.323* | | *.472* |
| C10 | **C-TK-03** | 60-300 | 1/2" | 548 | **5680 035-10** | 17 |
| | | *44-220* | | *21.575* | | *.669* |

## Torque wrench for modular assemblies, center bolt clamping




| Coupling size | **3. Torque wrench** **Ordering code** | Dimensions, mm, inch Torque range, Nm, ft-lbs | WSC | OAL | **2. Extension key** **Ordering code** | KIC | **1. Retaining nut spanner** **Ordering code** |
|---|---|---|---|---|---|---|---|
| C3 | **C-TK-02** | 40-200 | 1/2" | 345 | **5680 015-05** | 8 | **5680 065-13** |
| | | 30-148 | | 13.583 | | .315 | |
| C4 | **C-TK-02** | 40-200 | 1/2" | 345 | **5680 015-05** | 8 | **5680 065-10** |
| | | 30-148 | | 13.583 | | .315 | |
| C5 | **C-TK-02** | 40-200 | 1/2" | 345 | **5680 015-01** | 10 | **5680 065-11** |
| | | 30-148 | | 13.583 | | .394 | |
| C6 | **C-TK-02** | 40-200 | 1/2" | 345 | **5680 015-02** | 14 | **5680 065-12** |
| | | 30-148 | | 13.583 | | .551 | |
| C8 | **C-TK-02** | 40-200 | 1/2" | 440 | **5680 015-02** | 14 | **5680 065-12** |
| | | 30-148 | | 17.323 | | .551 | |
| C10 | **C-TK-04** | 80-400 | 3/4" | 683 | **5680 015-06** | 17 | **5680 065-14** |
| | | 60-295 | | 26.890 | | .669 | |

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 |

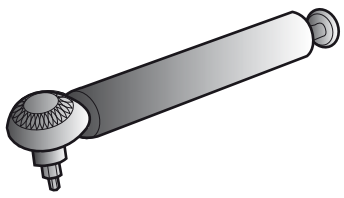
| Ordering code | ER size | MDI size | Bits interface |
|---|---|---|---|
| 5680 103-04 | ER 25 | | 16 |
| 5680 103-05 | ER 32 | 20 | 16 |
| 5680 103-06 | ER 40 | 25 | 16 |
| 5680 103-07 | | 32 | 16 |
| 5680 103-08 | | 40 | 16 |
| 5680 103-09 | | 50 | 16 |

## 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**

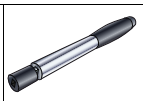


| **Ordering code** |
|---|
| 5680 099-01 |

# Assembly tools

## Coromant EH

### Main spare parts

| | | | | | |  | Torque range | |
|---|---|---|---|---|---|---|---|---|
| Coupling size | Key | Torque wrench head[1)] | Torque wrench head for 2-edge end mill[1)] | Torque value Nm | In-lbs | Torque wrench[1)] | Nm | In-lbs |
| E10 | 5680 093-01 | 5680 089-01 | 5680 089-06 | 12 | 106 | 5680 088-01 | 10-20 | 88-177 |
| E12 | 5680 093-02 | 5680 089-02 | 5680 089-07 | 15 | 132 | 5680 088-01 | 10-20 | 88-177 |
| E16 | 5680 093-03 | 5680 089-03 | 5680 089-08 | 30 | 265 | 5680 088-02 | 25-65 | 221-575 |
| E20 | 5680 093-04 | 5680 089-04 | | 50 | 442 | 5680 088-02 | 25-65 | 221-575 |
| E25 | 5680 093-05 | 5680 089-05 | | 65 | 575 | 5680 088-02 | 25-65 | 221-575 |

[1)] Accessories, must be ordered separately.

# Torx Plus® torque wrench

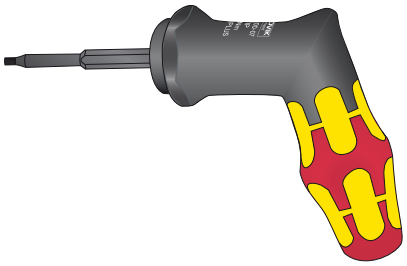
Correct torque when mounting the inserts in milling cutters is a prerequisite for a well functioning tool. Together with the Torx Plus screws, the new wrench guarantees improved and secure insert clamping.

The wrenches, available in 6 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 screws. The new wrench must be ordered separately.

**Note!** Torx Plus is a registered trademark of Camcar Textron (USA).

**Note!**
Please note that the new Torx Plus keys and screwdrivers do NOT fit into the standard Torx screws.



5680 100-07 (20IP) and 5680 100-08 (25IP)

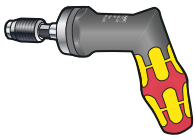
**Torx Plus® torque wrench**

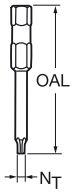
| Torque wrench | Size | Torque in.lbs | Torque Nm | |
|---|---|---|---|---|
| **5680 100-01** | 6IP | 4 | 0.6 | |
| **5680 100-02** | 7IP | 8 | 0.9 | |
| **5680 100-03** | 8IP | 10 | 1.2 | |
| **5680 100-04** | 9IP | 12 | 1.4 | |
| **5680 100-05** | 10IP | 18 | 2.0 | |
| **5680 100-06** | 15IP | 26 | 3.0 | |
| **5680 100-07** | 20IP | 44 | 5.0 | |
| **5680 100-08** | 25IP | 66 | 7.5 | |
| **5680 100-09** | HEX 5 | 53 | 6.0 | |
| **5680 100-10** | 20IP | 53 | 6.0 | |

# Torque wrench and bits

**5680 105-01**
**5680 105-02**
**5680 105-03**
**5680 105-04**

**5680 105-05**
**5680 105-06**
**5680 105-07**
**5680 105-08**





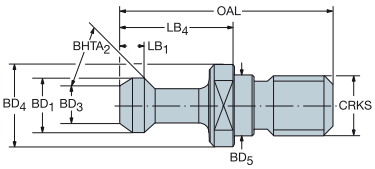

| Torque wrench | Torque range Nm | In-lbs | Handle |
|---|---|---|---|
| **5680 105-01** | 0.3 - 1.2 | | Straight |
| **5680 105-02** | 1.2 - 3.0 | | Straight |
| **5680 105-05** | 3.0 - 6.0 | | Angled |
| **5680 105-06** | 4.0 - 8.8 | | Angled |
| **5680 105-03** | | 2.5 - 11.5 | Straight |
| **5680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

| Bit | OAL mm | OAL inch | $N_T$ Torx Plus |
|---|---|---|---|
| **5680 084-01** | 50 | 1.969 | 8IP |
| **5680 084-02** | 50 | 1.969 | 15IP |
| **5680 084-03** | 89 | 3.504 | 15IP |
| **5680 084-04** | 50 | 1.969 | 7IP |
| **5680 084-05** | 50 | 1.969 | 9IP |
| **5680 084-06** | 50 | 1.969 | 10IP |
| **5680 084-07** | 50 | 1.969 | 20IP |
| **5680 084-08** | 89 | 3.504 | 20IP |
| **5680 084-09** | 89 | 3.504 | 25IP |
| **5680 084-10** | 89 | 3.504 | 30IP |
| **5680 084-11** | 50 | 1.969 | 6IP |
| **5680 084-12** | 80 | 3.150 | 27IP |
| **5680 084-13** | 35 | 1.378 | 50IP |

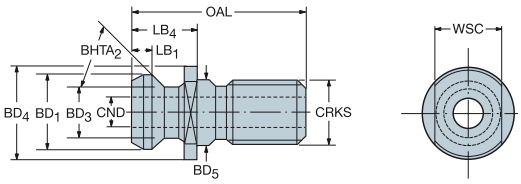
| Bit | OAL mm | OAL inch | $N_T$ Torx Plus |
|---|---|---|---|
| **5680 084-14** | 50 | 1.969 | 30IP |
| **5680 084-15** | 25 | .984 | 15IP |
| **5680 084-16** | 25 | .984 | 30IP |
| **5680 084-17** | 25 | .984 | 6IP |
| **5680 084-18** | 25 | .984 | 7IP |
| **5680 084-19** | 25 | .984 | 8IP |
| **5680 084-20** | 25 | .984 | 9IP |
| **5680 084-21** | 25 | .984 | 10IP |
| **5680 084-22** | 25 | .984 | 20IP |
| **5680 084-23** | 25 | .984 | 25IP |
| **5680 083-01** | 25 | .984 | HEX3 |
| **5680 083-04** | 50 | 1.969 | HEX2,5 |

# Pull stud

PS-Vxx




PS-VxxC



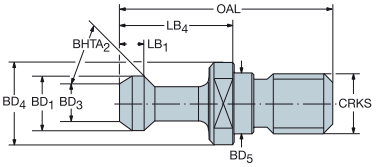

**CAT-V**

| CZC | CRKS | CNSC | CXSC | Ordering code | Dimensions, mm, inch WSC | $LB_1$ | $LB_4$ | CND | $BD_1$ | $BD_3$ | $BD_4$ | $BD_5$ | $BHTA_2$ | OAL | KG | Machine |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 40 | 5/8-11 UNC | 0 | 0 | PS-V40-45-001 | 19 | 7.2 | 32.3 | | 15.0 | 10.0 | 23.8 | 15 | 45° | 57 | 0.08 | |
| | | | | | *.750* | *.283* | *1.272* | | *.590* | *.394* | *.940* | *.614* | | *2.252* | | |
| | 5/8-11 UNC | 0 | 0 | PS-V40-45-002 | 19 | 7.0 | 32.1 | | 15.0 | 10.0 | 23.8 | 16 | 45° | 58 | 0.09 | |
| | | | | | *.750* | *.276* | *1.266* | | *.591* | *.394* | *.940* | *.641* | | *2.303* | | |
| | 5/8-11 UNC | 0 | 0 | PS-V40-45-003 | 19 | 5.0 | 16.2 | | 18.8 | 12.4 | 23.6 | 16 | 45° | 42 | 0.08 | |
| | | | | | *.750* | *.200* | *.640* | | *.740* | *.490* | *.930* | *.640* | | *1.681* | | |
| | 5/8-11 UNC | 0 | 0 | PS-V40-45-004 | 19 | 6.7 | 32.1 | | 14.9 | 9.9 | 23.1 | | 45° | 57 | 0.08 | |
| | | | | | *.750* | *.264* | *1.264* | | *.588* | *.390* | *.910* | | | *2.265* | | |
| | 5/8-11 UNC | 0 | 0 | PS-V40-90-001 | 17 | 7.2 | 32.5 | | 15.0 | 9.9 | 21.8 | 16 | 90° | 58 | 0.08 | |
| | | | | | *.690* | *.287* | *1.280* | | *.590* | *.390* | *.860* | *.640* | | *2.320* | | |
| | M16 | 1 | 1 | PS-V40C-45-001 | 18 | 5.4 | 16.4 | 7.5 | 19.0 | 12.9 | 22.5 | | 45° | 38 | 0.04 | |
| | | | | | *.709* | *.213* | *.646* | *.295* | *.746* | *.510* | *.886* | | | *1.496* | | |
| | 5/8-11 UNC | 1 | 1 | PS-V40C-45-002 | 19 | 5.1 | 16.2 | 7.1 | 18.8 | 12.4 | 23.6 | | 45° | 38 | 0.09 | |
| | | | | | *.750* | *.201* | *.640* | *.281* | *.740* | *.490* | *.929* | | | *1.500* | | |
| | 5/8-11 UNC | 1 | 1 | PS-V40C-45-003 | 17 | 7.1 | 32.2 | 4.1 | 15.0 | 9.9 | 21.8 | 16 | 45° | 58 | 0.07 | |
| | | | | | *.679* | *.280* | *1.268* | *.160* | *.590* | *.390* | *.858* | *.640* | | *2.307* | | |
| | 5/8-11 UNC | 1 | 1 | PS-V40C-45-004 | 19 | 5.1 | 16.2 | 6.0 | 18.8 | 12.4 | 23.6 | | 45° | 41 | 0.05 | |
| | | | | | *.750* | *.201* | *.640* | *.236* | *.740* | *.490* | *.929* | | | *1.624* | | |
| | M16 | 1 | 1 | PS-V40C-45-005 | 19 | 5.1 | 16.2 | 7.1 | 18.8 | 12.4 | 23.6 | 17 | 45° | 41 | 0.05 | |
| | | | | | *.750* | *.201* | *.640* | *.280* | *.739* | *.490* | *.929* | *.669* | | *1.650* | | |
| | M16 | 1 | 1 | PS-V40C-45-006 | 19 | 5.1 | 19.1 | 6.4 | 18.8 | 12.4 | 22.1 | 17 | 45° | 47 | 0.06 | Fadal |
| | | | | | *.750* | *.201* | *.752* | *.252* | *.740* | *.490* | *.870* | *.669* | | *1.854* | | |
| | M16 | 1 | 1 | PS-V40C-45-007 | 19 | 5.0 | 16.2 | 7.1 | 18.8 | 12.4 | 23.6 | | 45° | 38 | 0.20 | |
| | | | | | *.750* | *.200* | *.640* | *.280* | *.740* | *.490* | *.930* | | | *1.500* | | |
| | 5/8-11 UNC | 1 | 1 | PS-V40C-45-008 | 19 | 7.0 | 32.1 | 5.1 | 15.0 | 9.9 | 23.8 | 16 | 45° | 58 | 0.08 | |
| | | | | | *.750* | *.276* | *1.264* | *.200* | *.589* | *.390* | *.940* | *.640* | | *2.303* | | |
| | 5/8-11 UNC | 1 | 1 | PS-V40C-45-009 | 19 | 5.0 | 16.2 | 7.1 | 18.8 | 12.4 | 23.6 | 16 | 45° | 42 | 0.06 | |
| | | | | | *.750* | *.200* | *.640* | *.280* | *.740* | *.490* | *.930* | *.641* | | *1.680* | | |
| | M16 | 1 | 1 | PS-V40C-45-010 | 19 | 7.0 | 32.1 | 4.4 | 15.0 | 9.9 | 23.7 | 16 | 45° | 57 | 0.08 | |
| | | | | | *.750* | *.276* | *1.264* | *.173* | *.589* | *.392* | *.933* | *.669* | | *2.250* | | |
| | 5/8-11 UNC | 1 | 1 | PS-V40C-75-001 | 19 | 5.8 | 25.9 | 7.0 | 18.9 | 13.9 | 22.8 | 16 | 75° | 52 | 0.08 | |
| | | | | | *.750* | *.228* | *1.020* | *.276* | *.744* | *.547* | *.900* | *.640* | | *2.063* | | |
| | 5/8-11 UNC | 1 | 1 | PS-V40C-75-002 | 18 | 5.9 | 26.1 | 6.0 | 18.9 | 13.9 | 22.8 | 16 | 75° | 51 | 0.08 | |
| | | | | | *.740* | *.236* | *1.028* | *.236* | *.746* | *.549* | *.900* | *.641* | | *2.010* | | |
| | 5/8-11 UNC | 1 | 1 | PS-V40C-75-003 | 19 | 5.8 | 25.9 | 7.1 | 19.0 | 13.9 | 22.0 | 16 | 75° | 52 | 0.08 | |
| | | | | | *.750* | *.232* | *1.020* | *.281* | *.747* | *.549* | *.870* | *.641* | | *2.060* | | |
| | 5/8-11 UNC | 1 | 1 | PS-V40C-75-004 | 18 | 6.0 | 26.0 | 6.0 | 18.9 | 13.9 | 23.0 | 16 | 75° | 53 | 0.08 | |
| | | | | | *.740* | *.236* | *1.024* | *.236* | *.744* | *.547* | *.906* | *.642* | | *2.122* | | |

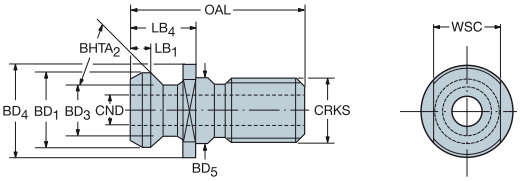
N22 N15

# Pull stud

PS-Vxx




PS-VxxC



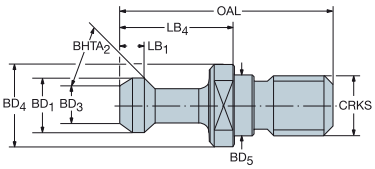

**CAT-V**

| CZC | CRKS | CNSC | CXSC | Ordering code | Dimensions, mm, inch WSC | $LB_1$ | $LB_4$ | CND | $BD_1$ | $BD_3$ | $BD_4$ | $BD_5$ | $BHTA_2$ | OAL | KG | Machine |
|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|---|
| 50 | 1-8 UNC | 0 | 0 | **PS-V50-90-001** | 30 | 10.0 | 44.9 | | 22.9 | 17.0 | 34.7 | 26 | 90° | 84 | 0.30 | |
| | | | | | *1.190* | *.394* | *1.770* | | *.902* | *.670* | *1.370* | *1.031* | | *3.310* | | |
| | M24 | 1 | 1 | **PS-V50C-45-001** | 30 | 7.7 | 25.5 | 11.5 | 29.1 | 19.6 | 37.0 | | 45° | 59 | 0.15 | |
| | | | | | *1.181* | *.305* | *1.006* | *.453* | *1.146* | *.772* | *1.457* | | | *2.323* | | |
| | 1-8 UNC | 1 | 1 | **PS-V50C-45-002** | 31 | 7.6 | 25.4 | 11.9 | 29.0 | 20.8 | 36.3 | | 45° | 58 | 0.18 | |
| | | | | | *1.250* | *.299* | *1.000* | *.469* | *1.140* | *.820* | *1.430* | | | *2.300* | | |
| | 1-8 UNC | 1 | 1 | **PS-V50C-45-003** | 30 | 10.4 | 45.4 | 6.4 | 22.9 | 16.7 | 34.7 | 26 | 45° | 84 | 0.25 | |
| | | | | | *1.190* | *.409* | *1.790* | *.250* | *.900* | *.660* | *1.370* | *1.031* | | *3.330* | | |
| | 1-8 UNC | 1 | 1 | **PS-V50C-45-004** | 31 | 7.6 | 25.4 | 11.9 | 29.0 | 20.8 | 36.5 | | 45° | 65 | 0.18 | |
| | | | | | *1.250* | *.299* | *1.000* | *.469* | *1.140* | *.820* | *1.437* | | | *2.575* | | |
| | 1-8 UNC | 1 | 1 | **PS-V50C-45-005** | 31 | 7.6 | 25.4 | 11.9 | 29.0 | 20.8 | 36.3 | 26 | 45° | 58 | 0.17 | Mazak |
| | | | | | *1.250* | *.299* | *1.000* | *.468* | *1.140* | *.820* | *1.430* | *1.031* | | *2.300* | | |
| | M24 | 1 | 1 | **PS-V50C-45-006** | 31 | 7.6 | 25.4 | 11.9 | 29.0 | 20.8 | 36.3 | 25 | 45° | 65 | 0.19 | |
| | | | | | *1.250* | *.299* | *1.000* | *.470* | *1.140* | *.820* | *1.429* | *.984* | | *2.580* | | |
| | 1-8 UNC | 1 | 1 | **PS-V50C-45-007** | 31 | 7.6 | 25.4 | 11.9 | 29.0 | 20.8 | 36.3 | 26 | 45° | 65 | 0.20 | |
| | | | | | *1.250* | *.300* | *1.000* | *.468* | *1.140* | *.820* | *1.430* | *1.030* | | *2.575* | | |
| | 1-8 UNC | 1 | 1 | **PS-V50C-45-008** | 29 | 9.9 | 45.2 | 9.9 | 22.9 | 16.9 | 38.1 | 24 | 45° | 79 | 0.20 | Makino |
| | | | | | *1.180* | *.390* | *1.780* | *.390* | *.903* | *.668* | *1.500* | *.980* | | *3.140* | | |
| | 1-8 UNC | 1 | 1 | **PS-V50C-60-001** | 29 | 9.9 | 44.9 | 6.1 | 23.0 | 17.0 | 38.1 | 25 | 60° | 82 | 0.29 | Okuma |
| | | | | | *1.180* | *.390* | *1.770* | *.240* | *.904* | *.670* | *1.500* | *1.020* | | *3.250* | | |

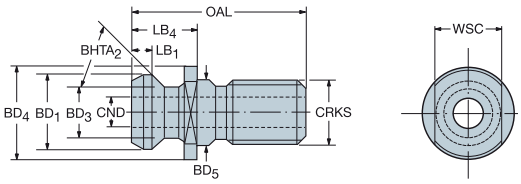
N22 N15

# Pull stud

PS-Ixx




PS-IxxC



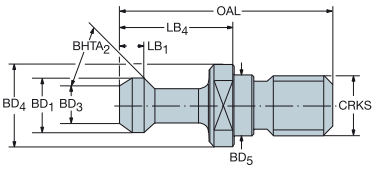

## ISO

| CZC | CRKS | CNSC | CXSC | Ordering code | Dimensions, mm, inch 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 | | |
| | | | | | *.551* | *.197* | *.945* | | *.512* | *.354* | *.669* | *.512* | | *1.732* | | | |
| 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 | |
| | | | | | *.748* | *.236* | *1.024* | | *.748* | *.551* | *.906* | *.669* | | *2.126* | | | |
| | M16 | 1 | 1 | PS-I40C-45-001 | 18 | 5.3 | 16.4 | 7.4 | 19.0 | 12.9 | 22.5 | 17 | 45° | 44 | 0.05 | ISO 7388 B | |
| | | | | | *.709* | *.209* | *.646* | *.289* | *.746* | *.510* | *.886* | *.669* | | *1.752* | | | |
| | M16 | 1 | 1 | PS-I40C-45-002 | 19 | 5.0 | 16.2 | 7.0 | 18.8 | 12.4 | 21.8 | 17 | 45° | 41 | 0.05 | | Mazak |
| | | | | | *.748* | *.200* | *.640* | *.276* | *.740* | *.490* | *.858* | *.669* | | *1.624* | | | |
| | M16 | 1 | 1 | PS-I40C-45-003 | 19 | 5.0 | 19.1 | 7.0 | 18.8 | 12.4 | 22.0 | 17 | 45° | 44 | 0.05 | | Mazak |
| | | | | | *.748* | *.200* | *.752* | *.276* | *.740* | *.490* | *.866* | *.669* | | *1.736* | | | |
| | M16 | 1 | 1 | PS-I40C-75-001 | 19 | 6.0 | 26.0 | 7.0 | 19.0 | 14.0 | 23.0 | 17 | 75° | 54 | 0.05 | DIN 69872 | |
| | | | | | *.748* | *.236* | *1.024* | *.276* | *.748* | *.551* | *.906* | *.669* | | *2.126* | | | |
| | M16 | 1 | 1 | PS-I40C-75-002 | 19 | 6.0 | 26.0 | 7.0 | 19.0 | 14.0 | 23.0 | 17 | 75° | 54 | 0.05 | ISO 7388 | |
| | | | | | *.748* | *.236* | *1.024* | *.276* | *.748* | *.551* | *.906* | *.669* | | *2.126* | | | |
| | M16 | 1 | 1 | PS-I40C-75-003 | 19 | 6.0 | 29.0 | 7.0 | 19.0 | 14.1 | 23.0 | 17 | 75° | 54 | 0.05 | | Mori Seiki |
| | | | | | *.748* | *.236* | *1.142* | *.276* | *.748* | *.555* | *.906* | *.669* | | *2.126* | | | |
| 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 | |
| | | | | | *1.181* | *.299* | *1.006* | | *1.146* | *.772* | *1.457* | *.984* | | *2.579* | | | |
| | 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 | |
| | | | | | *1.181* | *.354* | *1.339* | | *1.102* | *.827* | *1.417* | *.984* | | *2.913* | | | |
| | M24 | 0 | 0 | PS-I50-75-002 | 30 | 9.0 | 34.0 | | 28.0 | 21.0 | 36.0 | 20 | 75° | 74 | 0.15 | | |
| | | | | | *1.181* | *.354* | *1.339* | | *1.102* | *.827* | *1.417* | *.787* | | *2.913* | | | |
| | M24 | 0 | 0 | PS-I50-75-003 | 30 | 9.0 | 34.0 | | 28.0 | 21.1 | 36.0 | 25 | 75° | 74 | 0.15 | | |
| | | | | | *1.181* | *.354* | *1.339* | | *1.102* | *.831* | *1.417* | *.984* | | *2.913* | | | |
| | M24 | 0 | 0 | PS-I50-90-001 | 30 | 10.0 | 46.6 | | 22.0 | 16.0 | 39.0 | 32 | 90° | 99 | 0.15 | | GSP |
| | | | | | *1.181* | *.394* | *1.835* | | *.866* | *.630* | *1.535* | *1.260* | | *3.933* | | | |
| | M24 | 1 | 1 | PS-I50C-45-001 | 30 | 7.6 | 25.5 | 11.5 | 29.1 | 19.6 | 37.0 | 25 | 45° | 65 | 0.15 | ISO 7388 B | |
| | | | | | *1.181* | *.299* | *1.004* | *.453* | *1.146* | *.772* | *1.457* | *.984* | | *2.559* | | | |
| | M24 | 1 | 1 | PS-I50C-45-002 | 26 | 5.2 | 16.4 | 7.4 | 19.0 | 12.9 | 30.0 | 25 | 45° | 56 | 0.15 | | |
| | | | | | *1.024* | *.207* | *.646* | *.289* | *.746* | *.510* | *1.181* | *.984* | | *2.219* | | | |
| | M24 | 1 | 1 | PS-I50C-45-003 | 30 | 7.6 | 25.4 | 10.0 | 29.0 | 20.8 | 36.5 | 25 | 45° | 65 | 0.15 | | Yamazaki |
| | | | | | *1.187* | *.300* | *1.000* | *.394* | *1.140* | *.820* | *1.439* | *.984* | | *2.575* | | | |
| | M24 | 1 | 1 | PS-I50C-45-004 | 30 | 7.6 | 25.4 | 10.0 | 29.0 | 20.8 | 36.5 | 25 | 45° | 65 | 0.15 | | Yamazaki |
| | | | | | *1.187* | *.300* | *1.000* | *.394* | *1.140* | *.820* | *1.439* | *.984* | | *2.575* | | | |
| | M24 | 1 | 1 | PS-I50C-75-001 | 30 | 9.0 | 34.0 | 11.5 | 28.0 | 21.0 | 36.0 | 25 | 75° | 74 | 0.15 | DIN 69872 | |
| | | | | | *1.181* | *.354* | *1.339* | *.453* | *1.102* | *.827* | *1.417* | *.984* | | *2.913* | | | |
| | M24 | 1 | 1 | PS-I50C-75-002 | 30 | 9.0 | 34.0 | 11.5 | 28.0 | 21.0 | 36.0 | 25 | 75° | 74 | 0.15 | ISO 7388 | |
| | | | | | *1.181* | *.354* | *1.339* | *.453* | *1.102* | *.827* | *1.417* | *.984* | | *2.913* | | | |
| | M24 | 1 | 1 | PS-I50C-90-001 | 30 | 6.5 | 32.5 | 6.0 | 20.0 | 13.0 | 38.5 | | 90° | 70 | 0.15 | | Forest |
| | | | | | *1.181* | *.256* | *1.280* | *.236* | *.787* | *.512* | *1.516* | | | *2.756* | | | |

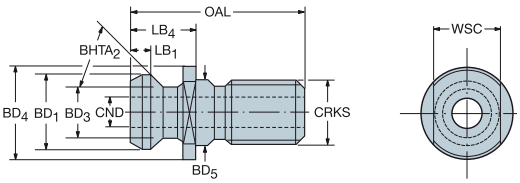
N22 N15

# Pull stud

PS-Bxx




PS-BxxC




**MAS-BT**

| CZC | CRKS | CNSC | CXSC | Ordering code | Dimensions, mm, inch 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 | | |
| | | | | | *.512* | *.197* | *.906* | | *.433* | *.276* | *.630* | *.472* | | *1.693* | | | |
| | M12 | 0 | 0 | PS-B30-60-001 | 13 | 7.0 | 35.0 | | 11.0 | 7.0 | 16.0 | 12 | 60° | 43 | 0.03 | | |
| | | | | | *.512* | *.276* | *1.378* | | *.433* | *.276* | *.630* | *.472* | | *1.693* | | | |
| | M12 | 1 | 1 | PS-B30C-45-001 | 13 | 5.0 | 23.0 | 2.4 | 11.0 | 7.0 | 16.5 | 12 | 45° | 43 | 0.03 | | |
| | | | | | *.512* | *.197* | *.906* | *.094* | *.433* | *.276* | *.650* | *.492* | | *1.693* | | | |
| | M12 | 1 | 1 | PS-B30C-45-002 | 13 | 5.0 | 23.0 | 2.5 | 11.0 | 7.0 | 16.5 | 12 | 45° | 43 | 0.03 | | Mori Seiki |
| | | | | | *.512* | *.197* | *.906* | *.098* | *.433* | *.276* | *.650* | *.492* | | *1.693* | | | |
| | M12 | 1 | 1 | PS-B30C-45-003 | 13 | 5.0 | 23.0 | 4.0 | 11.0 | 8.0 | 16.5 | 12 | 45° | 43 | 0.03 | | Fanuc |
| | | | | | *.512* | *.197* | *.906* | *.157* | *.433* | *.315* | *.650* | *.492* | | *1.693* | | | |
| | M12 | 1 | 1 | PS-B30C-60-001 | 13 | 5.0 | 23.0 | 2.4 | 11.0 | 7.0 | 16.5 | 12 | 60° | 43 | 0.03 | | |
| | | | | | *.512* | *.197* | *.906* | *.094* | *.433* | *.276* | *.650* | *.492* | | *1.693* | | | |
| | M12 | 1 | 1 | PS-B30C-60-002 | 13 | 5.0 | 23.0 | 2.5 | 11.0 | 7.5 | 16.5 | 12 | 60° | 43 | 0.03 | | Brother |
| | | | | | *.512* | *.197* | *.906* | *.098* | *.433* | *.295* | *.650* | *.492* | | *1.693* | | | |
| 40 | M16 | 0 | 0 | PS-B40-45-001 | 19 | 7.0 | 35.0 | | 15.0 | 10.0 | 23.0 | 17 | 45° | 60 | 0.05 | | |
| | | | | | *.748* | *.276* | *1.378* | | *.591* | *.394* | *.906* | *.669* | | *2.362* | | | |
| | M16 | 0 | 0 | PS-B40-60-001 | 19 | 7.0 | 35.0 | | 15.0 | 10.0 | 23.0 | 17 | 60° | 60 | 0.05 | | |
| | | | | | *.748* | *.276* | *1.378* | | *.591* | *.394* | *.906* | *.669* | | *2.362* | | | |
| | M16 | 0 | 0 | PS-B40-90-001 | 19 | 7.0 | 35.0 | | 15.0 | 10.0 | 23.0 | 17 | 90° | 60 | 0.05 | | |
| | | | | | *.748* | *.276* | *1.378* | | *.591* | *.394* | *.906* | *.669* | | *2.362* | | | |
| | M16 | 1 | 1 | PS-B40C-45-001 | 19 | 7.0 | 35.0 | 4.0 | 15.0 | 10.0 | 23.0 | 17 | 45° | 60 | 0.05 | | |
| | | | | | *.748* | *.276* | *1.378* | *.157* | *.591* | *.394* | *.906* | *.669* | | *2.362* | | | |
| | M16 | 1 | 1 | PS-B40C-45-002 | 17 | 6.9 | 34.9 | 5.0 | 14.9 | 9.9 | 21.8 | 17 | 45° | 60 | 0.05 | | |
| | | | | | *.689* | *.272* | *1.374* | *.197* | *.587* | *.390* | *.858* | *.669* | | *2.362* | | | |
| | M16 | 1 | 1 | PS-B40C-60-001 | 19 | 7.0 | 35.0 | 3.0 | 15.0 | 10.0 | 23.0 | 17 | 60° | 60 | 0.05 | | |
| | | | | | *.748* | *.276* | *1.378* | *.118* | *.591* | *.394* | *.906* | *.669* | | *2.362* | | | |
| | M16 | 1 | 1 | PS-B40C-75-001 | 18 | 11.4 | 25.1 | 7.4 | 25.3 | 21.1 | 25.3 | 17 | 75° | 53 | 0.05 | | |
| | | | | | *.709* | *.449* | *.988* | *.289* | *.996* | *.831* | *.996* | *.669* | | *2.091* | | | |
| | M16 | 1 | 1 | PS-B40C-75-002 | 19 | 6.0 | 29.0 | 7.0 | 19.0 | 14.0 | 23.0 | 17 | 75° | 54 | 0.05 | JIS 40 | |
| | | | | | *.748* | *.236* | *1.142* | *.276* | *.748* | *.551* | *.906* | *.669* | | *2.126* | | | |
| | M16 | 1 | 1 | PS-B40C-75-003 | 18 | 6.0 | 26.0 | 7.0 | 19.0 | 13.9 | 22.9 | 17 | 75° | 54 | 0.05 | | |
| | | | | | *.740* | *.236* | *1.024* | *.276* | *.748* | *.547* | *.902* | *.669* | | *2.130* | | | |
| | M16 | 1 | 1 | PS-B40C-90-001 | 19 | 7.0 | 35.0 | 3.0 | 15.0 | 10.0 | 23.0 | 17 | 90° | 60 | 0.05 | | |
| | | | | | *.748* | *.276* | *1.378* | *.118* | *.591* | *.394* | *.906* | *.669* | | *2.362* | | | |
| 50 | M24 | 0 | 0 | PS-B50-45-001 | 30 | 10.0 | 45.0 | | 23.0 | 17.0 | 38.0 | 25 | 45° | 85 | 0.25 | | |
| | | | | | *1.181* | *.394* | *1.772* | | *.906* | *.669* | *1.496* | *.984* | | *3.346* | | | |
| | M24 | 0 | 0 | PS-B50-45-002 | 30 | 10.0 | 45.0 | | 22.9 | 16.9 | 34.7 | 24 | 45° | 84 | 0.25 | | |
| | | | | | *1.185* | *.394* | *1.772* | | *.902* | *.665* | *1.370* | *.980* | | *3.339* | | | |
| | M24 | 0 | 0 | PS-B50-60-001 | 30 | 10.0 | 45.0 | | 23.0 | 17.0 | 38.0 | 25 | 60° | 85 | 0.25 | | |
| | | | | | *1.181* | *.394* | *1.772* | | *.906* | *.669* | *1.496* | *.984* | | *3.346* | | | |
| | M24 | 0 | 0 | PS-B50-90-001 | 30 | 10.0 | 45.0 | | 23.0 | 17.0 | 38.0 | 25 | 90° | 85 | 0.25 | | Okuma |
| | | | | | *1.181* | *.394* | *1.772* | | *.906* | *.669* | *1.496* | *.984* | | *3.346* | | | |
| | M24 | 1 | 1 | PS-B50C-45-001 | 30 | 10.0 | 45.0 | 7.5 | 23.0 | 17.0 | 38.0 | 25 | 45° | 85 | 0.25 | | |
| | | | | | *1.181* | *.394* | *1.772* | *.295* | *.906* | *.669* | *1.496* | *.984* | | *3.346* | | | |
| | M24 | 1 | 1 | PS-B50C-60-001 | 30 | 10.0 | 45.0 | 8.5 | 23.0 | 17.0 | 38.0 | 25 | 60° | 85 | 0.25 | | |
| | | | | | *1.181* | *.394* | *1.772* | *.335* | *.906* | *.669* | *1.496* | *.984* | | *3.346* | | | |
| | M24 | 1 | 1 | PS-B50C-75-001 | 30 | 9.0 | 34.0 | 11.5 | 28.0 | 21.0 | 36.0 | 25 | 75° | 74 | 0.22 | JIS 50 | |
| | | | | | *1.181* | *.354* | *1.339* | *.453* | *1.102* | *.827* | *1.417* | *.984* | | *2.913* | | | |
| | M24 | 1 | 1 | PS-B50C-90-001 | 30 | 8.0 | 31.0 | 6.0 | 24.0 | 18.0 | 36.0 | 25 | 90° | 71 | 0.20 | | Mitsui |
| | | | | | *1.181* | *.315* | *1.220* | *.236* | *.945* | *.709* | *1.417* | *.984* | | *2.795* | | | |
| | M24 | 1 | 1 | PS-B50C-90-002 | 30 | 10.0 | 45.0 | 8.0 | 23.0 | 17.0 | 38.0 | 25 | 90° | 85 | 0.25 | | Okuma |
| | | | | | *1.181* | *.394* | *1.772* | *.315* | *.906* | *.669* | *1.496* | *.984* | | *3.346* | | | |

N22 N15

# General information

# Wiper

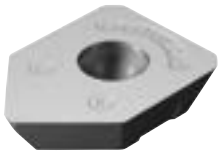
## Inserts for increased productivity

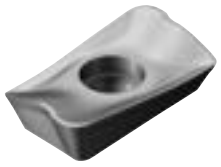
**Wiper**

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.

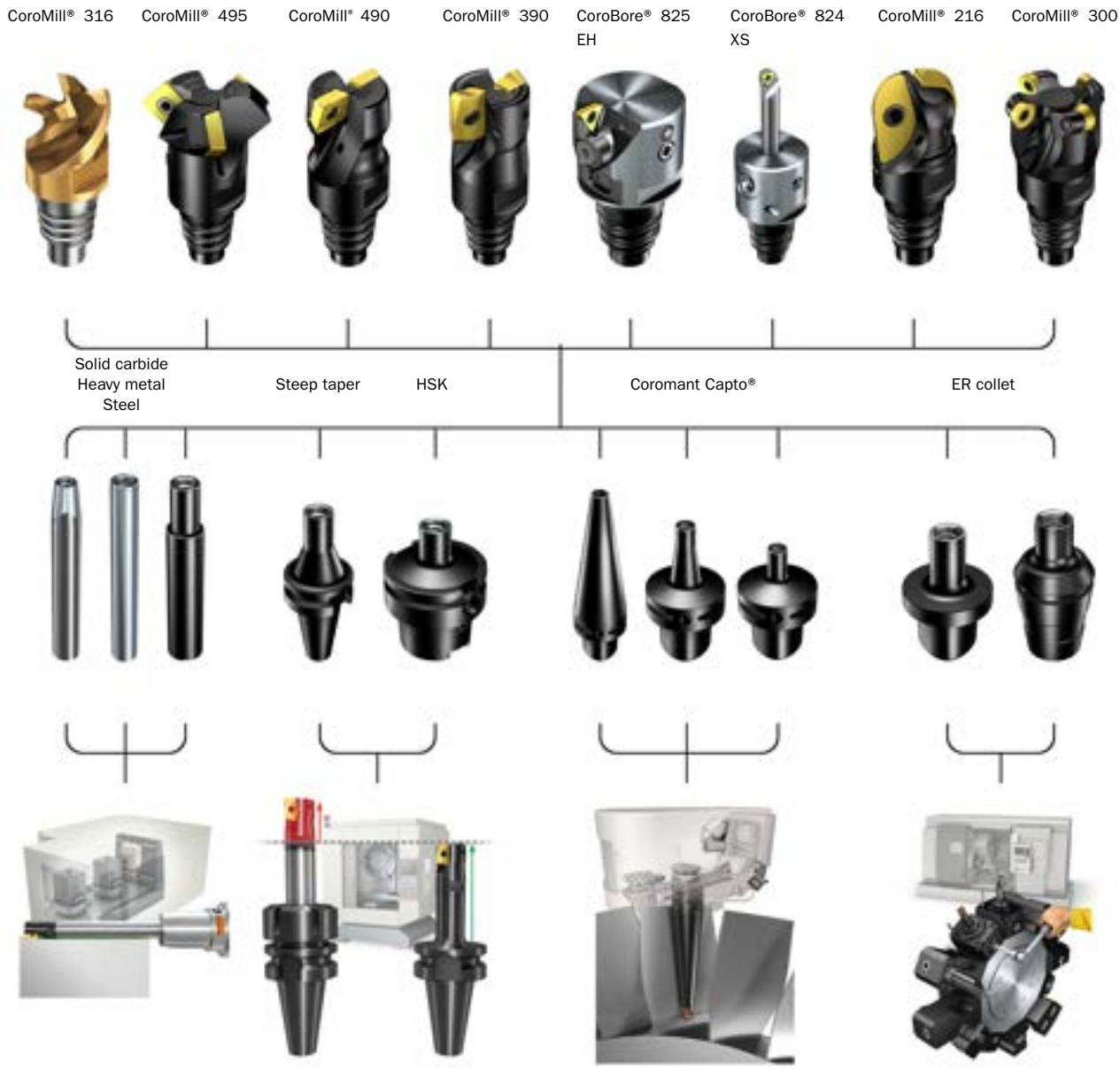
TECHNOLOGY Wiper





# Modular system - Coromant EH

## Tooling flexibility for small diameters




**Large machining centers**

Long overhang with stability and clearance.

**Small and medium machining centers**

When gauge line is critical.

**Medium to large machining centers**

Modularity with Coromant Capto® in different lengths.

**Turning centers with driven tool holders**

Short gauge length and swing diameter.

For more information about Coromant EH system, see:
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 common machine interfaces

### Benefits and features

- High metal removal rate provides increased productivity
- Secure process and safe machining
- Quick tool change and setup
- Enhanced surface finish and increased tool life
- Close hole tolerance
- Best pull-out security on the market thanks 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 the 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 (HPC) 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

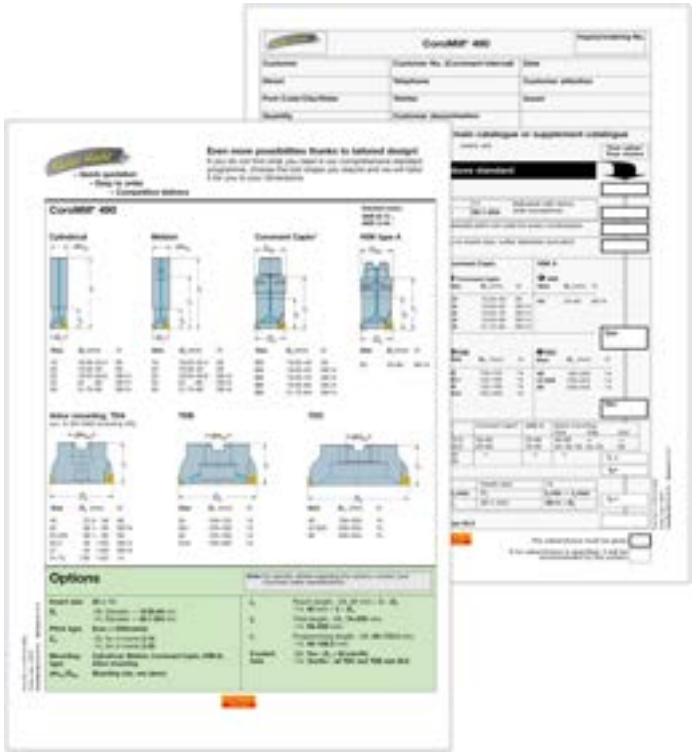
- ER sizes for CoroChuck® 970: 8, 11, 20, 25, 32, 40, and 50.
- ER size 50 has a square inside the adapter, and should be used with the largest tap (M48). The collet that will be used with this large tap will be a collet without a square.
- For HSK 63 and HSK 100, it is possible to use MQL on ER sizes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



In addition to our comprehensive standard program, we can offer tools to your dimensions on standard tool terms. With our Tailor Made Service, you are free to specify your own dimensions.

### What you can expect from us

- Quick quotation
- Easy ordering
- Performance guarantee for 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

## Drilling

- CoroDrill® 870
- CoroDrill® 880
- CoroDrill® 881
- Coromant U

## Adapters

- Coromant EH
- CoroChuck™ 930
- Coromant Capto®
- Coromant disc mill adapters

### ...and engineered solutions

When standard and Tailor Made solutions do not fulfill your needs, you can depend on Sandvik Coromant's extensive experience in engineered tool solutions to cope with particularly demanding criteria.
Access our Tailor Made forms at www.sandvik.coromant.com

# For the sake of the environment

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

The Coromant Recycling Concept (CRC) is a comprehensive service for used carbide inserts (including CBN and PCD if “carrier” is cemented carbide) and solid carbide tools offered by Sandvik Coromant to all its customers.
In the light of increasing consumption of non-renewable raw materials, the economic management of dwindling resources is a duty owed by all manufacturers.
Sandvik Coromant is playing its part by offering to collect used carbide inserts and solid carbide tools and recycle them in the most environmentally friendly way.
All used hard-metal 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 Coromant dealer who can also give you more information.

### The benefits of the CRC speak for themselves

- A one-stop worldwide recycling system.
- For direct and trade 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 center. 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 (wooden): | 92994 |
| Transport box inserts (wooden): | 92995 |

# Safety information

## Material compositon

Hard metal products contain tungsten carbide and cobalt. Other substances may contain titanium carbide, tantalum carbide, niobium carbide, chromium carbide, molybdenum carbide or vanadium carbide. Some grades contain titanium carbo nitride and/or nickel.

## Routes of exposure

Grinding or heating of hard metal blanks or hard metal products will produce dust or fumes with dangerous ingredients that can be inhaled, swallowed or come in contact with the skin or eyes.

## Acute toxicity

The dust is toxic by inhalation. 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. Personnel whose skin is sensitive may experience an allergic reaction.

## Chronic toxicity

Repeated inhalation of aerosols containing cobalt may cause obstruction in the airways. Prolonged inhalation of increased concentrations may cause lung fibrosis or lung cancer. Epidemiological studies indicate that workers exposed in the past 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.

## Risk phrases

Toxic: danger of serious damage to health by prolonged exposure through inhalation
Toxic by inhalation
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 the nationally authorised limits.
If ventilation is not available or adequate, use respirators nationally 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 as needed.
Do not eat, drink or smoke in the working area. Wash skin thoroughly before eating, drinking or smoking.

# General code key for CoroMill cutters

| 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 (2.480 inch)

**5 Type of coupling**

A = Cylindrical, mm
B = Weldon mm
C = Coromant Capto®
D = Cylindrical inch
J = CIS Tenon drive
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 (.866 inch)

**7** Extra long

L = Extra long

**8** Insert size

11 = 11 mm (.433 inch) (LE)

**9**

L = Coarse pitch
M = Close pitch
H = Extra close pitch

**10** Length, LF

E.g.: 050 = 50 mm (1.969 inch)

# 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

R = Right hand

L = Left hand

### 2 Main code

E.g.: 390= CoroMill® 390

### 3 Insert width

E.g.: 11=11 mm ( .433 inch )

### 4 Insert thickness, S

E.g.: T3 S = 3.97 (.156 inch)

04 S = 4.76 (.187 inch)

06 S = 6.33 (.250 inch)

### 5 Corner radius

E.g.: 12 = 1.2 mm ( .047 inch)

### 6 Edge performance

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

P M K N S H

### 8 Operation

L = Light cutting
M = Medium
H = Heavy
T = Turn milling

### 9 Wiper

W = Wiper

# 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 (.008 inch)
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
- inch: No. of threads per inch

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 DMM
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 (.008 inch)
6 Geometry
GM = Grooving
GC = Grooving and chamfering
TH = Threading
7 Chamfer 45°
8 Thread pitch — mm: pitch x 100; inch: No. of threads per inch
9 Type of thread — VM = V-Profile 60°

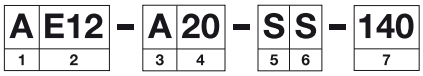
## CoroMill® 328 cutters

| 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

# Code key for toolholders

Cylindrical holder




Coromant Capto® holder

Solid holder

| 1 System of measurement | | 2 Size of interface | | 3 Holder type | |
|---|---|---|---|---|---|
| A = | Inch version | E12= | EH coupling size | A = | Cylindrical |

| 4 Holder diameter | | 5 Type of holder | | 6 Holder material | | 7 Length of holder | |
|---|---|---|---|---|---|---|---|
| E.g.: | DCON = 20 mm (.787 inch) | S = | Straight | S = | Steel | E.g.: | 140 = 140 mm (5.512 inch) |
| | | C = | Conical | E = | Solid carbide | | |

| 8 Coupling size | | 9 Family/ holder type | | 10 Size of interface | 11 Taper size |
|---|---|---|---|---|---|
| C = | Coromant Capto® | 391.EH = | Coromant Capto® EH holder | EH coupling size | Taper size for Coromant solid holders |
| | | 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 | | |

# 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 center**

**3 Spindle type**

1=ISO 7388/1 (DIN 69871)
2= MAS-BT
3=CAT V-Flange

**4 Options**

B= Coolant through flange
F= Flange mounting
X= Extra short

**5 Holder type**

05 = Face mill holder
14= ER Collet chuck
20=Endmill 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

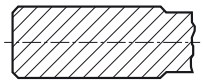
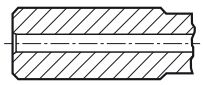
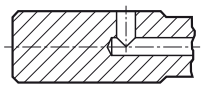
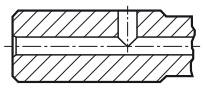
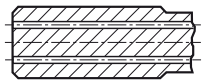
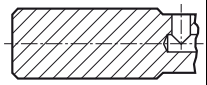
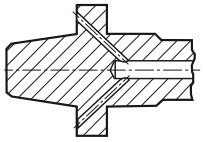
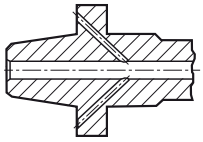
| | | |
|---|---|---|
| 09 (0.375) | 19 (0.750) | 38 (1.500) |
| 13 (0.500) | 25 (1.000) | 51 (2.000) |
| 16 (0.625) | 32 (1.250) | 63 (2.500) |

**8 Programming length, mm**

060 = 60 mm (2.362 inch)

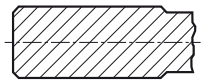
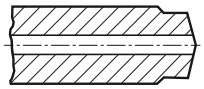
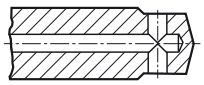
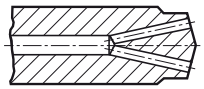
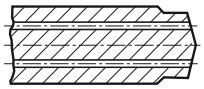
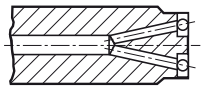
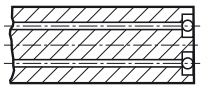
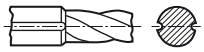
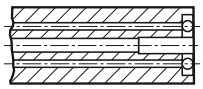
## CNSC

**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 adapter |  |
| 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 |  |

# Conversion table

**Metric to imperial**

Distance

1 meter = 39.370 inch
1 meter = 3.281 feet
1 millimeter = 0.039 inch

Weight

1 kilogram = 2.205 pounds
1 kilogram = 35.274 ounces

Torque

1 Newton meter (Nm) = 0.738 pound-force feet (ft-lbs)

1 Newton meter (Nm) = 8.851 pound-force inches (in-lbs)

**Imperial to metric**

Distance

1 inch = 25.4 millimeter
1 foot = 0.3 meter
1 foot = 304.8 millimeter

Weight

1 pound = 0.45 kilogram
1 ounce = 28.35 gram

Torque

1 pound-force foot (ft-lbf) = 1.4 Newton meter (Nm)

1 pound-force inch (in-lbf) = 0.1 Newton meter (Nm)

# Formulas and definitions:

| | **Metric** | **Imperial** |
|---|---|---|
| $v_c$ = Cutting speed | m/min (meter/minute) | ft/min (feet/minute) |
| $n$ = Spindle speed | rpm (revolution per minute) | |
| $v_f$ = table feed | mm/min | inch/min |
| $z_n$ = total number of cutting edges | | |
| $z_c$ = number of effective cutting edges | | |
| $f_z$ = feed per tooth | mm/z | inch/z |
| $f_n$ = Feed per revolution | mm/rev | inch/rev |
| $h_{ex}$ = maximum thickness | mm | inch |
| $a_p$ = Cutting depth | mm | inch |
| $l_a$ = insert width | mm | inch |
| $a_e$ = cutting width | mm | inch |
| $a_e/D_c$ % = Radial immersion | % | % |
| $T$ = Machining time | min | min |
| $Q$ = Metal removal rate | $cm^3/min$ | $inch^3/min$ |
| $nap$ = number of passes | | |
| TPI = threads per inch | | |
| $k_c$ = specific cutting force | $N/mm^2$ | $lbs/in^2$ |
| $R_a$ = Surface roughness | µm | µin |

**Insert size**

*iC* = inscribed circle in inch

△ = cutting edge length in mm

# 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** | | | | | | | | | | | |
| 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 | - |
| | 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<br>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 |

# Material cross reference list

| ISO | MC | CMC | Country<br>Europe | Germany | Great Britain | | Sweden | USA | France | Italy | Spain | Japan |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Standard<br>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<br>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<br>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<br>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.) |



SANDVIK Coromant

# Material cross reference list

| ISO | MC | CMC | Country<br>Europe | Germany | Great Britain | | Sweden | USA | France | Italy | Spain | Japan |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Standard<br>DIN EN | W.-nr. | BS | EN | SS | AISI/SAE/ASTM | AFNOR | UNI | UNE | JIS |
| M | **Austenitic stainless steel** | | | | | | | | | | | |
| | M1.0.Z.AQ | 05.11/15.11 | X3CrNiMo13-4 | 1.4313 | 425C11 | - | 2385 | CA6-NM | Z4CND13.4M<br>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<br>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) | | | | | | | |

Stainless steel

# Material cross reference list

| ISO | MC | CMC | Country<br>Europe | Germany | Great Britain | | Sweden | USA | France | Italy | Spain | Japan |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Standard<br>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 |
| | **Gray 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 | - | - | - |
| | **Nodular cast iron** | | | | | | | | | | | |
| 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<br>Europe | Germany | Great Britain | | Sweden | USA | France | Italy | Spain | Japan |
|---|---|---|---|---|---|---|---|---|---|---|---|---|
| | | | Standard<br>DIN EN | W.-nr. | BS | EN | SS | AISI/SAE/ASTM | AFNOR | UNI | UNE | JIS |
| N Non-ferrous metals | **Aluminum based alloys** | | | | | | | | | | | |
| | 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-AlSI12 | 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 Heat resistant super alloys | **Nickel based 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 base** | | | | | | | | | | | |
| | - | - | 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<br>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 base** | | | | | | | | | |
| | 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 |

**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 between software systems becomes very straightforward.

### How this benefits 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 catalogs 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 | Axial clearance angle |
| AN | Clearance angle major |
| ANN | Minor clearance angle |
| 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 | Workpiece side body angle |
| 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 |
| CBMD | Chip breaker manufacturer |
| 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 | Maximum axial groove outside diameter |
| 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 | Minimum cutting diameter |
| DCON | Connection diameter |
| $DCON_{MS}$ | Connection diameter machine side |
| $DCON_{WS}$ | Connection diameter work piece 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 |
| $DCSF_{WS}$ | Workpiece side contact surface diameter |
| DCX | Maximum cutting diameter |
| DHUB | Hub diameter |
| DIX | Maximum tool changer interference diameter |
| 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 | Actual thread height |
| HF | Functional height |
| HRY | Lowest point from reference plain |
| HSUP | Support height |
| 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 | Chip flute length |
| 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 | Minimum clamping length |
| LSCS | Distance to clamping start |
| LSCX | Maximum clamping length |
| LSD | Dead shank length |
| LU | Usable length (max. recommended) |
| LU_BFW | Usable length – Back facing |
| LUX | Usable maximum length |
| 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 | Minimum overhang |

| | |
|---|---|
| OHX | Maximum overhang |
| ORDCODE | Order code |
| 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 | Major left hand cutting edge angle |
| PSIRR | Major right hand cutting edge angle |
| PSW | Pre-machined 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 | Split line |
| 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 | Thread form type |
| THFTS | Thread form standard series |
| THL | Thread length |
| THUB | Hub thickness |
| TP | Thread pitch |
| TPI | Threads per inch |
| TPIN | Minimum threads per inch |
| TPIX | Maximum threads per inch |
| TPN | Minimum thread pitch |
| TPT | Thread profile type |
| TPX | Maximum thread pitch |
| TRMAX | Tap range max |
| TQ | Torque |
| TSYC | Tool style code |
| TTP | Thread type |
| ULDR | Usable length diameter ratio |
| VCX | Maximum cutting speed |
| W1 | Insert width |
| WB | Body width |
| WF | Functional width |
| WFCIRP | Width to cutting item reference point |
| WSC | Clamping width |
| WT | Weight of item |
| ZADJ | Insert adjustable count |
| ZEFF | Face effective cutting edge count |
| ZEFP | Peripheral effective cutting edge count (ZEFP) |
| ZWX | Maximum number of Wiper inserts |

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