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

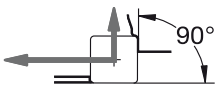


Extra close pitch

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

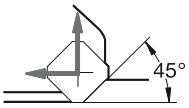
Entering angle

90° entering angle



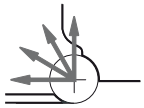
- Thin-walled components
- Weak-fixtured components
- Where 90° form is required

45° entering angle



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

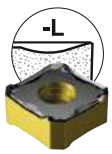
Round insert cutters



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

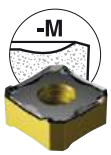
Insert geometries

Light



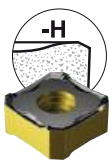
Extra positive, light machining, low cutting forces and for low feed rates.

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

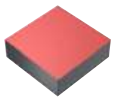
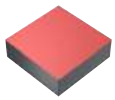
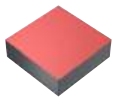
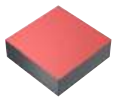
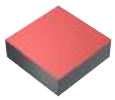
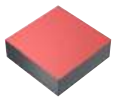
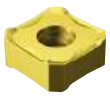
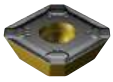
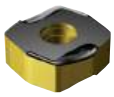
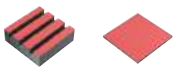

Grooving


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

CoroMill® 345

Face mill for high productivity

Application

- Face milling
- Roughing to finishing

ISO application area:

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

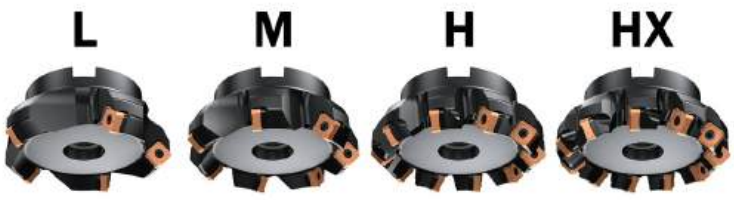
www.sandvik.coromant.com/coromill345

Couplings

- Coromant Capto®
- Arbor
- Cylindrical shank

Inserts

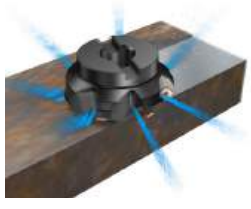
- Eight cutting edges
- Wiper inserts for excellent surface finish at high feed per tooth



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

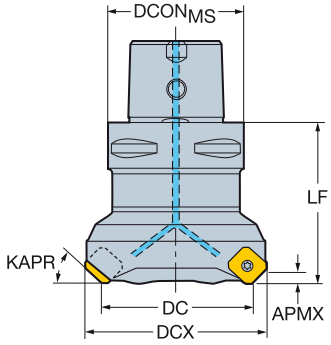
SANDVIK Coromant

CoroMill® 345 face milling cutter

Coromant Capto® - Internal coolant supply

STDNO ISO26623-1
KAPR 45°





Metric version

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

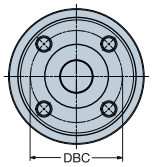
I9 L2 N22 N9 N15

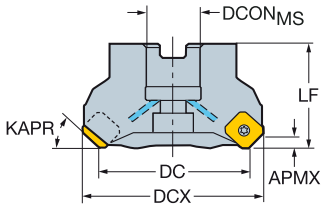
CoroMill® 345 face milling cutter

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

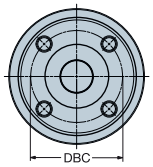
SANDVIK Coromant

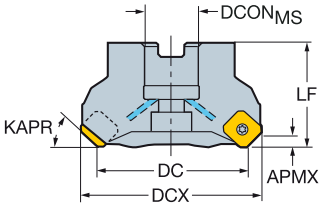
CoroMill® 345 face milling cutter

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

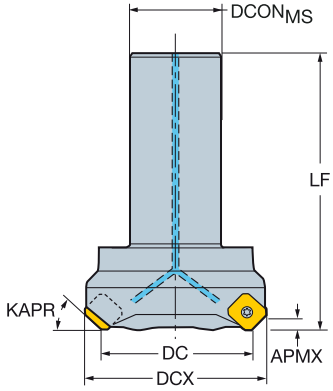
I9 L2 M1 N22 N9 N15

CoroMill® 345 face milling cutter

Cylindrical shank - Internal coolant supply

KAPR 45°





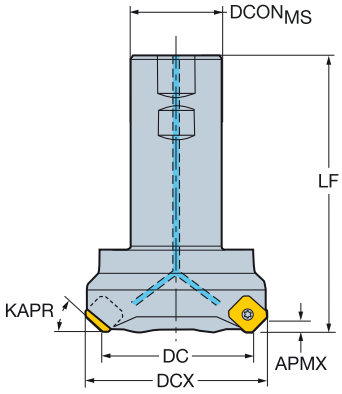
Metric version

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

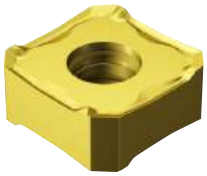
For the complete list of spare parts, visit www.sandvik.coromant.com

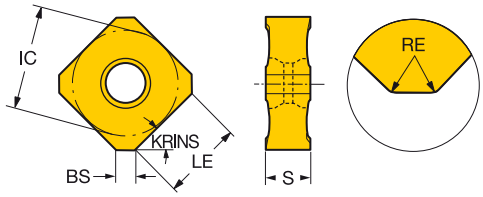
I9 L2 N22 N10 N15

SANDVIK Coromant

CoroMill® 345 insert for milling

KRINS 45°

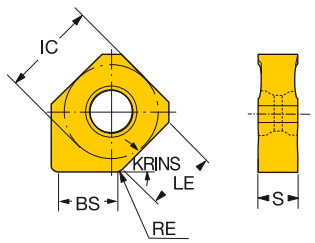




			RE	Ordering code	P 1130	P 4220	P 4330	P 4340	P 530	M 1040	M 2030	M 2040	M 530	M S30T	K 1020	K 3040	K 3220	K 3330	K K20W	N 1130	N 530	S S30T	S S40T	H 1010	H 1130	H 530	IC	LE	S	BS
Dimensions, mm, inch																													
Light	KL	13	0.80	345R-1305E-KL											★	☆	☆	☆	☆								13.0	8.8	5.05	2.0
			.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°





TECHNOLOGY Wiper

			RE	Ordering code	P 1010	P 1130	P 4330	P 530	M 1040	M 2030	M 2040	M 530	M S30T	K 1020	K 3220	K 3330	K K20W	N 1130	N 530	N H13A	S 2030	S 2040	S H13A	S S30T	S S40T	H 1010	H 1130	H 530	IC	LE	S	BS	BSR
Dimensions, mm, inch																																	
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

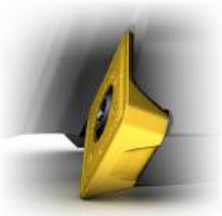
- Arbor
- Cylindrical shank

Inserts

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

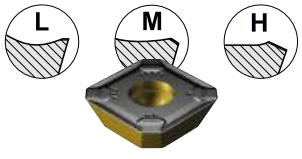


Coarse pitch Close pitch Extra close pitch



Light cutting action

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



I11 I15 N6

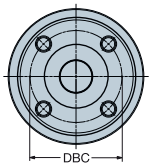
SANDVIK Coromant

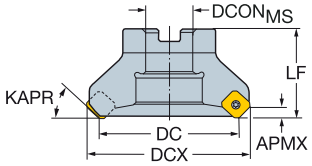
CoroMill® 245 face milling cutter

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

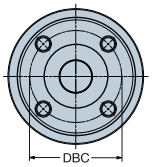
I15 L2 M1 N22 N6 N9

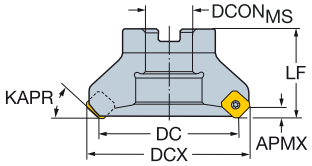
CoroMill® 245 face milling cutter

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

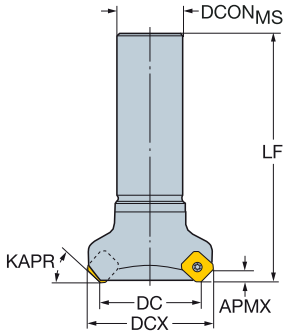
I15 L2 M1 N22 N6 N9

CoroMill® 245 face milling cutter

Cylindrical shank

KAPR 45°





Metric version

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

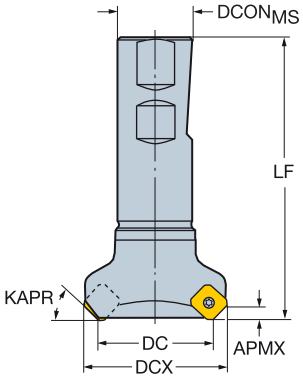
I15 L2 N22 N6 N9

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

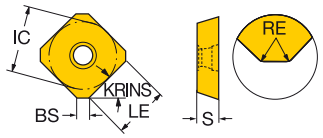
I15 L2 N22 N6 N9

SANDVIK Coromant

CoroMill® 245 insert for milling



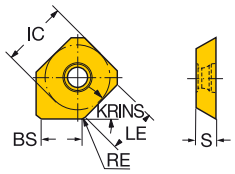
KRINS 45°



		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	R245-12 T3 E-W	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	13.4	3.5	3.97	6.4	400.0
			.098																					.528	.138	.156	.252	15.748
		18	1.00	R245-18 T6 E-W		☆			☆							☆			☆			☆		18.0	13.9	6.10	10.8	500.0
			.039																					.709	.547	.240	.425	19.685


I11

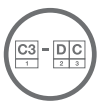

I222



I254



N22



N10

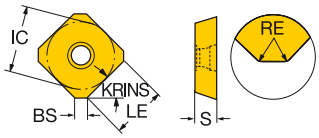

N2

CoroMill® 245 insert for milling

Advanced cutting materials

KRINS 45°





	RE		Ordering code	K 6190	K CB50	N CD10	H 6190	H CB50	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

Dimensions, mm, inch

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.



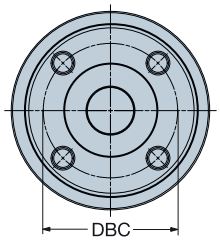
I18 I20

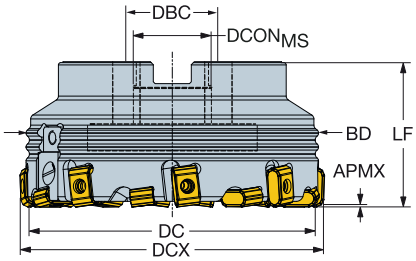
CoroMill® 425 face milling cutter

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

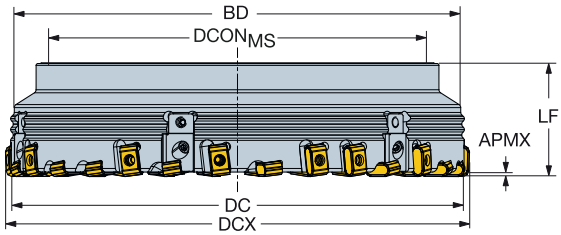
I20 L2 M1 N22 N9

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

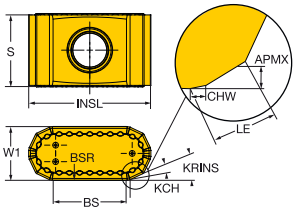
For the complete list of spare parts, visit www.sandvik.coromant.com

I20 L2 N22 N9

CoroMill® 425 insert for milling



KRINS 25°



			KCH	CHW	Ordering code	K 1010	K 1020	K 3220	K 3330	K K20W	Dimensions, mm, inch 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.

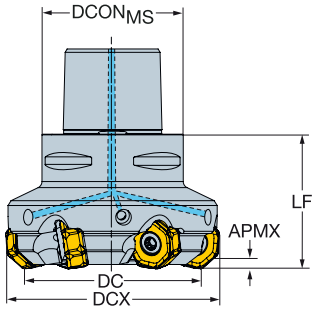
I22 I56

CoroMill® 745 face milling cutter

Coromant Capto® - Internal coolant supply

KAPR 42°





Metric version

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

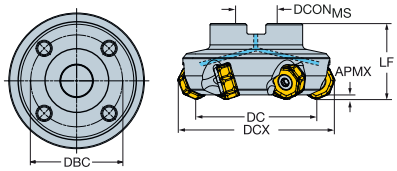
I56 L2 N22 N9 N15

CoroMill® 745 face milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462:2011
KAPR 42°





Metric version

DC		CZCMS	APMX	CNSC			Ordering code	Dimensions, mm DCONMS	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

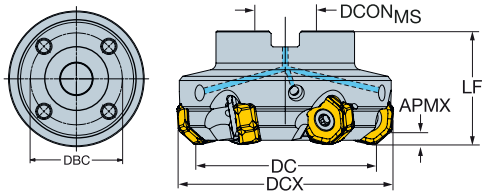
I56 L2 M1 N22 N9 N15

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

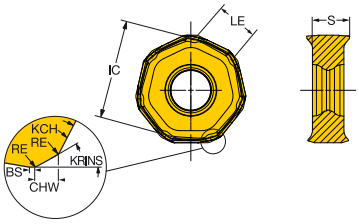
For the complete list of spare parts, visit www.sandvik.coromant.com

I56 L2 M1 N22 N9 N15

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.



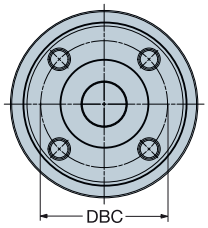
I27

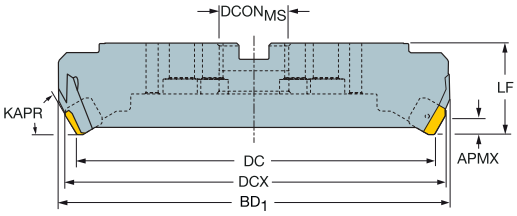
CoroMill® 360 face milling cutter

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

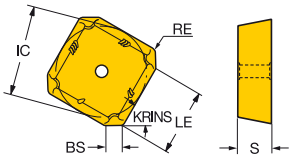
For the complete list of spare parts, visit www.sandvik.coromant.com

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

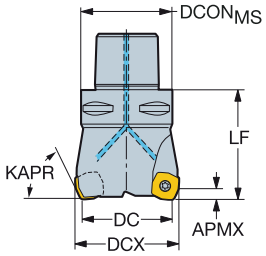
CoroMill® 365 face milling cutter

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

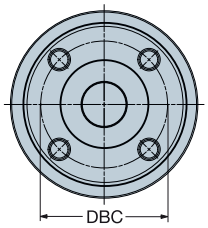
Arbor

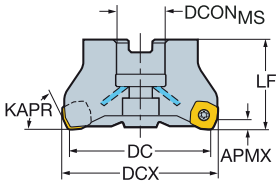
Screw clamp design

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

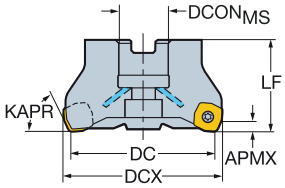
CoroMill® 365 face milling cutter

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

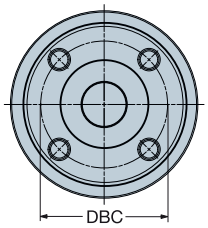
CoroMill® 365 face milling cutter

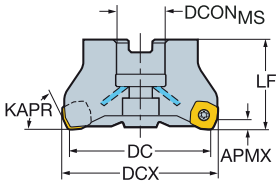
Arbor

Wedge clamp design

STDNO ISO6462
KAPR 65°







Metric version

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

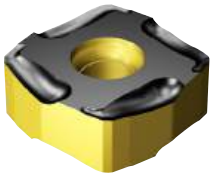
Spare parts	
Wedge screw	Wedge
339-831	5431 058-01

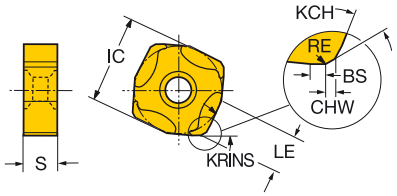
For the complete list of spare parts, visit www.sandvik.coromant.com

I34 L2 N22 N15 N9

CoroMill® 365 insert for milling

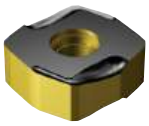
KRINS 65°

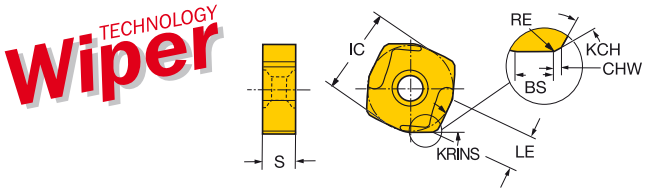




			RE	KCH	CHW	Ordering code	P			M	K				N	S	H		Dimensions, mm, inch				
							1130	4220	4330	1130	1020	3330	K20D	K20W	1130	1130	1010	1130	IC	LE	S	BS	BSR
Light	K L	15		30°	0.7	R/L365-1505ZNE-KL					★	☆							15.0	6.4	5.66	1.5	
	K L				.026														.591	.252	.223	.059	
	K L		0.30	35°	0.7	R365-1505ZNE-KL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





			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

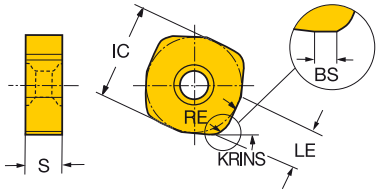
I30 I222 I254 N22 N10

CoroMill® 365 insert for milling

Advanced cutting materials

KRINS 65°

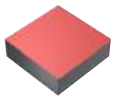
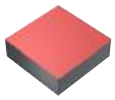
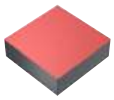
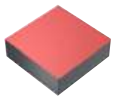
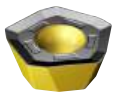
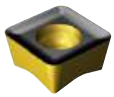
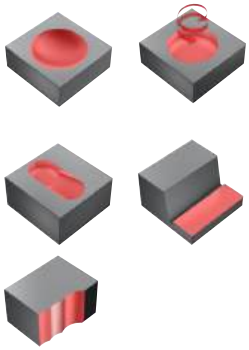
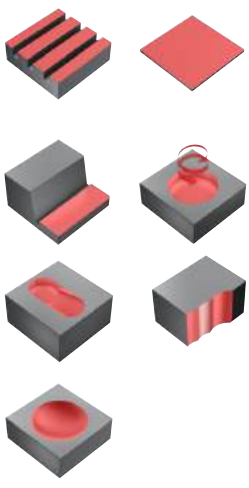
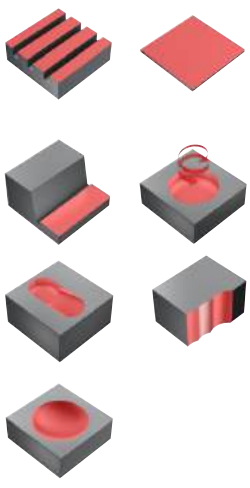
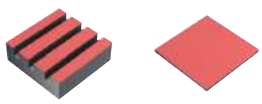




	RE	Ordering code	K 6190	H 6190	Dimensions, mm, inch IC	LE	S	BS	BSR
Light	15 3.60	N365-1505ZNE	☆	☆	15.0	6.4	5.66	1.2	150.0
	.142				.591	.252	.223	.047	5.906
Medium	15 3.60	N365-150536E	☆	☆	15.0	6.4	5.66		
	.142				.591	.252	.223		

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 D_c inch	17.4 - 85.3 .673 - 3.421	10.9 - 136 .445- 5.055	4.6 - 23.6 .169 - .917	63 - 160 2.5 - 6.0
DCX mm DCX inch	32.0 - 100.0 1.250 - 4.000	25 - 160 1000 - 6000	13 - 32 .500 - 1.250	86.4 - 183.4 3.421 - 6.921
APMX mm APMX inch	2 .079	1.2 - 2 .047 - .079	0.85 - 1.2 .033 - .047	2.80 .110
Insert				
Insert sizes	14	09 & 14	05 & 07	21
Couplings	Coromant Capto® Cylindrical shank Arbor	Coromant Capto® Cylindrical shank Arbor Threaded coupling Weldon	Cylindrical shank Coromant EH Threaded coupling	Coromant Capto® Arbor
Internal coolant	✓	✓	✓	✓
Options			iLock	
Other operations				

SANDVIK Coromant

CoroMill® 419

High-feed milling cutter

Application

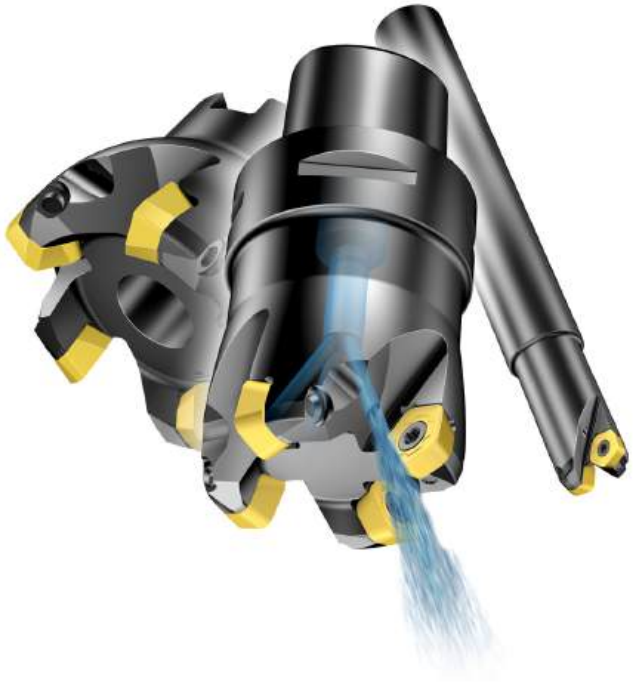
- High feed facemilling
- Profiling
- Ramping
- Helical interpolation
- Machining of components requiring long overhangs
- Suitable for low-powered machines and weak fixtures
- Roughing to semi-finishing

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

L



Coarse pitch

M



Close pitch

H



Extra close pitch

Face milling



Face and Profile Milling





I38



I41



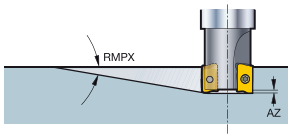
N6

CoroMill® 419 face milling cutter

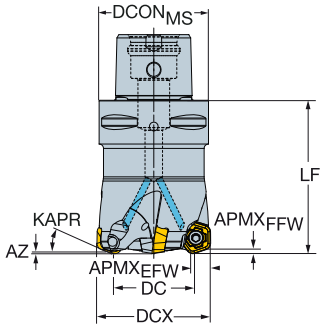
Coromant Capto® - Internal coolant supply

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

SANDVIK Coromant

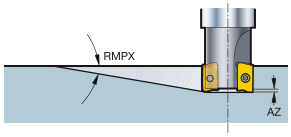
CoroMill® 419 face milling cutter

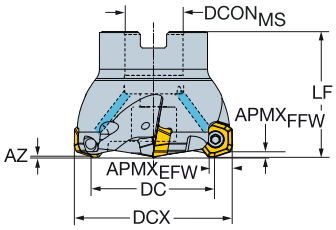
Arbor - Internal coolant supply

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

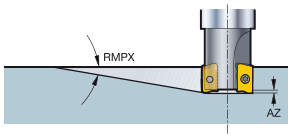
I41 L2 M1 N22 N6 N9 N15

CoroMill® 419 face milling cutter

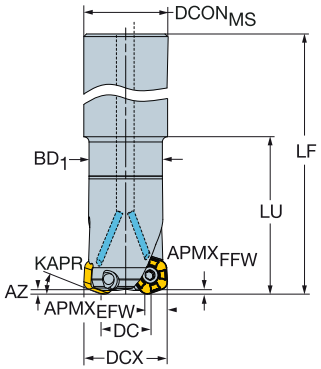
Cylindrical shank - Internal coolant supply

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

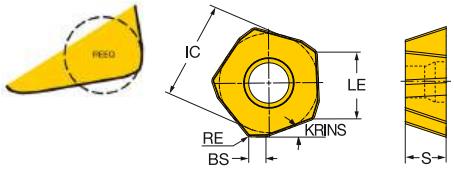
For the complete list of spare parts, visit www.sandvik.coromant.com

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

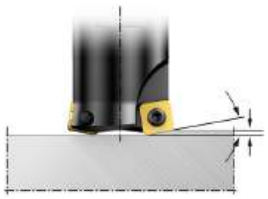
- Coromant Capto®
- Arbor
- Cylindrical shank
- Threaded coupling

Inserts

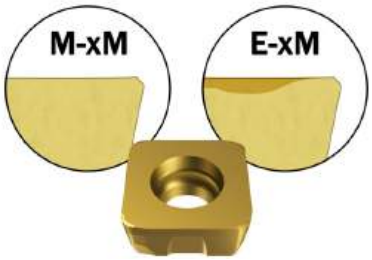
- Four cutting edges
- Insert geometries and grades for all materials apart from ISO N
- E-xM geometry for excellent performance in titanium



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

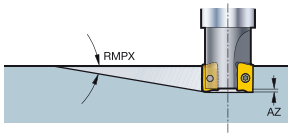
CoroMill® 210 face milling cutter

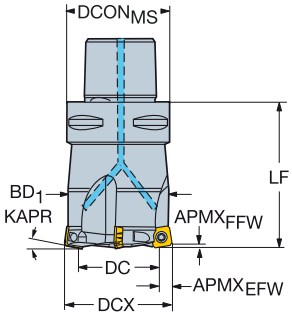
Coromant Capto® - Internal coolant supply

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

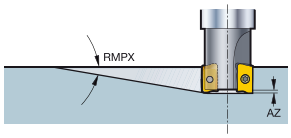
CoroMill® 210 face milling cutter

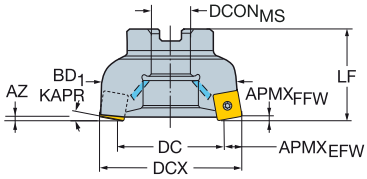
Arbor - Internal coolant supply

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

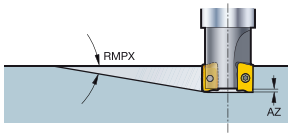
SANDVIK Coromant

CoroMill® 210 face milling cutter

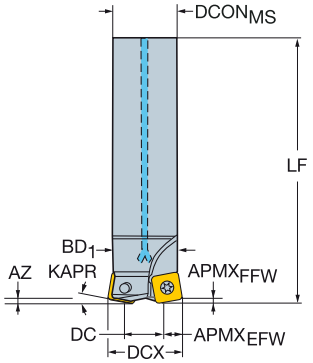
Cylindrical shank - Internal coolant supply

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

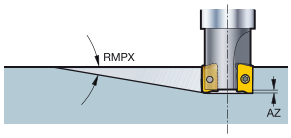
I47 L2 N22 N9 N15

CoroMill® 210 face milling cutter

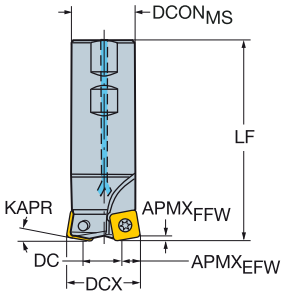
Weldon – Internal coolant supply

High-feed milling cutter





KAPR 10°

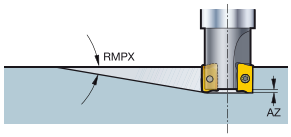


Inch version

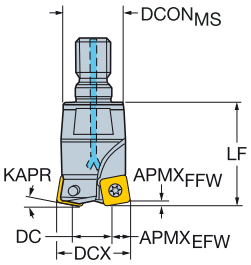
DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, inch DCONMS	ISO	DCX	BD	LB	LF	FT/LBS	LBS	RPMX	CICT	MIID
.445	09	1	.315	.047	14°	.071	1	2		RA210-025M25-09M	1.000	WE	1.000	.880	2.000	5.141	2.2	1.23	40200	2	R210-090412M-
.695	09	1 1/4	.315	.047	8°	.071	1	2		RA210-032M32-09M	1.250	WE	1.250	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-

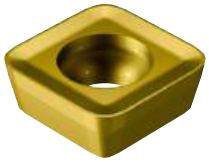
Spare parts
Insert screw
5513 020-02

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

I47 L2 N22 N9 N15

SANDVIK Coromant

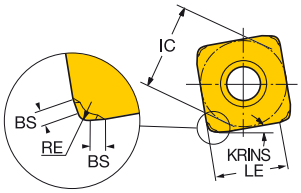
CoroMill® 210 insert for milling

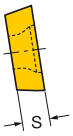


KRINS

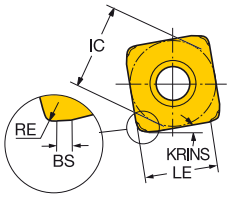


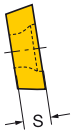
10°
R210..E-KM





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.

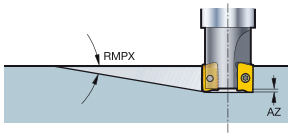
I49 I52

CoroMill® 415 face milling cutter

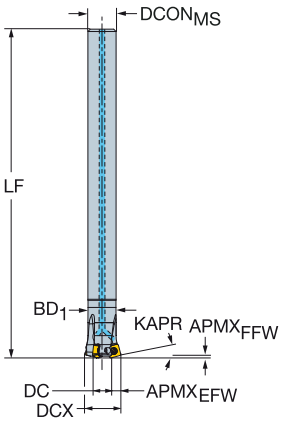
Cylindrical shank - Internal coolant supply

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

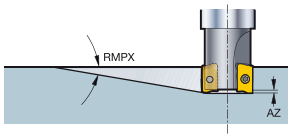
I52 L2 N22 N9 N15

CoroMill® 415 face milling cutter

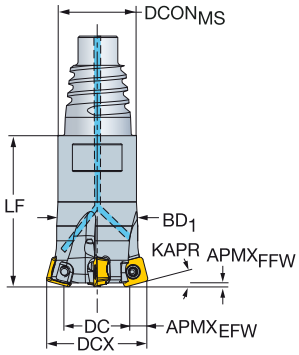
Coromant EH – Internal coolant supply

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

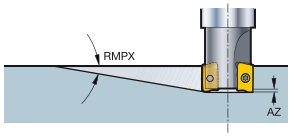
SANDVIK Coromant

CoroMill® 415 face milling cutter

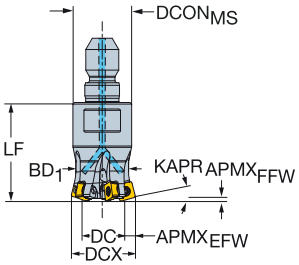
Threaded coupling – Internal coolant supply

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

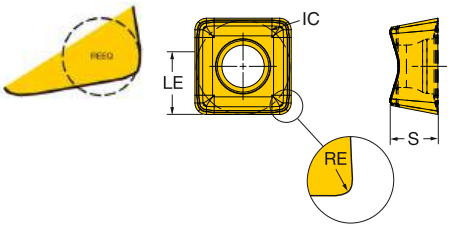
For the complete list of spare parts, visit www.sandvik.coromant.com

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

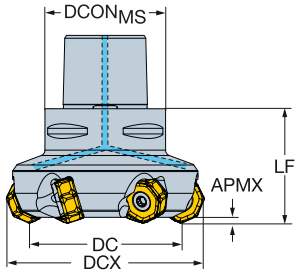
CoroMill® 745 face milling cutter

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

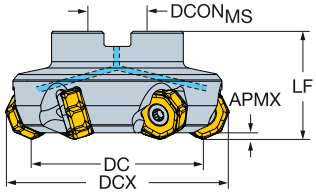
CoroMill® 745 face milling cutter

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	

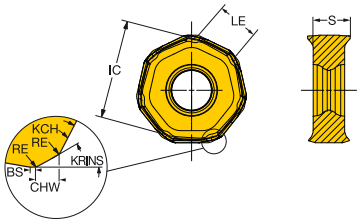
For the complete list of spare parts, visit www.sandvik.coromant.com

I56 L2 M1 N22 N9 N15

CoroMill® 745 insert for milling



KRINS 42°

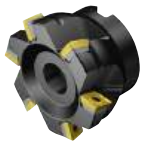
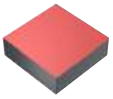
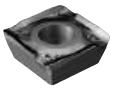
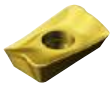
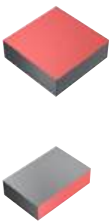
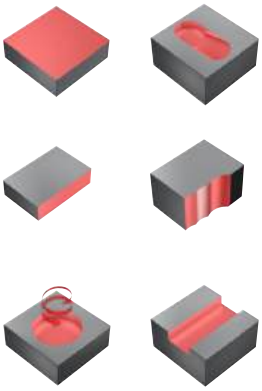
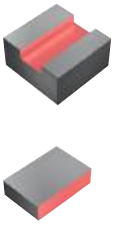
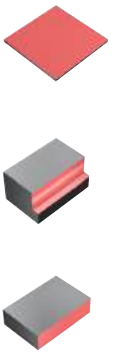


			RE	KC H	CH W	Ordering code	P 1130	P 4220	P 4230	P 4240	K 1020	K 3040	K K20D	K K20W	IC	LE	S	BS	BSR
Medium	M30	21	1.00	17°	1.3	745R-2109E-M30	★	☆	★	☆	★	☆	☆	☆	21.0	8.9	9.00	0.3	25.0
			.039		*.051*										*.827*	*.350*	*.354*	*.012*	*.984*
	M31	21	1.00			745R-2109E-M31	★	☆	★	☆	★	☆	☆	☆	21.0	7.1	9.00	1.9	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*

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

I54 I222 I254 N22 N10

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 D_c inch	20 - 250 .750 - 10.000	9.7 - 200 .375 - 8.000	40 - 100 1.500 - 4.000	40 - 200 2.000 - 8.000
APMX mm APMX inch	5.5 - 10.0 .216 - .394	5.8 - 85 .228 - 3.900	46 - 108 1.811 - 4.252	11 .433
Insert				
Insert sizes	08 & 14	07,11,17 & 18	10 & 14	11
Couplings	Coromant Capto® Coromant EH Cylindrical shank Weldon HSK Arbor	Coromant Capto® Coromant EH Cylindrical shank Arbor Weldon Threaded coupling	Coromant Capto® HSK Arbor	Coromant Capto® HSK Arbor
Internal coolant	✓	✓	✓	✓
Options		Damped cutter bodies available		Exchangeable cassette design
Other operations				

CoroMill® 490

Face and shoulder mill for precise profiles

Application

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



ISO application area:

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

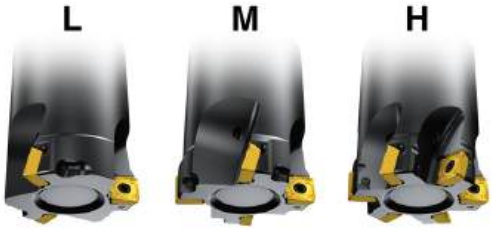
www.sandvik.coromant.com/coromill490

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.



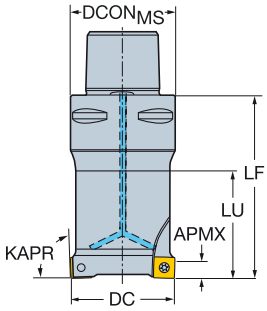
I59 I69 N6

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

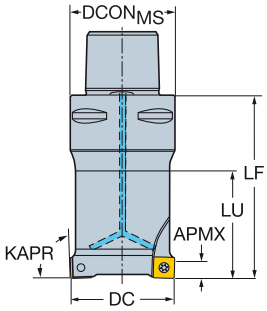
I69 L2 N22 N6 N9 N15

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

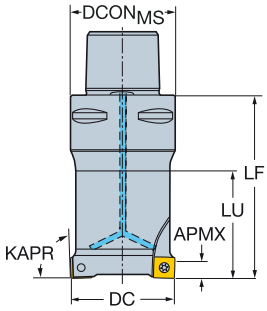
SANDVIK Coromant

CoroMill® 490 square shoulder milling cutter

Coromant Capto® - Internal coolant supply

STDNO ISO26623-1
KAPR 90°





Inch version

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

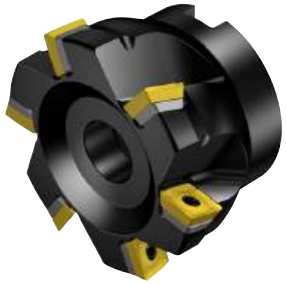
		Spare parts		
DC"		Insert screw	Shim	Shim screw
.750	08	5513 020-36		
1.000-2.500	08	5513 020-35		
1.500	14	5513 020-72		
2.000-2.500	14	5513 020-72	5322 471-01	5512 090-01

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

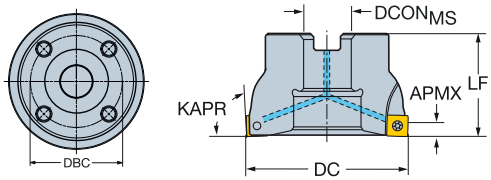
I69 L2 N22 N6 N9 N15

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

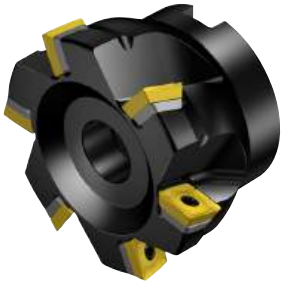
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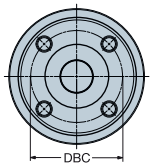
SANDVIK Coromant

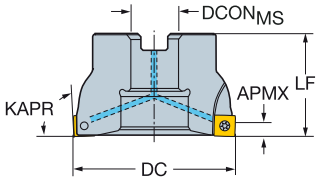
CoroMill® 490 square shoulder milling cutter

Arbor - Internal coolant supply

STDNO ISO6462
KAPR 90°







Inch version

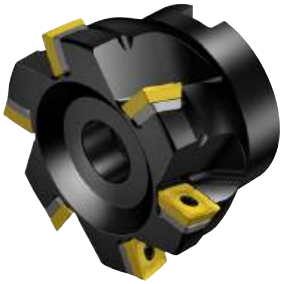
DC		CZCMS	APMX	CNSC			Ordering code	Dimensions, inch DCONMS	ISO	DBC	LF	FT/LBS	LBS	RPMX	CICT	MIID
1.500	08	3/4	.217	1		4	A490-038R19-08M	.750	A		1.575	.8	1.15	30200	4	490R-08T308
	08	3/4	.217	1	5		A490-038R19-08H	.750	A		1.575	.8	1.00	30200	5	490R-08T308
2.000	08	3/4	.217	1		4	A490-051R19-08L	.750	A		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

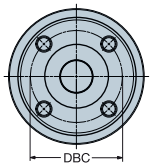
I69 L2 M1 N22 N6 N9 N15

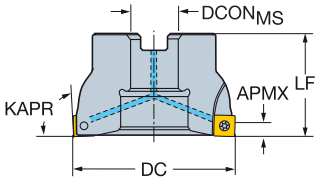
CoroMill® 490 square shoulder milling cutter

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

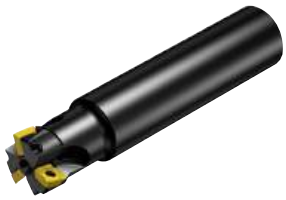
For spare parts, visit www.sandvik.coromant.com

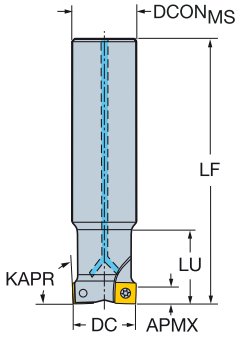
I69 L2 M1 N22 N6 N9 N15

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

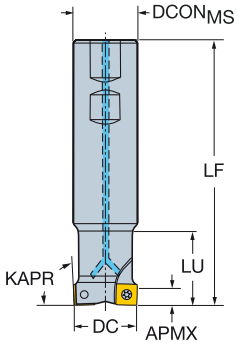
I69 L2 N22 N6 N9 N15

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

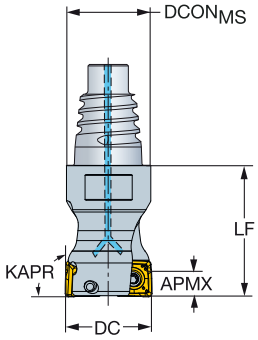
SANDVIK Coromant

CoroMill® 490 square shoulder milling cutter

Coromant EH – Internal coolant supply



KAPR 90°



Metric version

DC		CZC$_{MS}$	APMX$_{FFW}$	CNSC			Ordering code	Dimensions, mm DCON$_{MS}$	LF	NM	KG	RPMX	CICT	MIID
20.0	08	E20	5.50	1	2		490-020EH20-08L	19.3	30.0	1.2	0.14	48500	2	490R-08T308
25.0	08	E25	5.50	1	2		490-025EH25-08L	24.2	35.0	1.2	0.18	40400	2	490R-08T308
	08	E25	5.50	1	3		490-025EH25-08M	24.2	35.0	1.2	0.19	40400	3	490R-08T308
32.0	08	E25	5.50	1		3	490-032EH25-08L	24.2	35.0	1.2	0.21	33900	3	490R-08T308
	08	E25	5.50	1	4		490-032EH25-08M	24.2	35.0	1.2	0.18	33900	4	490R-08T308

Inch version

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

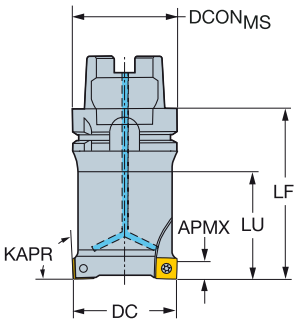
I69 L2 N22 N6 N9 N15 N3

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

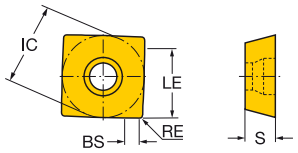
For the complete list of spare parts, visit www.sandvik.coromant.com

I69 L2 N22 N6 N9 N15

CoroMill® 490 insert for milling



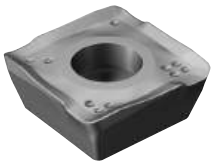
KRINS 90°



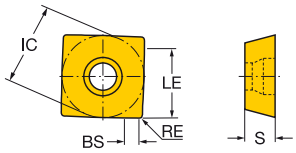
					P					M						K				N		S						H			Dimensions, mm, inch			
			RE	Ordering code	1130	4220	4330	4340	530	1040	1130	2030	2040	530	S30T	1020	3040	3220	3330	1130	H13A	1130	2030	2040	H13A	S30T	S40T	1010	1130	530	IC	LE	S	BS
Light	KL	08	0.40	490R-08T304M-KL												★	☆		☆												8.5	5.6	3.30	1.5
			.016																												*.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

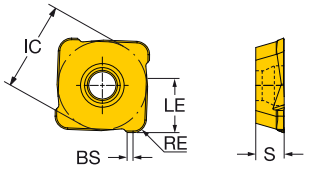
I59 I222 I254 N22 N10

CoroMill® 490 insert for milling

Advanced cutting materials

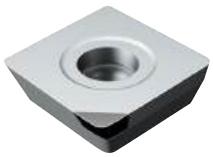
KRINS 90°

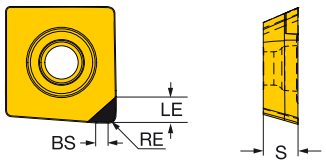




		RE	Ordering code	K 6190	H 6190	Dimensions, mm, inch IC	LE	S	BS
Medium	PO	14 2.00	490R-140420E	★	☆	13.8	5.0	3.90	0.8
		.079				.543	.197	.154	.031
		2.00	490R-140408E	★		13.8	5.0	3.90	0.8
		.079				.543	.197	.154	.031

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

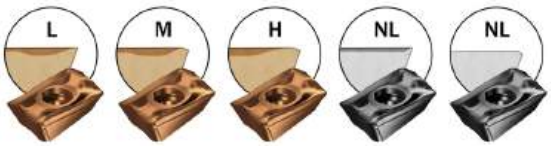
www.sandvik.coromant.com/coromill390

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

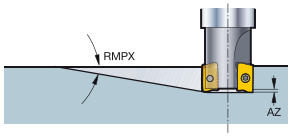
SANDVIK Coromant

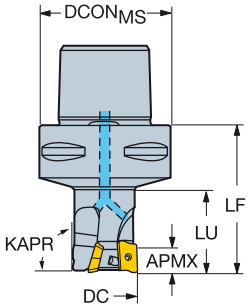
CoroMill® 390 square shoulder milling cutter

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..

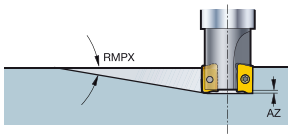
I94 L2 N22 N6 N9 N15

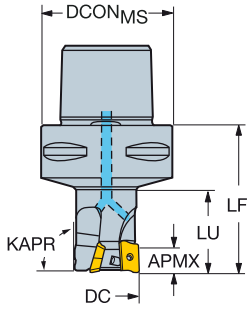
CoroMill® 390 square shoulder milling cutter

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

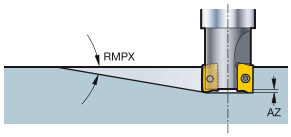
CoroMill® 390 square shoulder milling cutter

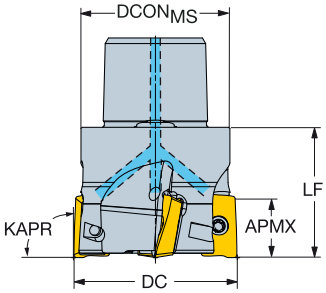
Coromant Capto® - Internal coolant supply

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

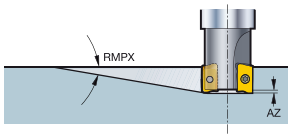
I94 L2 N22 N6 N9 N15

CoroMill® 390 square shoulder milling cutter

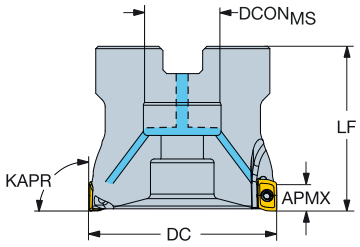
Arbor - Internal coolant supply

Lightweight shoulder milling cutter





KAPR 90°



Metric version

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

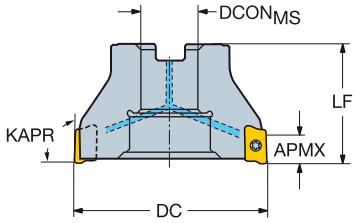
I94 N22 N15

CoroMill® 390 square shoulder milling cutter

Arbor - Internal coolant supply

STDNO ISO6462
KAPR 90°





Metric version

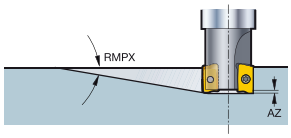
DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	ISO	LF	NM	KG	RPMX	CICT	MIID
40.0	07	16	2.0	5.80	0°	0.5	1		7	R390-040Q16-07M	16.0	A	35.0	0.5	0.20	21500	7	390R-07..
	07	16	2.0	5.80	0°	0.5	1		10	R390-040Q16-07H	16.0	A	35.0	0.5	0.20	21500	10	390R-07..
	11	16	5.5	10.00	2°	1.0	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

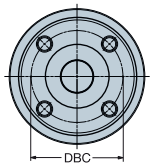
Arbor

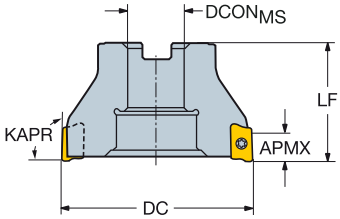




STDNO
KAPR

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

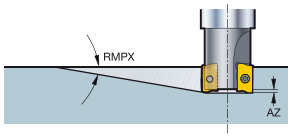
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 L2 M1 N22 N6 N9

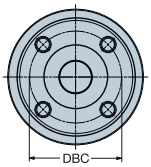
CoroMill® 390 square shoulder milling cutter

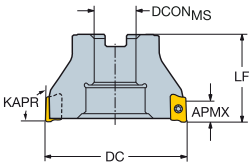
Arbor





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

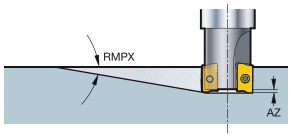
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 L2 M1 N22 N9 N6

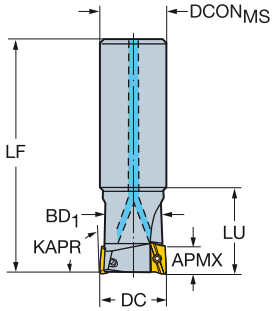
CoroMill® 390 square shoulder milling cutter

Cylindrical shank - Internal coolant supply





KAPR 90°



Metric version

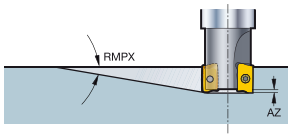
DC		CZCMS	APMXEFW	APMXFFW	RMPX	AZ	CNSC			Ordering code	Dimensions, mm DCONMS	BD	LF	LU	NM	KG	RPMX	CICT	MIID
9.7	07	10	2.0	5.80	7°	0.5	1	2		R390-0097A10-07L	10.0	9.2	60.0	15.0	0.5	0.07	55600	2	390R-07..
10.0	07	9	2.0	5.80	7°	0.5	1	2		R390-010A09L-07L	9.0	9.3	100.0		0.5	0.08	54100	2	390R-07..
	07	10	2.0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

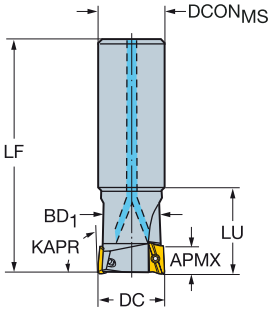
CoroMill® 390 square shoulder milling cutter

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

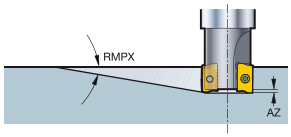
For the complete list of spare parts, visit www.sandvik.coromant.com

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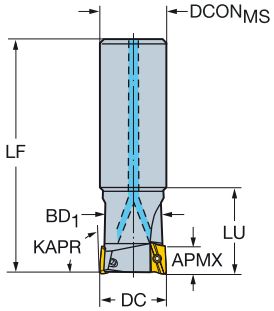
CoroMill® 390 square shoulder milling cutter

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

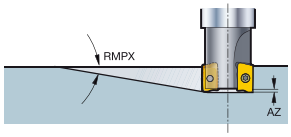
I94 L2 N22 N6 N9 N15

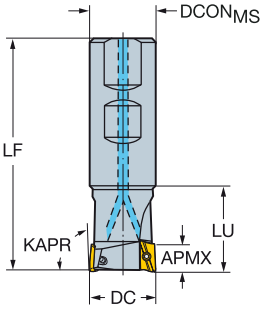
CoroMill® 390 square shoulder milling cutter

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

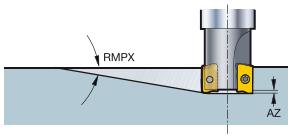
For the complete list of spare parts, visit www.sandvik.coromant.com

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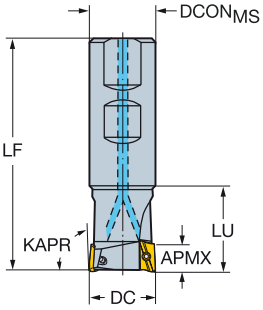
CoroMill® 390 square shoulder milling cutter

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

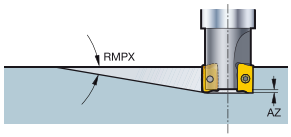
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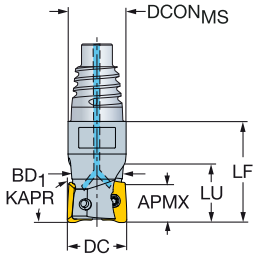
CoroMill® 390 square shoulder milling cutter

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

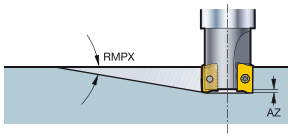
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 L2 N22 N6 N9 N15 N3

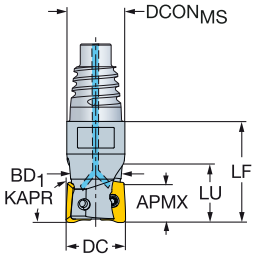
CoroMill® 390 square shoulder milling cutter

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	07	5513 020-82
.625-.750	11	5513 020-36
1.000-1.250	11	5513 020-35
1.000	17	5513 020-37
1.250	17	5513 020-39

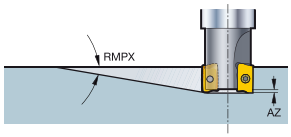
For the complete list of spare parts, visit www.sandvik.coromant.com

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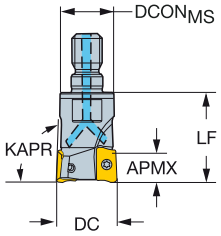
CoroMill® 390 square shoulder milling cutter

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

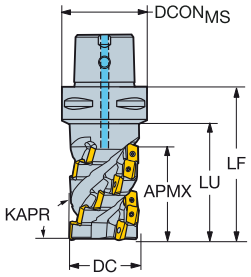
I94 L2 N22 N6 N9 N15

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

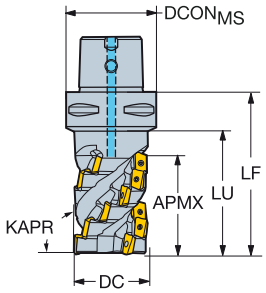
I94 L2 N22 N6 N9 N15

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..

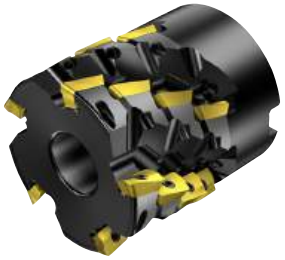
	Spare parts
	Insert screw
11	5513 024-01
18	5513 036-01

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

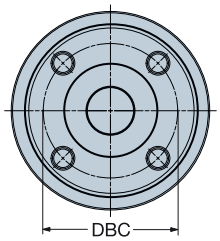
I94 L2 N22 N6 N9 N15

CoroMill® 390 long edge square shoulder milling cutter

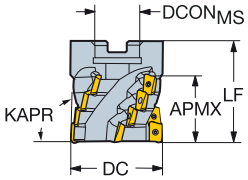
Arbor



STDNO
KAPR



ISO6462
90°



Metric version

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

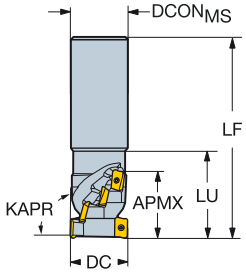
SANDVIK Coromant

CoroMill® 390 long edge square shoulder milling cutter

Cylindrical shank

KAPR 90°





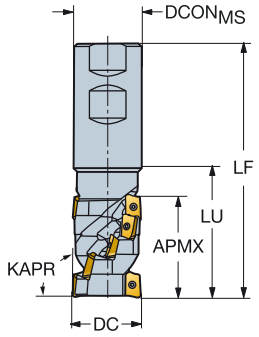
Metric version

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

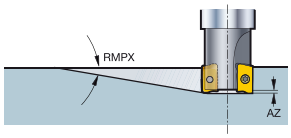
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 L2 N22 N6 N9

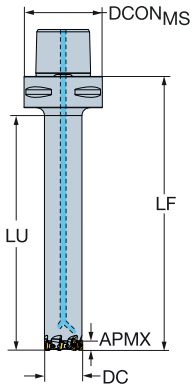
CoroMill® 390 damped square shoulder milling cutter

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

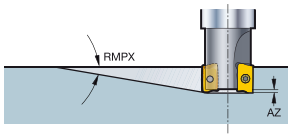
I94 L2 N22 N6 N9 N15 L167

SANDVIK Coromant

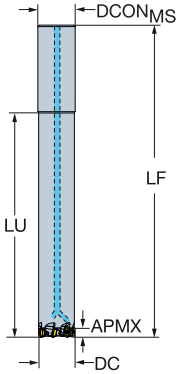
CoroMill® 390 damped square shoulder milling cutter

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..

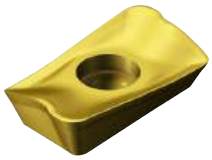
		Spare parts
DC		Insert screw
20.00-32.00	07	5513 020-82
20.00	11	5513 020-36
25.00-32.00	11	5513 020-35

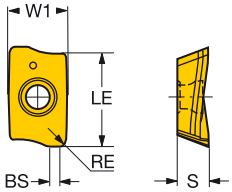
For the complete list of spare parts, visit www.sandvik.coromant.com

I94 L2 N22 N6 N9 N15 L167

CoroMill® 390 insert for milling

KRINS 90°





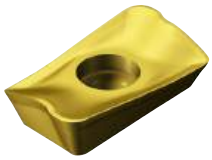
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					1130	4220	4230	4340	530	1040	1130	2050	2040	530	S30T	1020	3040	3330	1130	530	H13A	1130	2030	2040	H13A	S30T	S40T	1010	1130	530	W1	LE	S	BS
Light	KL	07	0.40	390R-070204E-KL												★															4.0	5.9	2.40	0.7
			.016																												.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

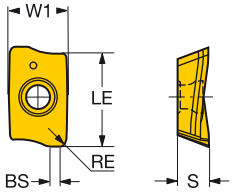
I73 I222 I254 N22 N10

SANDVIK Coromant

CoroMill® 390 insert for milling

KRINS 90°



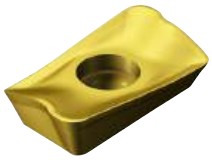


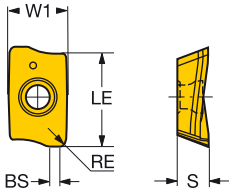
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Light	ML	11	0.80	R390-11 T3 08E-ML						★		☆	☆		☆								☆	☆		★	☆				6.8	10.0	3.59	1.5
			.031																											.268	.394	.141	.059
			1.60	R390-11 T3 16E-ML						★		☆	☆		☆								☆	☆		★	☆				6.8	10.0	3.59	0.8
			.063																											.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	
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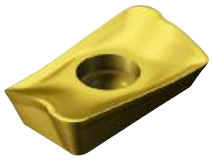
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Light	PL	07	0.20	390R-070202E-PL	★					☆								☆			☆							☆					
			.008																											.160	.232	.094	.028
			0.40	390R-070204E-PL	★					☆								☆			☆							☆					
			.016																											.160	.232	.094	.028
			0.80	390R-070208E-PL	★					☆								☆			☆							☆					
			.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	★				☆	☆			☆					☆	☆		☆						★	☆	☆				
			.031																											.268	.394	.141	.059
			0.80	R390-11 T3 08M-PL	★	☆	★	☆	☆	☆			☆	☆				☆	☆		☆				★	☆	★	☆	☆				
			.031																											.268	.394	.141	.047
		17	0.80	R390-17 04 08E-PL	★			★	☆	☆			☆					☆	☆		☆						★	☆	☆				
			.031																											.378	.618	.188	.059
			0.80	R390-17 04 08M-PL	★	☆	★	☆	☆	☆			☆	☆				☆	☆		☆				★	☆	★	☆	☆				
			.031																											.378	.618	.188	.059
		18	0.80	R390-18 06 08H-PL	★		★	☆		☆				☆				☆			☆				★	☆	★	☆					
			.031																											.433	.606	.249	.039
			1.20	R390-18 06 12H-PL	★	☆	★	☆		☆				☆				☆			☆				★	☆	★	☆					
			.047																											.433	.606	.249	.039
			1.60	R390-18 06 16H-PL	★			★		☆								☆			☆							☆					
			.063																											.433	.606	.249	.039
			2.00	R390-18 06 20H-PL	★					☆								☆			☆							☆					
			.079																											.433	.606	.249	.039
			2.40	R390-18 06 24H-PL	★					☆								☆			☆							☆					
			.094																											.433	.606	.249	.039
			3.10	R390-18 06 31H-PL	★					☆								☆			☆							☆					
			.122																											.433	.606	.249	.039
			4.00	R390-18 06 40H-PL	★					☆								☆			☆							☆					
			.157																											.433	.606	.249	.039
			5.00	R390-18 06 50H-PL	★					☆								☆			☆						★	☆					
			.197																											.433	.606	.249	.039
			6.00	R390-18 06 60H-PL	★					☆								☆			☆						★	☆					
			.236																											.433	.606	.249	.039
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			.252																											.433	.606	.249	.039

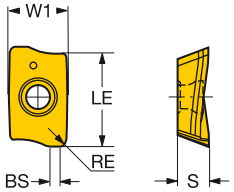
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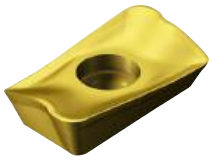


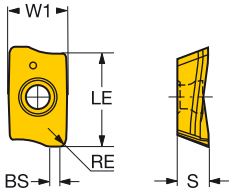
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Medium	KM	07	0.40	390R-070204M-KM												☆		★													4.0	5.9	2.40	0.7
			.016																												.160	.232	.094	.028
			0.80	390R-070208M-KM												☆		★													4.0	5.9	2.40	0.7
			.031																												.160	.232	.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
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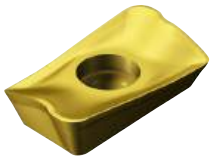
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Medium	KM	17	0.40	R390-17 04 04M-KM												☆	☆	★			★				☆						9.6	15.7	4.76	1.0
			.016																												*.378*	*.618*	*.188*	*.039*
			0.80	R390-17 04 08M-KM												☆	☆	★			★				☆						9.6	15.7	4.76	1.5
			.031																												*.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	
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			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*
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			.122																												*.433*	*.606*	*.249*	*.020*
	KMR	18	1.20	R390-18 06 12M-KMR												☆	☆	★													11.0	15.4	6.33	0.3
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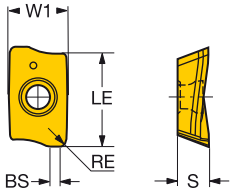
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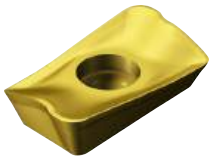


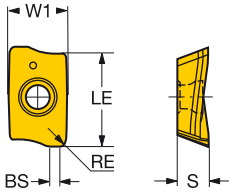
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Medium	MM	07	0.20						★																					4.0	5.9	2.40	0.7
			.008																											.160	.232	.094	.028
			0.40						★					☆											★					4.0	5.9	2.40	0.7
			.016																											.160	.232	.094	.028
			0.40						★					☆											★					4.0	5.9	2.40	0.7
			.016																											.160	.232	.094	.028
			0.80						★					☆											★					4.0	5.9	2.40	0.7
			.031																											.160	.232	.094	.028
			0.80						★					☆											★					4.0	5.9	2.40	0.7
			.031																											.160	.232	.094	.028
			1.20						★					☆											★					4.0	5.9	2.40	0.7
			.047																											.160	.232	.094	.028
			1.60						★					☆											★					4.0	5.9	2.40	0.2
			.063																											.160	.232	.094	.008
		11	0.20						★		☆										★									6.8	10.0	3.59	0.7
			.008																											.268	.394	.141	.028
			0.80						★		☆	☆		☆							☆	☆			★	☆				6.8	10.0	3.59	1.2
			.031																											.268	.394	.141	.047
			1.20						★		☆										★									6.8	10.0	3.59	0.8
			.047																											.268	.394	.141	.031
			1.60						★		☆										★									6.8	10.0	3.59	0.4
			.063																											.268	.394	.141	.016
			2.00						★		☆										★									6.8	10.0	3.59	
			.079																											.268	.394	.141	
			2.40						★		☆										★									6.8	10.0	3.59	
			.094																											.268	.394	.141	
			3.10						★		☆										★									6.8	10.0	3.59	
			.122																											.268	.394	.141	

I73 I222 I254 N22 N10

CoroMill® 390 insert for milling

KRINS 90°



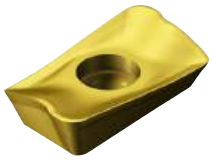


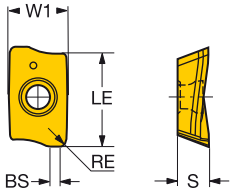
			RE	Ordering code	P					M						K				N			S						H			Dimensions, mm, inch			
					1130	4220	4330	4340	530	1040	1130	2030	2040	530	S30T	1020	3040	3330	1130	530	H13A	1130	2030	2040	H13A	S30T	S40T	1010	1130	530	W1	LE	S	BS
Medium	MM	17	0.40	R390-17 04 04E-MM						★		☆											★									9.6	15.7	4.76	1.0
			.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

CoroMill® 390 insert for milling

KRINS 90°

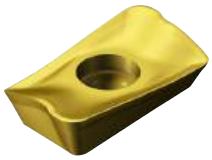


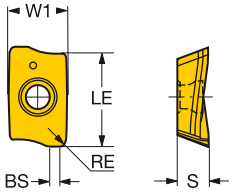


					Ordering code	P					M						K			N			S					H			Dimensions, mm, inch			
			RE			1130	4220	4330	4340	530	1040	1130	2030	2040	530	S30T	1020	3040	3330	1130	530	H13A	1130	2030	2040	H13A	S30T	S40T	1010	1130	530	W1	LE	S	BS
Medium	PM	07	0.20		390R-070202M-PM	★			★		☆									☆			☆							☆		4.0	5.9	2.40	0.7
			.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*	

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	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

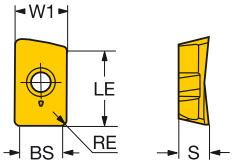
I73 I222 I254 N22 N10

SANDVIK Coromant

CoroMill® 390 insert for milling

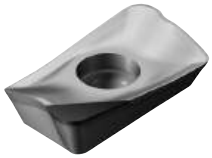
KRINS 90°

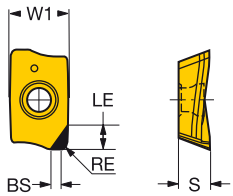




			RE	Ordering code	P		M		K		N		S		H		Dimensions, mm, inch			
					1025	1130	1025	1130	1020	1025	1025	1130	1025	1130	1025	1130	W1	LE	S	BS
Light	KTW	18	1.60	R390-18 06 16H-KTW					★								11.0	15.4	6.33	8.6
			.063														.433	.606	.249	.339
	PLW	11	0.80	R390-11 T3 08E-PLW	☆	★	☆	☆		☆	☆	☆	☆	☆	☆	☆	6.8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

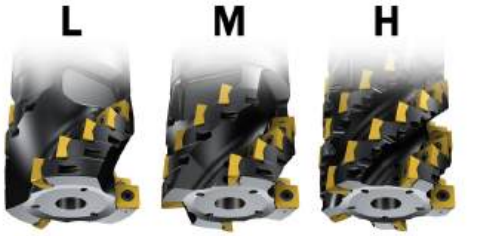
- Coromant Capto®
- Arbor
- HSK
- Oversized version available

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.



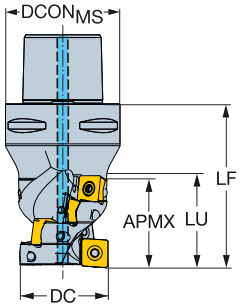
I105 I108

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

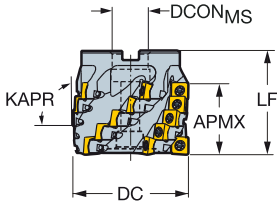
I108 L2 N22 N9 N15

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

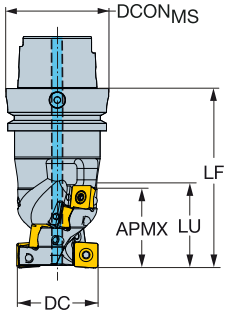
SANDVIK Coromant

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

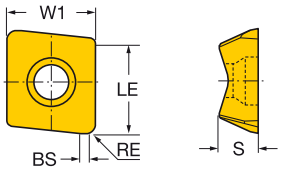
For the complete list of spare parts, visit www.sandvik.coromant.com

I108 L2 N22 N9 N15

CoroMill® 690 insert for milling

KRINS 90°



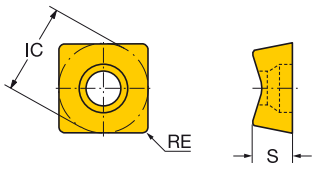


End insert

		RE	Ordering code	S 1030	S 2040	S 30T	S 40T	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 30T	S 40T	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.



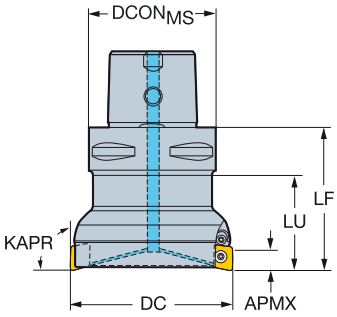
I110 I114 N6

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

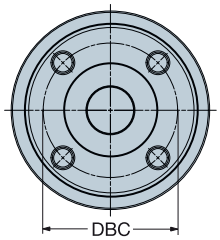
I114 L2 N22 N9 N15

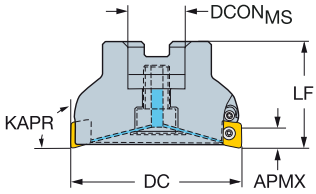
CoroMill® Century square shoulder milling cutter

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

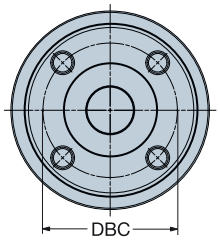
I114 L2 M1 N22 N9 N15

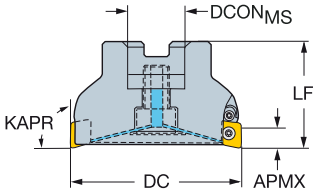
CoroMill® Century square shoulder milling cutter

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

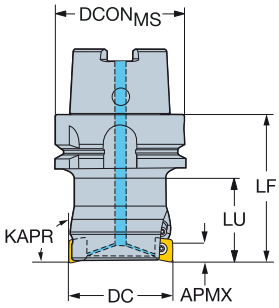
SANDVIK Coromant

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..

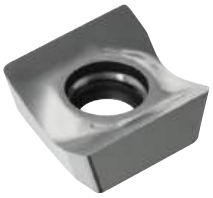
Spare parts		
Insert screw	Setting device	Setting device screw
5513 020-25	5513 014-021	5513 014-02

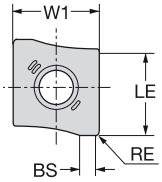
For the complete list of spare parts, visit www.sandvik.coromant.com

I114 L2 N22 N10 N15

CoroMill® Century insert for milling

KRINS 90°

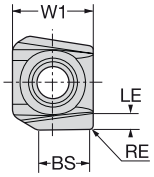




		RE	Ordering code	K 1020	K H10	N 1130	H 1130	W1	LE	S	BS	BSR
Light	KL	11 0.80	R590-110508H-KL	★				11.5	11.0	5.00	1.7	200.0
		.031						.453	.433	.197	.067	7.874
	NL	11 0.40	R590-110504H-NL		☆	★		11.5	11.0	5.00	2.0	200.0
		.016						.453	.433	.197	.079	7.874
	PL	11 0.80	R590-110508H-PL				☆	11.5	11.0	5.00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

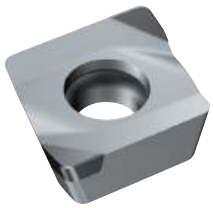
I110 I222 I254 N22 N6 N10 N2

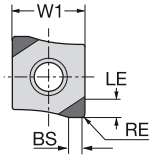
SANDVIK Coromant

CoroMill® Century insert for milling

Advanced cutting materials

KRINS 90°

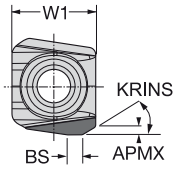




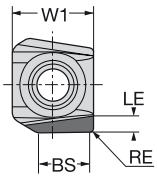
			RE	KCH	CHW	Ordering code	K CB50	H CB50	Dimensions, mm, inch W1	LE	S	BS	BSR
Light	KL	11		30°	1.0	L590-1105H-ZC2-KL	☆	☆	11.5	3.0	5.00	2.3	200.0
					.039				.453	.118	.197	.092	7.874
				60°	1.5	R590-1105H-ZC2-KL	☆	☆	11.5	3.0	5.00	2.3	200.0
					.059				.453	.118	.197	.092	7.874
Medium	KM	11	0.80			R590-110508H-PR2-KM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

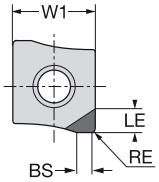
I110 I222 I254 N22 N6 N10 N2

CoroMill® Century insert for milling

Advanced cutting materials

KRINS 90°

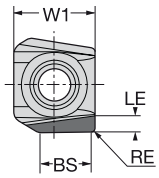




		RE	KCH	CHW	Ordering code	N CD10	Dimensions, mm, inch W1	LE	S	BS	BSR
Light	NL	11	45°	1.0	R590-1105H-PC2-NL	★	11.5	3.0	5.00	1.5	200.0
				.039			.453	.118	.197	.059	7.874
			45°	1.0	R590-1105H-PC5-NL	★	11.5	6.0	5.00	1.5	200.0
				.039			.453	.236	.197	.059	7.874
		0.40			R590-1105H-PR2-NL	★	11.5	3.0	5.00	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

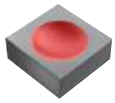
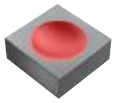
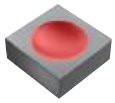
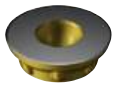
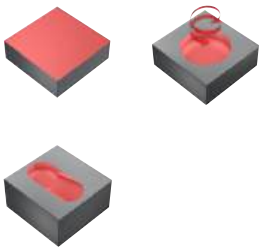
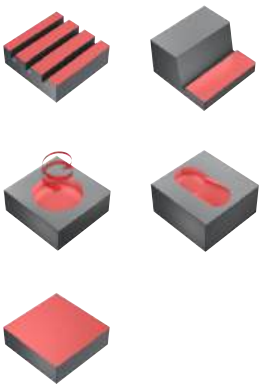
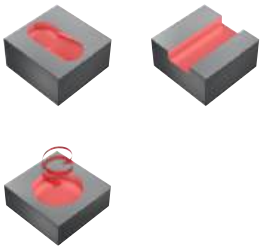
		RE	KCH	CHW	Ordering code	N CD10	Dimensions, mm, inch W1	LE	S	BS	BSR
Light	NW	11	45°	1.2	R590-1105H-RC2-NW	☆	11.5	3.0	5.00	6.0	500.0
				.047			.453	.118	.197	.236	19.685
		0.40			R590-1105H-RR2-NW	☆	11.5	3.0	5.00	6.8	500.0
		.016					.453	.118	.197	.268	19.685
			45°	0.3	R590-1105H-RS2-NW	☆	11.5	3.0	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 D_c inch	5 - 180 .178 - 7.213	15 - 140 .625 - 9.250	10 - 50 .375 - 2.000
DCX mm DCX inch	10 - 200 .375 - 8000	25 - 140 1000 - 10000	
APMX mm APMX inch	2.5 - 10 .098 - .492	5 - 10 .187 - .375	8.6 - 44.6 .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, 38,40,50,51
Couplings	Coromant Capto® Coromant EH Cylindrical Arbor Weldon Threaded coupling	Cylindrical shank Whistle notch / Weldon Arbor	Coromant Capto® Cylindrical shank Coromant EH Threaded coupling 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

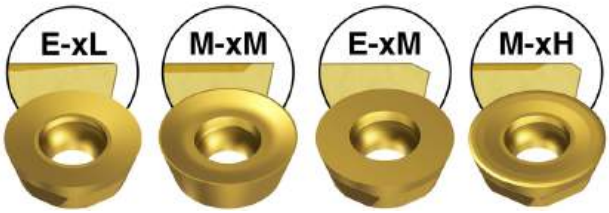
www.sandvik.coromant.com/coromill300

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

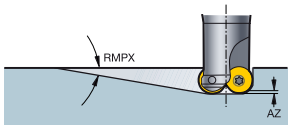
SANDVIK Coromant

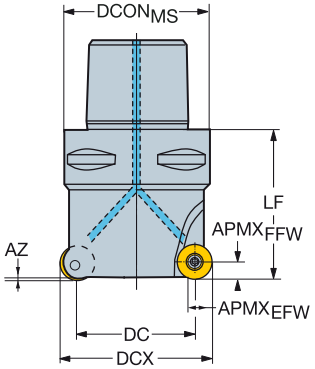
CoroMill® 300 face milling cutter

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

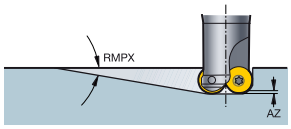
I131 L2 N22 N6 N9 N15

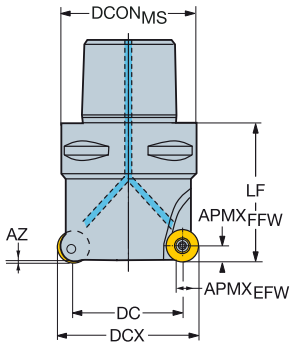
CoroMill® 300 face milling cutter

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

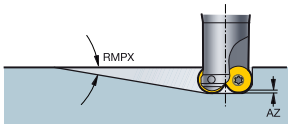
I131 L2 N22 N6 N9 N15

CoroMill® 300 face milling cutter

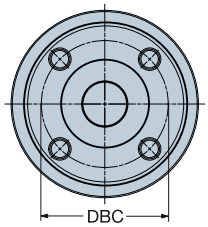
Arbor - Internal coolant supply

Positive design

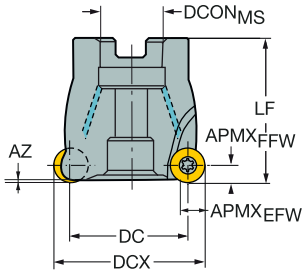




STDNO



ISO6462



Metric version

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

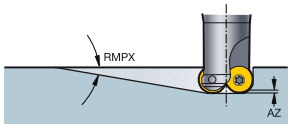
I131 L2 M1 N22 N6 N9 N15

CoroMill® 300 face milling cutter

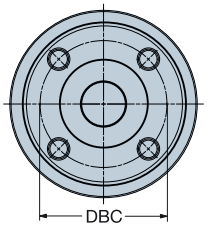
Arbor - Internal coolant supply

Positive design

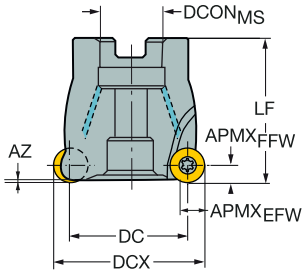




STDNO



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

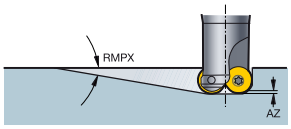
SANDVIK Coromant

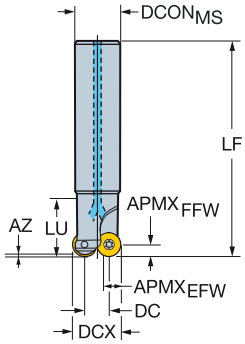
CoroMill® 300 face milling cutter

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

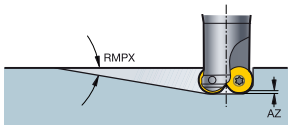
I131 L2 N22 N6 N9 N15

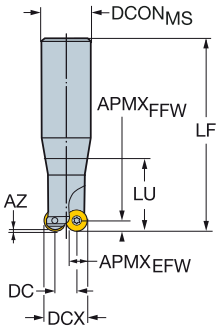
CoroMill® 300 face milling cutter

Cylindrical shank

Neutral design







Metric version

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

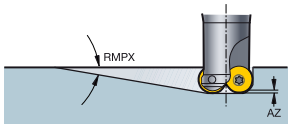
I131 L2 N22 N6 N9

CoroMill® 300 face milling cutter

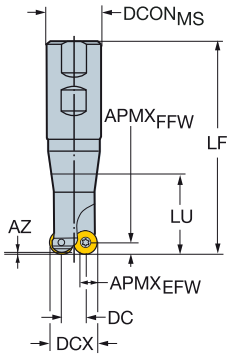
Weldon – Internal coolant supply

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

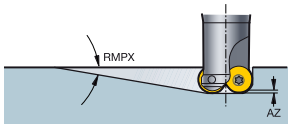
I131 L2 N22 N6 N9 N15

CoroMill® 300 face milling cutter

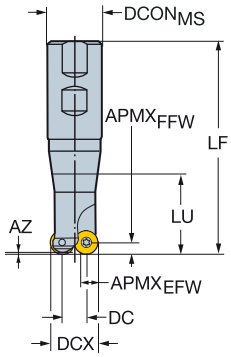
Weldon

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

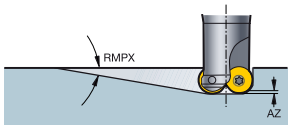
SANDVIK Coromant

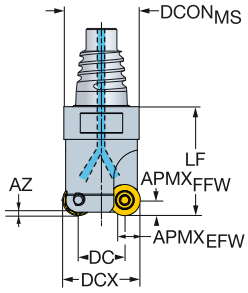
CoroMill® 300 face milling cutter

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

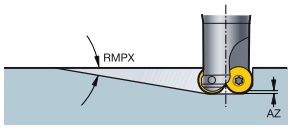
I131 L2 N22 N6 N9 N15 N3

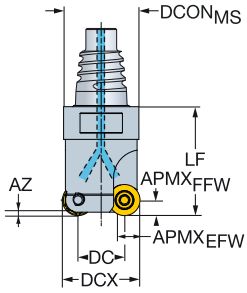
CoroMill® 300 face milling cutter

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

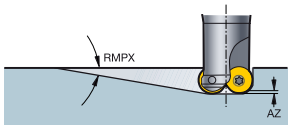
I131 L2 N22 N6 N9 N15 N3

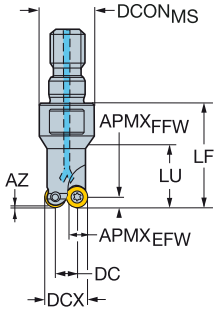
CoroMill® 300 face milling cutter

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

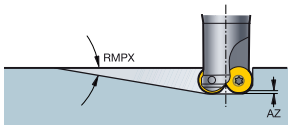
I131 L2 N22 N6 N9 N15

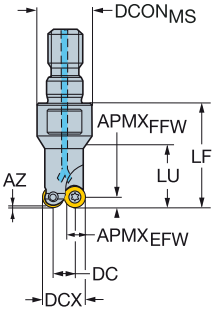
CoroMill® 300 face milling cutter

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

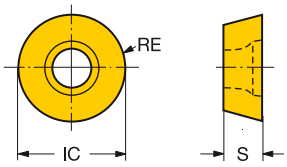
For the complete list of spare parts, visit www.sandvik.coromant.com

I131 L2 N22 N6 N9 N15

SANDVIK Coromant

CoroMill® 300 insert for milling





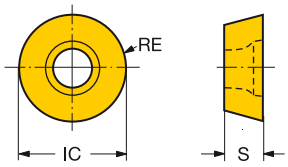
Metric version

	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

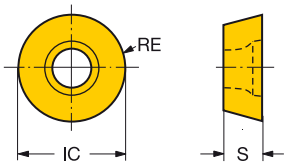
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Medium	16	8.00					★			☆														16.0	4.76
		.315																						.630	.188
	16	8.00	☆			★		☆			☆				☆		☆		☆		★	☆		16.0	4.76
		.315																						.630	.188
		8.00					★		☆	☆														16.0	4.76
		.315																						.630	.188
		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).



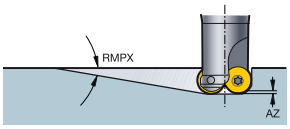
I135 I139

SANDVIK Coromant

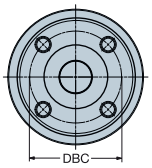
CoroMill® 200 face milling cutter

Arbor

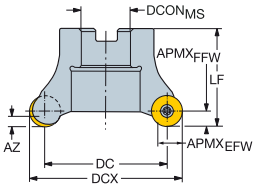




STDNO



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		

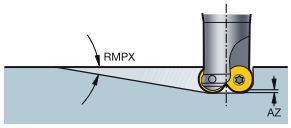
For the complete list of spare parts, visit www.sandvik.coromant.com

I139 L2 M1 N22 N9

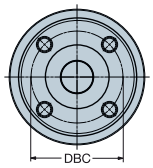
CoroMill® 200 face milling cutter

Arbor

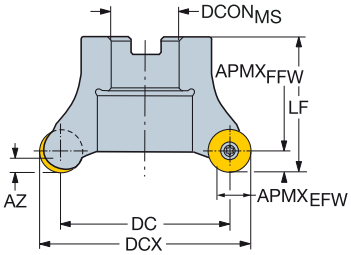




STDNO



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



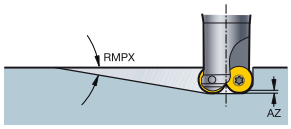
N9

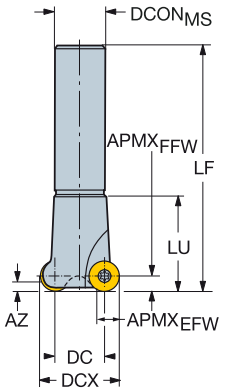
SANDVIK Coromant

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

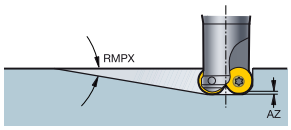
For the complete list of spare parts, visit www.sandvik.coromant.com

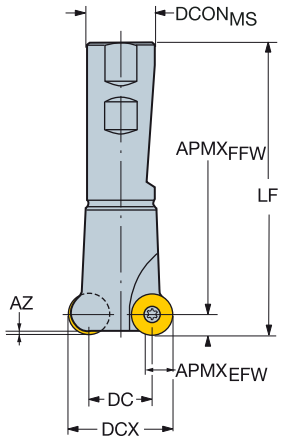
I139 L2 N22 N9

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

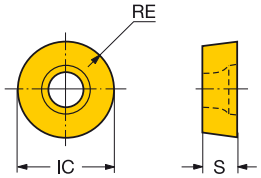
For the complete list of spare parts, visit www.sandvik.coromant.com

I139 L2 N22 N9

SANDVIK Coromant

CoroMill® 200 insert for milling





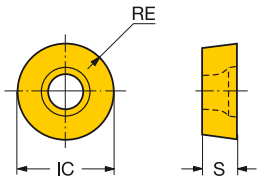
Metric version

				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





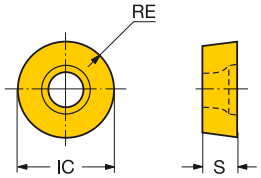
Metric version

						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	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

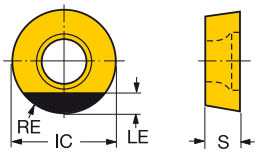
					Ordering code	P				M					K			N			S						H		Dimensions, mm, inch	
				RE		1130	4220	4330	4340	1040	1130	2030	2040	S30T	S40T	1020	3040	3330	1130	H10F	H13A	1130	2030	H10F	H13A	S30T	S40T	1010	1130	IC	S
Light	09	3/8	4.76		RCHT 09 T3 00-PL	★					☆								☆			☆						★	☆	9.5	3.97
			.188																											.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

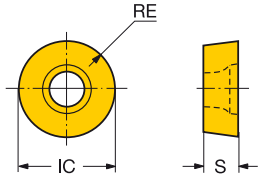
CoroMill® 200 insert for milling



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

SANDVIK Coromant

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

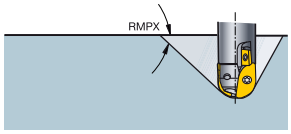
I144 I151

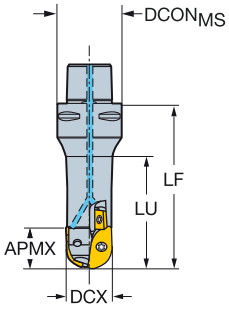
CoroMill® 216 ball nose milling cutter

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

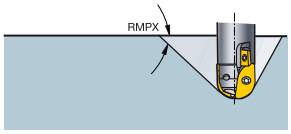
I151 L2 N22 N9 N15

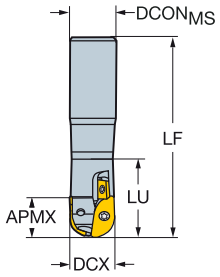
CoroMill® 216 ball nose milling cutter

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

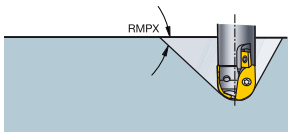
For the complete list of spare parts, visit www.sandvik.coromant.com

I151 L2 N22 N9 N15

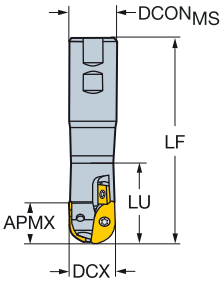
CoroMill® 216 ball nose milling cutter

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

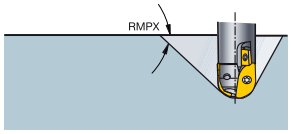
I151 L2 N22 N9 N15

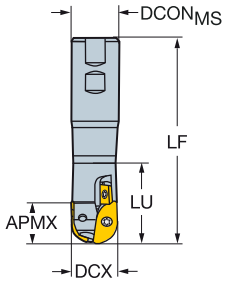
CoroMill® 216 ball nose milling cutter

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

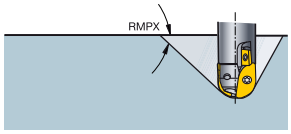
I151 L2 N22 N9 N15

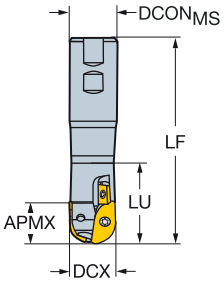
CoroMill® 216 ball nose milling cutter

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

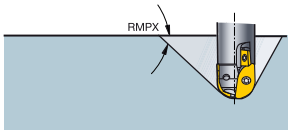
SANDVIK Coromant

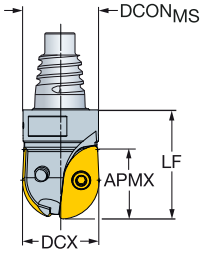
CoroMill® 216 ball nose milling cutter

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

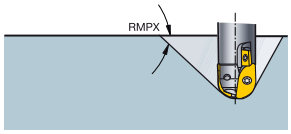
I151 L2 N22 N9 N15 N3

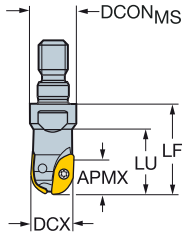
CoroMill® 216 ball nose milling cutter

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

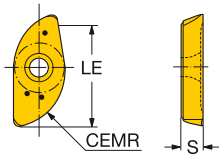
For the complete list of spare parts, visit www.sandvik.coromant.com

I151 L2 N22 N9 N15

SANDVIK Coromant

CoroMill® 216 ball nose insert





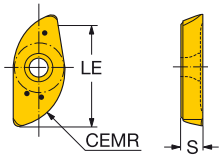
Metric version

					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

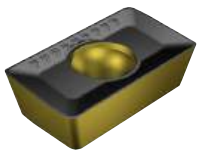


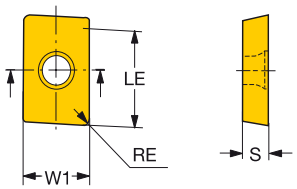


Inch version

						P		M		K		N		S		H		Dimensions, mm, inch	
			CEMR	Ordering code		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



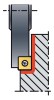
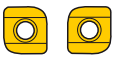
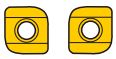
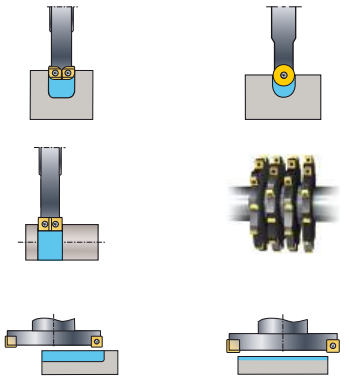
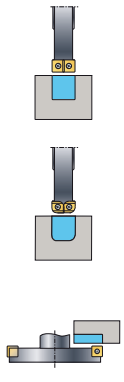
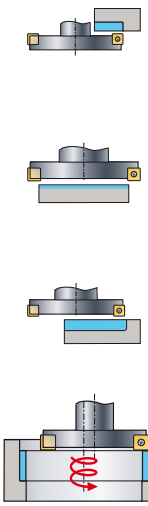


					P	M	K	Dimensions, mm, inch		
		RE	Ordering code		4340	4340	4340	W1	LE	S
Medium	WHX	16	0.80	APMT 16 04 08-M	☆	☆	☆	9.2	16.0	4.76
			.031					.364	.630	.188

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 D_c inch	80 - 315 3.150 - 12.000	40 - 125 1.500 - 3.000	80 - 315 3.150 - 6.000
APMX mm APMX inch	6.0 - 26.5 .236 - 1.043	6.0 - 10 .250 - .500	7.6 - 10.6 .299 - .417
CDX mm CDX inch	114.5 4.508	34 1.339	114.5 4.508
Insert	 N331.1A  R/L331.1A  RCHT, RCKT	 N331.1A	 N331.1A  R/L331.1A
Insert sizes	04,05,08,11 & 14 * 04,05,08,11 & 14 09,10,12,13 & 16	04,05 & 08	11 * 04,05,08,11 & 14
Couplings	Arbor Cylindrical Bore with keyway Weldon	Arbor Cylindrical Bore with keyway	Arbor Cylindrical Bore with keyway Weldon
Other operations			

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

CoroMill® 331

Multi-purpose side and face milling cutter

Application

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



ISO application area:

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

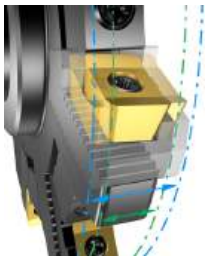
- Bore with keyway
- Arbor
- Cylindrical shank
- Adjustable pockets for high precision
- Fixed pockets for high teeth density

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

Half side

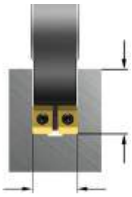


CDX ≤ 114.5 mm
CDX ≤ 4.311 inch

a_p ≤ 10.6 mm
a_p ≤ .417 inch

Tailor Made

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

Tailor Made

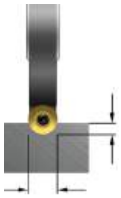
Full slot with radius



CDX ≤ 114.5 mm
CDX ≤ 4.311 inch

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

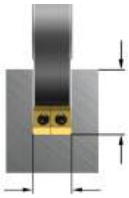
Full radius



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

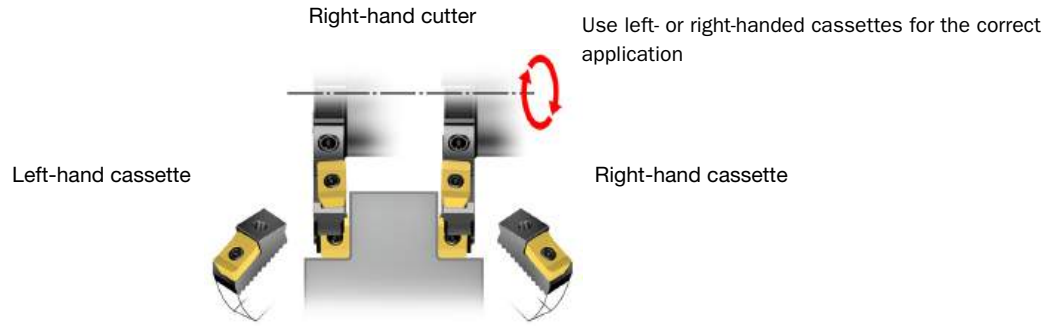
Cutter bodies				Neutral inserts		Right- and left-hand inserts				
Groove width range mm	Groove width range inch	Cutter versions (end of code)	Insert size	Radius (RE) 0.5 mm .020 inch	Radius (RE) 0.8 mm .031 inch	Radius (RE) 1.52 mm .060 inch	Radius (RE) 2.29 mm .090 inch	Radius (RE) 3.05 mm .120 inch	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

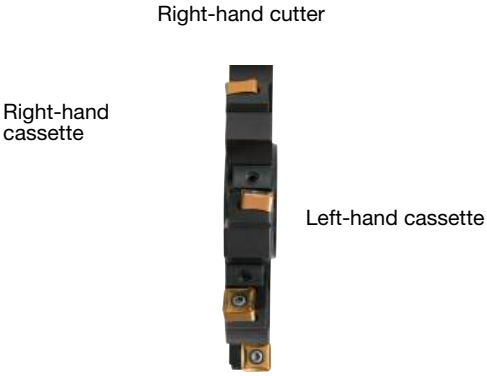
Other insert radii available as Tailor Made.

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

Half side and face mill



Full side and face mill

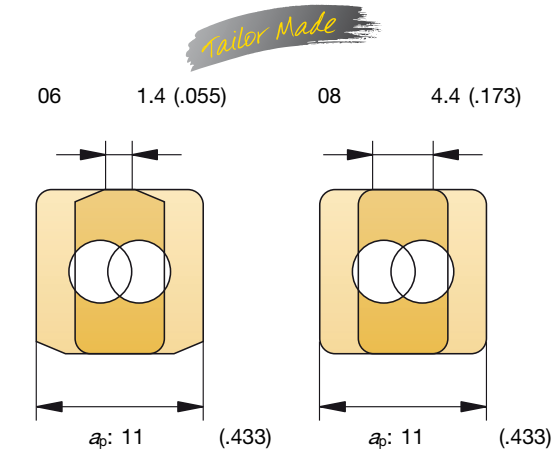


Reduced cutting edge length for Tailor Made inserts

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

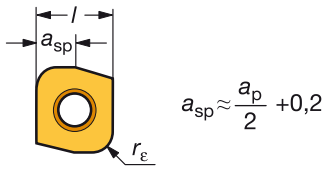
Reduced cutting edge length reduces overlapping, which in turn reduces wear in the overlapping zone, producing better chip control and reducing power consumption by up to 10%.

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

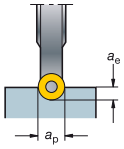


$$a_{sp} \approx \frac{a_p}{2} + 0{,}2$$

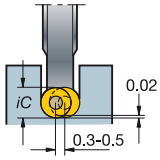
Facilitated chip evacuation

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°

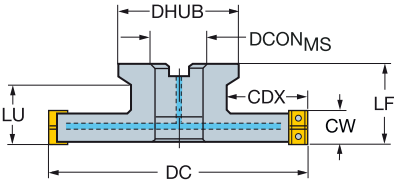
For slots deeper than IC/2, a 0.3 - 0.5 mm (.012 - .020 inch) adjustment of each cassette is recommended. This will widen the slot 0.3 - 0.5 mm (.012 - .020 inch) and reduce the contact length for each insert to 90°, which produces a more favorable chip formation and evacuation, and reduces vibration 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

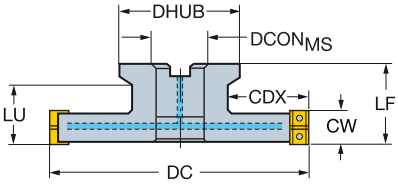
I183 L2 M1 N22 N6

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

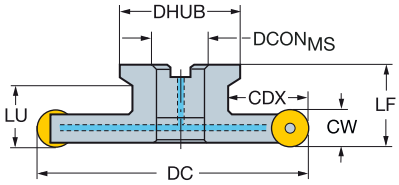
I183 L2 M1 N22 N6

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462:2011





Metric version

CW	DC	CDX		CZCMS	CNSC		Ordering code	Dimensions, mm DCONMS	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
CZCMS	Coolant screw
27	5512 098-05
32	5512 098-04
40	5512 098-03

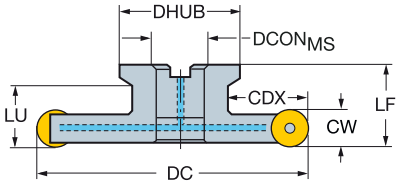
I183 L2 M1 N22 N6

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor - Internal coolant supply

STDNO ISO 6462:2011





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

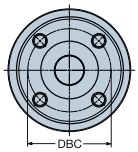
I183 L2 M1 N22 N6

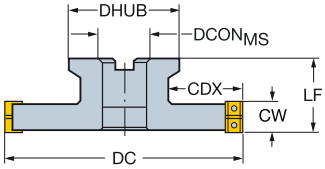
CoroMill® 331 adjustable full side and face disc milling cutter

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

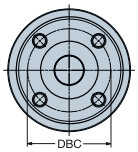
I183 L2 M1 N22 N6

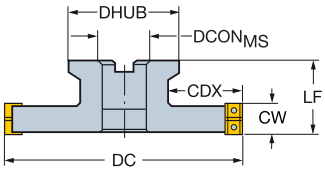
CoroMill® 331 adjustable full side and face disc milling cutter

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

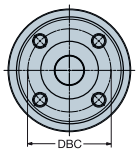
SANDVIK Coromant

CoroMill® 331 adjustable full side and face disc milling cutter

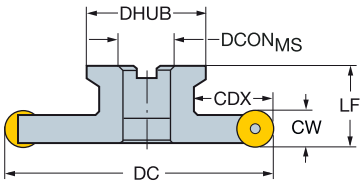
Arbor



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

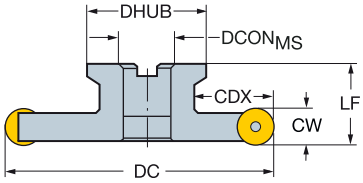
I183 L2 M1 N22 N6

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

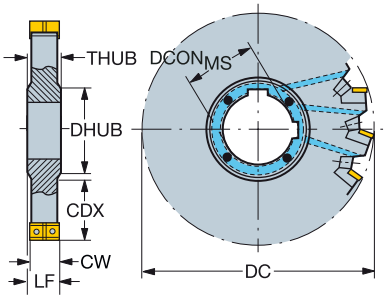
Bore with keyway – Internal coolant supply

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

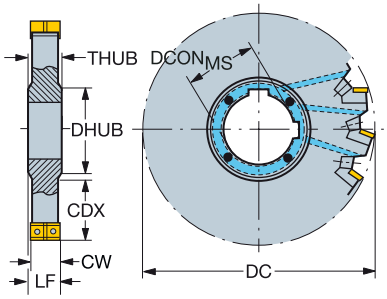
Bore with keyway – Internal coolant supply

KAPR 90°





N331.1A



Inch version

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

SANDVIK Coromant

CoroMill® 331 adjustable full side and face disc milling cutter

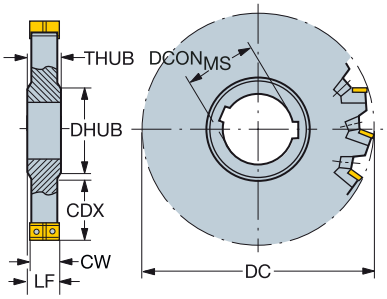
Bore with keyway

KAPR 90°





N331.1A



Metric version

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

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

I183 L2 N22 N6

CoroMill® 331 adjustable full side and face disc milling cutter

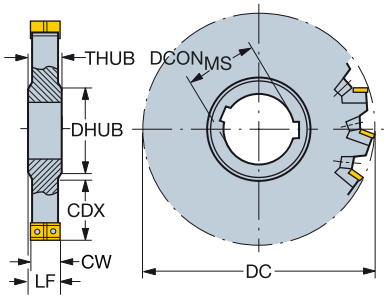
Bore with keyway

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

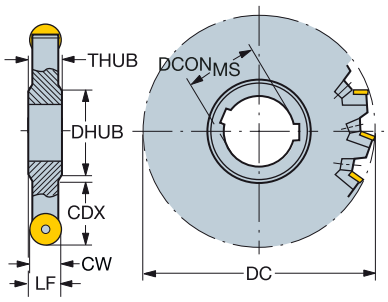
CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway





RCKT
RCHT



Metric version

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

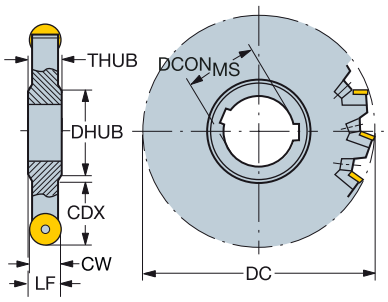
CoroMill® 331 adjustable full side and face disc milling cutter

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

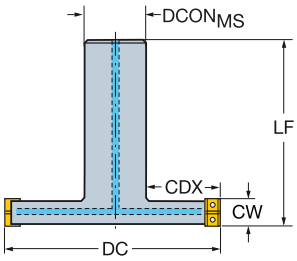
I183 L2 N22 N6

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

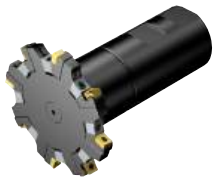
For the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 N22 N15 N6

CoroMill® 331 adjustable full side and face disc milling cutter

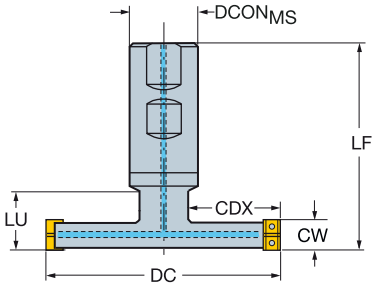
Weldon – Internal coolant supply

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

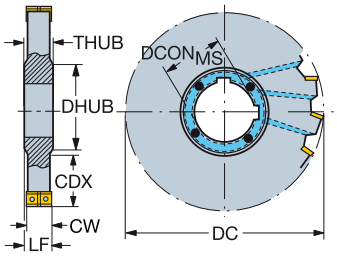
I183 L2 N22 N15 N6

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

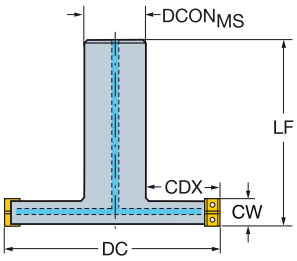
I183 L2 N22 N15 N6

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

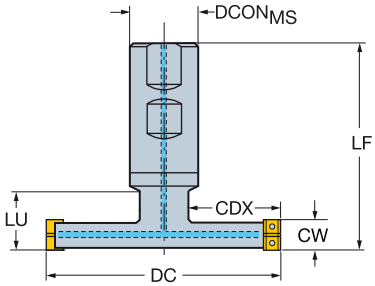
Weldon – Internal coolant supply

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

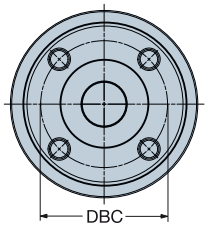
CoroMill® 331 adjustable half side and face disc milling cutter

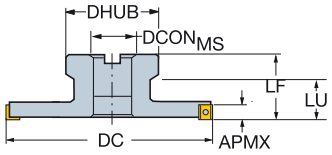
Arbor

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

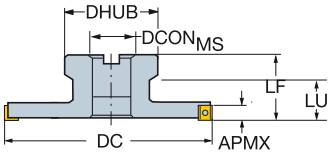
SANDVIK Coromant

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

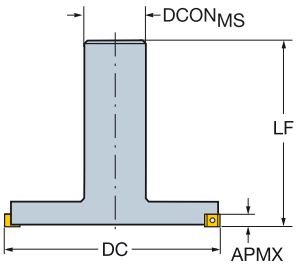
I183 L2 M1 N22 N6

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

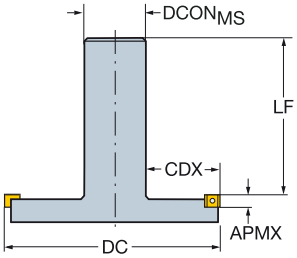
For the complete list of spare parts, visit www.sandvik.coromant.com

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

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

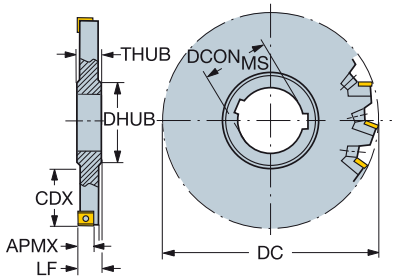
Bore with keyway

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

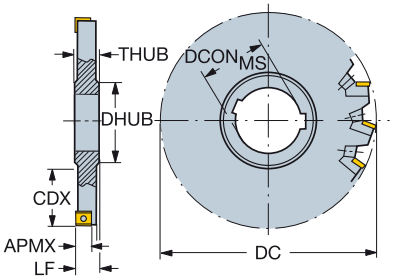
Bore with keyway

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

SANDVIK Coromant

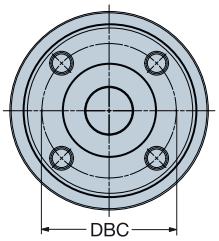
CoroMill® 331 adjustable half side and back face disc milling cutter

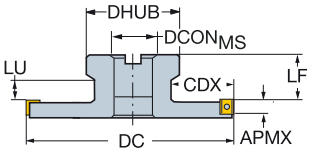
Arbor

STDNO
KAPR

ISO 6462:2011
90°









N331.1A

Metric version

DC	CDX		CZC$_{MS}$	APMX		Ordering code	Dimensions, mm DCON$_{MS}$	ISO	DBC	LF	LU	DHUB	NM	KG	RPMX	CICT	MIID
80	20.0	08	27	7.6	6	R331.52-080Q27EML	27.0	A		53.00	30	54.0	1.2	0.80	18100	6	N331.1A-08
80	20.0	08	27	7.6	6	R331.52-080Q27FML	27.0	A		51.00	28	54.0	1.2	0.98	18100	6	N331.1A-08
100	22.0	08	27	7.6	8	R331.52-100Q27EML	27.0	A		53.00		54.0	1.2	1.20	15900	8	N331.1A-08
100	22.0	08	27	7.6	8	R331.52-100Q27FML	27.0	A		51.00		54.0	1.2	1.30	15900	8	N331.1A-08
125	29.5	08	32	7.6	10	R331.52-125Q32EML	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



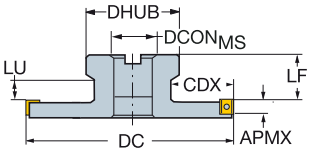
N6

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

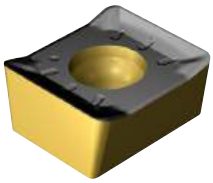
	Spare parts		
Ordering code	Insert screw	Wedge	Screw
R331.52-080R25EML	5513 020-24	5431 105-01	269-832
R331.52-080R25FML	5513 020-24	5431 105-02	269-832
R331.52-101R25EML	5513 020-24	5431 105-01	339-831
R331.52-101R25FML	5513 020-24	5431 105-02	339-831
R331.52-127R32EML	5513 020-24	5431 105-01	339-831
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

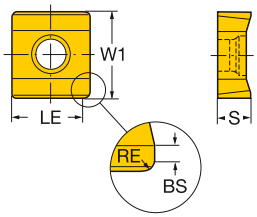
For the complete list of spare parts, visit www.sandvik.coromant.com

I183 L2 M1 N22 N6

CoroMill® 331 insert for side and face milling

KRINS 90°



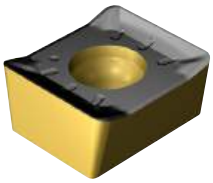


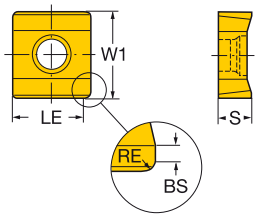
			RE	Ordering code	P				M				K				N				S				H		Dimensions, mm, inch			
					1130	4230	4240	530	1040	2040	530	S30T	1020	3040	3220	3330	1130	530	H10	H13A	1130	2040	H13A	S30T	1130	530	W1	LE	S	BS
Light	KL	04	0.50	N331.1A-04 35 05E-KL									★	☆	☆	☆											9.5	4.6	3.50	0.4
			.020																								.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

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CoroMill® 331 insert for side and face milling

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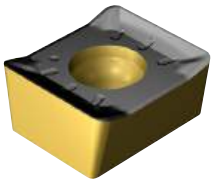
		RE	Ordering code	P				M				K				N				S				H		Dimensions, mm, inch			
				1130	4330	4340	530	1040	2040	530	S30T	1020	3040	3220	3330	1130	530	H10	H13A	1130	2040	H13A	S30T	1130	530	W1	LE	S	BS
Light	L50	04	0.50	★				★	☆		☆									☆	☆		★			9.5	4.6	3.49	0.4
			.020																							.374	.181	.137	.016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

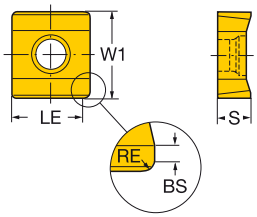
I167 I222 I254 N22 N6 N10

SANDVIK Coromant

CoroMill® 331 insert for side and face milling

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			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

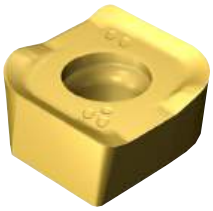
			RE	Ordering code	P		K		N	S	H	Dimensions, mm, inch			
					1130	4330	1020	3040	1130	1130	1130	W1	LE	S	BS
Light	KL	08	2.00	N331.1A-08 45 20E-KL			★					9.5	6.5	4.50	1.2
			.079									.374	.256	.177	.047
		11	2.00	N331.1A-11 50 20E-KL			★					11.5	9.5	5.00	1.2
			.079									.453	.374	.197	.047
	PL	08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

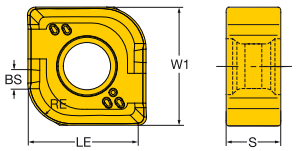
I167 I222 I254 N22 N6 N10

CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor Made.

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		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*

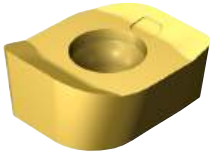
I167 I222 I254 N22 N6 N10

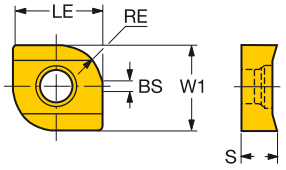
SANDVIK Coromant

CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor Made.

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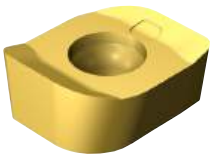
					P		M		K		N		S				H	Dimensions, mm, inch			
			RE	Ordering code	1130	4340	1040	1130	1025	4340	1130	H10F	1040	1130	S30T	H10F	1130	W1	LE	S	BS
Light	WL	04	1.52	L331.1A-04 35 15H-WL	★		★	☆	☆		☆		★	☆			★	9.5	4.6	3.50	0.4
			.060															.374	.181	.138	.016
			2.29	L331.1A-04 35 23H-WL	★		★	☆	☆		☆		★	☆			★	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

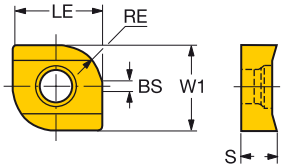
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CoroMill® 331 insert for side and face milling

Cutter bodies for radii inserts available as Tailor Made.

KRINS 90°



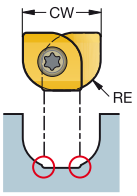


			RE	Ordering code	P		M		K		N		S				H	Dimensions, mm, inch			
					1130	4340	1040	1130	1025	4340	1130	H10F	1040	1130	S30T	H10F	1130	W1	LE	S	BS
Light	WL	14	1.52	L331.1A-14 50 15H-WL	★		★	☆	☆		☆		★	☆			★	11.5	13.7	4.95	1.2
			.060															.453	.539	.195	.047
			2.29	L331.1A-14 50 23H-WL	★		★	☆	☆		☆		★	☆			★	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

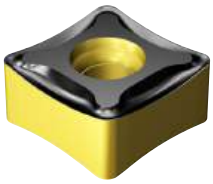
Full slot milling

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

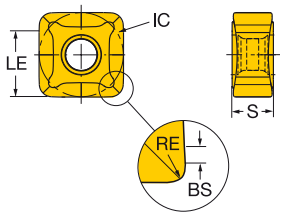


I167 I222 I254 N22 N6 N10

CoroMill® 331 insert for side and face milling

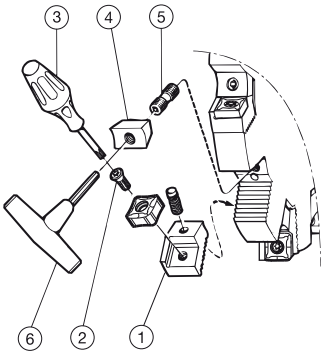


KRINS 88°



		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.



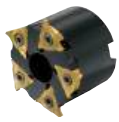
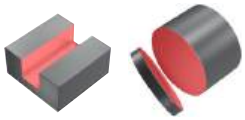
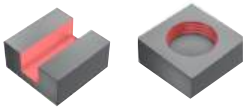
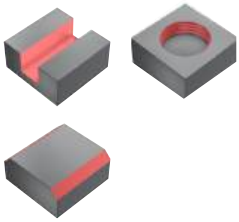
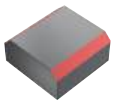
Note that the diameter of the cutter increases by 3.2 mm (.126 inch) when using the cassettes for double sided inserts.

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



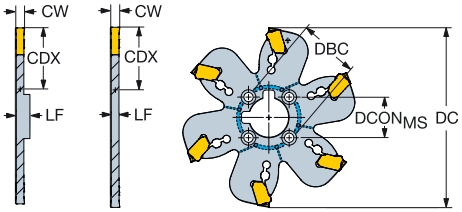
I192 I198 N6

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

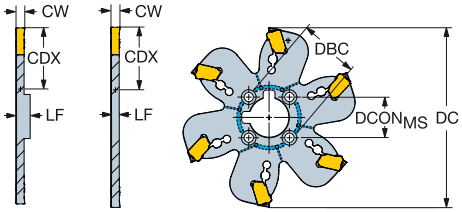
I198 L2 N22 N6 N15

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

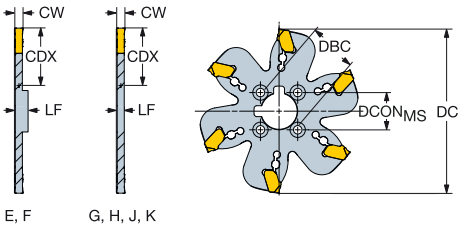
I198 L2 N22 N6 N15

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

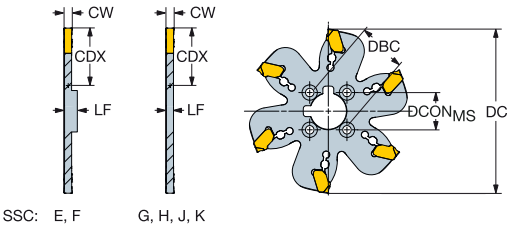
I198 L2 N22 N6

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

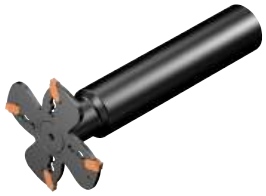
For spare parts, visit www.sandvik.coromant.com

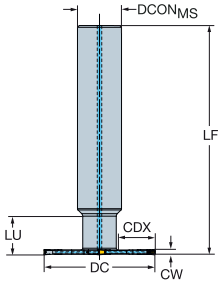
I198 L2 N22 N6

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

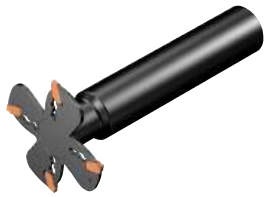
For the complete list of spare parts, visit www.sandvik.coromant.com

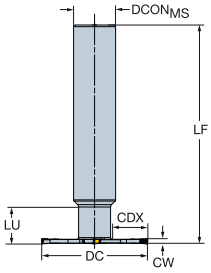
I198 L2 N22 N6 N15

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

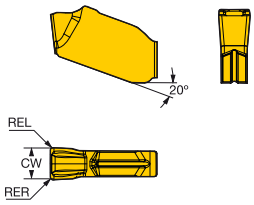
CW	DC	CDX	SSC	CZCMS		Ordering code	Dimensions, inch DCONMS	LF	LU	LBS	RPMX	BD	LB	MIID
.079	2.480	.827	E	1	4	AQD-E-063O25-M	1.000	5.118	.921	1.54	4900	.748	.858	QD-NE-0200-020E-PM
.094	2.480	.827	F	1	4	AQD-F-063O25-M	1.000	5.118	.941	1.55	5600	.748	.878	QD-NF-0239-020E-PM
.125	2.480	.827	G	1	4	AQD-G-063O25-M	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





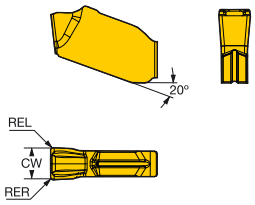
	SSC	CW	REL	RER	Ordering code	P 1130	P 4340	M 1040	M 2040	M S30T	K 1020	K 3330	N 1130	N H13A	S 1130	S H13A	S S30T	S S40T	H 1130	Dimensions, mm, inch AN	CWTOLL	CWTOLU
	E	2.00	0.10	0.10	QD-NE-0200-010E-NL									★		☆				7°	0.005	0.055
		.079	.004	.004																7°	.0002	.0022
		2.00	0.20	0.20	QD-NE-0200-020E-KL						★	☆								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
Light	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

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SANDVIK Coromant

CoroMill® QD insert for grooving

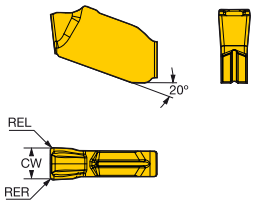




	SSC	CW	REL	RER	Ordering code	P 1130	P 4340	M 1040	M 2040	M S30T	K 1020	K 3330	N 1130	N H13A	S 1130	S H13A	S S30T	S S40T	H 1130	Dimensions, mm, inch AN	CWTOLL	CWTOLU
Light	J	4.76	0.20	0.20	QD-NJ-0476-020E-NL									★		☆				7°	0.005	0.055
		.187	*.008*	*.008*																*7°*	*.0002*	*.0022*
		4.76	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*

CoroMill® QD insert for grooving





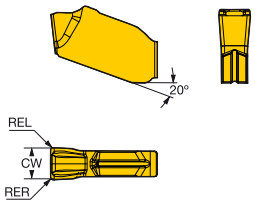
	SSC	CW	REL	RER	Ordering code	P 1130	P 4340	M 1040	M 2040	M S30T	K 1020	K 3330	N 1130	N H13A	S 1130	S H13A	S S30T	S S40T	H 1130	Dimensions, mm, inch AN	CWTOLL	CWTOLU
Medium	E	2.00	0.20	0.20	QD-NE-0200-020E-MM			★	☆											7°	0.005	0.055
		.079	.008	.008																7°	.0002	.0022
		2.00	0.20	0.20	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

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SANDVIK Coromant

CoroMill® QD insert for grooving



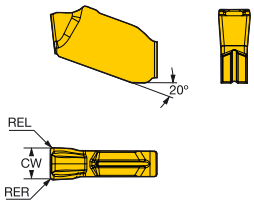


	SSC	CW	REL	RER	Ordering code	P 1130	P 4340	M 1040	M 2040	M S30T	K 1020	K 3330	N 1130	N H13A	S 1130	S H13A	S S30T	S S40T	H 1130	Dimensions, mm, inch AN	CWTOLL	CWTOLU
Medium	J	4.76	0.30	0.30	QD-NJ-0476-030E-MM			★	☆											7°	0.005	0.055
		.187	.012	.012																7°	.0002	.0022
		4.76	0.30	0.30	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

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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

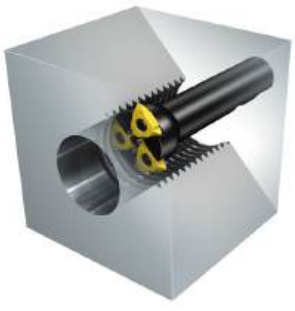
www.sandvik.coromant.com/coromill328

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

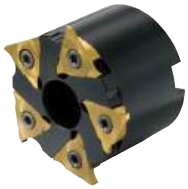


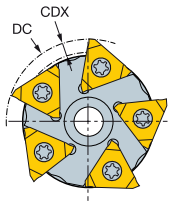
I207

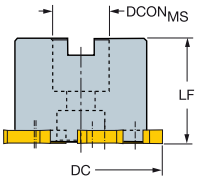
CoroMill® 328 groove milling cutter

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

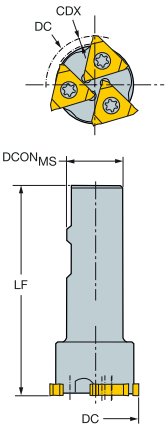
SANDVIK Coromant

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

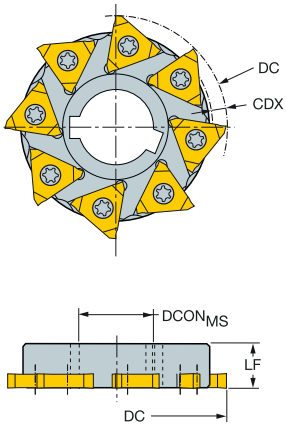
I207 L2 N22 N12

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

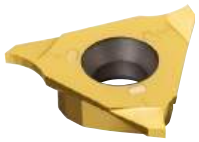
For the complete list of spare parts, visit www.sandvik.coromant.com

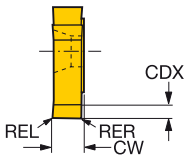
I207 L2 N22 N12

SANDVIK Coromant

CoroMill® 328 insert for groove milling

For circlip grooves

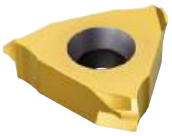


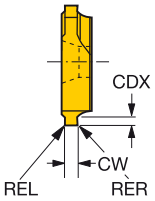


For circlip grooves

		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



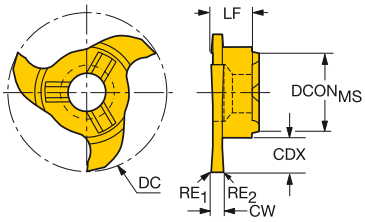

I209


L2

SANDVIK Coromant

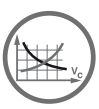
CoroMill® 327 solid-carbide head for grooving





							P	M	K	N	S	Dimensions, mm, inch					
CW	RE1	RE2	CZCMS	CDX	ZEFP	Ordering code	1025	1025	1025	1025	1025	DCONMS	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



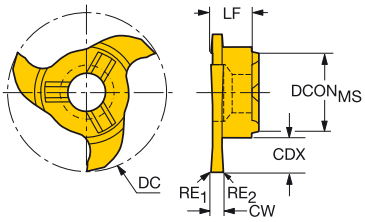
N22



N11

CoroMill® 327 solid-carbide head for grooving



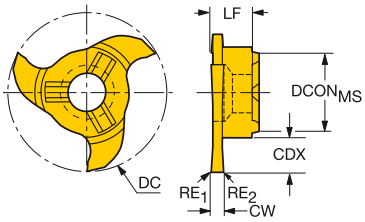


CW	RE1	RE2	CZCMS	CDX	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	DCONMS	DC	LF	CWTOLL	CWTOLU	RPMX
Dimensions, mm, inch																	
1.50	0.10	0.10	14.0	10.0	6	327R14-35 15001-GMM	☆	☆	☆	☆	☆	14.30	34.70	6.25	0.000	0.020	50000
.059	*.004*	*.004*		*.394*								*.563*	*1.366*	*.246*	*.0000*	*.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

CoroMill® 327 solid-carbide head for grooving





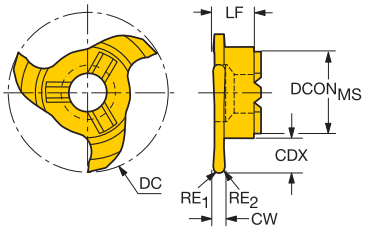
For circlip grooves

							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

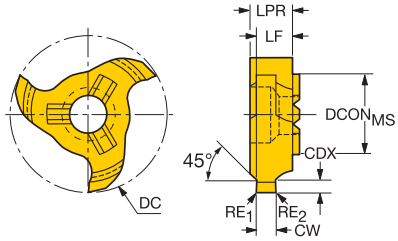




For full radius grooves

CW	RE1	RE2	CZCMS	CDX	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	DCONMS	DC	LF	CWTOLL	CWTOLU	RPMX
							Dimensions, mm, inch										
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

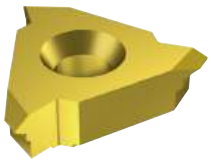
CW	RE1	RE2	CZCMS	CDX	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	DCONMS	DC	LF	LPR	CWTOLL	CWTOLU	RPMX
							Dimensions, mm, inch											
1.10	0.00	0.00	12.0	0.5	3	327R12-22 11045-GC	☆	☆	☆	☆	☆	12.00	21.70	5.00	5.80	0.090	0.110	50000
.043	*.000*	*.000*		*.020*								*.472*	*.854*	*.197*	*.228*	*.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*	

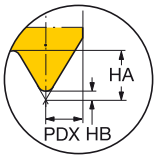
L2 I222 I254 N22 N11

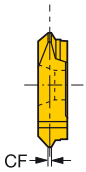
SANDVIK Coromant

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

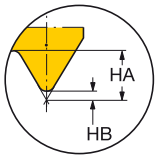
SSC	TPN	TPX	TPIN	TPIX	NT	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	H 1025	Dimensions, mm, inch CF	HA	HB	PDX
13	1.5	3.5	7.0	16.0	1	328R13-150 VM-TH	☆	☆	☆	☆	☆	☆	0.2	2.31	0.13	1.95
													.007	.0909	.0051	.077
	4.0	6.0	4.0	6.0	1	328R13-400 VM-TH	☆	☆	☆	☆	☆	☆	0.5	4.06	0.41	2.60
													.020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

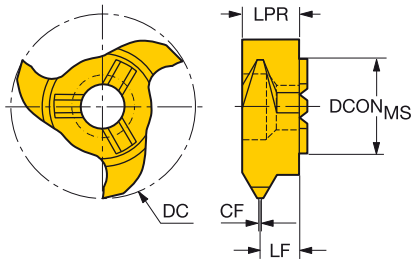
I204 I222 I254 N22 N12

CoroMill® 327 solid-carbide head for thread milling

For internal threads



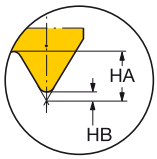


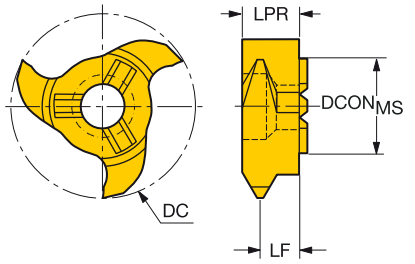


V-profile 60° Non-topping

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

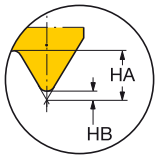
L2 I222 I254 N22 N11

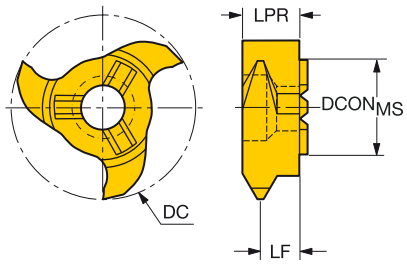
SANDVIK Coromant

CoroMill® 327 solid-carbide head for thread milling

For internal threads







UN 60° Topping

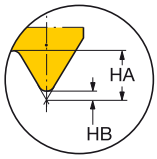
TPI	D_c	CZC_{MS}	APMX	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	Dimensions, mm, inch $DCON_{MS}$	HA	HB	LF	LPR
20	17.70	9.0	0.69	3	327R09-18 20UN-TH	☆	☆	☆	☆	☆	9.00	0.82	0.14	5.2	5.85
	.697										*.354*	*.032*	*.006*	*.205*	*.230*
18	17.70	9.0	0.76	3	327R09-18 18UN-TH	☆	☆	☆	☆	☆	9.00	0.92	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*

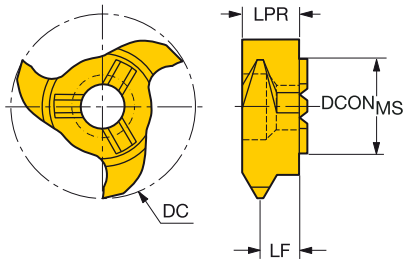
L2 I222 I254 N22 N11

CoroMill® 327 solid-carbide head for thread milling

For internal threads







Metric 60° Topping

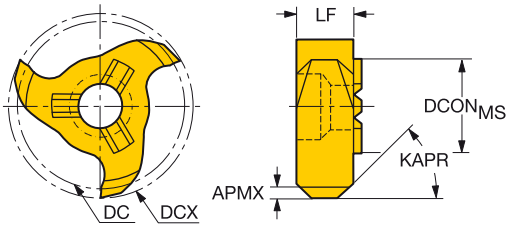
TP	DC	CZC_{MS}	ZEFP	Ordering code	P 1025	M 1025	K 1025	N 1025	S 1025	Dimensions, mm $DCON_{MS}$	HA	HB	LF	LPR
1.50	17.70	9.0	3	327R09-18 150MM-TH	☆	☆	☆	☆	☆	9.00	0.97	0.16	4.8	5.85
.059	.697									.354	.038	.006	.189	.230
1.50	17.70	9.0	6	327R09-18 150MM-THM	☆	☆	☆	☆	☆	9.00	0.97	0.16	5.0	5.85
.059	.697									.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

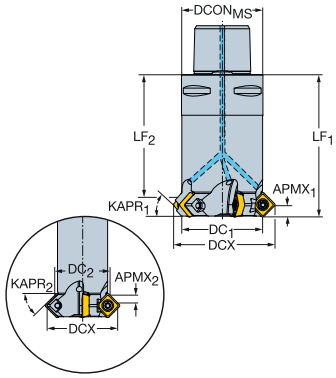
I219 I221

CoroMill® 495 chamfer milling cutter

Coromant Capto® - Internal coolant supply

STDNO ISO26623-1



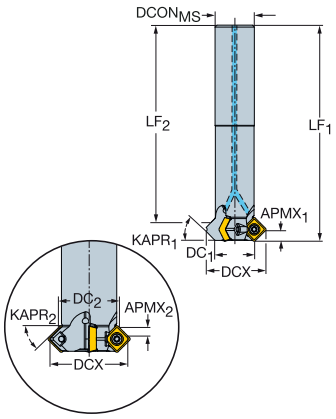


Metric version

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

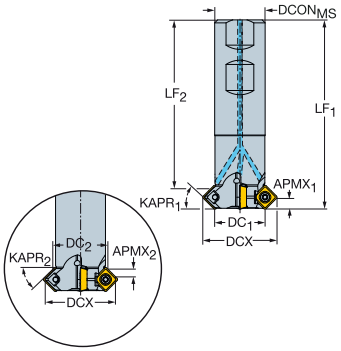
I221 L2 N22 N9 N15

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

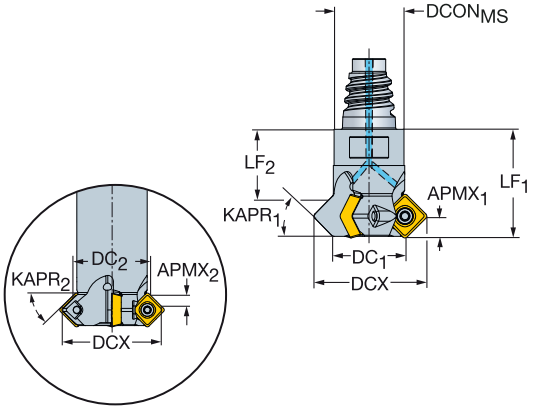
I221 L2 N22 N9 N15

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

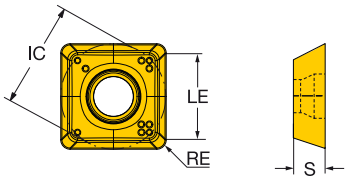
Spare parts
Insert screw
5513 020-04

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

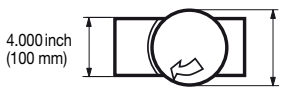
L2 I222 N22 N9 N15 N3

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

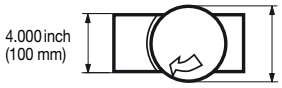
ISO N			Specific cutting force k_{c1}	Hardness Brinell		CD10	H10	CT530
						Max chip thickness, h_{ex} mm		
						0.1 – 0.15 – 0.2	0.1 – 0.15 – 0.2	0.1 – 0.15 – 0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_c, m/min		
		Aluminum alloys						
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, 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).

SANDVIK Coromant

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					

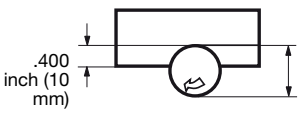
Milling with small engagement, metric values

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).

SANDVIK Coromant

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

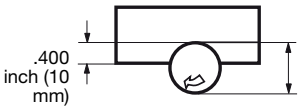
ISO N			Specific cutting force k_{c1}	Hardness Brinell		CD10	CT530	H10
						Max chip thickness, h_{ex} mm		
						0.1 – 0.15 – 0.2	0.1 – 0.15 – 0.2	0.1-0.15-0.2
MC No.	CMC No.	Material	N/mm²	HB	mc	Cutting speed v_{c1} m/min		
		Aluminum alloys						
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, 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).

SANDVIK Coromant

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	1100 –1100 –1050	1050 –1050 –1000	850 –830 –820							
1000 –980 –970	1000 –980 –970	950 –940 –920	760 –750 –740							
1100 –1100 –1050	1100 –1100 –1050	1050 –1050 –1000	850 –830 –820							
110 –1100 –1100	1100 –1100 –1100	950 –940 –920	760 –750 –740							
1100 –1100 –1100	1100 –1100 –1100	1050 –1050 –1050	850 –840 –825							
445 –440 –430	445 –440 –430	425 –420 –410	340 –335 –330							
335 –330 –325	335 –330 –325	320 –315 –310	255 –250 –245							
560 –550 –540	560 –550 –540	530 –520 –510	425 –415 –410							
560 –550 –540	560 –550 –540	530 –520 –510	425 –415 –410							
390 –380 –375	390 –380 –375	370 –365 –360	295 –290 –285							

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	60 –60 –60	–	–	65 –65 –65	70 –65 –65					
50-50-50	45 –45 –40	–	–	50 –50 –45	50 –50 –45					
65-65-60	60 –55 –55	–	–	65 –60 –60	65 –65 –60					
40-39-38	36 –35 –33	–	–	40 –38 –38	40 –39 –38					
50-50-50	45 –45 –40	–	–	50 –45 –45	50 –50 –45					
28-27-26	26 –24 –23	–	–	28 –27 –26	28 –27 –26					
20-19-19	18 –17 –16	–	–	20 –19 –19	20 –19 –19					
19-19-18	17 –16 –16	–	–	19 –18 –17	19 –18 –17					
140-140-135	130 –125 –120	170 –165 –160	145 –145 –140	140 –135 –130	145 –140 –135					
55-55-55	50 –50 –45	75 -75 -70	55-50-50	55-55-55	50 –50 –50					
45-40-40	38 –37 –36	65 –60 –66	45-45-45	50 –45 –45	45 –40 –40					

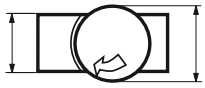
GC4220	GC3040	GC1010	GC1130							
Max chip thickness, h_{ex} mm										
0.1-0.12-0.25	0.1-0.2-0.25	0.07-0.12-0.2	0.07-0.12-0.2							
Cutting speed v_c, m/min										
65–65–60	55-50-50	130-125-120	45-45-45							
125–125–115	100-95-95	250-240-230	90-85-85							

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

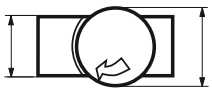
ISO N			Specific cutting force k_{c1}	Hardness Brinell		CD10	H10	H13A
						Max chip thickness, h_{ex} inch		
						.004-.006-.008	.004-.006-.008	.004-.006-.008
MC No.	CMC No.	Material	lbs/in²	HB	mc	Cutting speed v_{c_f} ft/min		
		Aluminum alloys						
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, 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_f} 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_f} 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.



Conditions:

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

SANDVIK Coromant

US

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			

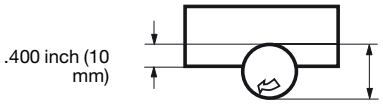
GC4220	GC3040	GC1010	GC1025					
Max chip thickness, h_{ex} inch								
.004-.006-.010	.004-.008-.010	.003-.005-.008	.003-.005-.008					
Cutting speed v_c, ft/min								
175-150-115	140-110-95	360-310-255	130-115-95					
330-285-220	270-205-180	690-600-490	250-215-175					

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



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

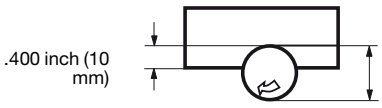
ISO N			Specific cutting force k_{c1}	Hardness Brinell		CD10	CT530	H10
						Max chip thickness, h_{ex} inch		
						.004-.006-.008	.004-.006-.008	.004-.006-.008
MC No.	CMC No.	Material	lbs/in²	HB	mc	Cutting speed v_{c}, ft/min		
		Aluminum alloys						
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, 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

	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.)
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

	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.)
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

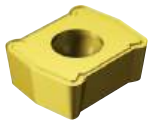
Drilling is often carried out late in the manufacturing process, after previous operations have already enhanced the initial component's value. The drilling application, although seemingly simple, is a complex operation that can have significant consequences if the tool malfunctions or is run beyond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

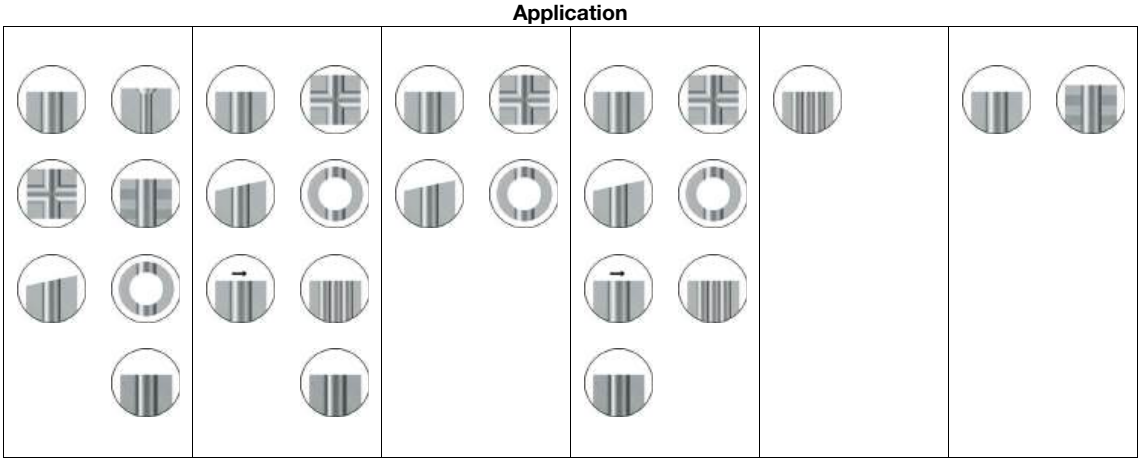
Important factors to consider:
- When drilling holes deeper than 6xD with CoroDrill® 870, use a piloting operation
- Ensure that coolant flow is sufficient to evacuate chips
- Adjust your cutting data to obtain satisfactory chips, a stable process and to ultimately meet the demands for your hole

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 D_c inch	10.00-33.00 .393-1.299	15.00-40.00 .591-1.575	12.00-63.50 .500-2.500	65.00-84.00 2.559-3.307	60.00-110.00 2.362-4.331	
ISO application area	P M K N S	P M K N S H	P M K N S H	P M K N S H	P M K N S H	P M K N S H
ULDR	3-10 x DC	4-7 x DC	2-3 x DC	3-4 x DC	2.5 x DC	
TCHA	H9-H10	IT13-IT14	H12-H13	IT13	IT13	
Coolant	Internal	Internal	Internal	Internal	External	
Page	**J4**	**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 10×DC	0/+0.043 (.0017) 0/+0.070 (.0028)	0/+0.052 (.0020) 0/+0.084 (.0033)	0/+0.062 (.0024) 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

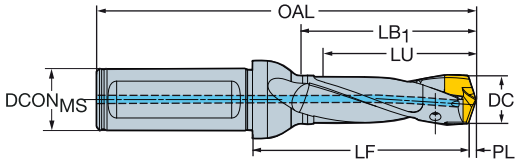
- New, thin, multi-layer PVD coating (AlTiCrN) with improved resistance against flaking and chipping on secondary edge.
- A tough, high Cr content, fine-grain substrate for high reliability and chipping resistance.
- First choice in ISO M

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	

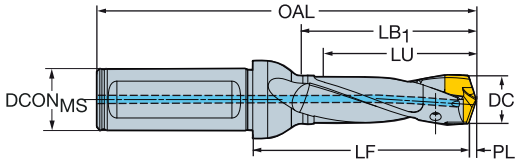
J12 L2 N22 N6 N15

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	

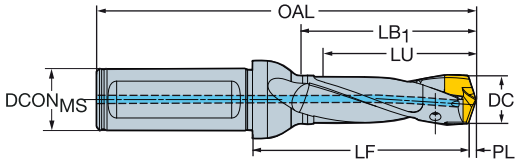
J12 L2 N22 N6 N15

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
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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

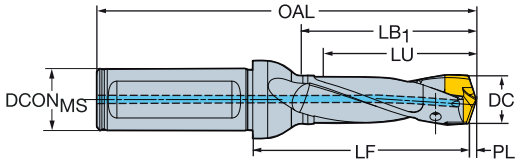
J12 L2 N22 N6 N15

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	

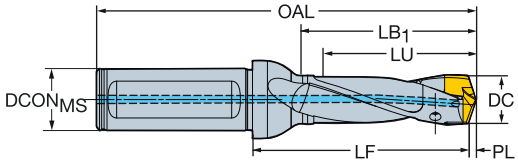
J12 L2 N22 N6 N15

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	

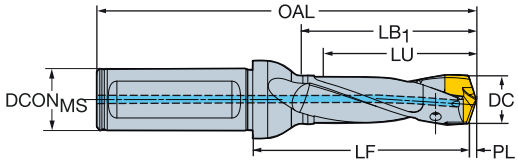
J12 L2 N22 N6 N15

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	

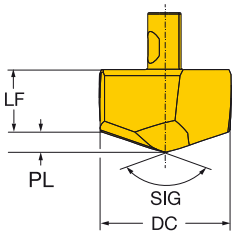
	Spare parts
	Insert screw
6	5513 031-15
7	5513 031-15
8	5513 031-15
9	5513 031-15
10	5513 031-12
11	5513 031-12
12	5513 031-12
13	5513 031-12
14	5513 031-12
15	5513 031-12
16	5513 031-13
17	5513 031-13
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21	5513 031-14
22	5513 031-14
23	5513 031-14
24	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





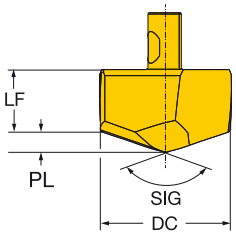
DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
10.00	.393	6	870-1000-6-PM		★		☆		☆	☆		☆	4.7	.183	1.5	.061	142°	H9
10.00	.393		870-1000-6-MM			★					☆		4.7	.183	1.5	.061	142°	H9
10.00	.393		870-1000-6-KM	☆				★					4.4	.172	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

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SANDVIK Coromant

CoroDrill® 870 drill tip



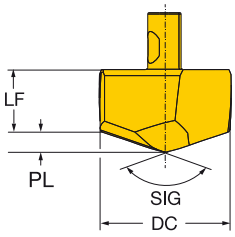


DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	LF	LF"	PL	PL"	SIG	TCHA
				Dimensions, mm, inch														
11.20	.440	8	870-1120-8-PM		★		☆		☆	☆		☆	5.2	.204	1.7	.067	142°	H9
11.20	.440		870-1120-8-MM			★					☆		5.2	.204	1.7	.067	142°	H9
11.20	.440		870-1120-8-KM	☆				★					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

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CoroDrill® 870 drill tip





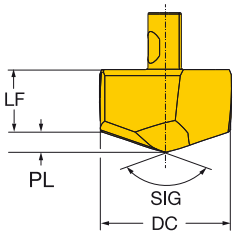
DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
12.50	.492	11	870-1250-11-PM		★		☆		☆	☆		☆	5.6	.220	1.9	.075	142°	H9
12.50	.492		870-1250-11-MM			★					☆		5.6	.220	1.9	.075	142°	H9
12.50	.492		870-1250-11-KM	☆				★					5.2	.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

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SANDVIK Coromant

CoroDrill® 870 drill tip



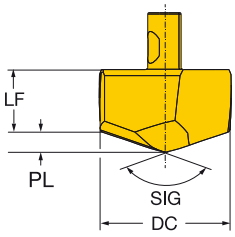


DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	LF	LF"	PL	PL"	SIG	TCHA
				Dimensions, mm, inch														
13.80	.543	13	870-1380-13-PM		★		☆		☆	☆		☆	5.9	.231	2.1	.084	142°	H9
13.80	.543		870-1380-13-MM			★					☆		5.9	.231	2.1	.084	142°	H9
13.80	.543		870-1380-13-KM	☆				★					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

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CoroDrill® 870 drill tip





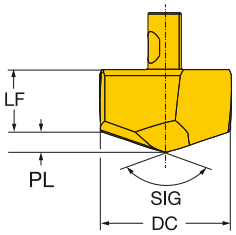
DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
15.00	.590	15	870-1500-15-PM		★		☆		☆	☆		☆	7.0	.276	2.3	.090	142°	H9
15.00	.590		870-1500-15-MM			★					☆		7.0	.276	2.3	.090	142°	H9
15.00	.590		870-1500-15-KM	☆				★					6.5	.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

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SANDVIK Coromant

CoroDrill® 870 drill tip



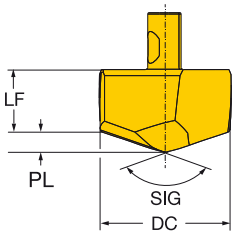


DC	DC"		Ordering code	P		M		K		N	S		Dimensions, mm, inch					
				3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	LF"	PL	PL"	SIG	TCHA
16.13	.635	16	870-1613-16-PM		★		☆		☆	☆		☆	7.6	.297	2.5	.096	142°	H9
16.13	.635		870-1613-16-PL		☆		★						6.7	.264	3.3	.130	142°	H9
16.13	.635		870-1613-16-MM			★					☆		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





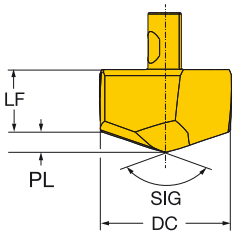
DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
17.40	.685	17	870-1740-17-PM		★		☆		☆	☆		☆	8.0	.313	2.7	.104	142°	H9
17.40	.685		870-1740-17-MM			★					☆		8.0	.313	2.7	.104	142°	H9
17.40	.685		870-1740-17-KM	☆				★					7.3	.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

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CoroDrill® 870 drill tip



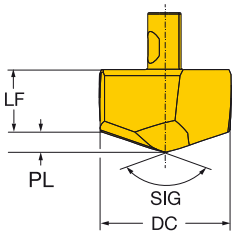


DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
18.60	.732	18	870-1860-18-PM		★		☆		☆	☆		☆	8.5	.334	2.8	.111	142°	H9
18.60	.732		870-1860-18-MM			★					☆		8.5	.334	2.8	.111	142°	H9
18.60	.732		870-1860-18-KM	☆				★					7.8	.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

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CoroDrill® 870 drill tip





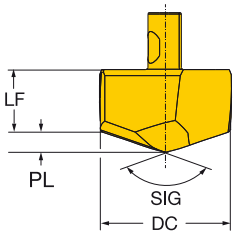
DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
19.60	.771	19	870-1960-19-PM		★		☆		☆	☆		☆	8.9	.352	3.0	.117	142°	H9
19.60	.771		870-1960-19-MM			★					☆		8.9	.352	3.0	.117	142°	H9
19.60	.771		870-1960-19-KM	☆				★					8.2	.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

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CoroDrill® 870 drill tip



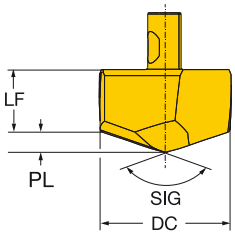


DC	DC"		Ordering code	P		M		K		N	S		Dimensions, mm, inch					
				3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	LF"	PL	PL"	SIG	TCHA
20.80	.818	20	870-2080-20-PM		★		☆		☆	☆		☆	9.3	.368	3.2	.124	142°	H9
20.80	.818		870-2080-20-MM			★					☆		9.3	.368	3.2	.124	142°	H9
20.80	.818		870-2080-20-KM	☆				★					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

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CoroDrill® 870 drill tip





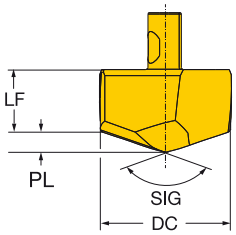
DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
22.10	.870	22	870-2210-22-PM		★		☆		☆	☆		☆	10.5	.412	3.3	.131	142°	H9
22.10	.870		870-2210-22-MM			★					☆		10.5	.412	3.3	.131	142°	H9
22.10	.870		870-2210-22-KM	☆				★					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



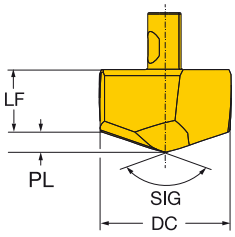


DC	DC"		Ordering code	P		M		K		N	S		Dimensions, mm, inch					
				3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	LF"	PL	PL"	SIG	TCHA
23.30	.917	23	870-2330-23-PM		★		☆		☆	☆		☆	11.0	.433	3.5	.138	142°	H9
23.30	.917		870-2330-23-MM			★					☆		11.0	.433	3.5	.138	142°	H9
23.30	.917		870-2330-23-KM	☆				★					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





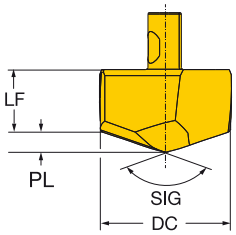
DC	DC"		Ordering code	P 3334	P 4334	M 2334	M 4334	K 3334	K 4334	N 4334	S 2334	S 4334	Dimensions, mm, inch LF	LF"	PL	PL"	SIG	TCHA
24.50	.964	24	870-2450-24-PM		★		☆		☆	☆		☆	11.3	.445	3.7	.146	142°	H9
24.50	.964		870-2450-24-MM			★					☆		11.3	.445	3.7	.146	142°	H9
24.50	.964		870-2450-24-KM	☆				★					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

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SANDVIK Coromant

CoroDrill® 870 drill tip



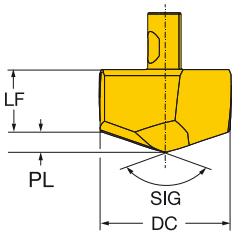


DC	DC"		Ordering code	P		M		K		N	S		Dimensions, mm, inch					
				3334	4334	2334	4334	3334	4334	4334	2334	4334	LF	LF"	PL	PL"	SIG	TCHA
25.80	1.015	25	870-2580-25-PM		★		☆		☆	☆		☆	11.8	.465	3.9	.153	142°	H9
25.80	1.015		870-2580-25-MM			★					☆		11.8	.465	3.9	.153	142°	H9
25.80	1.015		870-2580-25-KM	☆				★					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

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 - Hardened steel - Low to medium feed - Light cutting
M7		P K	- Short-chipping material - Low to high feed - Strong reinforced edge

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

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

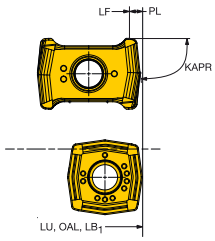
Peripheral insert		Grade information
	P M K H	**GC4334** - Good to average conditions - CVD coating with Inveio® technology provides a high level of wear resistance
	M S	**GC2044** - PVD-oxide coating for excellent wear resistance
	P M K N S H	**GC4344** - PVD coating with Zertivo® technology - Tough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

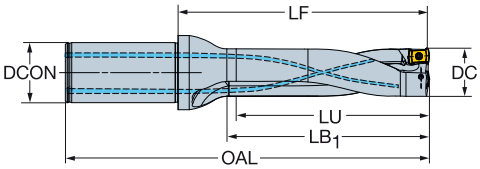
CoroDrill® DS20 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply







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

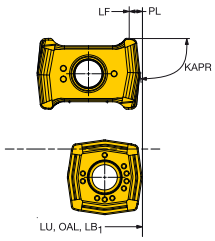
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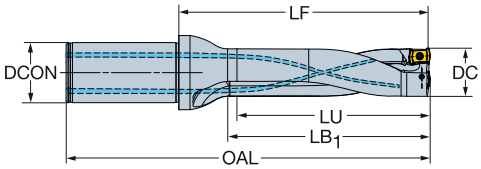
CoroDrill® DS20 indexable insert drill

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

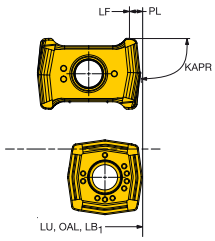
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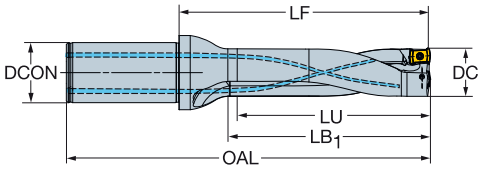
CoroDrill® DS20 indexable insert drill

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

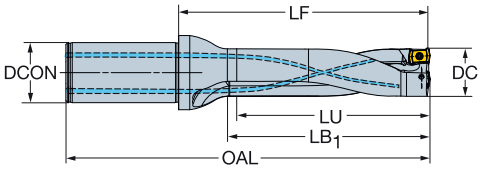
J37 L2 N22 N15

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

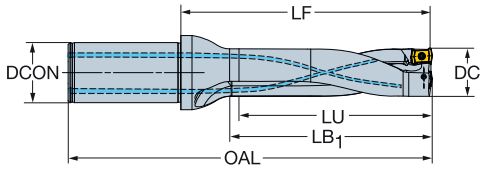
J37 L2 N22 N15

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



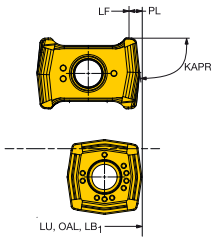
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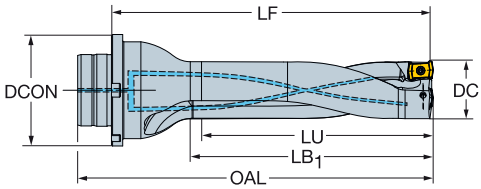
CoroDrill® DS20 indexable insert drill

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

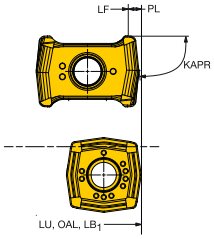
J37 L2 N22 N15

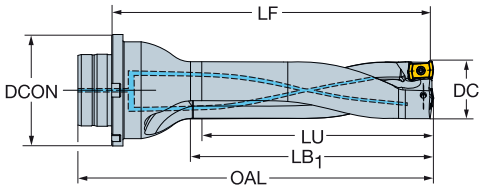
CoroDrill® DS20 indexable insert drill

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 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


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L2



N22



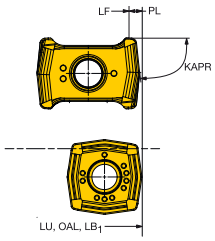
N15

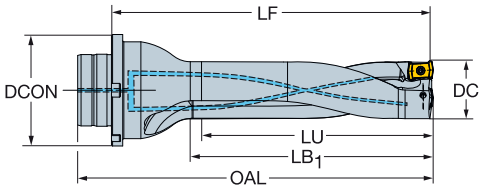
CoroDrill® DS20 indexable insert drill

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 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

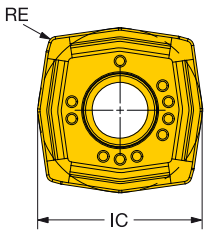
For the complete list of spare parts, visit www.sandvik.coromant.com

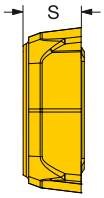
J37 L2 N22 N15

CoroDrill® DS20 insert for drilling

Central insert







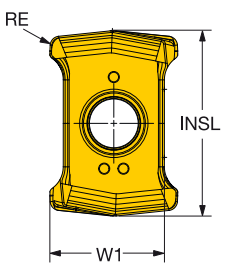
	INSUC	Ordering code	P			M	K	N		S		H	Dimensions, mm, inch		
			1344			1144	1344	H13A	1344	1344	H13A	1344	S	RE	IC
01C	C	DS20-0104-C-L5	★			★		★	☆	★	☆	★	2.30	0.35	6.0
													.091	*.014*	*.237*
01C	C	DS20-0104-C-M7	★				★					☆	2.30	0.35	6.0
													.091	*.014*	*.237*
02C	C	DS20-0205-C-L5	★			★		★	☆	★	☆	★	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*

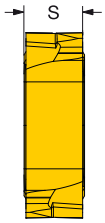
J29 L2 N22

CoroDrill® DS20 insert for drilling

Peripheral insert







			P			M			K			N		S			H		Dimensions, mm, inch			
	INSUC	Ordering code	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:

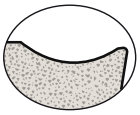
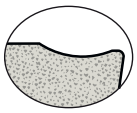
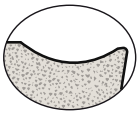
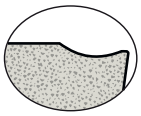
2 – 3 x DC

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

Grade overview

4334

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

4324

- Wear-resistant choice for ISO P and K

4344

- Secure grade that works in all types of materials

2044

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

N124

- Diamond coating
- First choice in ISO N

H13A

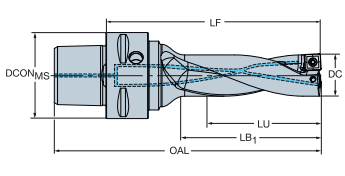
- Uncoated grade

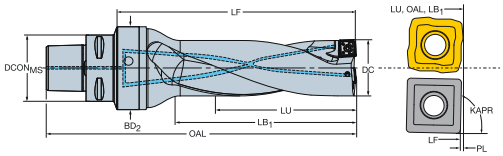
CoroDrill® 880 indexable insert drill

Coromant Capto® - 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
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

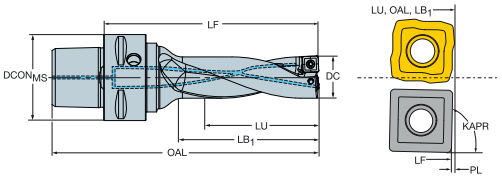
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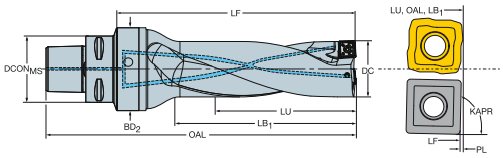
CoroDrill® 880 indexable insert drill

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

Spare parts	
DC	Insert screw
12.70-16.00	01-02 5513 020-87
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

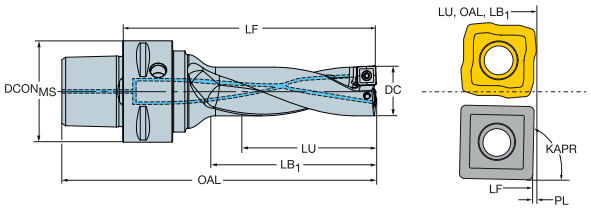
J53 L2 J86 J40 N22 N6 N15

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 020-87
.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

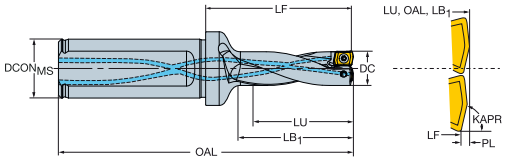
CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

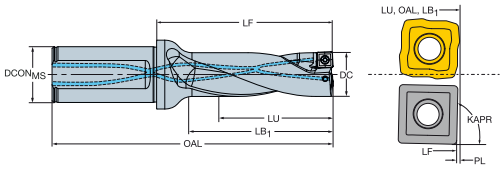
Internal coolant supply



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

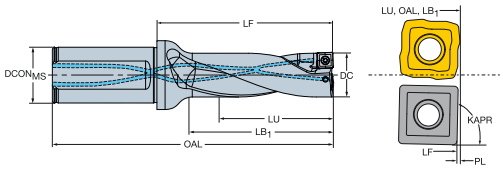
SANDVIK Coromant

CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply





Metric design

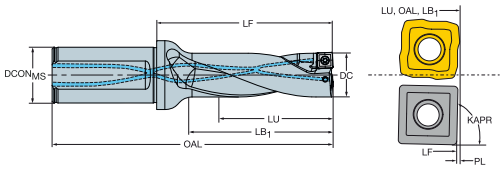
DC			LU	CZC_{MS}	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm $DCON_{MS}$	LF	OAL	LB_1	PL	KAPR	BAR	KG	RPMX
25.50	05C	05P	77.00	25	0.90	0.00	0.25	880-D2550L25-03	25.00	99.48	156.00	80.00	0.51	88°	10	0.501	16000
26.00	05C	05P	52.00	32	0.90	0.00	0.25	880-D2600L32-02	32.00	76.47	137.00	56.00	0.52	88°	10	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

CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply





Metric design

DC			LU	CZCMS	ADJLX	TCHAL	TCHAU	Ordering code	Dimensions, mm DCONMS	LF	OAL	LB1	PL	KAPR	BAR	KG	RPMX
46.00	08C	08P	92.00	40	1.30	0.00	0.28	880-D4600L40-02	40.00	129.22	200.00	97.00	0.78	88°	10	1.610	15000
			138.00	40	1.30	0.00	0.28	880-D4600L40-03	40.00	175.22	246.00	143.00	0.78	88°	10	1.881	15000
47.00	08C	08P	94.00	40	1.10	0.00	0.28	880-D4700L40-02	40.00	131.21	202.00	99.00	0.78	88°	10	1.800	15000
			141.00	40	1.10	0.00	0.28	880-D4700L40-03	40.00	178.21	249.00	146.00	0.78	88°	10	2.140	15000
48.00	08C	08P	96.00	40	1.00	0.00	0.28	880-D4800L40-02	40.00	134.20	205.00	101.00	0.79	88°	10	1.925	15000
			144.00	40	1.00	0.00	0.28	880-D4800L40-03	40.00	182.20	253.00	149.00	0.79	88°	10	2.235	15000
49.00	08C	08P	98.00	40	0.90	0.00	0.28	880-D4900L40-02	40.00	136.19	207.00	103.00	0.80	88°	10	1.970	15000
			147.00	40	0.90	0.00	0.28	880-D4900L40-03	40.00	185.19	256.00	152.00	0.80	88°	10	2.275	15000
50.00	08C	08P	100.00	40	0.80	0.00	0.28	880-D5000L40-02	40.00	139.18	210.00	105.00	0.81	88°	10	2.031	15000
			150.00	40	0.80	0.00	0.28	880-D5000L40-03	40.00	189.18	260.00	155.00	0.81	88°	10	2.430	15000
51.00	08C	08P	102.00	40	0.60	0.00	0.28	880-D5100L40-02	40.00	143.18	214.00	108.00	0.82	88°	10	2.110	15000
			153.00	40	0.60	0.00	0.28	880-D5100L40-03	40.00	193.18	264.00	158.00	0.82	88°	10	2.480	15000
52.00	08C	08P	104.00	40	0.50	0.00	0.28	880-D5200L40-02	40.00	145.17	216.00	110.00	0.82	88°	10	2.180	15000
			156.00	40	0.50	0.00	0.28	880-D5200L40-03	40.00	196.17	267.00	161.00	0.82	88°	10	2.595	15000
53.00	09C	09P	106.00	40	2.00	0.00	0.30	880-D5300L40-02	40.00	148.12	219.00	112.00	0.87	88°	10	2.307	5000
			159.00	40	2.00	0.00	0.30	880-D5300L40-03	40.00	200.12	271.00	164.00	0.87	88°	10	2.600	5000
54.00	09C	09P	108.00	40	1.90	0.00	0.30	880-D5400L40-02	40.00	150.11	221.00	114.00	0.88	88°	10	2.380	5000
			162.00	40	1.90	0.00	0.30	880-D5400L40-03	40.00	203.11	274.00	167.00	0.88	88°	10	2.714	5000
55.00	09C	09P	110.00	40	1.70	0.00	0.30	880-D5500L40-02	40.00	153.10	224.00	116.00	0.89	88°	10	2.349	5000
			165.00	40	1.70	0.00	0.30	880-D5500L40-03	40.00	208.10	279.00	171.00	0.89	88°	10	2.850	5000
56.00	09C	09P	112.00	40	1.60	0.00	0.30	880-D5600L40-02	40.00	156.10	227.00	118.00	0.89	88°	10	2.451	5000
			168.00	40	1.60	0.00	0.30	880-D5600L40-03	40.00	212.10	283.00	174.00	0.89	88°	10	2.977	5000
57.00	09C	09P	114.00	40	1.50	0.00	0.30	880-D5700L40-02	40.00	158.09	229.00	120.00	0.90	88°	10	2.530	5000
			171.00	40	1.50	0.00	0.30	880-D5700L40-03	40.00	215.09	286.00	177.00	0.90	88°	10	3.120	5000
58.00	09C	09P	116.00	40	1.40	0.00	0.30	880-D5800L40-02	40.00	161.08	232.00	122.00	0.91	88°	10	2.650	5000
			174.00	40	1.40	0.00	0.30	880-D5800L40-03	40.00	219.08	290.00	180.00	0.91	88°	10	3.593	5000
59.00	09C	09P	118.00	40	1.20	0.00	0.30	880-D5900L40-02	40.00	163.07	234.00	124.00	0.92	88°	10	2.703	5000
			177.00	40	1.20	0.00	0.30	880-D5900L40-03	40.00	222.07	293.00	183.00	0.92	88°	10	3.346	5000
60.00	09C	09P	120.00	40	1.10	0.00	0.30	880-D6000L40-02	40.00	166.06	237.00	126.00	0.93	88°	10	2.820	5000
			180.00	40	1.10	0.00	0.30	880-D6000L40-03	40.00	226.06	297.00	186.00	0.93	88°	10	3.570	5000
61.00	09C	09P	122.00	40	1.00	0.00	0.30	880-D6100L40-02	40.00	170.06	241.00	129.00	0.93	88°	10	3.032	5000
			183.00	40	1.00	0.00	0.30	880-D6100L40-03	40.00	231.06	302.00	190.00	0.93	88°	10	4.039	5000
62.00	09C	09P	124.00	40	0.80	0.00	0.30	880-D6200L40-02	40.00	172.05	243.00	131.00	0.94	88°	10	3.020	5000
			186.00	40	0.80	0.00	0.30	880-D6200L40-03	40.00	234.05	305.00	193.00	0.94	88°	10	4.115	5000
63.00	09C	09P	126.00	40	0.70	0.00	0.30	880-D6300L40-02	40.00	175.04	246.00	133.00	0.95	88°	10	3.173	5000
			189.00	40	0.70	0.00	0.30	880-D6300L40-03	40.00	238.04	309.00	196.00	0.95	88°	10	4.300	5000

Spare parts		
DC		Insert screw
12.00-16.00	01-02	5513 020-87
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

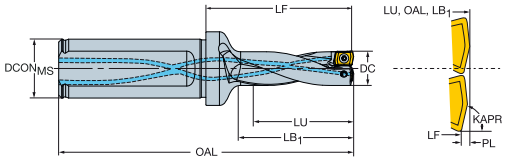
CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

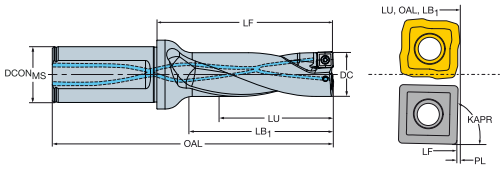
Internal coolant supply



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

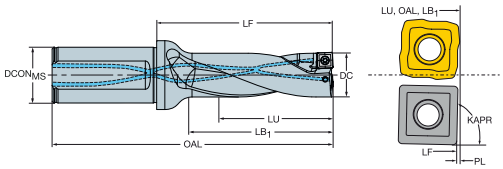
J53 L2 J86 J40 N22 N6 N15

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	01-02	5513 020-87
.656-.750	03	5513 020-33
.812-.937	04	5513 020-58
1.000-1.125	05	5513 020-57
1.187-1.687	06-07	416.1-833
1.750-2.500	08-09	416.1-834

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

J53 L2 J86 J40 N22 N6 N15

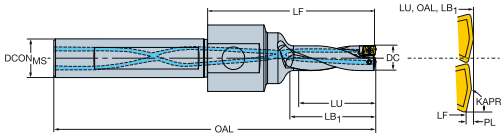
CoroDrill® 880 indexable insert drill

Cylindrical shank with flat, US P shank

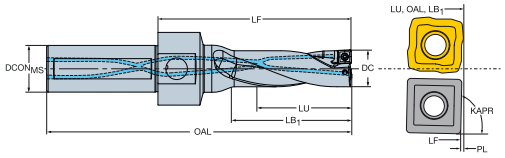
Internal coolant supply



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

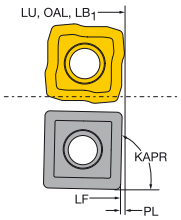
J53 L2 J86 J40 N22 N6 N15

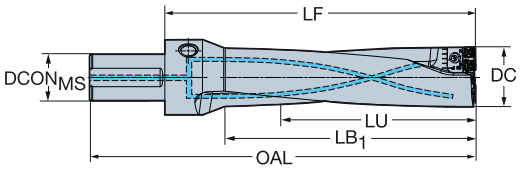
CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply







Metric shank

DC	C	I	I	P	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

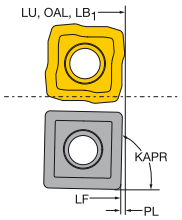
J53 L2 J86 J40 N22 N6 N15 J101

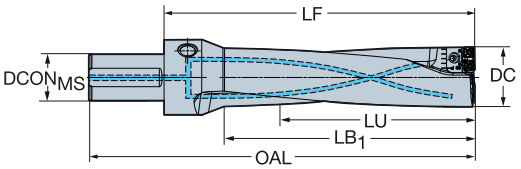
CoroDrill® 880 indexable insert drill

Cylindrical shank with flat according to ISO 9766

Internal coolant supply







Inch shank

DC	C	I	I	P	LU	CZC_{MS}	TCHAL	TCHAU	Ordering code	Dimensions, inch $DCON_{MS}$	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

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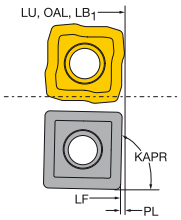
J53 L2 J86 J40 N22 N6 N15 J101

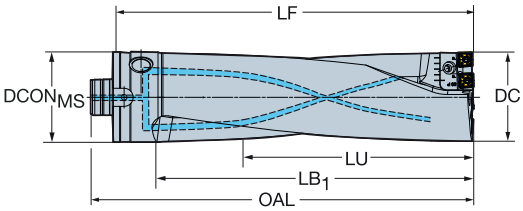
CoroDrill® 880 indexable insert drill

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

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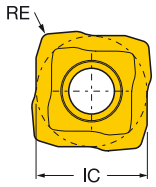
J53 L2 J86 J40 N22 N6 N15 J101

CoroDrill® 880 insert for drilling

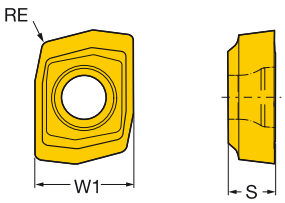
Central insert



880..C



880-01..C



Medium feed

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

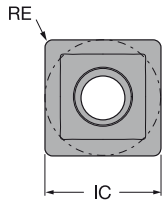
J41 J86 J40 N22

CoroDrill® 880 insert for drilling

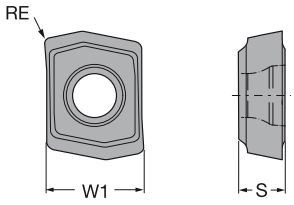
Peripheral insert



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

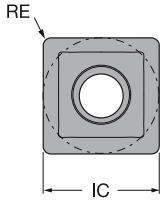
SANDVIK Coromant

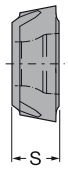
CoroDrill® 880 insert for drilling

Peripheral insert

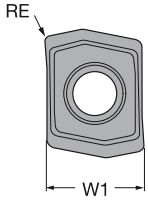


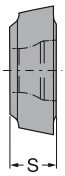
880..P





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.

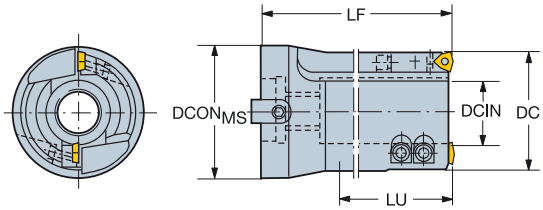
J57 J58

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

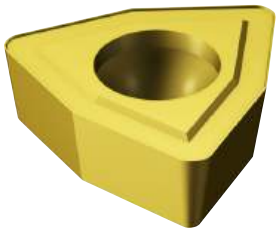


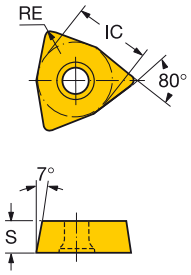
N22



N15

Trepanning inserts



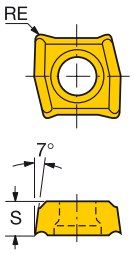


				P					M					K					N			S			H		Dimensions, mm, inch		
		INSUC	Ordering code	1020	1125	235	3040	4235	1020	1105	235	3040	4235	1020	1105	1125	3040	4235	1020	4235	H13A	1020	1125	H13A	1020	3040	S	RE	IC
Medium feed	06	P	WCMX 06 T3 08 R-51			☆					☆										★			☆			3.97	0.80	9.5
																											.156	.031	.375
	06	P+C	WCMX 06 T3 08 R-53	☆		☆	☆		☆		☆	☆		☆			☆		☆		☆	☆		☆	☆	☆	3.97	0.80	9.5
																											.156	.031	.375
	06	P	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

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Coromant U insert for drilling

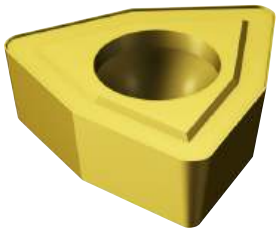


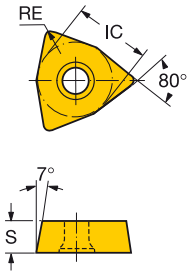


		INSUC	Ordering code	P				M				K			N			S			H			Dimensions, mm, inch	
				1020	1120	235	3040	1020	1120	235	3040	1020	1120	3040	1020	1120	H13A	1020	1120	H13A	1020	1120	3040	S	RE
Medium feed	02	C	LCMX 02 02 04C-53	★				★				★			★			★			★			2.38	0.40
																								.094	.016
	02	P	LCMX 02 02 04P-53		☆		☆		☆		☆		☆	☆		☆			☆			☆	☆	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

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Coromant U insert for drilling





		INSUC	Ordering code	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	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

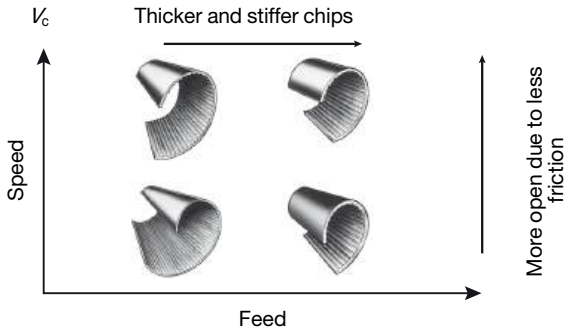
Cutting speed that is too high:
Rapid flank wear
Plastic deformation
Poor hole quality and bad hole tolerance

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

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

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 Recommended starting value at middle of feed range -S5W	-L5W	-L6W	-M7W	-H5W	Drill length 7xD -S5W	-L5W	-L6W	-M7W	-H5W
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				
									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
P	P1.0.Z.AN	Unalloyed steel C=0.05-0.10%	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
				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 C=0.05-0.25%	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
				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 C=0.25-0.55%	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**	-
				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 C=0.55-0.80%	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**	-
				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 Cast - untreated	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**	-
				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 Annealed	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**	-
				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 Annealed	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**	-
				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 Hardened and tempered	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**	-
				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 Cast - untreated	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**	-
				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 Annealed	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**	-
				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	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
		C=0.05-0.10%		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	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
		C=0.05-0.25%		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	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**	-
		C=0.25-0.55%		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	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**	-
		C=0.55-0.80%		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	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**	-
		Cast - untreated		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	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**	-
		Annealed		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	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**	-
		Annealed		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	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**	-
		Hardened and tempered		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	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**	-
		Cast - untreated		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	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**	-
		Annealed		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	-

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	160-280	12.00-13.99	0.04-0.10			
						14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
						16.50-19.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
				4334	130-240	24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
				4044	100-170	30.00-35.99	0.06-0.24	0.06-0.24	**0.06-0.24**	0.06-0.24
						36.00-43.99	0.06-0.24	0.06-0.24	**0.06-0.24**	0.06-0.24
						44.00-52.99	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
						53.00-63.50	0.10-0.24	0.10-0.24	**0.10-0.24**	0.10-0.24
	P3.0.Z.HT (03.21)	Hardened steel	250-350	4324	80-210	12.00-13.99	0.04-0.10			
						14.00-16.49	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
						16.50-19.99	0.06-0.14	0.06-0.14	**0.06-0.14**	0.06-0.14
						20.00-23.99	0.06-0.18	0.06-0.18	**0.06-0.18**	0.06-0.18
				4334	75-175	24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
				4044	70-125	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	140-365	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
				4334	135-265	24.00-29.99	0.04-0.10	0.04-0.10	**0.04-0.10**	0.04-0.10
				4044	125-190	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	110-265	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
				4334	105-210	24.00-29.99	0.06-0.18	0.08-0.18	**0.08-0.18**	0.08-0.18
				4044	100-150	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 4334 4344	140-245 110-200 80-155	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
						20.00-23.99	0.08-0.14	0.10-0.18	**0.14-0.28**	0.10 - 0.26
						24.00-29.99	0.08-0.14	0.10-0.20	**0.16-0.32**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.34**	
						44.00-52.99	0.12-0.18	0.12-0.22	**0.12-0.34**	
						53.00-63.50				
	K1.1.C.NS (07.2)	Pearlitic (long chipping)	150-270	4324 4334 4344	105-180 85-150 65-110	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
						20.00-23.99	0.08-0.14	0.10-0.16	**0.10-0.24**	0.10 - 0.24
						24.00-29.99	0.08-0.14	0.10-0.18	**0.10-0.28**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.30**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						44.00-52.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						53.00-63.50				
	K2.1.C.UT (08.1)	Gray cast iron: Low tensile strength	150-220	4324 4334 4344	210-325 170-270 130-205	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
						20.00-23.99	0.08-0.14	0.10-0.18	**0.10-0.28**	0.10 - 0.28
						24.00-29.99	0.08-0.14	0.10-0.20	**0.10-0.32**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.34**	
						44.00-52.99	0.12-0.18	0.12-0.22	**0.12-0.34**	
						53.00-63.50				
	K2.2.C.UT (08.2)	High tensile strength	200-330	4324 4334 4344	125-245 100-195 75-150	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
						20.00-23.99	0.08-0.14	0.10-0.16	**0.10-0.24**	0.10 - 0.24
						24.00-29.99	0.08-0.14	0.10-0.18	**0.10-0.28**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.30**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						44.00-52.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						53.00-63.50				
	K3.1.C.UT (09.1)	Nodular cast iron (Ferritic)	150-230	4324 4334 4344	125-225 100-185 80-145	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
						20.00-23.99	0.08-0.14	0.10-0.16	**0.12-0.24**	0.10 - 0.24
						24.00-29.99	0.08-0.14	0.10-0.18	**0.14-0.28**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.30**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						44.00-52.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						53.00-63.50				
	K3.3.C.UT (09.2)	Pearlitic	200-330	4324 4334 4344	110-210 90-175 70-130	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
						20.00-23.99	0.08-0.14	0.10-0.16	**0.12-0.24**	0.10 - 0.24
						24.00-29.99	0.08-0.14	0.10-0.18	**0.14-0.28**	
						30.00-35.99	0.10-0.16	0.10-0.20	**0.10-0.30**	
						36.00-43.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						44.00-52.99	0.10-0.16	0.10-0.20	**0.10-0.32**	
						53.00-63.50				

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

CoroDrill® 880

2 – 3 x DC

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 4334 4344	30-85 30-85 30-85	12.00-13.99 14.00-16.49 16.50-19.99 20.00-23.99 24.00-29.99 30.00-35.99 36.00-43.99 44.00-52.99 53.00-63.50	0.10-0.16 0.04-0.08 0.05-0.12 0.05-0.14 0.05-0.14 0.06-0.16 0.06-0.16 0.10-0.16	**0.10-0.20** **0.04-0.12** **0.06-0.14** **0.06-0.18** **0.06-0.18** **0.06-0.20** **0.06-0.20** **0.10-0.20**	0.10-0.32 0.04-0.08 0.05-0.12 0.05-0.14 0.05-0.14 0.06-0.16 0.06-0.16 0.10-0.16	 0.04 - 0.08 0.05 - 0.12 0.05 - 0.14 0.05 - 0.14
N	N1.2.Z.AG (30.12)	Al. alloys Wrought or wrought and aged	30-150	4344 H13A	300-405 300-400	12.00-13.99 14.00-16.49 16.50-19.99 20.00-23.99 24.00-29.99 30.00-35.99 36.00-43.99 44.00-52.99 53.00-63.50	**0.04-0.08** **0.04-0.14** **0.04-0.16** **0.06-0.18** **0.10-0.20** **0.10-0.25** **0.10-0.25** **0.12-0.28** **0.12-0.28**	 0.04-0.12 0.04-0.14 0.06-0.16 0.10-0.18 0.10-0.20 0.10-0.20 0.12-0.22 0.12-0.22	0.04-0.08 0.04-0.12 0.04-0.14 0.06-0.16 0.10-0.18 0.10-0.20 0.10-0.20 0.12-0.22 0.12-0.22	 0.04-0.12 0.04 - 0.14 0.06 - 0.16 0.10-0.18
	N1.3.C.UT (30.21)	Cast, non-aging	40-100	4344 H13A	300-405 300-400	12.00-13.99 14.00-16.49 16.50-19.99 20.00-23.99 24.00-29.99 30.00-35.99 36.00-43.99 44.00-52.99 53.00-63.50	**0.04-0.12** **0.04-0.12** **0.04-0.14** **0.06-0.16** **0.10-0.18** **0.10-0.20** **0.10-0.20** **0.12-0.22** **0.12-0.22**	 0.04-0.14 0.04-0.16 0.06-0.18 0.10-0.20 0.10-0.22 0.10-0.24 0.12-0.26 0.12-0.26	0.04-0.12 0.04-0.12 0.04-0.14 0.06-0.16 0.10-0.18 0.10-0.20 0.10-0.20 0.12-0.22 0.12-0.22	 0.04-0.12 0.04 - 0.14 0.06 - 0.16 0.10-0.18
	N1.3.C.AG (30.22)	Cast or cast and aged	70-140	4344 H13A	250-350 250-350	12.00-13.99 14.00-16.49 16.50-19.99 20.00-23.99 24.00-29.99 30.00-35.99 36.00-43.99 44.00-52.99 53.00-63.50	**0.04-0.12** **0.04-0.12** **0.04-0.14** **0.06-0.16** **0.10-0.18** **0.10-0.20** **0.10-0.20** **0.12-0.22** **0.12-0.22**	 0.04-0.14 0.04-0.16 0.06-0.18 0.10-0.20 0.10-0.22 0.10-0.24 0.12-0.26 0.12-0.26	0.04-0.12 0.04-0.12 0.04-0.14 0.06-0.16 0.10-0.18 0.10-0.20 0.10-0.20 0.12-0.22 0.12-0.22	 0.04-0.12 0.04 - 0.14 0.06 - 0.16 0.10-0.18
	N3.3.U.UT (33.1)	Copper and copper alloys	70-160	4344 H13A	250-400 250-400	12.00-13.99 14.00-16.49 16.50-19.99 20.00-23.99 24.00-29.99 30.00-35.99 36.00-43.99 44.00-52.99 53.00-63.50	**0.04-0.14** **0.04-0.14** **0.04-0.16** **0.06-0.18** **0.10-0.20** **0.10-0.25** **0.10-0.25** **0.12-0.28** **0.12-0.28**	 0.04-0.12 0.04-0.14 0.06-0.16 0.10-0.18 0.10-0.20 0.10-0.20 0.12-0.22 0.12-0.22	0.04-0.12 0.04-0.12 0.04-0.14 0.06-0.16 0.10-0.18 0.10-0.20 0.10-0.20 0.12-0.22 0.12-0.22	 0.04-0.12 0.04 - 0.14 0.06 - 0.16 0.10-0.18
	N3.2.C.UT (33.2)	Brass and leaded alloys (Pb < 1%)	50-200	4344 H13A	180-240 180-240	12.00-13.99 14.00-16.49 16.50-19.99 20.00-23.99 24.00-29.99 30.00-35.99 36.00-43.99 44.00-52.99 53.00-63.50	**0.04-0.14** **0.04-0.14** **0.04-0.16** **0.06-0.18** **0.10-0.20** **0.10-0.25** **0.10-0.25** **0.12-0.28** **0.12-0.28**	 0.04-0.12 0.04-0.14 0.06-0.16 0.10-0.18 0.10-0.20 0.10-0.20 0.12-0.22 0.12-0.22	0.04-0.12 0.04-0.12 0.04-0.14 0.06-0.16 0.10-0.18 0.10-0.20 0.10-0.20 0.12-0.22 0.12-0.22	 0.04-0.12 0.04 - 0.14 0.06 - 0.16 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-.005	.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	4324	360-690	.472-.550				
						.551-.649	0.06-0.10	0.06-0.12	**0.08-0.16**	
				4334	295-575	.650-.787	0.06-0.12	0.08-0.14	**0.10-0.18**	0.08 - 0.18
				4344	230-430	.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				

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 05.52	Austenitic Ferritic (duplex)	180–320	12.7–17.0	0.04–0.10	110 (90–145)	53/3040	53/1020	53/1120	53/1020
				17.5–25.4	0.04–0.12		53/3040		53/1020	
				26.0–30.0	0.08–0.14		53/3040		53/1020	
				31.0–41.3	0.10–0.16		53/3040		53/1020	
				42.0–80.0	0.11–0.18		53/3040		53/1020	

Insert positioning: C = Central
P = Peripheral

Wiper TECHNOLOGY -WM geometry: For machining steel and cast iron with hardness < 200 HB in stable conditions, increase feed (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	α, near α 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	α, near α 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%)					

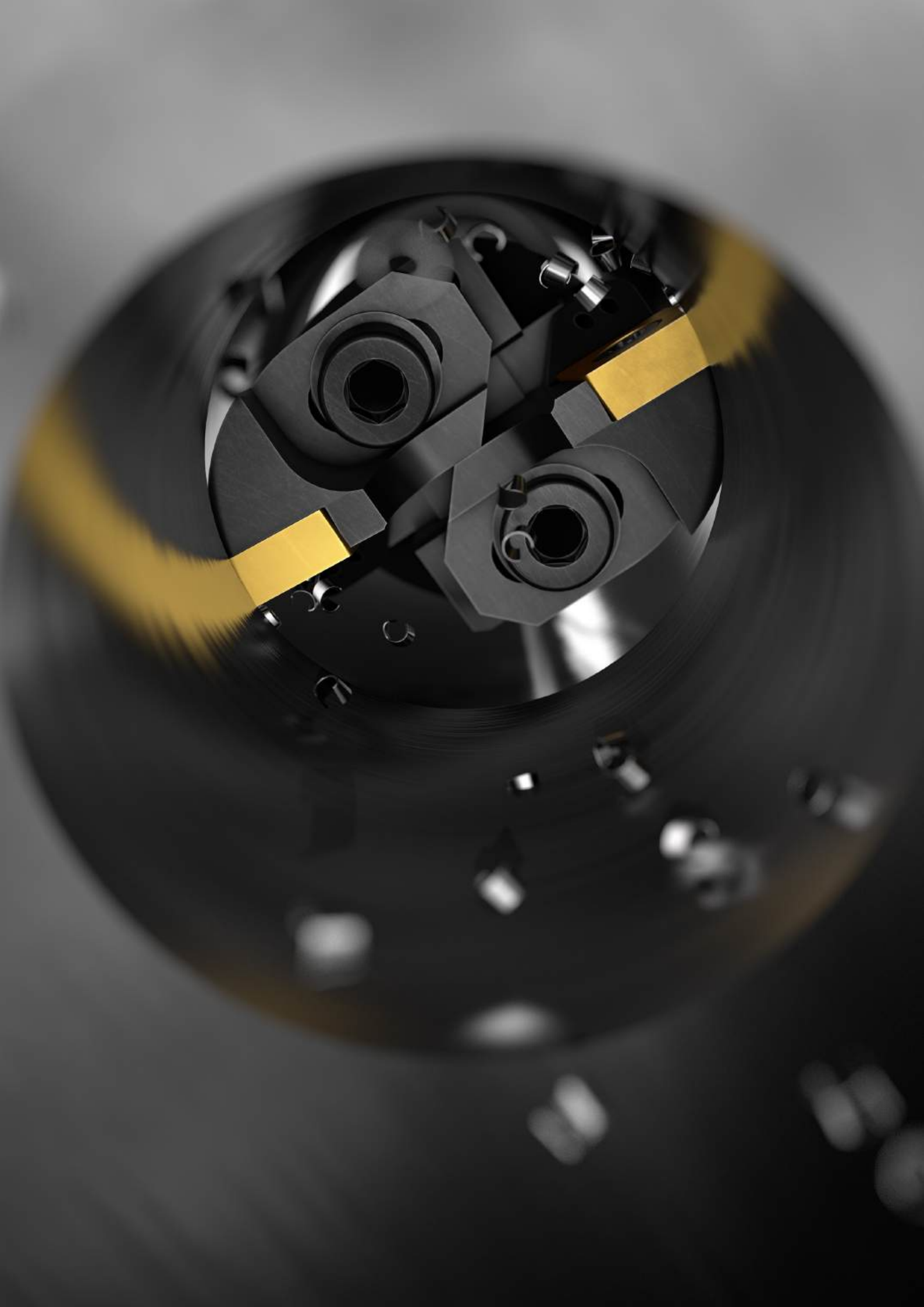
SANDVIK Coromant

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 880-06...P	1 1	880-06...P	2
70-73 (2.756 - 2.874)	880-06...C 880-06...P	1 1	880-06...P	2
74 (2.913)	880-06...C 880-06...P	1 1	880-07...P	2
75-79 (2.953 - 3.110)	880-07...C 880-07...P	1 1	880-07...P	2
80-84 (3.150 - 3.307)	880-07...C 880-07...P	1 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-D080-084LX63-3 880-D080-084V80-3	880-D080-084LX63-4 880-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.

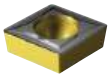


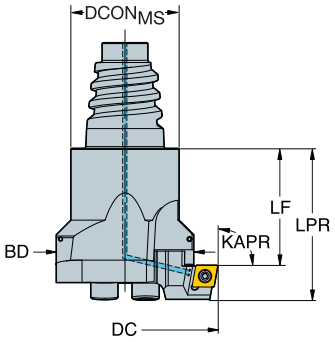
CoroBore® BR10 rough boring tool for back boring

Coromant EH – Internal coolant supply

KAPR 90°







CCMT, CCGT
CCGX, CCET

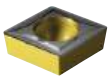
CCMW

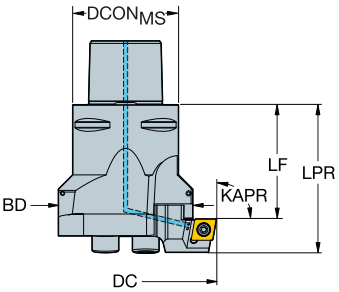
DCN	DCX	⟷	IC	CZC_{MS}	CNSC	Ordering code	$DCON_{MS}$	$ADJLX_{RDL}$	LF	LPR	BD_1	BAR PSI	KG	CICT	MIID
							Dimensions, mm, inch								
32.00	38.00	06	1/4	E20	1	BR10-38CC06F-EH20	19.30	3.00	15.00	25.00	20.00	70	0.070	1	CCMT 06 02 04
1.260	*1.496*						*.760*	*.118*	*.591*	*.984*	*.787*	*1015*			
37.00	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	CZC_{MS}	CNSC	Ordering code	$DCON_{MS}$	$ADJLX_{RDL}$	LF	LPR	BD_1	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

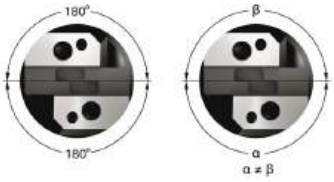
www.sandvik.coromant.com/coroborebr20

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®

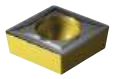
Problem-solver when working with long overhangs. When using Silent Tools™, you have the opportunity to double the depth of cut, while maintaining productive boring.

CoroBore® BR20 twin-edge rough boring tool

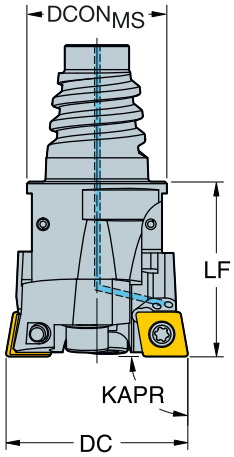
Coromant EH – Internal coolant supply

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

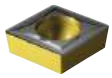
For inserts, see Turning catalog

L2 M1 N22 N15 K91

CoroBore® BR20 twin-edge rough boring tool

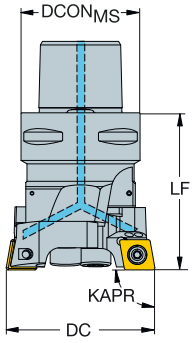
Coromant Capto® - Internal coolant supply

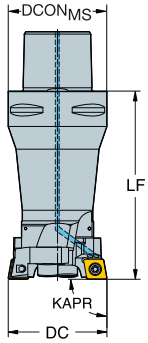




CCMT, CCGT
CCGX, CCET
CCMW

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

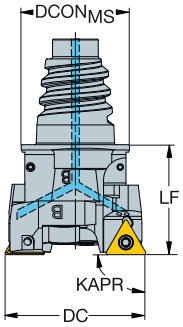
SANDVIK Coromant

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

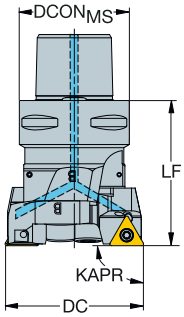
CoroBore® BR20 twin-edge rough boring tool

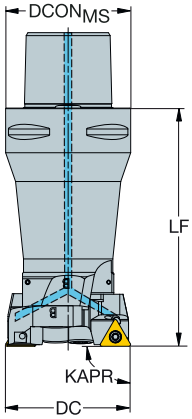
Coromant Capto® - Internal coolant supply

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

CoroBore® BR20 twin-edge rough boring tool

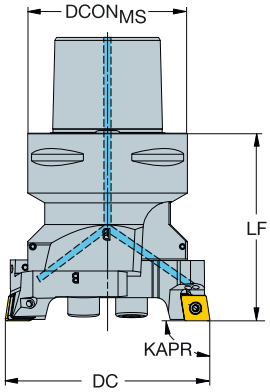
Coromant Capto® - Internal coolant supply

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

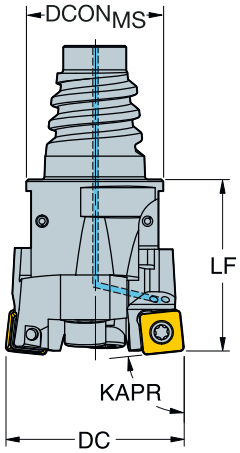
Coromant EH – Internal coolant supply





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

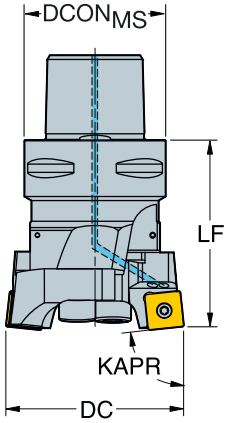
Coromant Capto® - Internal coolant supply

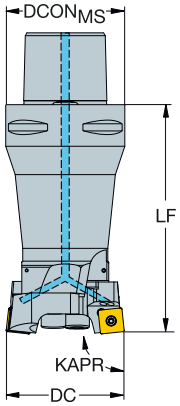




SPMT

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

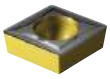
K33 L2 M1 N22 N15 K91

CoroBore® BR20 twin-edge damped rough boring tool

Coromant Capto® - Internal coolant supply

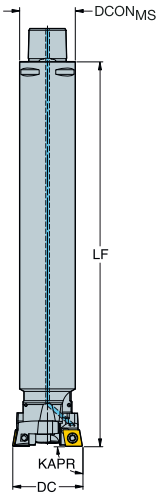


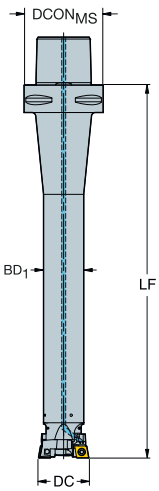
SilentTools®



CCMT, CCGT
CCGX, CCET
CCMW

KAPR	90°	90°
DSGN	1	2





DCN	DCX	ap	IC	CZCMS	CNSC	DSGN	Ordering code	Dimensions, mm, inch DCONMS	ADJLXRDL	ULDR	LF	BD1	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

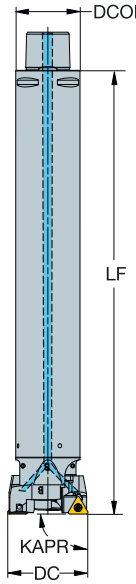
SilentTools®

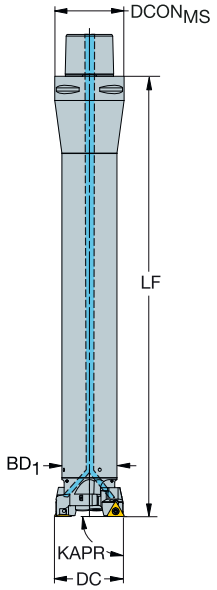




TCMT, TCMX,
TCGT, TCGX
TCEX

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

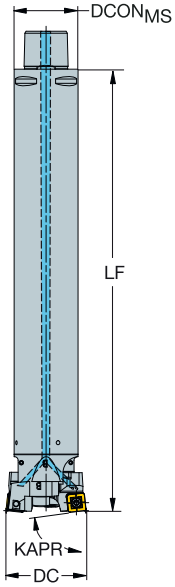
KAPR	84°	84°
DSGN	1	2

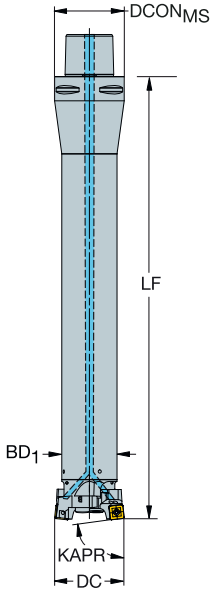
SilentTools®





SPMT





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*			

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For all DSGN 2; LU = DC*ULDR

K33 L2 M1 N22 N15 K91

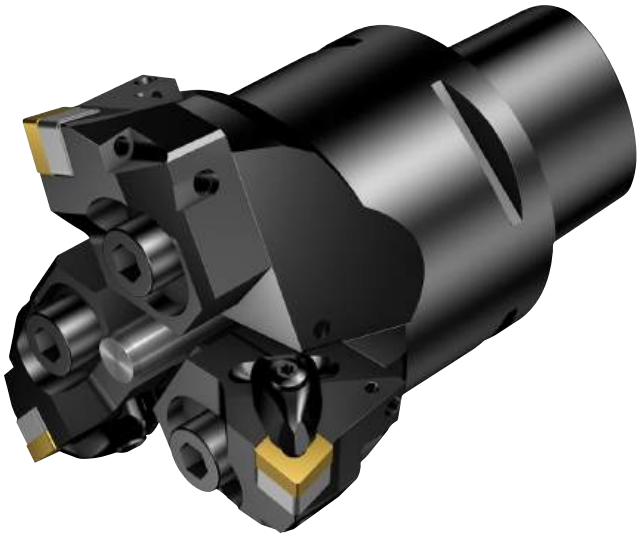
SANDVIK Coromant

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

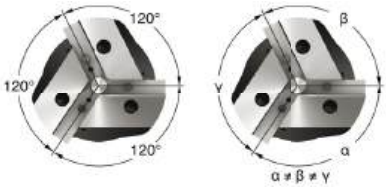
www.sandvik.coromant.com/coroborebr30

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.



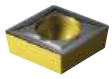
Dedicated CoroBore® 111 rough boring inserts. Excellent chip breaking and increased lifetime.

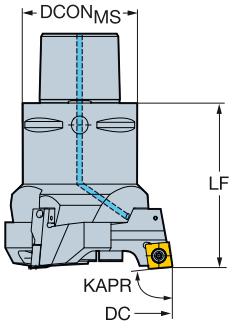
CoroBore® BR30 three-edge rough boring tool

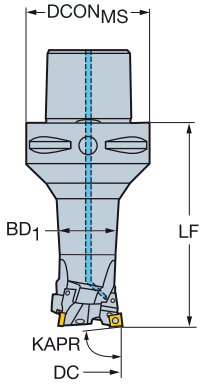
Coromant Capto® - Internal coolant supply

KAPR 90° 90°
DSGN 1 2









CCMT, CCGT
CCGX, CCET

CCMW

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*			

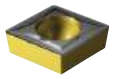
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com
For inserts, see Turning catalog
For all DSGN 2; LU = DC*ULDR

L2 M1 N22 N15 K92

CoroBore® BR30 three-edge rough boring tool

Coromant Capto® - Internal coolant supply

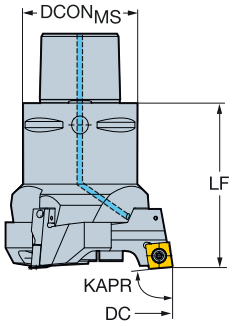


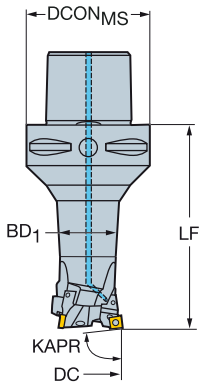


CCMT, CCGT
CCGX, CCET

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

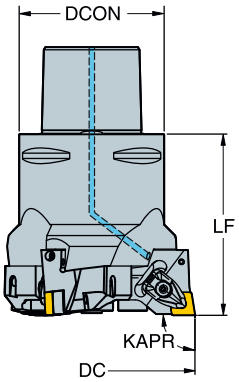
CoroBore® BR30 three-edge rough boring tool

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

SANDVIK Coromant

CoroBore® BR30 three-edge rough boring tool

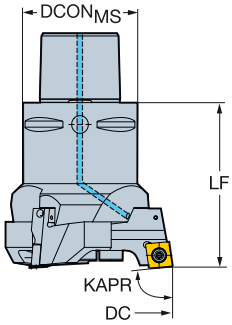
Coromant Capto® - Internal coolant supply

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



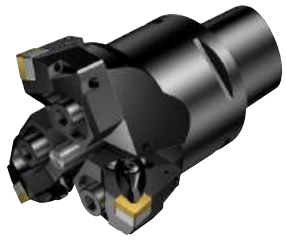
N15

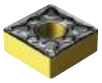

K92

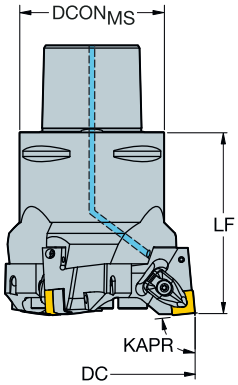
CoroBore® BR30 three-edge rough boring tool

Coromant Capto® - Internal coolant supply

KAPR 84°







SNMM
SNMG
SNMA, SNGA

DCN	DCX		IC	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

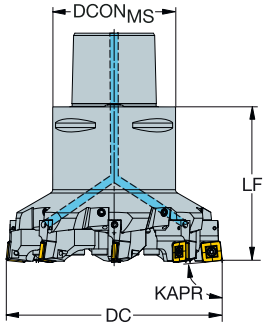
Dedicated for cavity boring operations

KAPR 84°





SPMT



DCN	DCX	← →	↕ IC	CZCMS	CNSC	Ordering code	Dimensions, mm, inch DCONMS	ADJLXRDL	LF	BAR PSI	KG	CICT	MIID
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

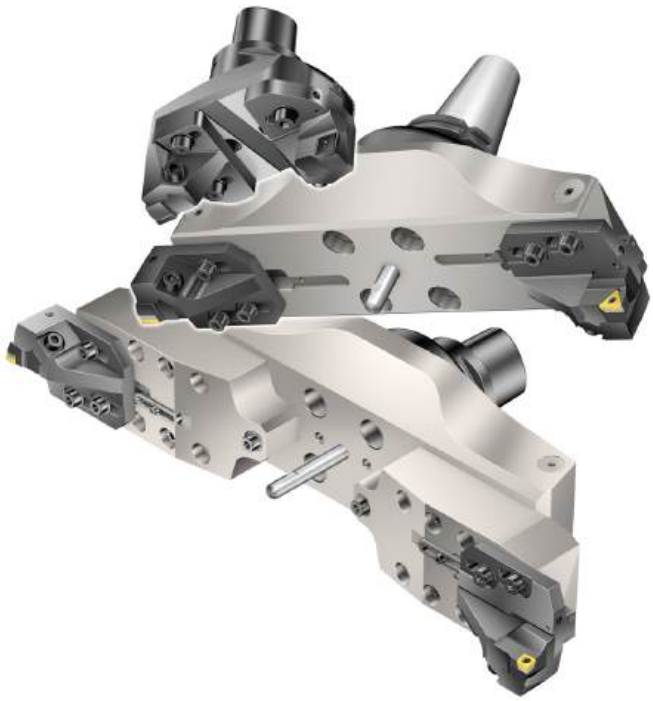
Rough boring tool for large diameters

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.

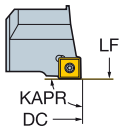
CoroBore® 820 XL rough boring tool

Coromant Capto® - Internal coolant supply

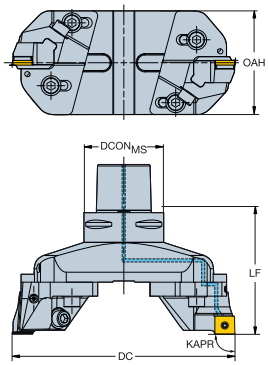


SPMT

KAPR



90°



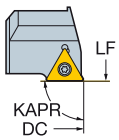
DCN	DCX	↔	↔IC↔	CZCMS	CNSC	Ordering code	Dimensions, mm, inch DCONMS	ADJLXAXL	ADJLXRDL	LF	OAH	BAR PSI	KG	CICT	MIID
148.00	200.00	18	18	C8	3	820-200SP18-C8	80.00	1.50	26.00	122.00	104.00	70	6.900	2	SPMT 1810-BM
5.827	*7.874*						*3.150*	*.059*	*1.024*	*4.803*	*4.094*	*1015*			
148.00	200.00	18	18	C10	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*			



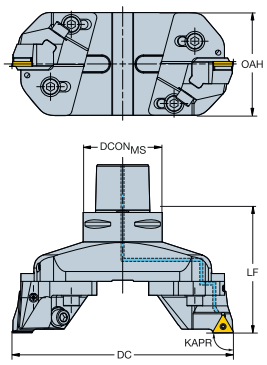
TCMT, TCMX, TCGT, TCGX TCEX

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*			

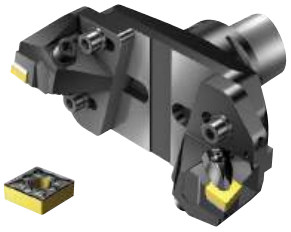
For boring tool components, accessories, and spare parts, visit www.sandvik.coromant.com

For inserts, see Turning catalog

K33 M1 L2 N22 N15 K93

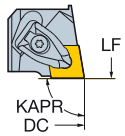
CoroBore® 820 XL rough boring tool

Coromant Capto® - Internal coolant supply

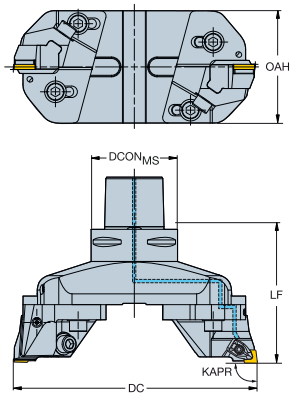


CNMM
CNMG
CNMA, CNGA

KAPR



90°



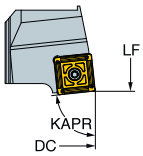
DCN	DCX	⟷	IC	CZCMS	CNSC	Ordering code	Dimensions, mm, inch DCONMS	ADJLXAXL	ADJLXRDL	LF	OAH	BAR PSI	KG	CICT	MIID
148.00	200.00	19	3/4	C8	3	820-200CN19-C8	80.00	1.50	26.00	122.00	104.00	70	8.240	2	CNMG 19 06 12
5.827	*7.874*						*3.150*	*.059*	*1.024*	*4.803*	*4.094*	*1015*			
148.00	200.00	19	3/4	C10	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

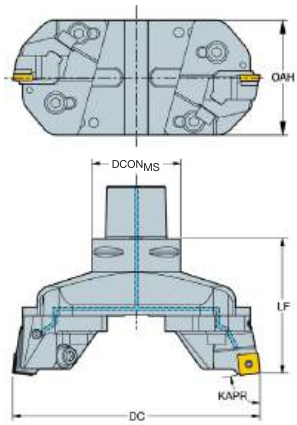


SPMT

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

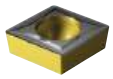
SANDVIK Coromant

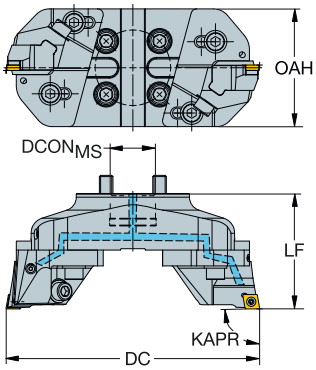
CoroBore® 820 XL lightweight rough boring tool

Arbor - Internal coolant supply

KAPR 90°







CCMT, CCGT
CCGX, CCET

CCMW

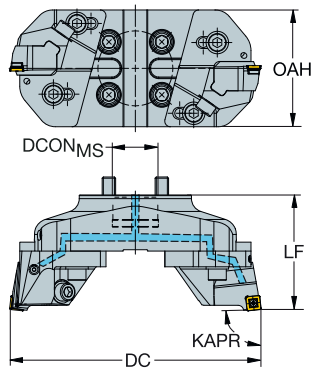
DCN	DCX	↔	↔IC↔	CZCMS	CNSC	Ordering code	DCONMS	ISO	ADJLXAXL	ADJLXRDL	LF	OAH	BAR PSI	KG	CICT	MIID
							Dimensions, mm, inch									
148.00	200.00	12	1/2	40S	1	**820L-200CC12F**	40.00	C	1.50	26.00	102.00	104.00	70	3.860	2	CCMT 12 04 08
5.827	*7.874*						*1.575*		*.059*	*1.024*	*4.016*	*4.094*	*1015*			
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	↔	↔IC↔	CZCMS	CNSC	Ordering code	DCONMS	ISO	ADJLXAXL	ADJLXRDL	LF	OAH	BAR PSI	KG	CICT	MIID
							Dimensions, mm, inch									
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

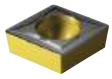
K33 L2 N22 N15 K93

CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

Dedicated for Silent Tools™ boring

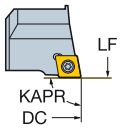




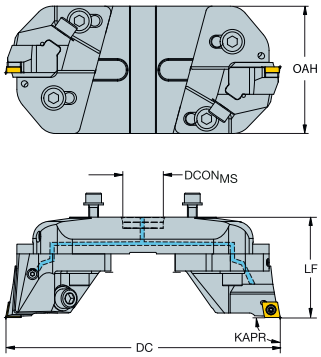
CCMT, CCGT
CCGX, CCET

CCMW

KAPR



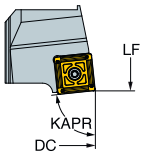
90°



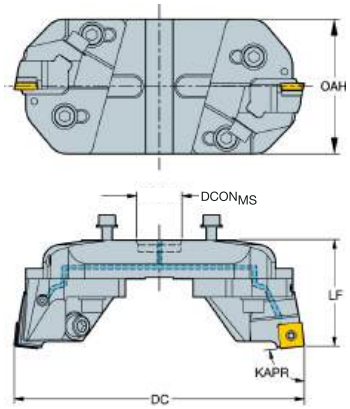
DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{AXL}$	$ADJLX_{RDL}$	LF	OAH	BAR PSI	KG	CICT	MIID
148.00	200.00	12	1/2	33	1	**820D-200CC12**	33.00	1.50	26.00	82.00	104.00	70	3.350	2	CCMT 12 04 08
5.827	*7.874*						*1.299*	*.059*	*1.024*	*3.228*	*4.094*	*1015*			
198.00	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	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{AXL}$	$ADJLX_{RDL}$	LF	OAH	BAR PSI	KG	CICT	MIID
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

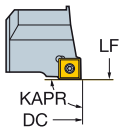
Arbor - Internal coolant supply



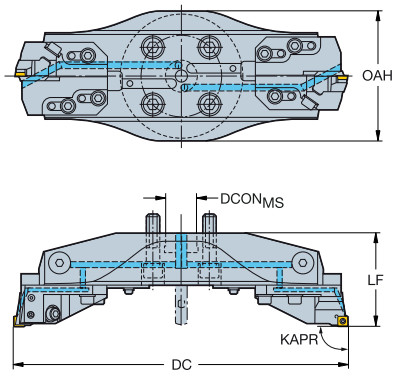


SPMT

KAPR

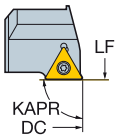


90°

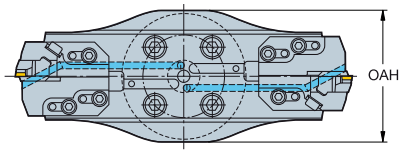


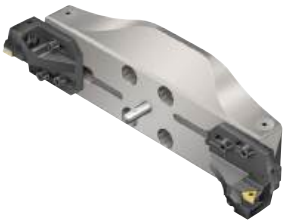
DCN	DCX	↔	↔IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{AXL}$	$ADJLX_{RDL}$	LF	OAH	BAR PSI	KG	CICT	MIID
298.00	380.00	18	18	40X	1	**820-380SP18**	40.00	1.50	41.00	114.00	164.00	70	10.000	2	SPMT 1810-BM
11.732	*14.961*						*1.575*	*.059*	*1.614*	*4.488*	*6.457*	*1015*			
378.00	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°

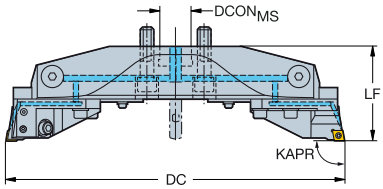






TCMT, TCMX,
TCGT, TCGX
TCEX

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

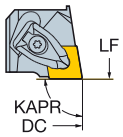
Arbor - Internal coolant supply



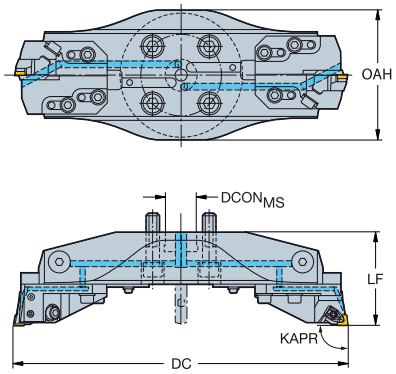


CNMM
CNMG
CNMA, CNGA

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*			

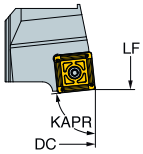
For inserts, see Turning catalog



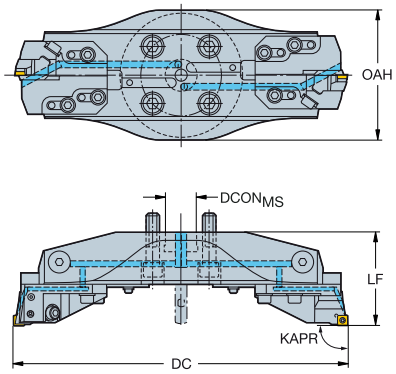


SPMT

KAPR



84°



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

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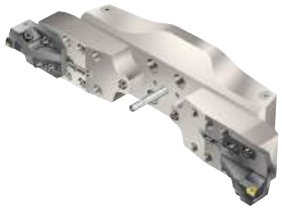
K33 L2 N22 N15 K93

SANDVIK Coromant

CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

With bridge extension

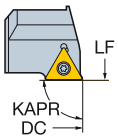




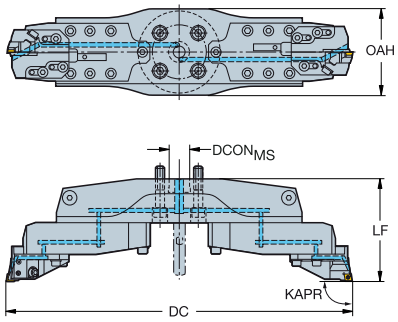
TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR



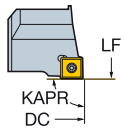
90°



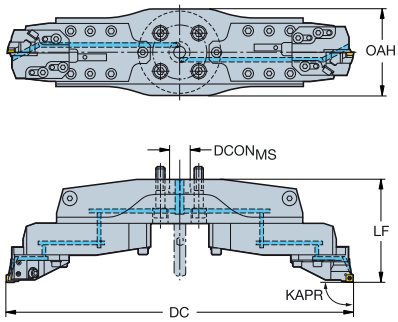
DCN	DCX	↔	↔IC	CZC$_{MS}$	CNSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	ADJLX$_{AXL}$	ADJLX$_{RDL}$	LF	OAH	BAR PSI	KG	CICT	MIID
538.00	780.00	22	1/2	40X	1	**820-780TC22**	40.00	1.50	121.00	198.00	164.00	70	28.000	2	TCMT 22 04 08
21.181	*30.709*						*1.575*	*.059*	*4.764*	*7.795*	*6.457*	*1015*			
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*			

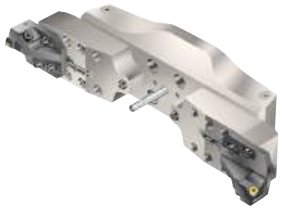
For inserts, see Turning catalog

KAPR



90°







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
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*			

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K33 L2 N22 N15 K93

CoroBore® 820 XL rough boring tool

Arbor - Internal coolant supply

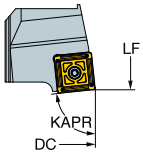
With bridge extension



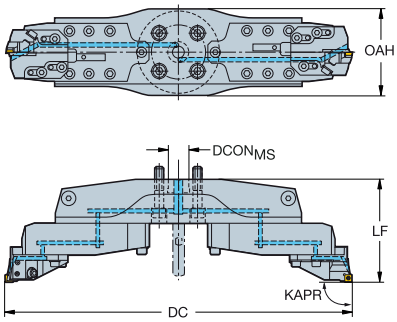


SPMT

KAPR

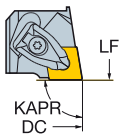


84°

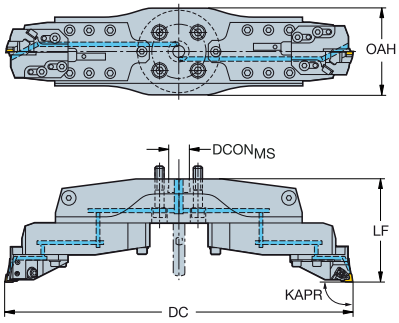


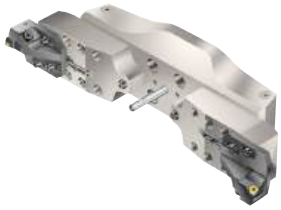
DCN	DCX	↔	↕	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{AXL}$	$ADJLX_{RDL}$	LF	OAH	BAR PSI	KG	CICT	MIID
538.00	780.00	18	18	40X	1	**820-780SP18Y**	40.00	1.50	121.00	198.00	164.00	70	25.190	2	SPMT 1810-BM
21.181	*30.709*						*1.575*	*.059*	*4.764*	*7.795*	*6.457*	*1015*			
778.00	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	↔	↕	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, inch $DCON_{MS}$	$ADJLX_{AXL}$	$ADJLX_{RDL}$	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

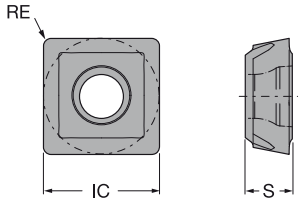
K33 L2 N22 N15 K93

SANDVIK Coromant

CoroBore® 111 inserts for rough boring

S-style insert (Square)



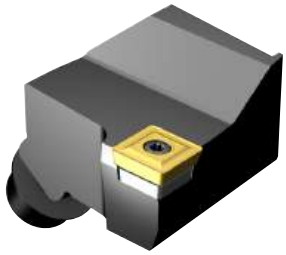


			IC	S	RE	ISO CODE	P 4325	M 2025	K 3210	S 1145
Medium	BM	06	6.0	2.60	0.60	SPMT0606-BM		☆		☆
			.236	.102	.024					
		08	8.9	3.00	0.80	SPMT0808-BM		☆		☆
			.350	.118	.031					
		12	12.65	4.00	1.00	SPMT1210-BM		☆		☆
			.498	.157	.039					
		18	18.6	5.50	1.00	SPMT1810-BM		☆		☆
			.732	.217	.039					
Roughing	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

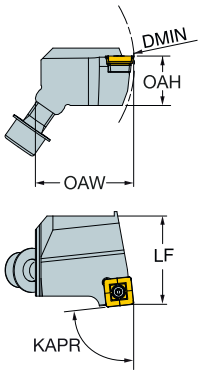
Cartridge for CoroBore® XL

KAPR 84°





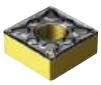
SPMT



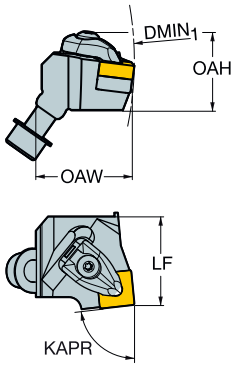
DMIN1		CZCMS	Ordering code	Dimensions, mm, inch LF	HF	WF	OAH	OAL	KG	CICT	MIID
148.0	12	S12	S12-R820XLR40SSYP12	40.00	22.40	42.00	30.16	43.30	0.250	1	SPMT 1210-BM
5.827				*1.575*	*.882*	*1.654*	*1.187*	*1.705*			

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 - Indexable carbide bars	- Single edge boring	- CoroTurn® 107 - CoroTurn® XS	- Coromant Capto® - Coromant EH	K36-K38
391.37A/B 	Conventional	3-36 (.118-1.417)	IT6	- Solid carbide bars - Indexable carbide bars - Indexable steel bars	- Single edge boring	- CoroTurn® 107 - Solid bars with ground geometry	- Coromant Capto® - 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 - Back boring	- CoroTurn® 107	- Coromant Capto® - Cylindrical shank - Coromant EH	K46-K54
	Lightweight	69-167 (2.717-6.575)	IT6	- Indexable cartridges	- Single edge boring - Back boring	- CoroTurn® 107	- Coromant Capto®	K55
	Damped	19-167 (.748-6.575)	IT6	- Indexable cartridges	- Single edge boring - Back boring	- CoroTurn® 107	- Coromant Capto®	K56
CoroBore® 825 XL/ CoroBore® 826 XL 	Conventional	148-315 (5.827-12.402) 298-1275 (11.732-50.197)	IT6	- Indexable cartridges	- Single edge boring Back boring External boring	- CoroTurn® 107	- Coromant Capto® - 40X with 4 bolt circle	K57-K59 K66-K69
	Lightweight	148-315 (5.827-12.402)	IT6	- Indexable cartridges	- Single edge boring - Back boring - External boring	- CoroTurn® 107	- Coromant Capto® - 40S with 4 bolt circle	K60-K63
	Damped	148-315 (5.827-12.402)	IT6	- Indexable cartridges	- Single edge boring - Back boring - 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

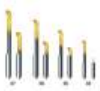
Tools

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).

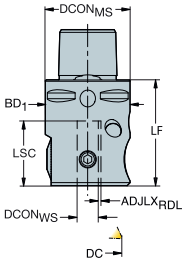
Coromant Capto® to CoroTurn® XS adapter

CoroBore® 824 XS

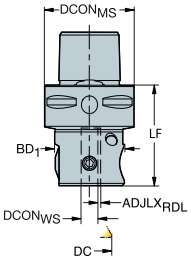
Internal coolant supply



DSGN 1



2



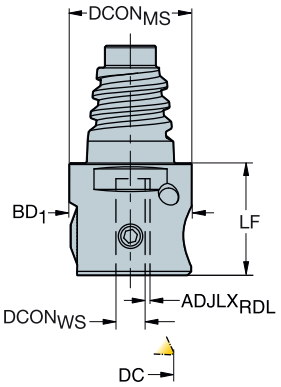
							Dimensions, mm, inch						
DCN	DCX	CZC_{MS}	CZC_{WS}	CNSC	DSGN	Ordering code	$DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	LF	BD_1	BAR PSI	KG
1.00	6.00	C3	4	3	2	C3-R824XS04-021	32.00	4.00	1.00	36.00	25.00	20	0.213
.039	*.236*						*1.260*	*.157*	*.039*	*1.417*	*.984*	*290*	
6.00	10.00	C3	6	3	2	C3-R824XS06-016	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

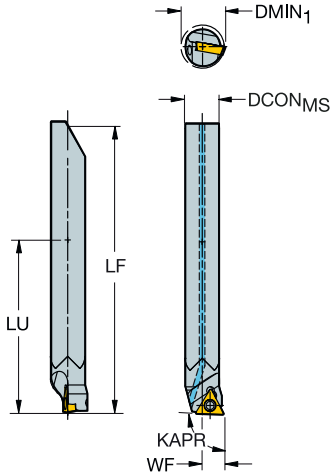




TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR 92°



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

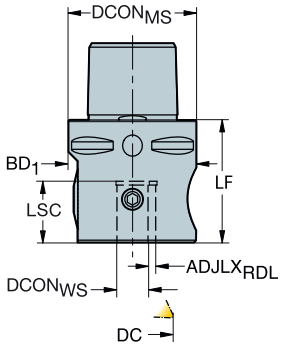


Adjusts diameter 0.002 mm (.000079 inch) with a nonius scale. A 360° turn change diameter by 0.5 mm (.020 inch).

Coromant Capto® to fine boring head adapter

Internal coolant supply

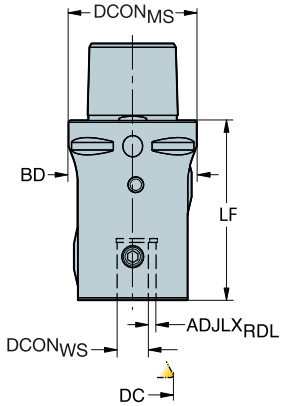




391.37A adapter

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*	

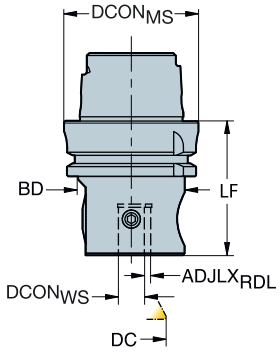
To be used with R429U/R429.90 boring bars
For spare parts, visit www.sandvik.coromant.com

L2 M37 N22 N15

HSK to fine boring head adapter

Internal coolant supply

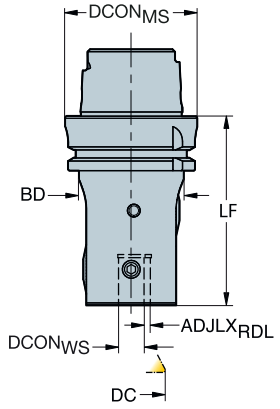




391.37A adapter

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

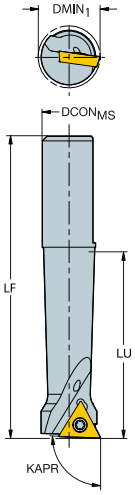




TCMT, TCMX,
TCGT, TCGX
TCEX

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

SANDVIK Coromant

Boring bar with indexable insert for fine boring heads

Cylindrical shank - Internal coolant supply
Steel bar

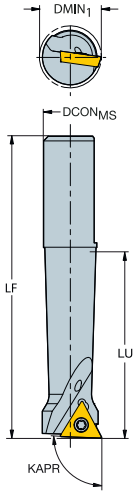




TCMT, TCMX,
TCGT, TCGX
TCEX

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*			

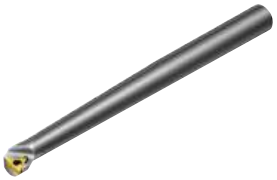
Recommended adapters:
A12: 391.37A/B
A16, A20: 391.37A
For spare parts, visit www.sandvik.coromant.com
For inserts, see Turning catalog

K40 M37 N22 N15

Boring bar with indexable insert for fine boring heads

Cylindrical shank - Internal coolant supply
Carbide bar with brazed steel head

KAPR 92°



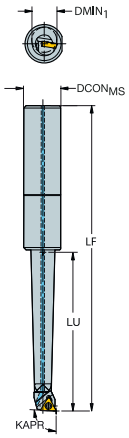




TCMT, TCMX,
TCGT, TCGX
TCEX



TCMW



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



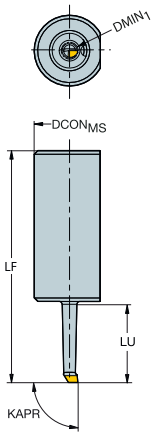
N15

SANDVIK Coromant

Solid boring bar for fine boring head



KAPR 90°



DMIN1	CZCMS	CNSC	Ordering code	Dimensions, mm, inch DCONMS	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*	

DMIN1	CZCMS	CNSC	Ordering code	P H10F	M H10F	K H10F	N H10F	S H10F	Dimensions, mm, inch DCONMS	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

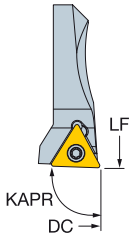


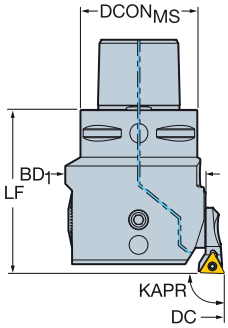


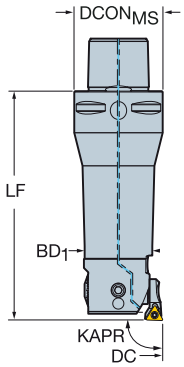
TCMT, TCMX,
TCGT, TCGX
TCEX

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

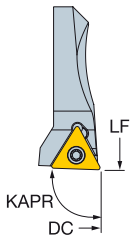




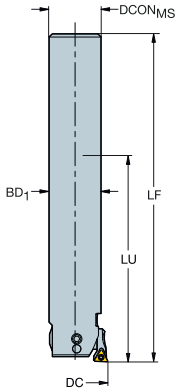
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

KAPR



92°



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

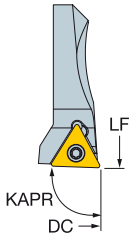
CoroBore® 825 fine boring tool

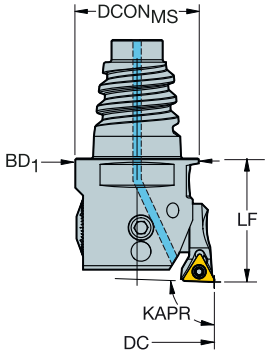
Coromant EH coupling - Internal coolant supply





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
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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For inserts, see Turning catalog

L2 N22 N15 K94

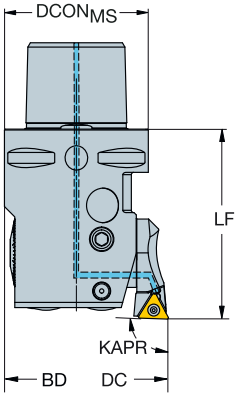
CoroBore® 826 fine boring tool

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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For inserts, see Turning catalog

L2 N22 N15 K94

CoroBore® 826 fine boring tool

Coromant Capto® - Precision coolant supply

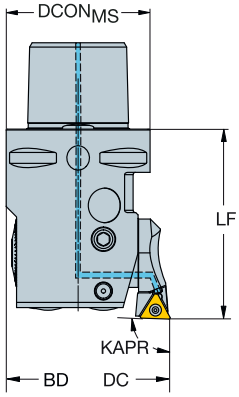
KAPR 92°






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
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



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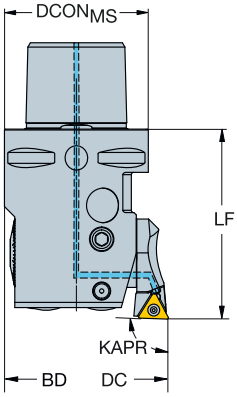
CoroBore® 826 fine boring tool

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*			

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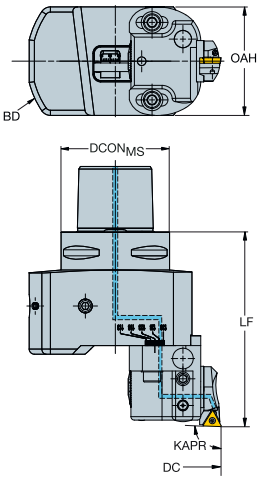
L2 N22 N15 K94

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	DCON$_{MS}$	ADJLX$_{RDL}$	LF	OAH	BD$_1$	BAR PSI	KG	CICT	MIID
							Dimensions, mm, inch								
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

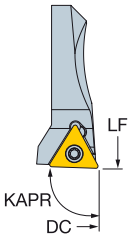




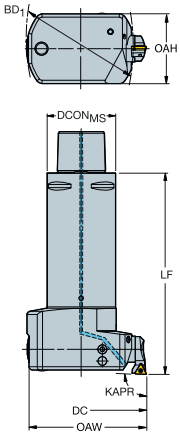
TCMT, TCMX,
TCGT, TCGX
TCEX

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®

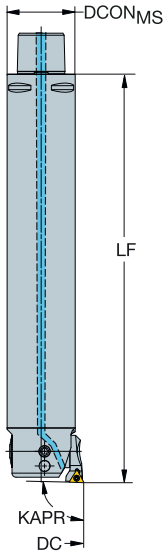


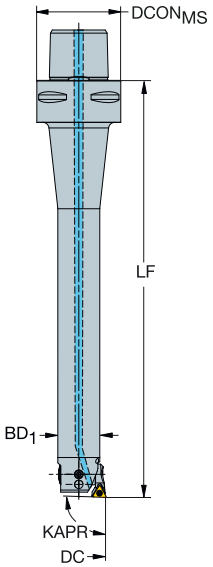


TCMT, TCMX, TCGT, TCGX TCEX

TCMW

KAPR	92°	92°
DSGN	1	2





DCN	DCX	↔	IC	CZCMS	CNSC	DSGN	Ordering code	Dimensions, mm, inch DCONMS	ADJLXRDL	ULDR	LF	OAH	BD1	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

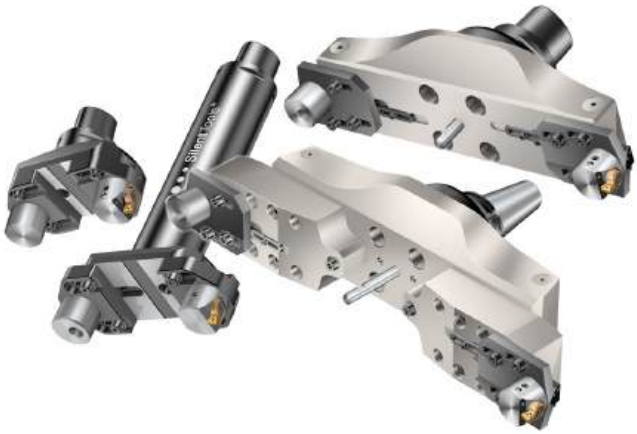
Fine boring tool for large diameters

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

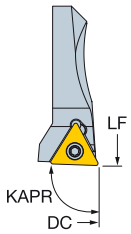


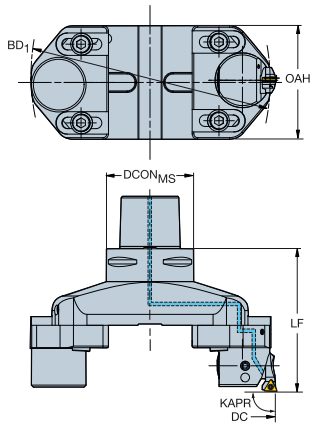


TCMT, TCMX, TCGT, TCGX TCEX

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

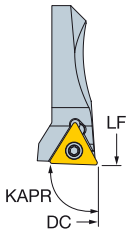
CoroBore® 826 XL fine boring tool

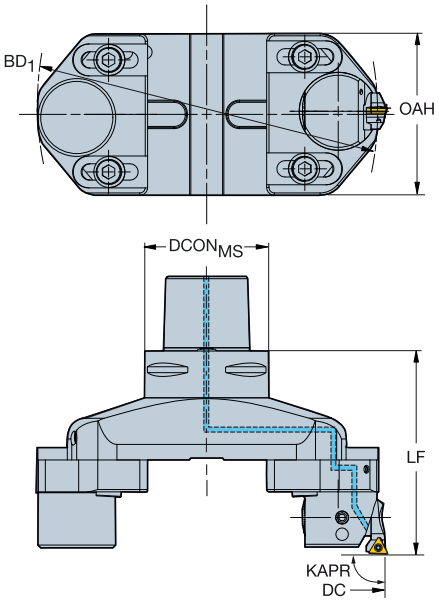
Coromant Capto® - Internal coolant supply



KAPR
STDNO

92°
ISO26623-1







TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

DCN	DCX		IC	CZC_{MS}	CNSC	Ordering code	Dimensions, mm, 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

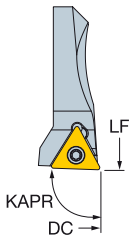




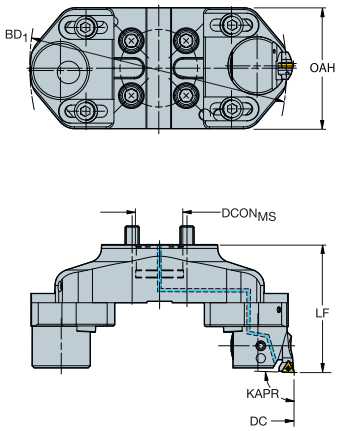
TCMT, TCMX,
TCGT, TCGX
TCEX

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

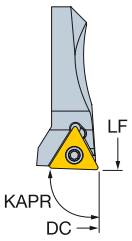




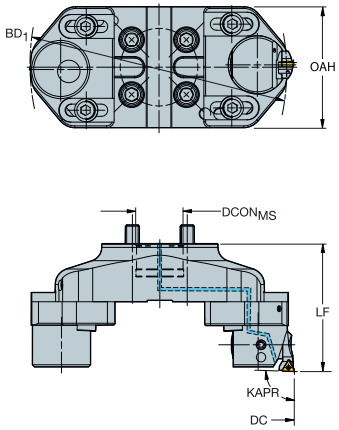
TCMT, TCMX,
TCGT, TCGX
TCEX

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

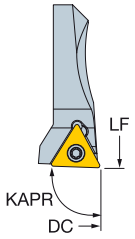




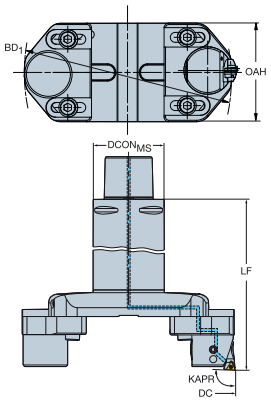
TCMT, TCMX,
TCGT, TCGX
TCEX

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

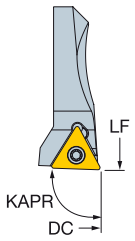




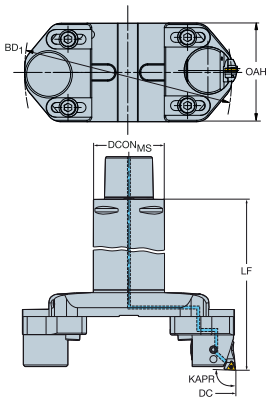

TCMT, TCMX,
TCGT, TCGX
TCEX


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



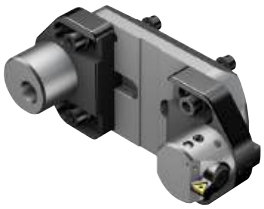
N15


K96

CoroBore® 825 XL fine boring tool

Arbor - Internal coolant supply

Dedicated for Silent Tools™ boring

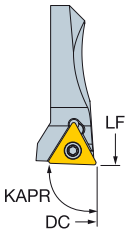


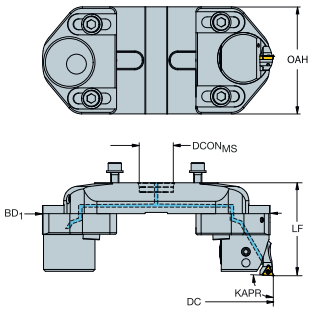


TCMT, TCMX,
TCGT, TCGX
TCEX

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

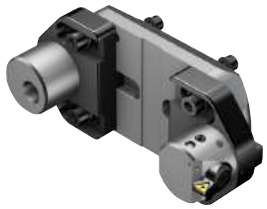
For inserts, see Turning catalog

L2 N22 N15 K96

CoroBore® 826 XL fine boring tool

Arbor - Internal coolant supply

Dedicated for Silent Tools™ boring

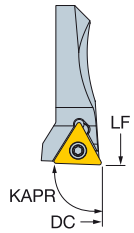




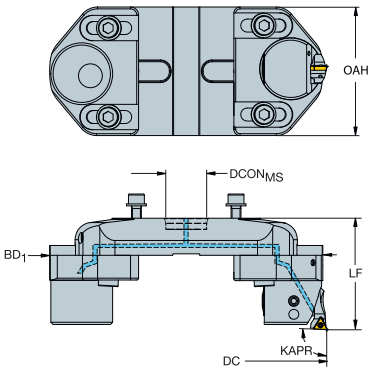
TCMT, TCMX,
TCGT, TCGX
TCEX

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

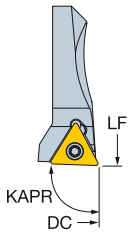




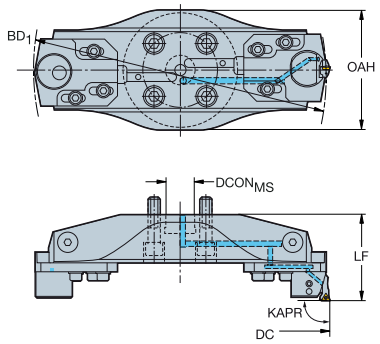
TCMT, TCMX,
TCGT, TCGX
TCEX

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
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

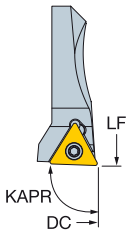




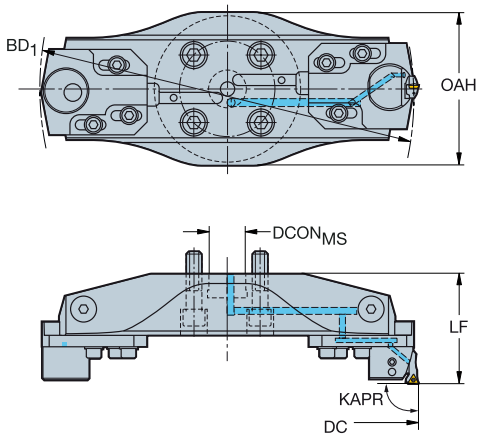
TCMT, TCMX,
TCGT, TCGX
TCEX

TCMW

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
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

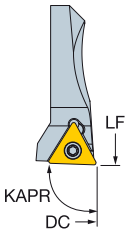
CoroBore® 825 XL fine boring tool

Arbor - Internal coolant supply

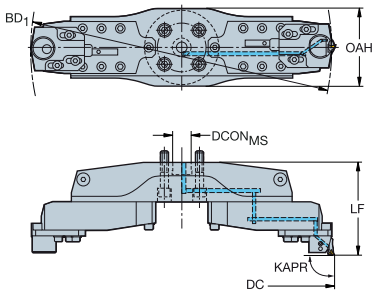
With bridge extension



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

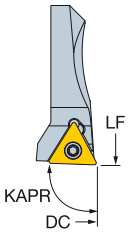
CoroBore® 826 XL fine boring tool

Arbor - Internal coolant supply

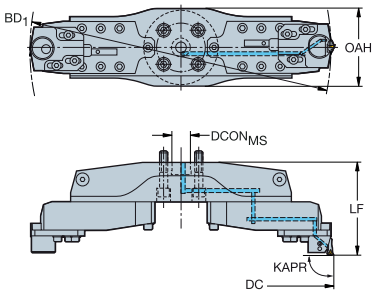
With bridge extension



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
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.

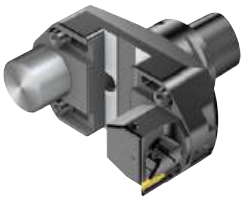
In the case of a direct flange to the machine spindle, use a centering plug. See page K82

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® - 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

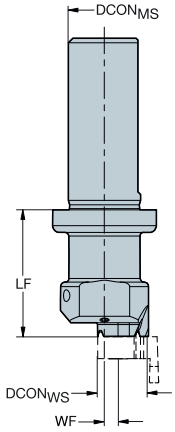
For face grooving

Internal coolant supply





MB...FA



CZC$_{MS}$	CZC$_{WS}$	CNSC	Ordering code	Dimensions, mm, inch 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)

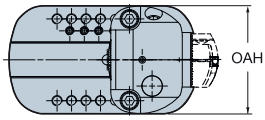
If grooves with greater width tolerance are required, chose -GF geometry. Recommended starting value for feed: 0.10 mm/rev (.004 inch/rev)

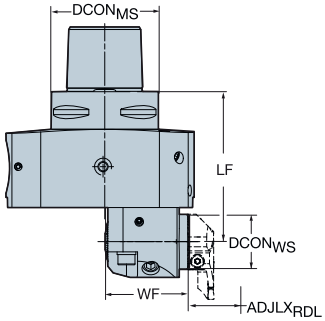


Coromant Capto® to CoroTurn® SL adjustable adapter

Coromant Capto® - Internal coolant supply

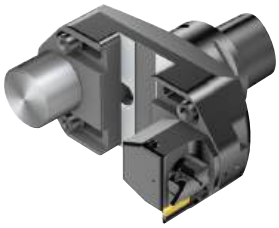


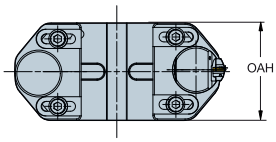


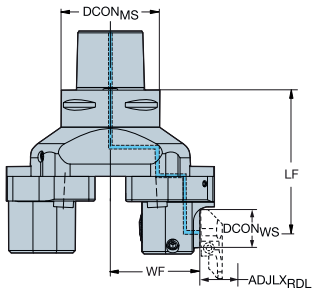


CoroBore® 825 fine adjustment

				Dimensions, mm, inch								BAR PSI	KG
CZC_{MS}	CZC_{WS}	CNSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	LF	LPR	WF	OAH	OAW		
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								BAR PSI	KG
CZC_{MS}	CZC_{WS}	CNSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	LF	LPR	WF	OAH	OAW		
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



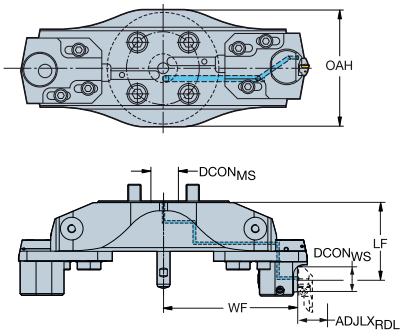
N15

Arbor to CoroTurn® SL adjustable adapter

Arbor - Internal coolant supply

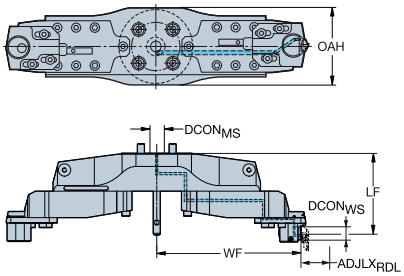
STDNO ISO 6462





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™

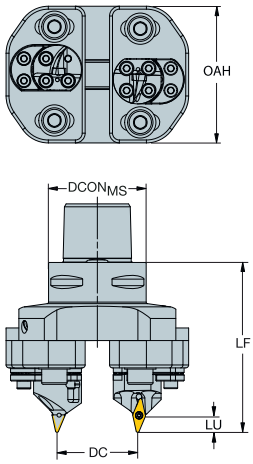
Coromant Capto® - Internal coolant supply

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

CoroBore® XL adjustable tool for SpiroGrooving™

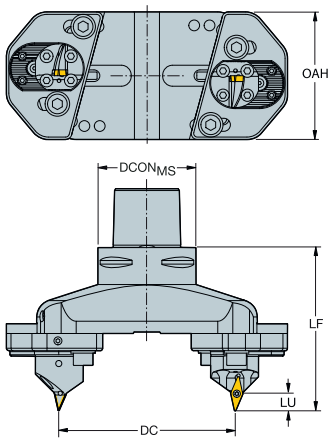
Coromant Capto® - Internal coolant supply

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

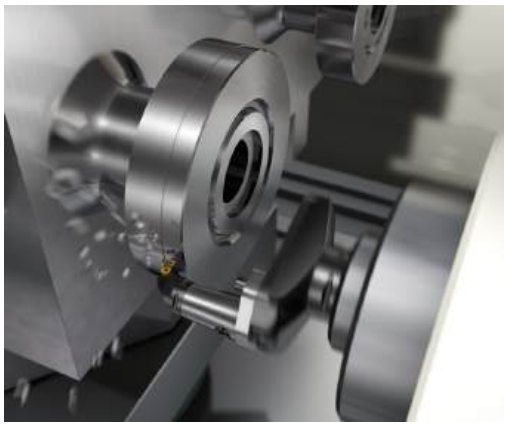
- Flexible solution, making it possible to use machining centers with modular tool setups instead of dedicated boring machines with U- or W-axis facing heads
- The component can be machined completely without being moved – especially beneficial for large, non-symmetrical components
- Reduced tool investment 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



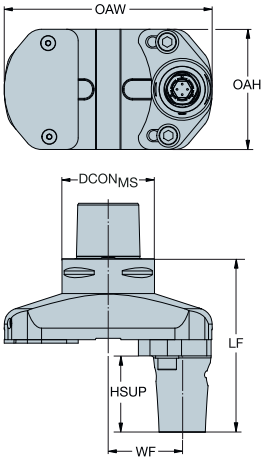
Component can be machined completely without moving it—especially beneficial for large, non-symmetrical components

Coromant Capto® adjustable adapter with quick change

For Interpolation Turning

Internal coolant supply

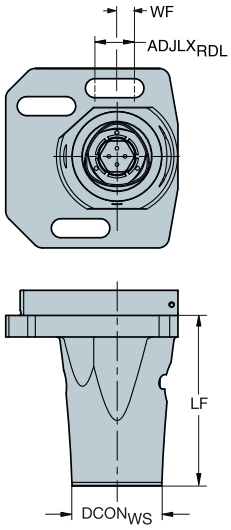




				Dimensions, mm, inch								
CZC_{MS}	CZC_{WS}	CNSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	$ADJLX_{RDL}$	LF	WF	OAH	OAW	BAR PSI	KG
C8	C4	3	**820-100C4-QC-C8**	80.00	40.00	26.00	150.00	51.00	104.00	180.00	70	7.090
				3.150	*1.575*	*1.024*	*5.906*	*2.008*	*4.094*	*7.087*	*1015*	
C8	C4	3	**820-150C4-QC-C8**	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





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

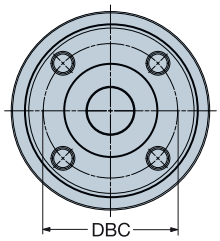
For cutting heads and inserts, see Turning tools catalog

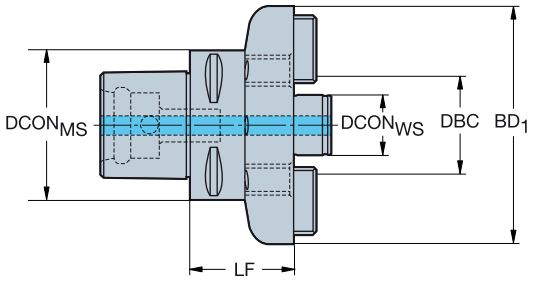
L2 N22 N15

Coromant Capto® to CoroBore® XL adapter

Internal coolant supply





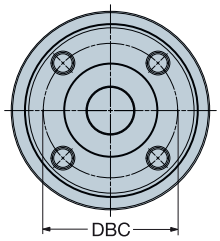


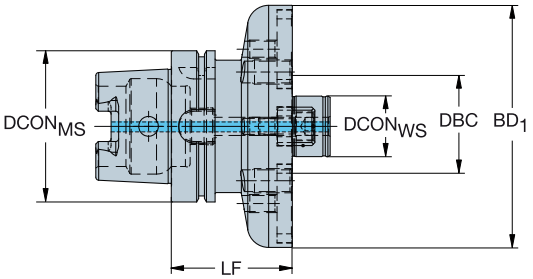
					Dimensions, mm, inch						
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	DBC	LF	BD_1	BAR PSI	KG
C8	40X	1	1	C8-391.XL-40 065	80.0	40.0	101.6	65.0	160.0	80	7.09
					3.150	*1.575*	*4.000*	*2.559*	*6.299*	*1160*	
C10	40X	1	1	C10-391.XL-40 070	100.0	40.0	101.6	70.0	160.0	80	8.67
					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*	

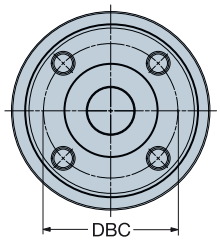
All CoroBore XL solid holders have ground backside of flange and threads for the option to mount a shim to increase stability if needed. Shim needs to be ordered separately and ground to fit the specific machine and holder, see accessories page M11.

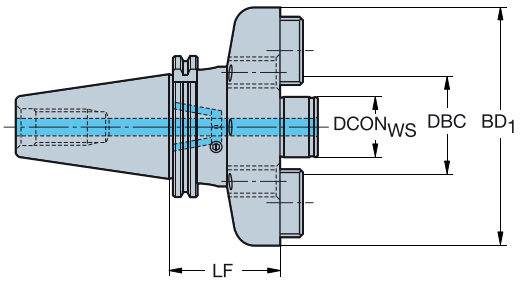
N22 N15

CAT-V to CoroBore® XL adapter

Internal coolant supply







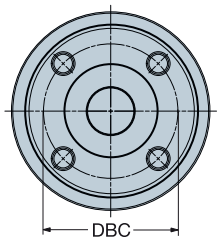
CAT V-Flange

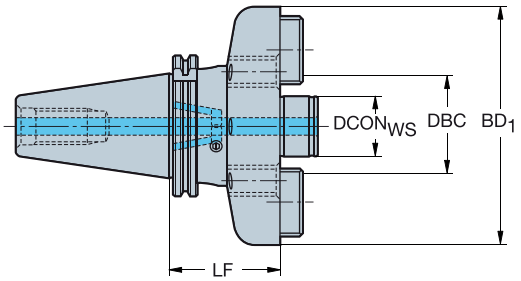
						Dimensions, mm, inch						
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	DBC	$DCON_{WS}$	LF	LB_1	BD_1	BAR PSI	KG
50	40X	7	1	1	A392.645XL-5040 075	101.6	40.0	75.0	75.0	160.0	20	3.38
						4.000	*1.575*	*2.953*	*2.953*	*6.299*	*290*	

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*	

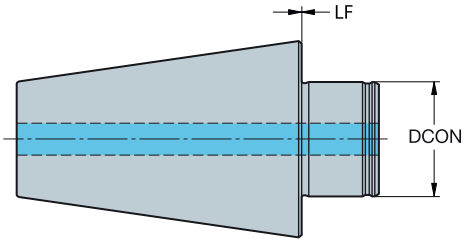
All CoroBore XL solid holders have ground backside of flange and threads for the option to mount a shim to increase stability if needed. Shim needs to be ordered separately and ground to fit the specific machine and holder, see accessories page M11.

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

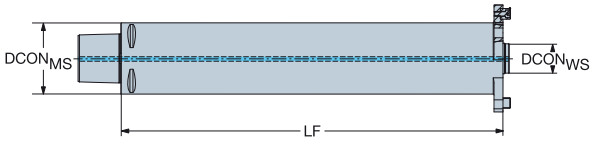
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	Dimensions, mm, inch LF	BAR PSI	KG
50	40 plug	1	1	A392.647XL-5040	0.0	20	8.17
					.000	*290*	

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

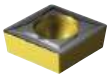
L2 N22 N15

Indexable boring cartridge

Axial and radial adjustment

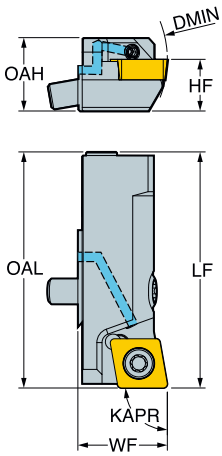
KAPR 90°





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			

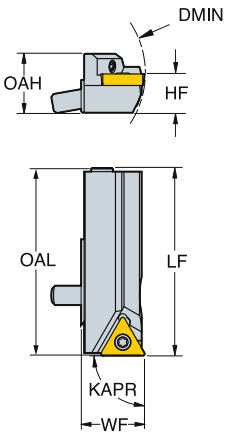
KAPR 90°





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			

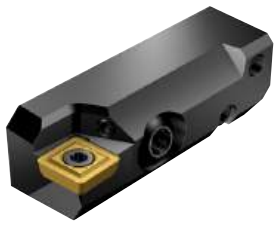
For inserts, see Turning catalog

N22 N15

Indexable boring cartridge

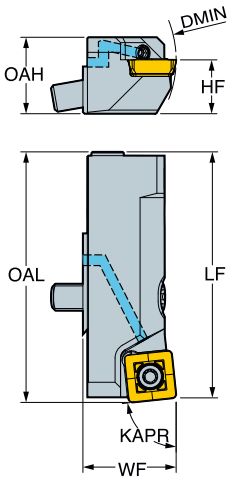
Axial and radial adjustment

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

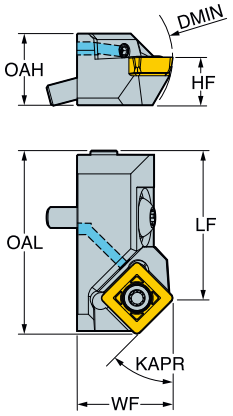
Axial adjustment

KAPR 45°





SPMT



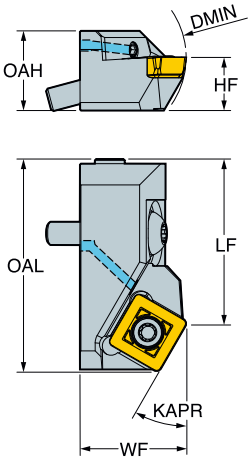
DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm, inch ADJLXAXL	LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID
20.0	06	06CC	2	**SSSPR06CCX06**	0.50	21.00	6.00	11.00	10.20	24.80	70	0.020	1	SPMT 0606-BM
.787					.020	.827	.236	.433	.402	.976	1015			
25.0	08	08CC	2	**SSSPR08CCX08**	0.50	25.00	8.00	16.00	12.20	30.70	70	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			

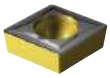
K33 N22 N15

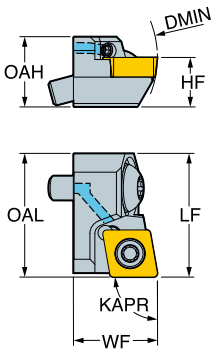
Indexable boring cartridge

No adjustment

KAPR 90°







CCMT, CCGT
CCGX, CCET

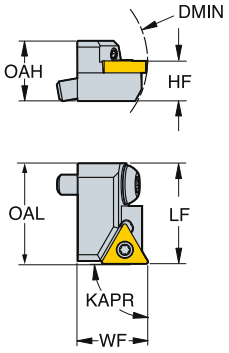
CCMW

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			

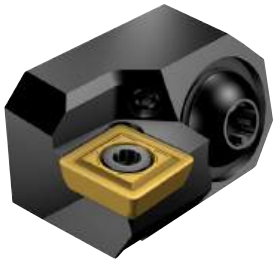
For inserts, see Turning catalog

N22 N15

Indexable boring cartridge

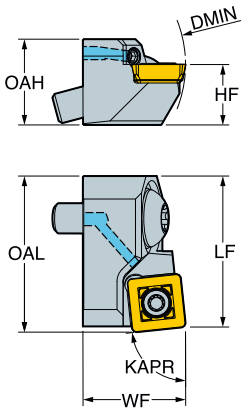
No adjustment

KAPR 84°







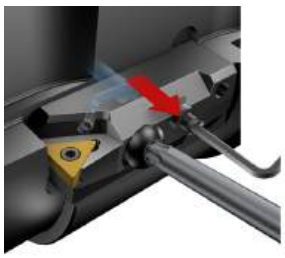


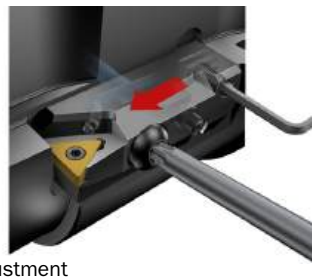
DMIN1		CZCMS	CNSC	Ordering code	Dimensions, mm, inch LF	HF	WF	OAH	OAL	BAR	KG	CICT	MIID
20.0	06	06CD	2	**SSYPR06CDX06**	16.00	6.00	11.00	10.20	16.60	70	0.020	1	SPMT 0606-BM
.787					.630	.236	.433	.402	.654	1015			
25.0	08	08CD	2	**SSYPR08CDX08**	20.00	8.00	14.00	12.20	20.80	70	0.030	1	SPMT 0808-BM
.984					.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

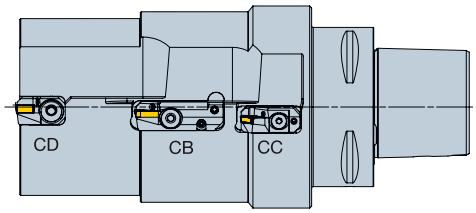


CC - Chamfer axial adjustment



CD - Fixed, no adjustment

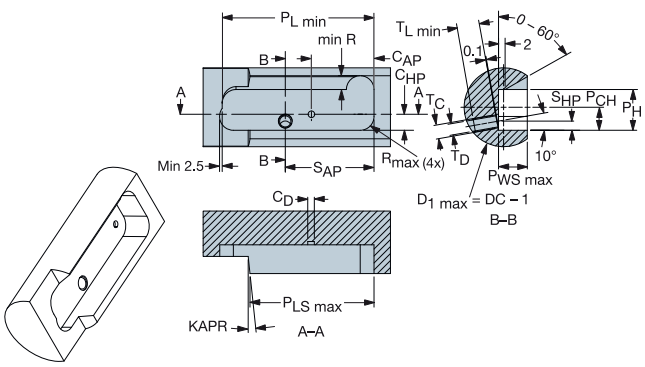




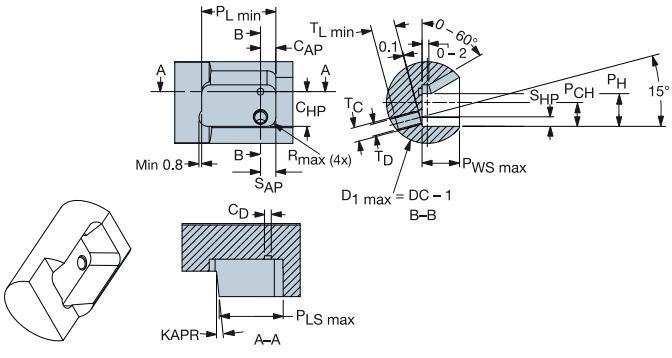
Size/type	Clamping set	Clamping torque		Key size
		Nm	In-lbs	
06CB	5519 201-01	4.8	42.5	15IP
10CB	5519 201-02	9.0	79.7	20IP
12CB	5519 201-03	16.0	141.6	25IP
06CC	5519 202-01	3.2	28.3	10IP
08CC	5519 202-02	4.8	42.5	15IP
10CC	5519 202-04	16.0	141.6	25IP
06CD	5519 202-01	3.2	28.3	10IP
08CD	5519 202-02	4.8	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



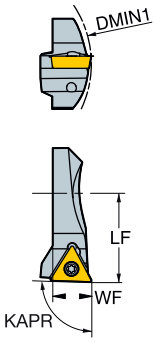
Type CC and CD



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



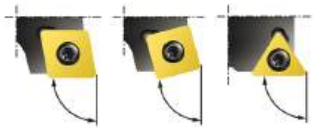
1



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

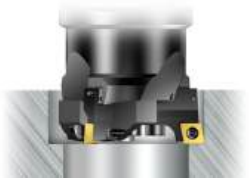
Dedicated rough boring insert with optimized grade selection for P, M, K, S

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

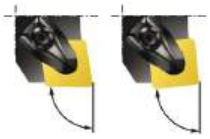
Adapter size	Shim set	Thickness mm	inch	Cover
A	R820A-AS00B	0.5+1	.020+.039	R820A-AC10B
B	R820B-AS00B	0.5+1	.020+.039	R820B-AC11B
C	R820C-AS00B	0.5+1	.020+.039	R820C-AC15B
D	R820D-AS00B	0.5+1	.020+.039	R820D-AC17A
E	R820E-AS00B	0.8+1.6	.031+.063	R820E-AC20A
F	R820F-AS00B	0.8+1.6	.031+.063	R820F-AC22A
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.

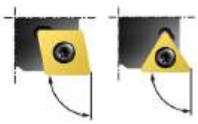
3. Single-edge boring:
   - Adjust unused cutting edge to a smaller diameter and use it as a counterweight.

Holders for CoroBore XL, diameter 150-1275 mm (5.906-50.197 inch)

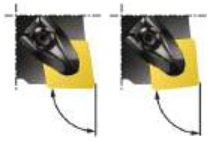
Must be bought separately. Available interfaces: C8, C10, HSK-A 100, HSK-A 125, CAT-V 50, ISO 7388/1 50, MAS BT 50

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

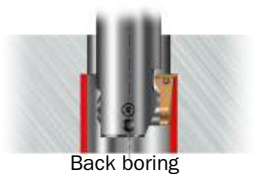
SANDVIK Coromant

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 mm *inch*	Slide extension (A)	Thickness mm *inch*	Diameter extension mm *inch*
55-1275 *2.165-50.197*	825C-048A	+4.8 *+.189*	+9.6 *+.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

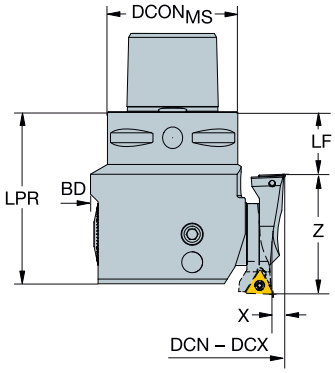
First choice is the CoroCut 2 system insert.
Use -TF geometry for low feed, -CM geometry for medium feed, and -RM geometry for radial bottom face grooving.
The -TF and -CM geometries have positive geometries that eliminate the risk of built-up-edge. The -TF geometry gives good chip control and generates high surface finish due to the Wiper design. The -GF enables larger widths to be selected.
Depending on chosen nose radius:

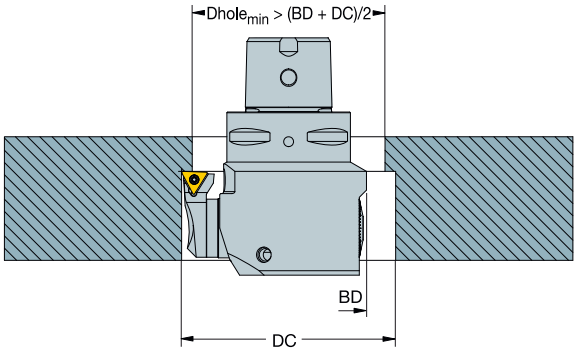
- Choose -CM for a smaller nose radius (0.2)
- Choose -TF for a larger nose radius (>0.3)
- Recommended start feed: 0.15 mm/rev (0.006 inch/rev)
- If grooves with tighter tolerance are required, choose -GF
- Recommended start feed: 0.10 mm/rev (0.004 inch/rev)

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

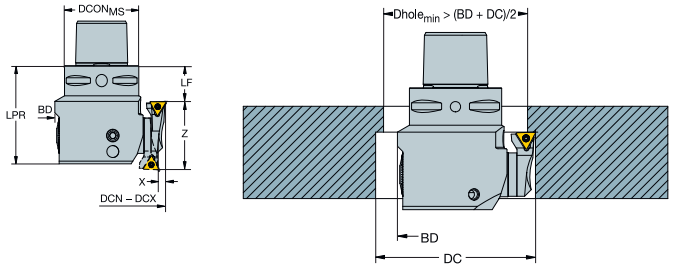
In case of backboring, LF will be reduced by twice LF of cartridge. That means:
- LF – 46 mm (1.811 inch) for Size C (e.g. R825C-AF**23**STUC1103A)
- Attention, change rotation direction –> left-handed!

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:

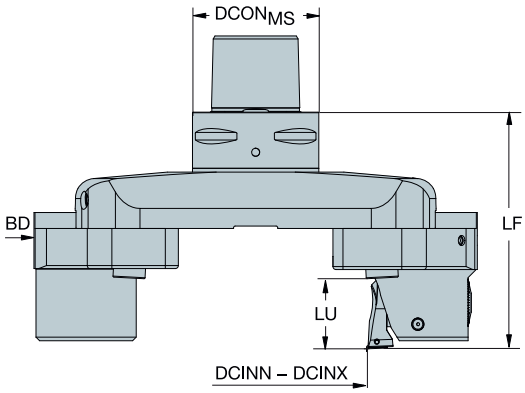
- LF – 22 mm (.866 inch) for Size A
- LF – 32 mm (1.260 inch) for Size B
- LF – 43 mm (1.693 inch) for Size C
- Attention: rotation direction will remain right-handed!

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) 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) 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) 825: 148-315 (5.866-12.402) 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) 825: 298-1275 (11.732-50.197) 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) 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) 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 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 -Extension with quick change -Reduction L4-L8 Coolant inducer L166	-Adapter -Quick change L44-L47	-Adapter -Quick change L64	-Adapter -Quick change L72-L73	-Adapter -Quick change L82-L83	-Adapter -Quick change L92-L93	-Adapter -Quick change -Turning L106-L108
	Coromant EH	–Adapter L9-L13	–Adapter L48		–Adapter L74		–Adapter L94	–Adapter L109-L110
	Arbor	-Adapter -With driving screws -Side and face mill L14-L24	-Adapter -With driving screws L49-L51	–Adapter L65	–Adapter L75	–Adapter L84	-Adapter -With driving screws -Side and face mill L95-L96	-Adapter -With driving screws -Side and face mill L111-L113
	VL	–Adapter L21	–Adapter L51	–Adapter L66	–Adapter L76	–Adapter L85	–Adapter L97	–Adapter L113
	Weldon	–Adapter L22-L24	–Adapter L52-L53				–Adapter L98	–Adapter L114
	MDI	–Adapter L25	–Adapter L54					
	ISO 9766	–Adapter L26 Coolant inducer L166	–Adapter L55				-Adapter -Adjustable adapter L99	-Adapter -Adjustable adapter L115
	Weldon/ ISO 9766	–Adapter L27		–Adapter L66	–Adapter L76	–Adapter L85		
	CoroMill® 327	–Adapter L28						
	CoroChuck™ 930	–Adapter L29-L34	–Adapter L56-L59	–Adapter L67-L68	–Adapter L77-L78	–Adapter L86-L87	–Adapter L100-L117	–Adapter L116-L117
	Shrink fit chuck	–Adapter L35-L38	–Adapter L60					
	ER	-Collet chuck -Drill chuck L39-L41	-Collet chuck L61	-Collet chuck L69	-Collet chuck L79	–Adapter L89	-Collet chuck L103	-Collet chuck L118
	CoroChuck™ 970	–Adapter L42	–Adapter L62	–Adapter L70	–Adapter L80	–Adapter L90	–Adapter L104	–Adapter L119

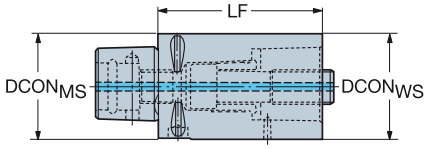
Damped adapters

		Machine side	
		Coromant Capto®	**HSK**
Workpiece side	**Coromant EH**	–Adapter L168	
	Arbor	-Adapter -With driving screws L169-L171	–Adapter L172

CAT-V	DIN 2080	DIN 2079	Cylindrical shank	Weldon shank	Bridgeport	Coromant EH	ER	NMTB
-Adapter -Quick change L121-L122	–Adapter L136	-Adapter -Quick change L139						–Adapter L165
–Adapter L123			–Adapter L141-L148				–Adapter L161-L162	
-Adapter -With driving screws -Side and face mill L124-L125			-With driving screws L149		–Adapter L157			
–Adapter L126								
–Adapter L126-L129								
-Adapter -Adjustable adapter L128-L129								
				–Adapter L153-L154		–Adapter L159	–Adapter L163	
–Adapter L130-L132								
-Collet chuck L133			-Collet chuck L150			–Adapter L159		
–Adapter L134			–Adapter L151	–Adapter L155		–Adapter L159		

Coromant Capto® extension adapter





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

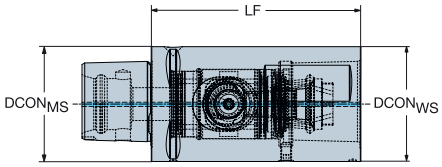
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	BAR PSI	NM	KG
C3	C3	3	1	C3-391.01-32 035	32.0	32.0	35.0	80	45.0	0.22
					1.260	*1.260*	*1.378*	*1160*		
C4	C4	3	1	C4-391.01-40 040	40.0	40.0	40.0	80	55.0	0.40
					1.575	*1.575*	*1.575*	*1160*		
C5	C5	3	1	C5-391.01-50 050	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*		

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M1 N22 N6 N15

Coromant Capto® extension adapter with quick change

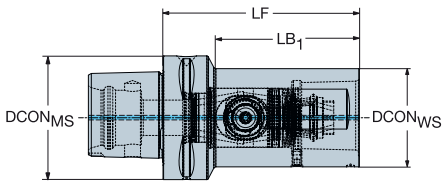




CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	BAR PSI	NM	KG	RPMX
C4	C4	3	1	C4-QC-C4-085	40.0	40.0	85.0	150	50.0	0.75	39000
					1.575	*1.575*	*3.346*	*2175*			
C5	C5	3	1	C5-QC-C5-100	50.0	50.0	100.0	150	70.0	1.39	28000
					1.969	*1.969*	*3.937*	*2175*			
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





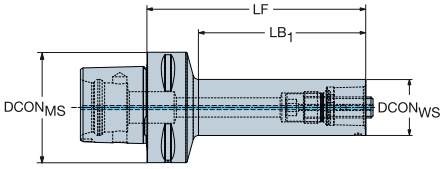
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	BAR PSI	NM	KG	RPMX
C5	C4	3	1	C5-QC-C4-085	50.0	40.0	85.0	60.5	150	50.0	0.95	28000
					1.969	*1.575*	*3.346*	*2.382*	*2175*			
C6	C5	3	1	C6-QC-C5-100	63.0	50.0	100.0	73.0	150	70.0	1.75	20000
					2.480	*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





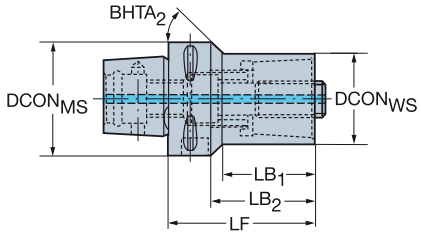
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	BAR PSI	NM	KG
C4	C3	3	1	C4-391.02-32 055A	40.0	32.0	55.0	31.0	80	45.0	0.49
					1.575	*1.260*	*2.165*	*1.220*	*1160*		
	C3	3	1	C4-391.02-32 120	40.0	32.0	120.0	95.7	80	45.0	0.81
					1.575	*1.260*	*4.724*	*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

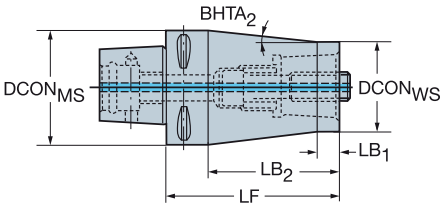
Coromant Capto® reduction adapter





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

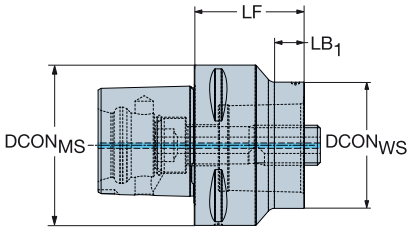
M1 N22 N6 N15

Coromant Capto® reduction adapter

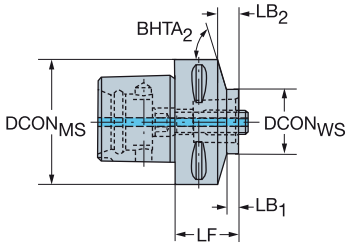
Short design, for segment clamping only

DSGN 2





7



						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	$BHTA_2$			
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*		

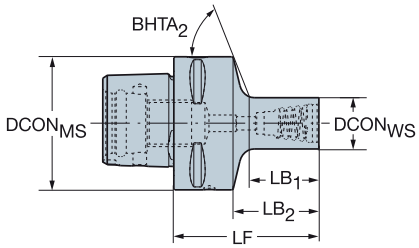
For spare parts, visit www.sandvik.coromant.com

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*			

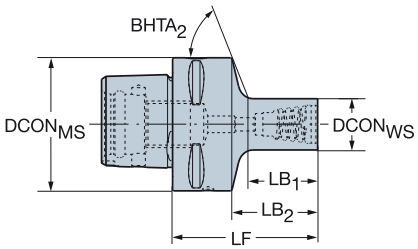
For spare parts, visit www.sandvik.coromant.com

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*			

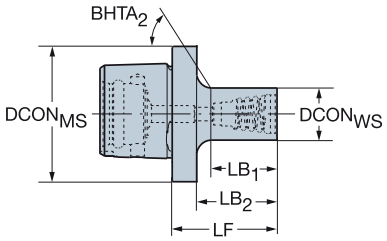
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15 N3

Coromant Capto® to Coromant EH adapter

Short design, for segment clamping only





Metric 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	$BHTA_2$				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*			

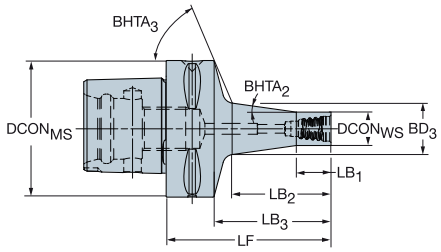
For spare parts, visit www.sandvik.coromant.com

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*			

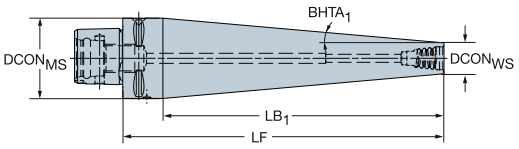
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M1 N22 N6 N15 N3

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*			

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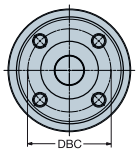
M1 N22 N6 N15 N3

Coromant Capto® to arbor adapter

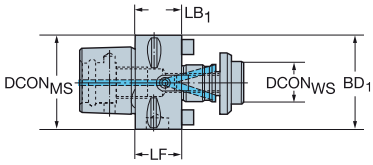
Coolant through arbor



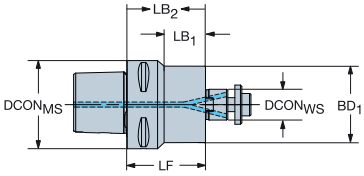
DSGN



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



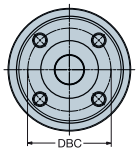
N15

Coromant Capto® to arbor adapter

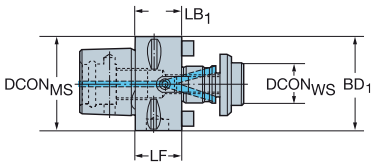
Coolant through arbor



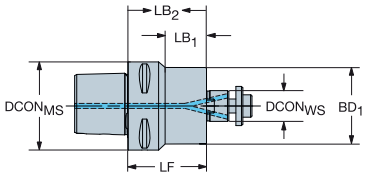
DSGN



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



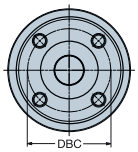
N22

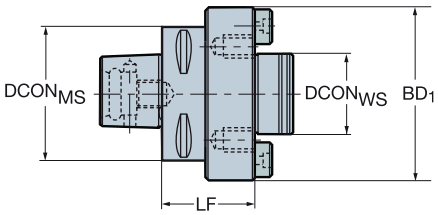


N15

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

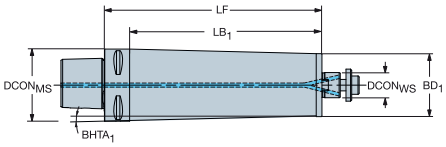
Coromant Capto® to arbor adapter

Coolant through arbor

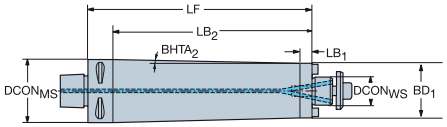
Long conical design



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*			

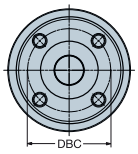
For spare parts, visit www.sandvik.coromant.com

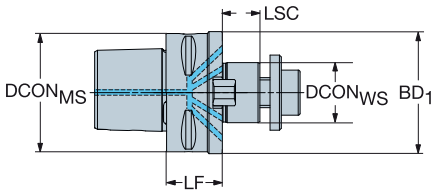
M1 N22 N15

Coromant Capto® to arbor adapter

For CoroMill® QD driving collars



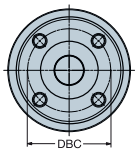


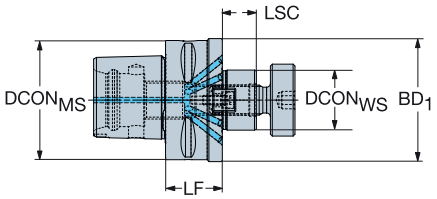


Metric pilot

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

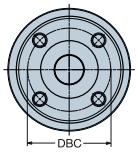
M1 N22 N15

Coromant Capto® to arbor with driving screws adapter

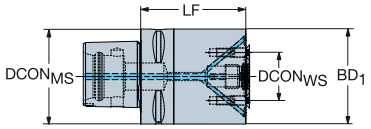
For CoroMill® QD with internal coolant supply



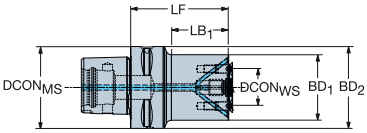
DSGN



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*			

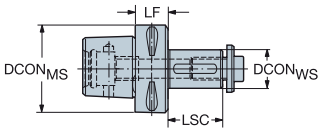
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

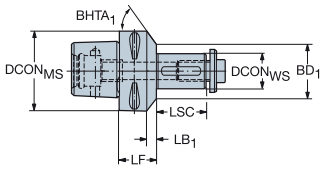
Coromant Capto® to side and face-mill arbor adapter



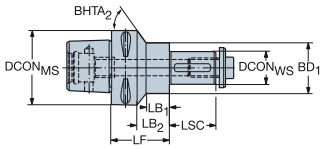
DSGN 1



DSGN 3



DSGN 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*			

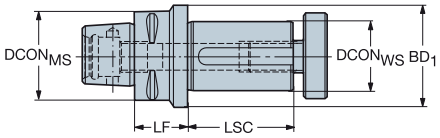
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M1 N22 N15

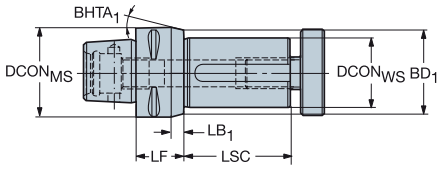
Coromant Capto® to side and face-mill arbor adapter



DSGN 1



DSGN 3

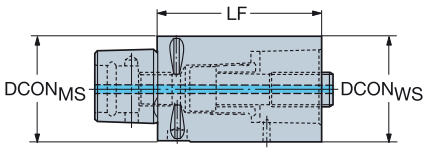


Inch pilot

						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

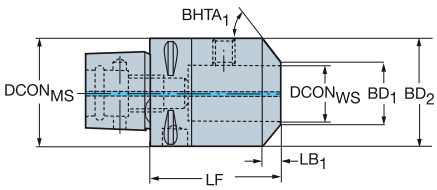
M1 N22 N15

Coromant Capto® to Weldon adapter

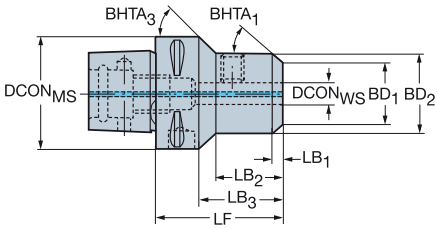
Workpiece side interface DIN 6535-HB and DIN 1835-B



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*			

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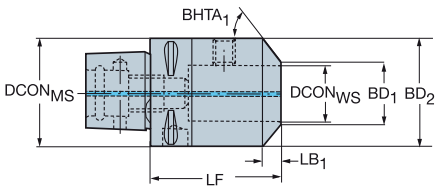
M1 N22 N15

Coromant Capto® to Weldon adapter

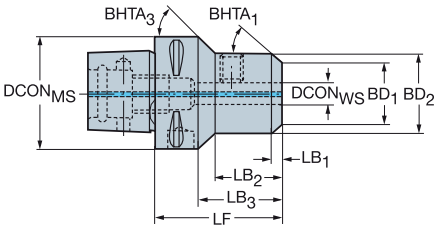
Workpiece side interface DIN 6535-HB and DIN 1835-B



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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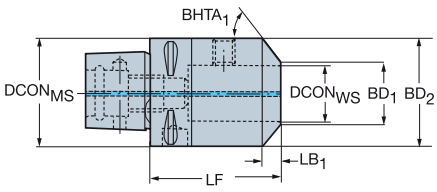
M1 N22 N15

Coromant Capto® to Weldon adapter

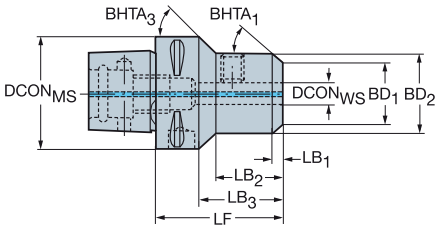
Workpiece side interface ANSI B94.19



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*			

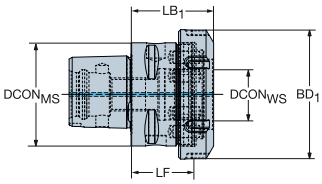
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

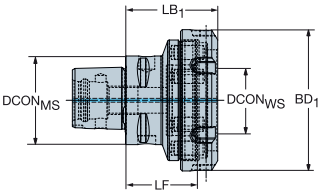
Coromant Capto® to MDI adapter



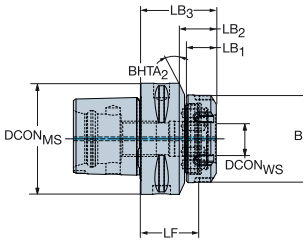
DSGN 1



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*			

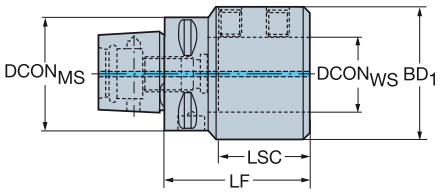
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M1 N22 N15 N5

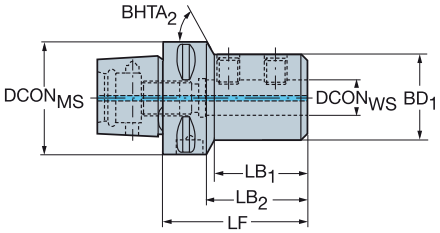
Coromant Capto® to ISO 9766 adapter



DSGN 1



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$_2$	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*			

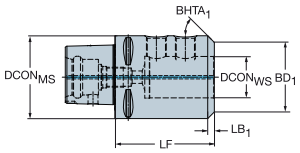
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M1 N22 N15

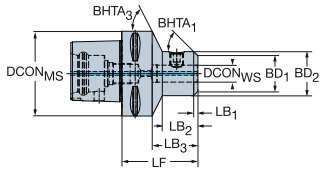
Coromant Capto® to Weldon/ISO 9766 adapter



DSGN 3



DSGN 14



Metric bore

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$_3$	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

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$_3$	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*		

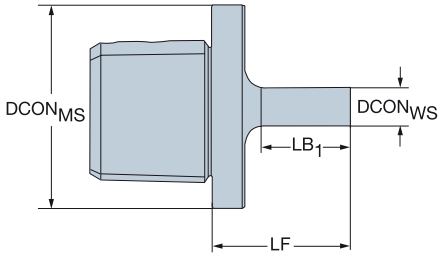
For spare parts, visit www.sandvik.coromant.com

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

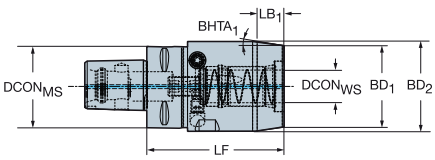
M1 N22 N15

Coromant Capto® to CoroChuck™ 930

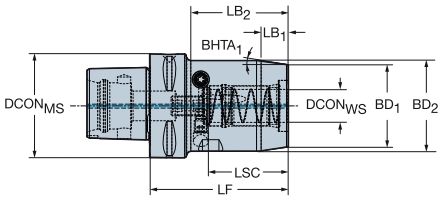
Heavy-duty design



DSGN 3



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*			

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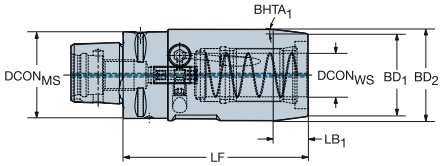
M1 N22 N6 N15 N4

Coromant Capto® to CoroChuck™ 930

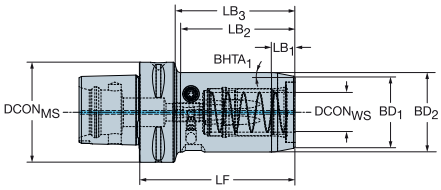
Slender design



DSGN 3



6



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	$BHTA_1$				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											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	$BHTA_1$				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*			

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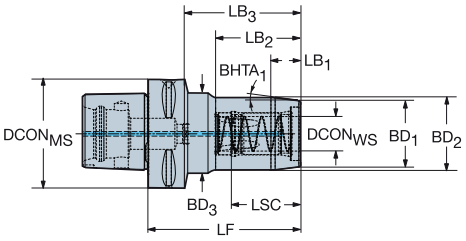
M1 N22 N6 N15 N4

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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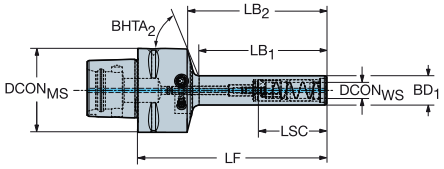
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Coromant Capto® to CoroChuck™ 930

Pencil design

DSGN 5



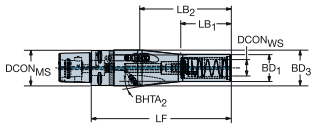


Metric bore

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*			

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

M1 N22 N6 N15 N4

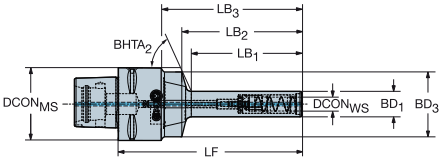
SANDVIK Coromant

Coromant Capto® to CoroChuck™ 930

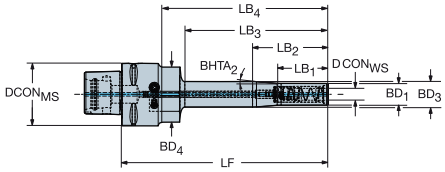
Pencil design



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*			

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

M1 N22 N6 N15 N4

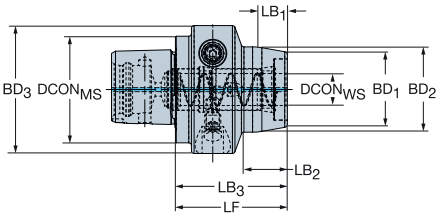
Coromant Capto® to CoroChuck™ 930

For driven toolholders

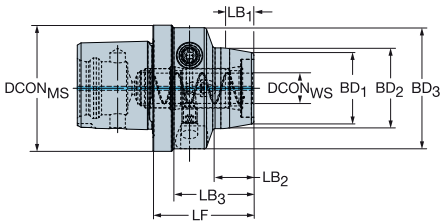
Segment clamping and manual tool change only



DSGN 6



DSGN 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*			

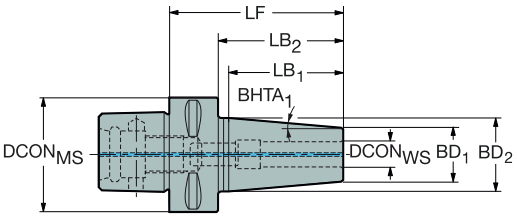
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15 N4

Coromant Capto® to shrink-fit chuck

Short design





Metric bore

					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	$BHTA_1$			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*		

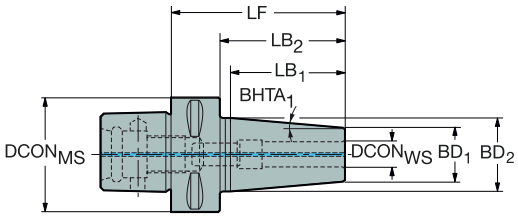
For spare parts, visit www.sandvik.coromant.com

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*		

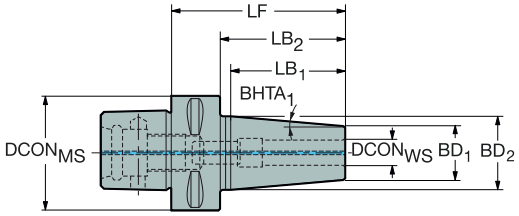
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M1 N22 N15

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*		

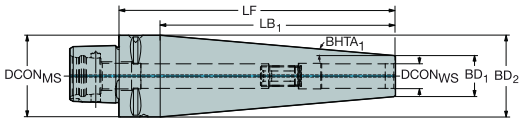
For spare parts, visit www.sandvik.coromant.com

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*		

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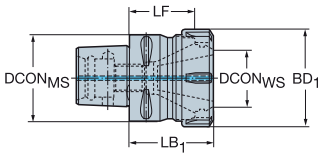
M1 N22 N15

Coromant Capto® to ER collet chuck

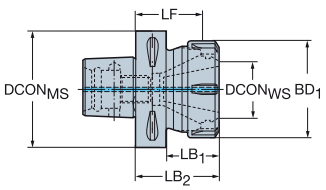
Workpiece side interface DIN 6499-B



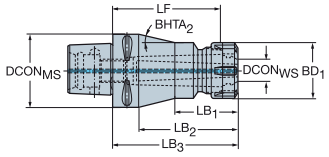
DSGN 1



2



7



						Dimensions, mm, inch										BAR PSI	KG	
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	$BHTA_2$			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*		

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M1



N22



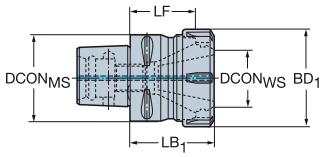
N15

Coromant Capto® to ER collet chuck

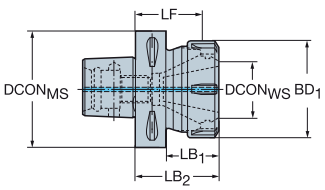
Workpiece side interface DIN 6499-B



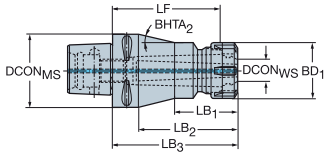
DSGN 1



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*		

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M1 N22 N15

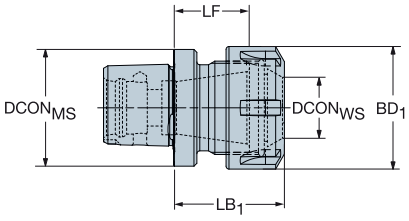
Coromant Capto® to ER collet chuck

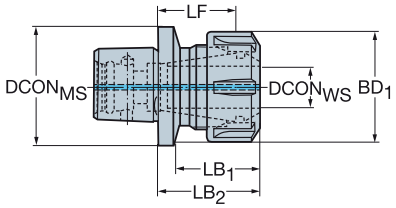
Short design, for segment clamping only

Workpiece side interface DIN 6499-B

DSGN 1 2







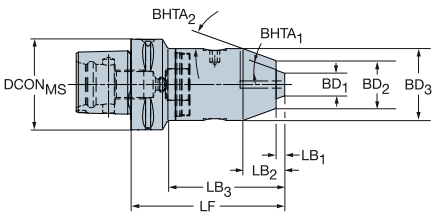
					Dimensions, mm, inch									
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_1	BD_2	BAR PSI	KG	RPMX
C3	ER16	3	1	C3-391.14-16 035	32.0	17.0	24.0	26.6	34.6	28.0	32.0	80	0.10	55000
					1.260	*.669*	*.945*	*1.047*	*1.362*	*1.102*	*1.260*	*1160*		
	ER20	3	1	C3-391.14-20 036	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*		

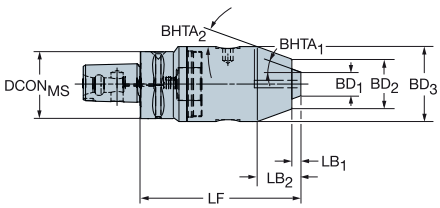
Coromant Capto® to drill chuck

Internal and external coolant supply

DSGN 16 8







						Dimensions, mm, inch													
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	$BHTA_1$	$BHTA_2$	BAR PSI	NM	KG	RPMX
C3	8 - 1	3	1	8	C3-391.32-08 076	32.0	76.0	3.0	19.1	76.0	9.9	24.1	36.0		19°	20°	50	10.0	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*			

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M1



N22



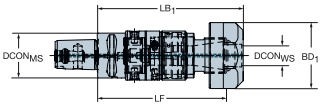
N15

Coromant Capto® to CoroChuck™ 970

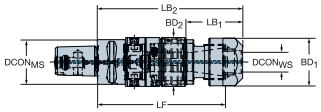
Workpiece side interface DIN 6499-B



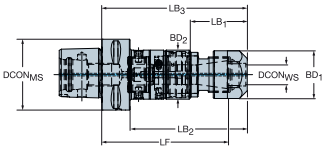
DSGN 1



2



5

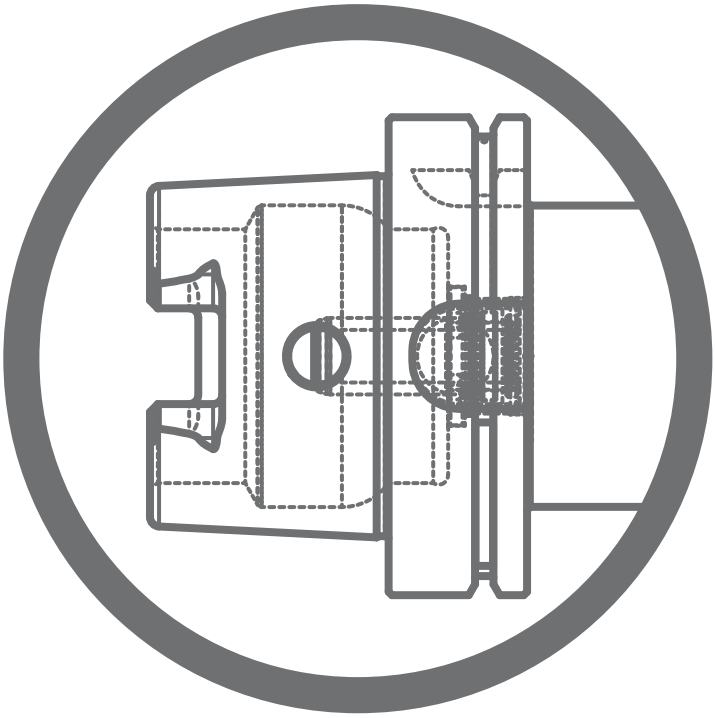


							Dimensions, mm, inch											
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BAR PSI	KG	RPMX
C3	ER11	M5	3	1	5	970-C3-11-078	32.0	11.3	74.2	24.1	63.0	78.0	18.7	23.5	32.0	80	0.27	8000
							1.260	*.445*	*2.921*	*.949*	*2.480*	*3.071*	*.736*	*.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*		

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M1 N22 N15 N5

Machine-side interface HSK

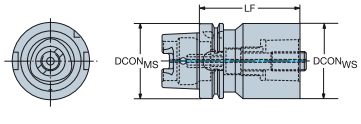


HSK to Coromant Capto® adapter

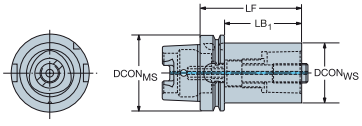
Machine side interface HSK A/C



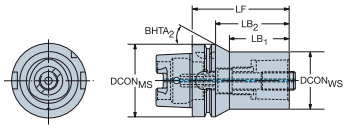
DSGN 1



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

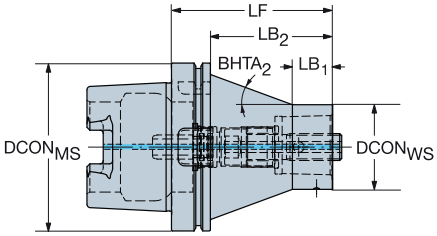
M1 N22 N15

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

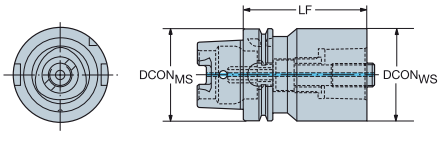
M1 N22 N15

HSK to Coromant Capto® adapter

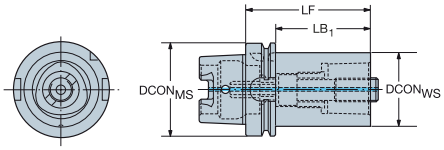
Machine side interface HSK A/C/T



DSGN 1



2

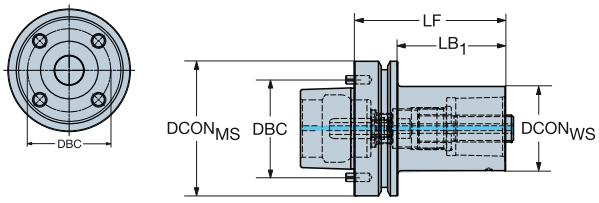


						Dimensions, mm, inch								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	BD_2	BAR PSI	NM	KG
40.0	C3	1	1	2	C3-390.419-40 065	40.0	32.0	65.0	45.0	65.0	40.0	100	45.0	0.46
						1.575	*1.260*	*2.559*	*1.772*	*2.559*	*1.575*	*1450*		
	C4	1	1	1	C4-390.419-40 075	40.0	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

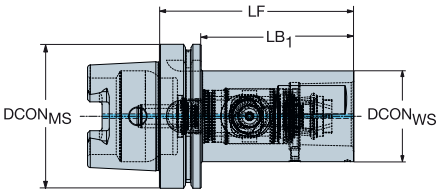
For spare parts, visit www.sandvik.coromant.com

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*			

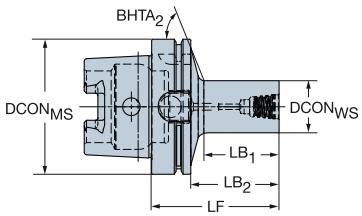
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15

HSK to Coromant EH adapter

Machine side interface HSK A/C

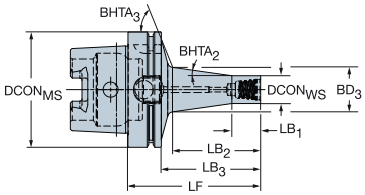




Short design

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*			

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M1 N22 N6 N15 N3

SANDVIK Coromant

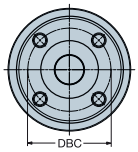
HSK to arbor adapter

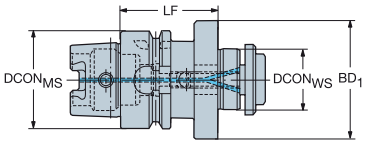
Machine side interface HSK A/C

Coolant through arbor

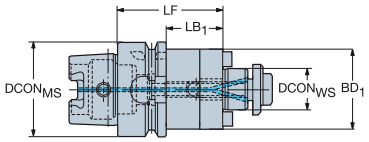


DSGN 1





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



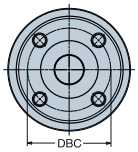
N15

HSK to arbor adapter

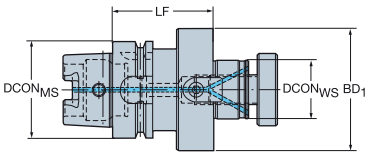
Machine side interface HSK A/C

Coolant through arbor

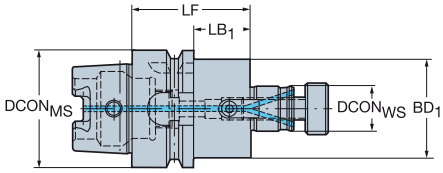




DSGN 1



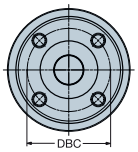
DSGN 2



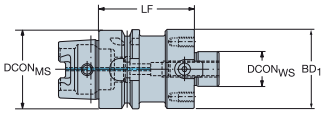
Inch pilot

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
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

CZC$_{MS}$	CZC$_{WS}$	DSGN	Ordering code	Dimensions, mm, inch 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

CZC$_{MS}$	CZC$_{WS}$	DSGN	Ordering code	Dimensions, mm, inch 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*			

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

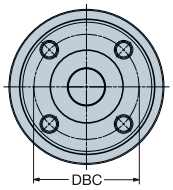
M1 N22 N15

HSK to arbor with driving screws adapter

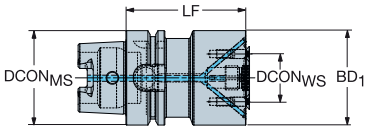
Machine side interface HSK A/C

For CoroMill® QD with internal coolant supply

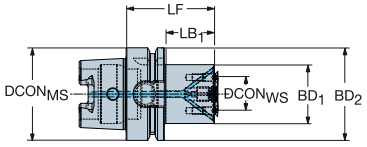




DSGN 1



2



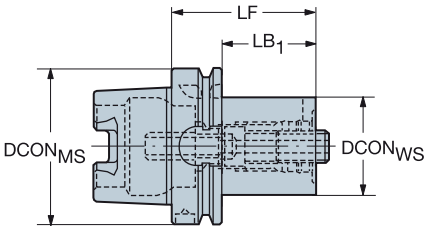
Metric pilot

						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*		

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

M1 N22 N15

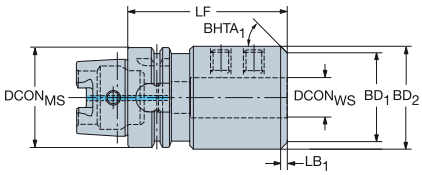
HSK to Weldon adapter

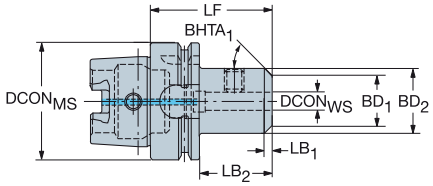
Machine side interface HSK A/C

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

DSGN 3 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

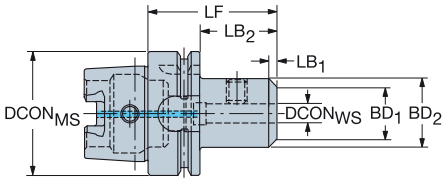
M1 N22 N15

HSK to Weldon adapter

Machine side interface HSK A/C

Workpiece side interface ANSI B94.19





Inch bore

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$_3$	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*			

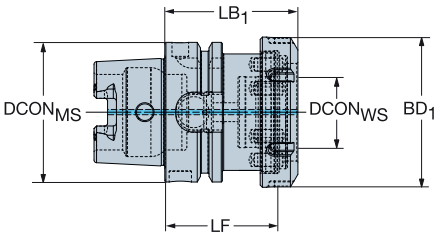
For spare parts, visit www.sandvik.coromant.com

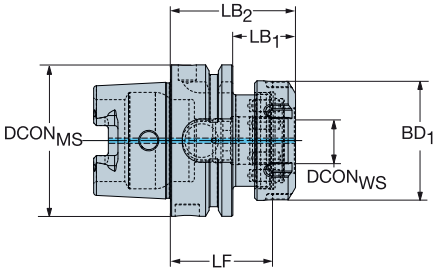
M1 N22 N15

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

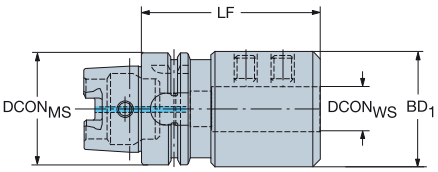
M1 N22 N15 N5

HSK to ISO 9766 adapter

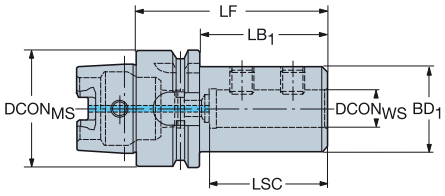
Machine side interface HSK A/C



DSGN 1



2



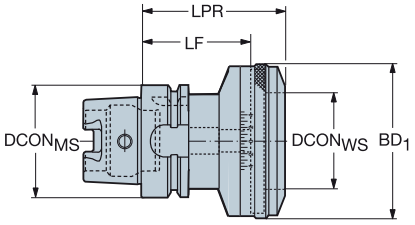
Metric bore

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*		

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

M1 N22 N15

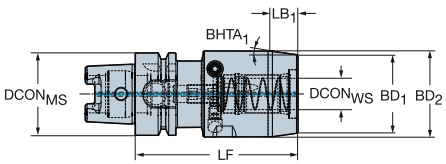
HSK to CoroChuck™ 930

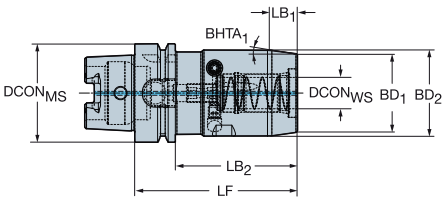
Heavy-duty design

Machine side interface HSK A/C

DSGN 3 6







Metric bore

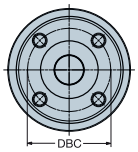
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_2$	BD$_3$	BHTA$_1$	BAR PSI	NM	KG	RPMX
63.0	20	1	1	6	930-HA06-HD-20-104	63.0	20.0	51	104.0	17.8	78.0	104.0	50.0	55.0	62.9	8°	80	10.0	1.89	20000
						2.480	*.787*	*2.008*	*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*			

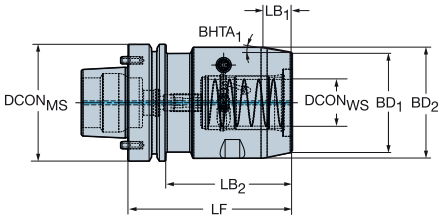
Inch bore

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

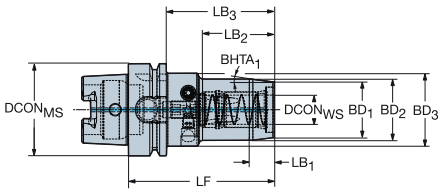
SANDVIK Coromant

HSK to CoroChuck™ 930

Slender design

Machine side interface HSK A/C





Metric bore

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$_2$	BD$_3$	BD$_4$	BHTA$_1$	BAR PSI	NM	KG	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*			

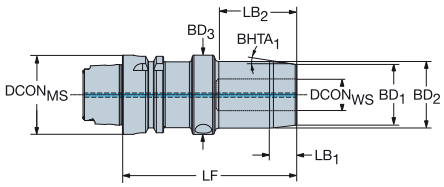
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M1 N22 N6 N15 N4

HSK to CoroChuck™ 930

Slender design





Metric bore

					Dimensions, mm, inch												
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	LSC	LF	LB_1	LB_2	BD_1	BD_2	$BHTA_1$	BAR 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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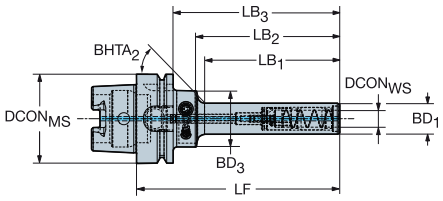
M1 N22 N6 N15 N4

HSK to CoroChuck™ 930

Pencil design

Machine side interface HSK A/C

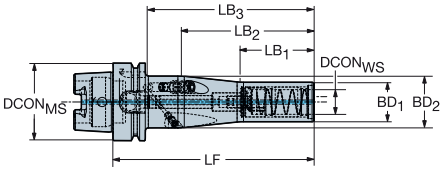




Metric bore

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*			

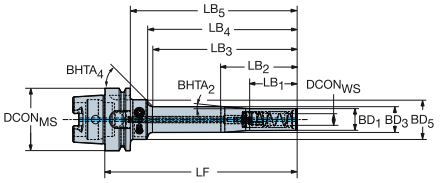




Metric bore

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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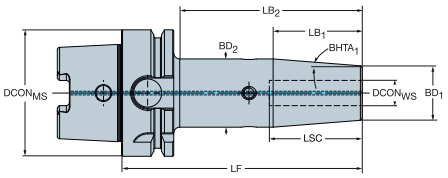
M1 N22 N6 N15 N4

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

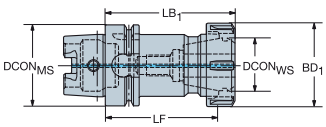
HSK to ER collet chuck

Machine side interface HSK A/C

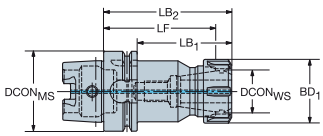
Workpiece side interface DIN 6499-B



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

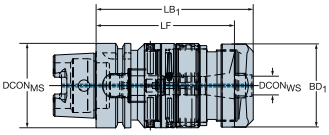
HSK to CoroChuck™ 970

Machine side interface HSK A/C

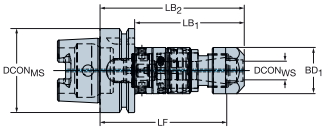
Workpiece side interface DIN 6499-B



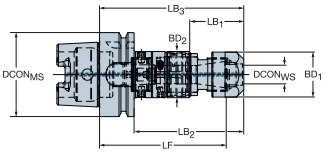
DSGN 1



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*		

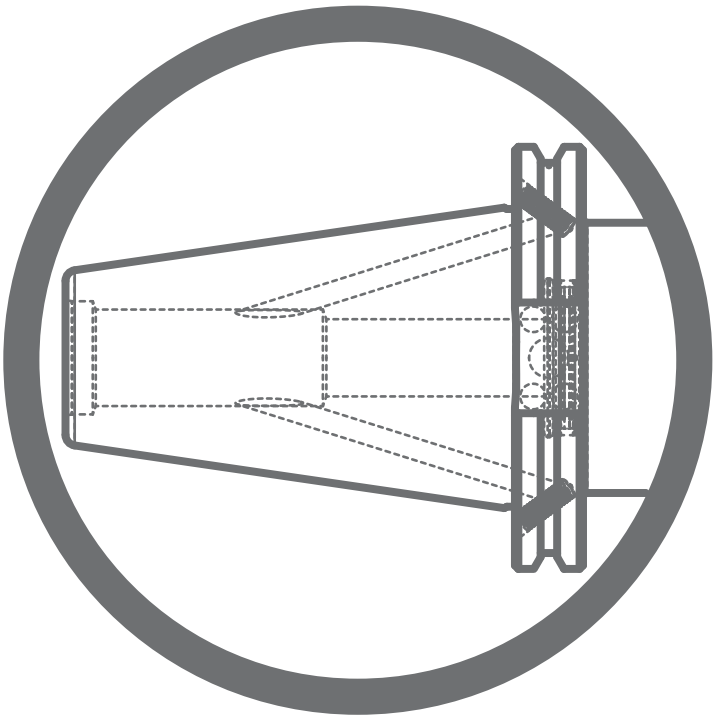
For MQL machining

							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

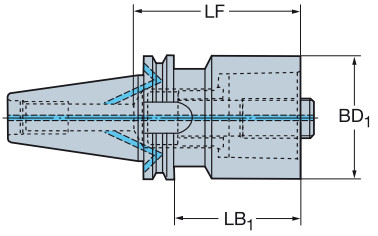


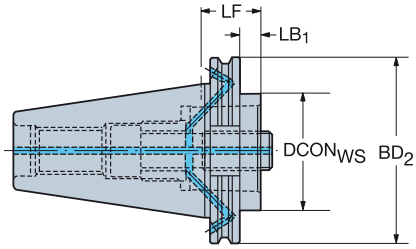
BIG-PLUS ISO to Coromant Capto® adapter

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

DSGN 1 2





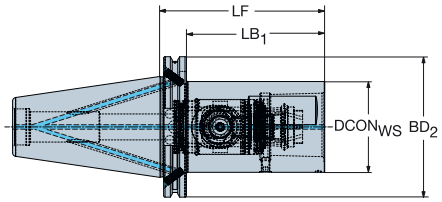


CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm, inch DCON$_{WS}$	CRKS	LF	LB$_1$	LB$_2$	BD$_2$	BAR PSI	NM	KG
40.0	C3	7	1	2	C3-390B.540-40 030	32.0	M16	30.0	10.9	30.0	63.5	80	45.0	0.89
						1.260		*1.181*	*.429*	*1.181*	*2.500*	*1160*		
	C4	7	1	2	C4-390B.540-40 040	40.0	M16	40.0	20.9	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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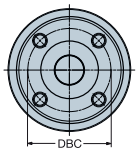
M1 N22 N15

BIG-PLUS ISO to arbor adapter

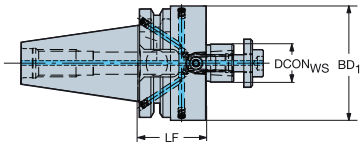
Coolant through arbor

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

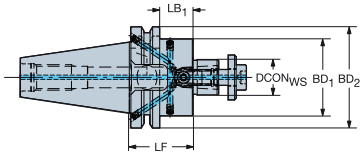




DSGN 1



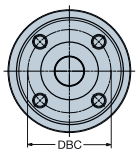
DSGN 2

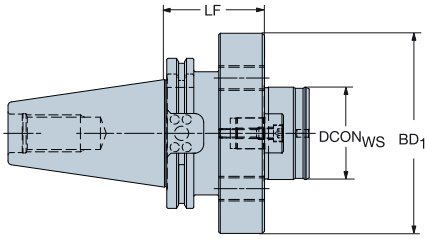


Metric pilot

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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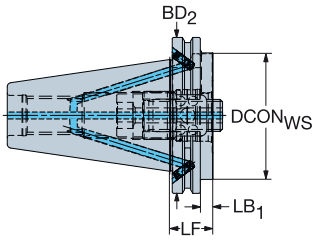
M1 N22 N15

BIG-PLUS ISO to VL adapter

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

Workpiece side interface DIN 6499-B





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	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*			

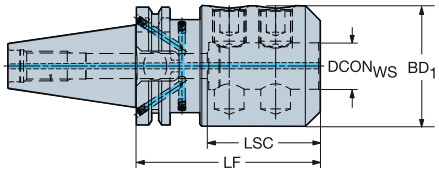
BIG-PLUS® SYSTEM licensed by BIG Daishowa

BIG-PLUS ISO to Weldon / ISO 9766 adapter

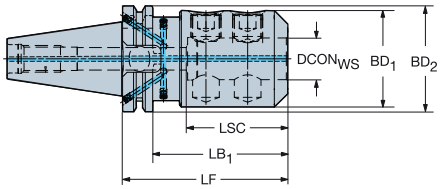
Machine side interface compatible with ISO 7388-1 and DIN 69871-ADB



DSGN 1



2



Metric bore

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	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

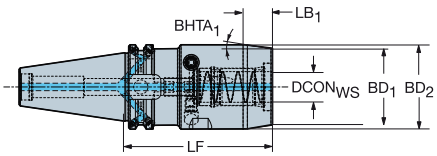
BIG-PLUS ISO to CoroChuck™ 930

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

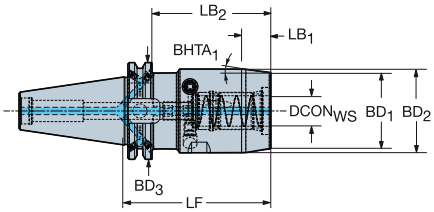
Heavy-duty design



DSGN 3



6



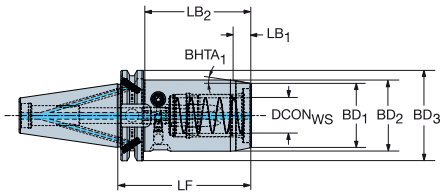
Metric bore

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*			

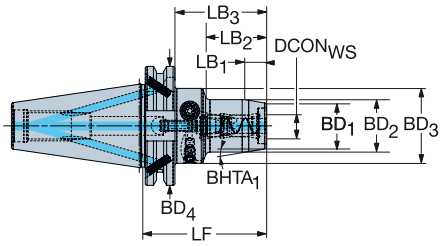
Slender design

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

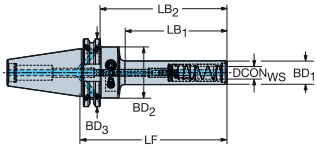
BIG-PLUS ISO to CoroChuck™ 930

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

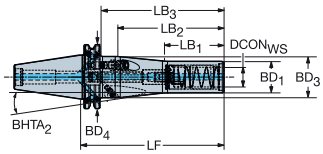
Pencil design



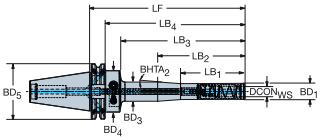
DSGN 5



DSGN 11



DSGN 17

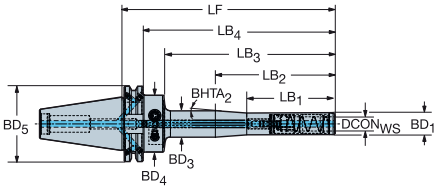


Metric bore

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



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
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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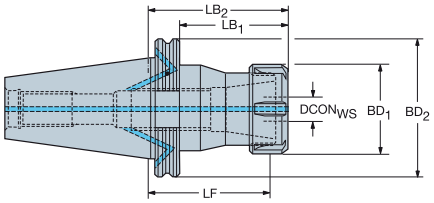
M1 N22 N15 N4

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





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

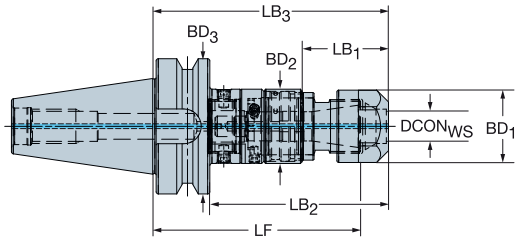
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M1 N22 N15

BIG-PLUS ISO to CoroChuck™ 970





Metric bore

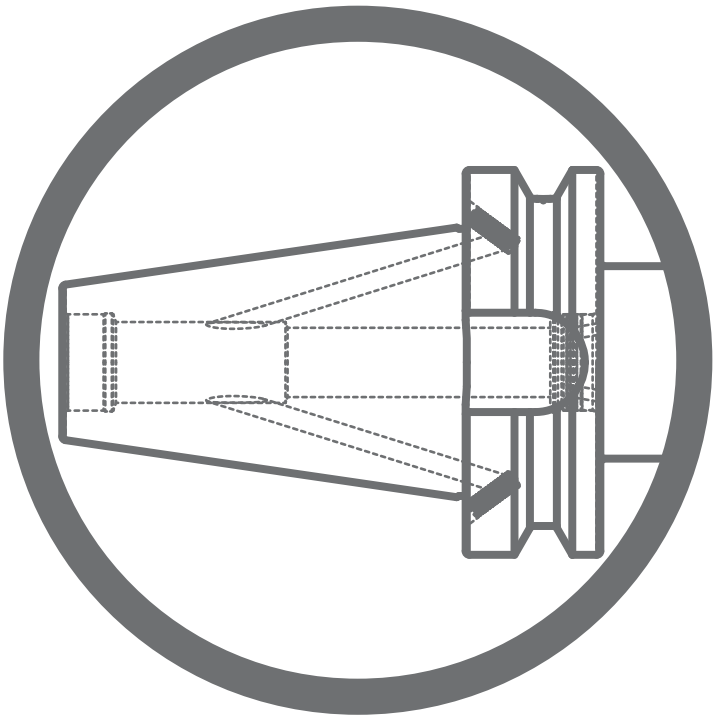
						Dimensions, mm, inch											
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BAR PSI	KG	RPMX
50.0	ER20	M12	7	1	**970-IB50-20-106**	20.8	M24	93.2	35.3	82.1	101.2	33.7	35.0	97.5	80	3.00	8000
						.819		*3.669*	*1.390*	*3.232*	*3.984*	*1.327*	*1.378*	*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

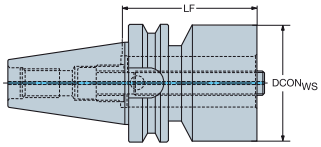


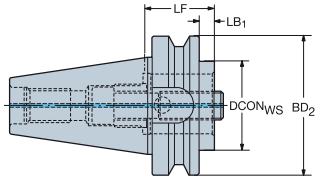
BIG-PLUS MAS-BT to Coromant Capto® adapter

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

DSGN 1 2



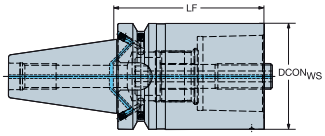


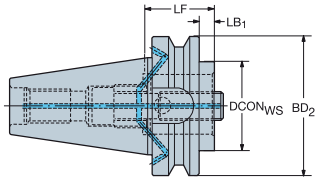


CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm, inch DCON$_{WS}$	CRKS	LF	LB$_1$	LB$_2$	BD$_2$	BAR PSI	NM	KG
30.0	C3	1	1	2	C3-390.555-30 040	32.0	M12	40.0	18.0	40.0	46.0	80	45.0	0.48
						1.260		*1.575*	*.709*	*1.575*	*1.811*	*1160*		
	C4	1	1	2	C4-390.555-30 060	40.0	M12	60.0	38.0	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

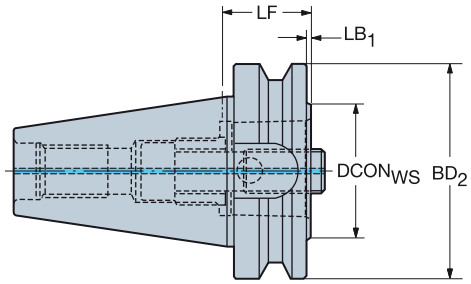
SANDVIK Coromant

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





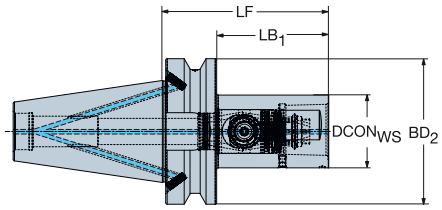
					Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LF	LB_1	BD_2	BAR PSI	NM	KG
40.0	C5	1	1	**C5-390.562-40 050**	50.0	M16	50.0	23.0	63.0	80	45.0	1.16
					1.969		*1.969*	*.906*	*2.480*	*1160*		
50.0	C6	1	1	**C6-390.562-50 050**	63.0	M24	50.0	12.0	100.0	80	65.0	3.66
					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*		

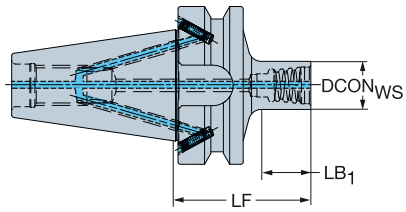
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M1 N22 N15

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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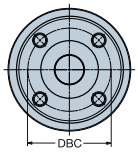
M1 N22 N6 N15 N3

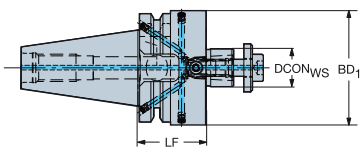
BIG-PLUS MAS-BT to arbor adapter

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

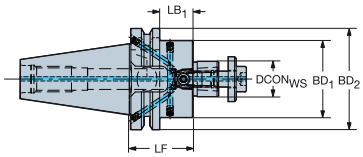


DSGN 1





DSGN 2

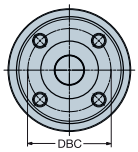


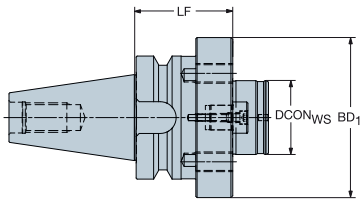
Metric pilot

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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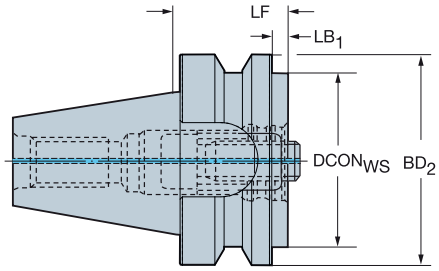
M1 N22 N15

BIG-PLUS MAS-BT to VL adapter

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

Coolant through center





Metric pilot

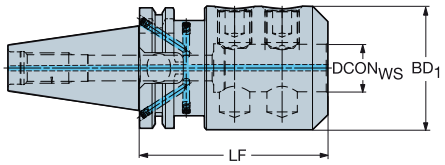
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{WS}$	CRKS	LF	LB$_1$	BD$_2$	BAR PSI	NM	KG
50.0	80	1	1	390.558-50 80 040	80.0	M24	40.0	2.0	100.0	80	170.0	3.50
					3.150		*1.575*	*.079*	*3.937*	*1160*		

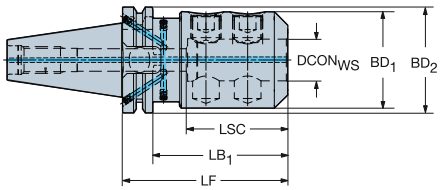
BIG-PLUS MAS-BT to Weldon / ISO 9766 adapter

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

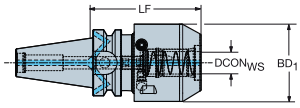
BIG-PLUS MAS-BT to CoroChuck™ 930

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

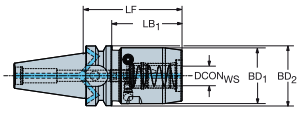
Metric bore



DSGN 3



6

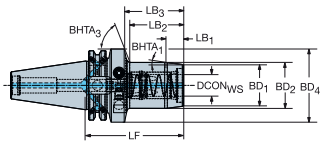


Heavy-duty design

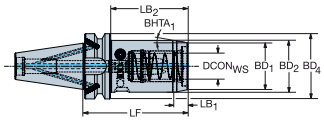
						Dimensions, mm, inch														
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{WS}$	CRKS	LSC	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	$BHTA_1$	BAR PSI	NM	KG	RPMX
40.0	20	7	1	6	**930-BB40-HD-20-088**	20.0	M16	51	88.0	17.8	61.0	88.0	50.0	55.0	63.0	8°	80	10.0	1.95	18000
						.787		*2.008*	*3.465*	*.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

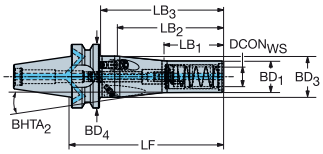
BIG-PLUS MAS-BT to CoroChuck™ 930

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

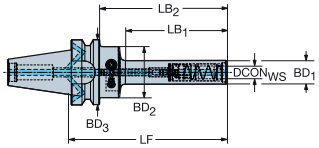
Metric bore

DSGN 11





DSGN 5

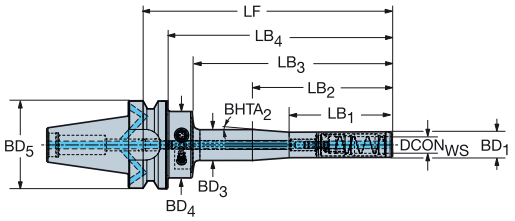


Pencil design

						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
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

						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
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

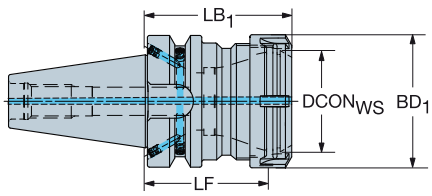
BIG-PLUS MAS-BT to ER collet chuck

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

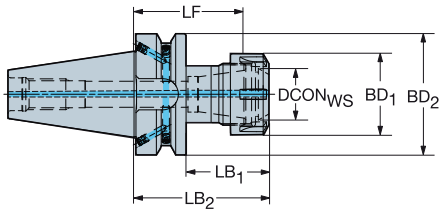
Workpiece side interface DIN 6499-B



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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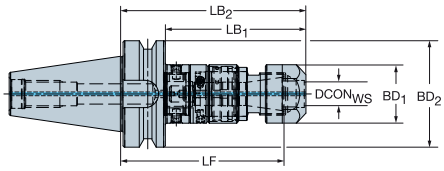
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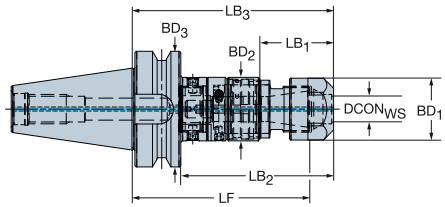
M1 N22 N15

BIG-PLUS MAS-BT to CoroChuck™ 970

DSGN 2 5







Metric bore

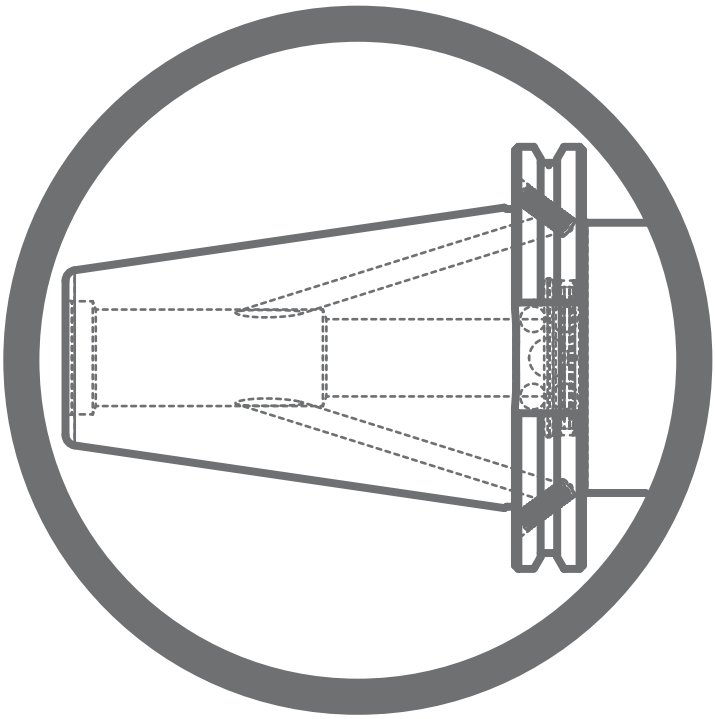
							Dimensions, mm, inch											
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{WS}$	CRKS	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BAR PSI	KG	RPMX
30.0	ER11	M5	1	1	5	**970-BB30-11-082**	11.3	M12	78.2	24.1	60.0	82.0	18.7	23.5	46.0	80	0.52	8000
							.445		*3.079*	*.949*	*2.362*	*3.228*	*.736*	*.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

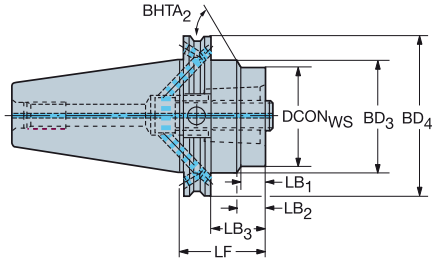


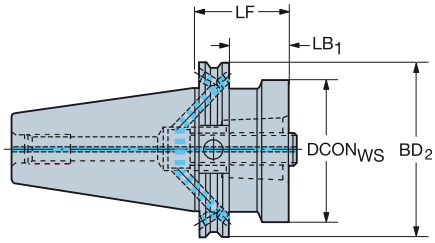
BIG-PLUS CAT-V to Coromant Capto® adapter

Machine side interface ASME B5.50-1985

DSGN 11 2



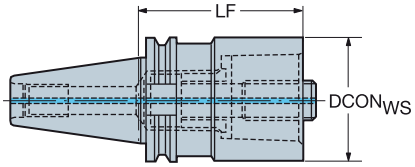




Machine side interface ASME B5.50-1985

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*		

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

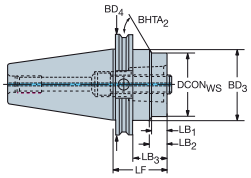
M1 N22 N15

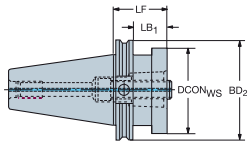
BIG-PLUS CAT-V to Coromant Capto® adapter

90° rotated polygon for precision tool tip control

DSGN 11 2



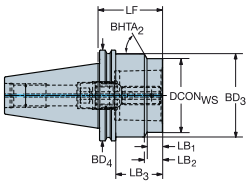




Machine side interface compatible with ASME B5.50-1985

						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*		





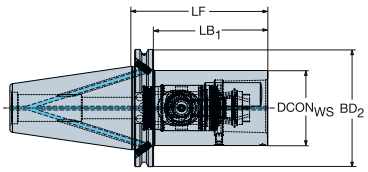
Machine side interface heavy-duty version outside the ASME standard

					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

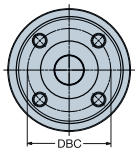
BIG-PLUS CAT-V to arbor adapter

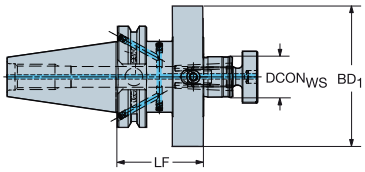
Coolant through arbor

Machine side interface compatible with ASME B5.50-1985

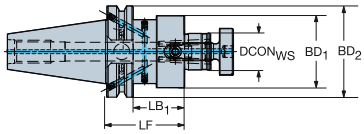


DSGN 1





DSGN 2



Inch pilot

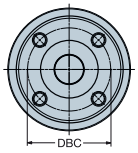
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm, inch DCON$_{WS}$	DBC	CRKS	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR PSI	NM	KG
40.0	3/4	7	4	2	A392.54505C4019040	19.1		5/8"-11	40.0	20.9	40.0	44.5	63.5	80	25.0	1.17
						.750			*1.575*	*.823*	*1.575*	*1.752*	*2.500*	*1160*		
	1	7	4	2	A392.54505C4025055	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*		

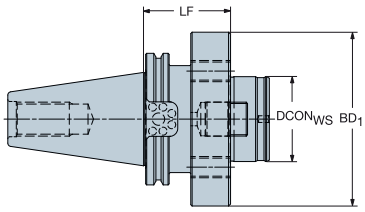
Machine side interface compatible with ASME B5.50-2009

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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M1



N22

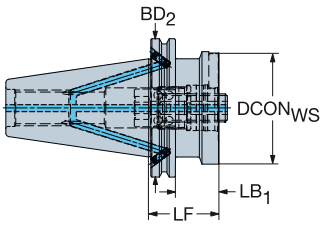


N15

BIG-PLUS CAT-V to VL adapter

Machine side interface compatible with ASME B5.50-2009





					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	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*			

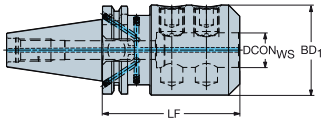
For spare parts, visit www.sandvik.coromant.com

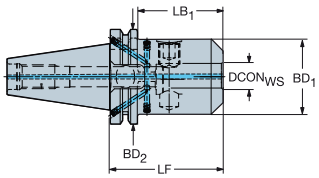
BIG-PLUS CAT-V to Weldon / ISO 9766 adapter

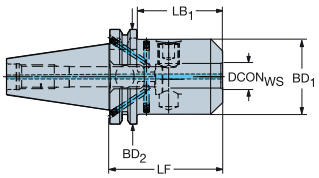
Machine side interface compatible with ASME B5.50-1985

DSGN 1 2 6









Inch bore

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

						Dimensions, mm, inch										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{WS}$	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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M1



N22



N15

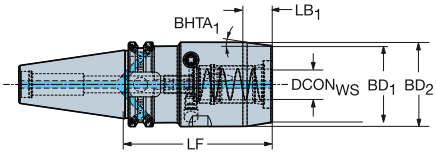
BIG-PLUS CAT-V to CoroChuck™ 930

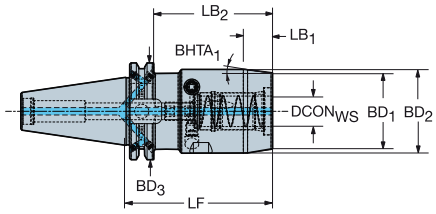
Machine side interface ASME B5.50-2009

Heavy-duty design

DSGN 3 6



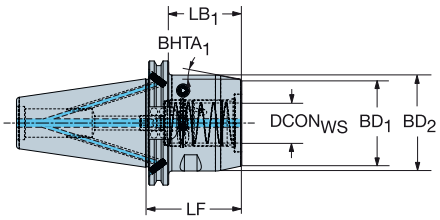




Metric bore

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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M1 N22 N6 N15 N4

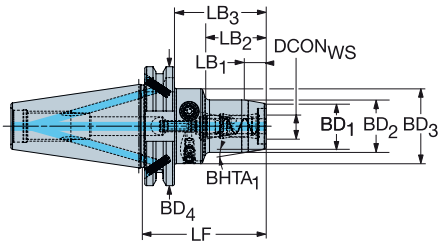
BIG-PLUS CAT-V to CoroChuck™ 930

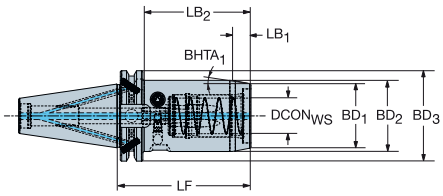
Machine side interface compatible with ASME B5.50-2009

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*			

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M1 N22 N6 N15 N4

BIG-PLUS CAT-V to CoroChuck™ 930

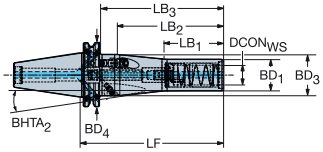
Machine side interface compatible with ASME B5.50-2009

Slender design

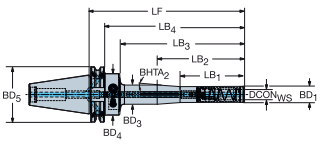
Pencil design



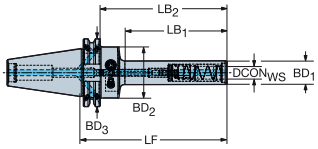
DSGN 11



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

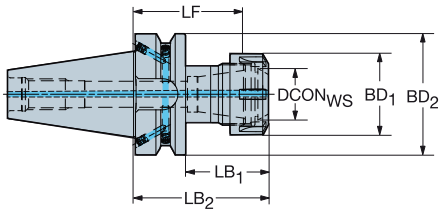
BIG-PLUS CAT-V to ER collet chuck

Machine side interface compatible with ASME B5.50-1985

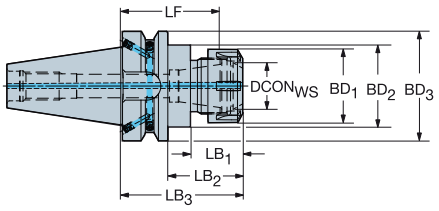
Workpiece side interface DIN 6499-B



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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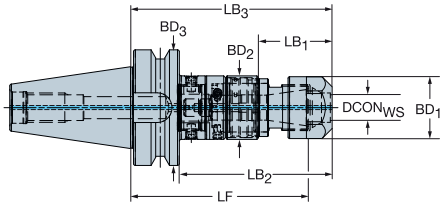
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M1 N22 N15

BIG-PLUS CAT-V to CoroChuck™ 970

Machine side interface ASME B5.50-2009





Metric bore

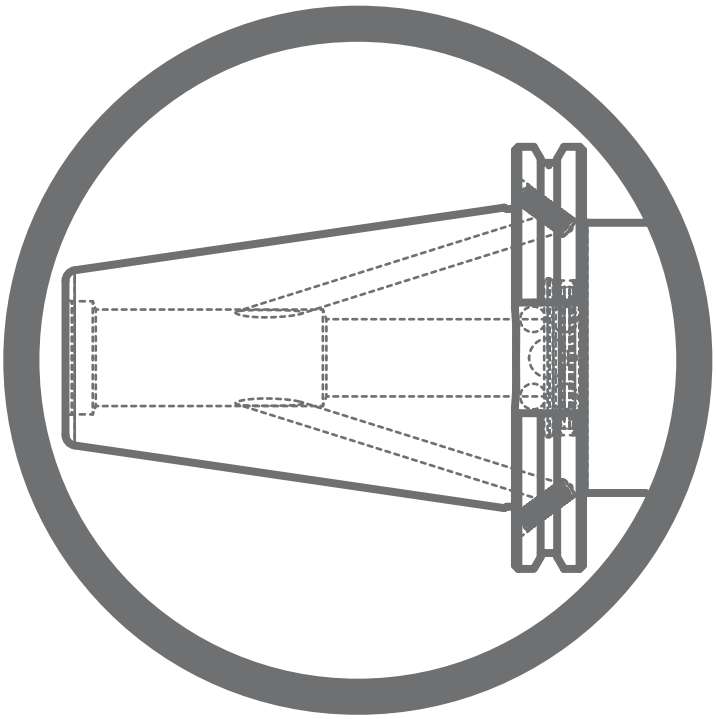
CZC$_{MS}$	CZC$_{WS}$	TRMAX	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{WS}$	CRKS	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_2$	BD$_3$	BAR PSI	KG	RPMX
40.0	ER20	M12	7	1	**970-VB40-20-102**	20.8	5/8"-11	89.2	35.3	78.1	97.2	33.7	35.0	63.5	80	1.28	8000
						.819		*3.512*	*1.390*	*3.075*	*3.827*	*1.327*	*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

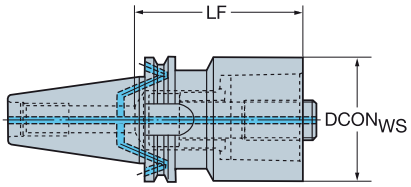


ISO 7388-1 to Coromant Capto® adapter

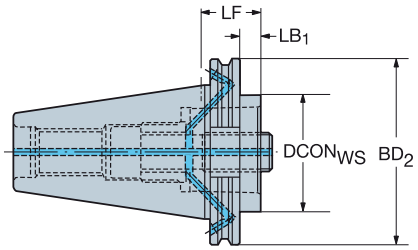
Machine side interface compatible with DIN 69871-ADB



DSGN 1



2



						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	C3-390B.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*		

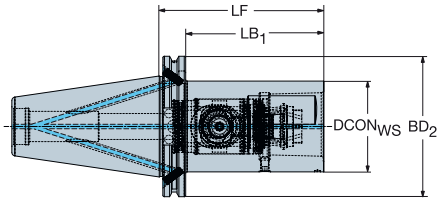
For spare parts, visit www.sandvik.coromant.com

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

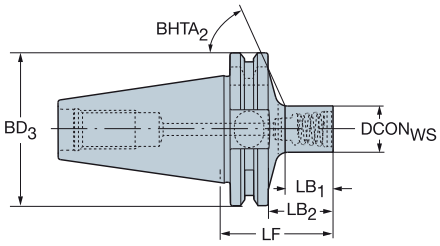
M1 N22 N6 N15

ISO 7388-1 to Coromant EH adapter

Machine side interface compatible with DIN 69871-AD

Short design



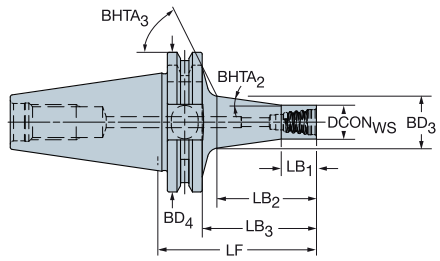


Metric version

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*			

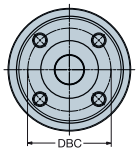
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15 N3

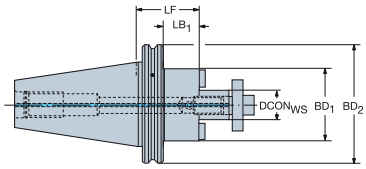
ISO 7388-1 to arbor adapter

Machine side interface compatible with DIN 69871-ADB

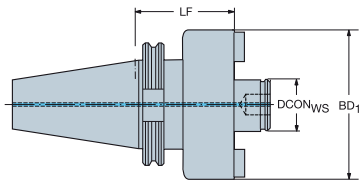




DSGN 2



DSGN 1



Metric pilot

						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
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

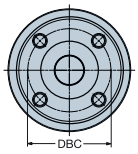
M1 N22 N15

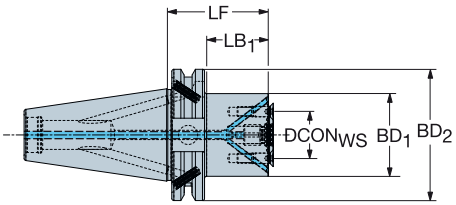
ISO 7388-1 to arbor with driving screws adapter

Machine side interface compatible with DIN 69871-ADB

For CoroMill® QD with internal coolant supply







Metric pilot

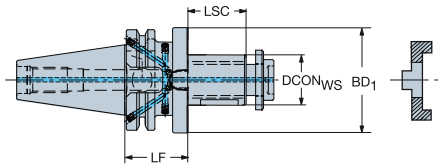
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{WS}$	DBC	CRKS	LSC	LF	LB$_1$	BD$_1$	BD$_2$	BAR PSI	NM	KG	RPMX
40.0	X10	7	3	I40-X10-032-045	10.0	22.0	M16	2	45.0	24.5	32.0	63.5	80	6.4	1.00	12000
					.394	*.866*		*.094*	*1.772*	*.965*	*1.260*	*2.500*	*1160*			
	X22	7	3	I40-X22-040-050	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

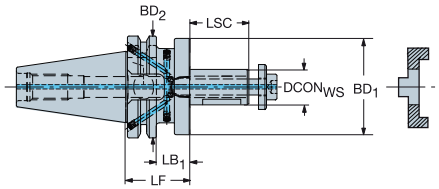
Machine side interface compatible with DIN 69871-ADB



DSGN 1



2



Metric pilot

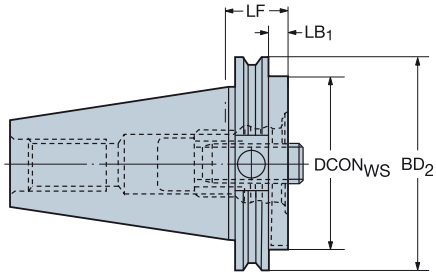
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm, inch DCON$_{WS}$	CRKS	LSC	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR PSI	NM	KG	RPMX
40.0	22	7	1	2	A1B08-40 22 055	22.0	M16	31	43.0	19.9	43.0	40.0	63.5	80	45.0	1.26	18000
						.866		*1.220*	*1.693*	*.783*	*1.693*	*1.575*	*2.500*	*1160*			
	27	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

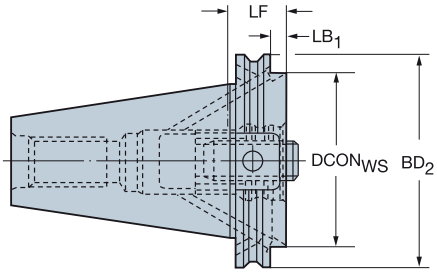




Machine side interface compatible with DIN 69871-AD

					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	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

					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	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

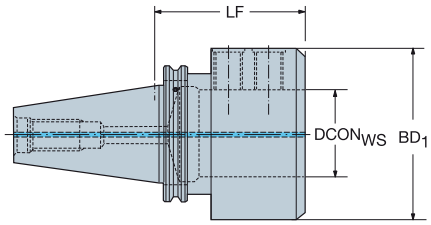
ISO 7388-1 to Weldon adapter

Machine side interface compatible with DIN 69871-ADB

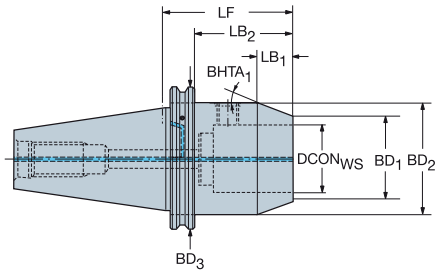
Workpiece side interface DIN 6535-HB and DIN 1835-B

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*			

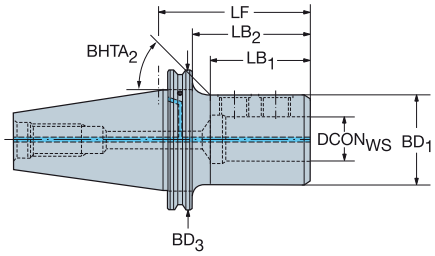
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M1 N22 N15

ISO 7388-1 to ISO 9766 adapter

Machine side interface compatible with DIN 69871-ADB





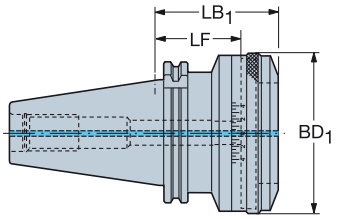
Metric bore

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

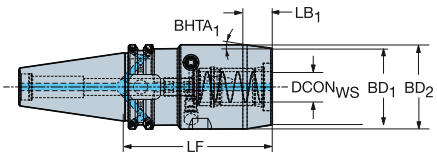
ISO 7388-1 to CoroChuck™ 930

Machine side interface compatible with DIN 69871-ADB

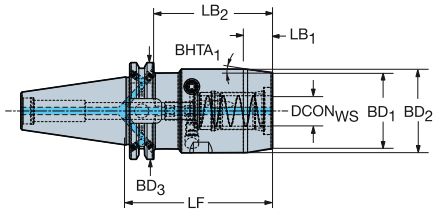
Metric bore



DSGN 3



DSGN 6



Heavy-duty design

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-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

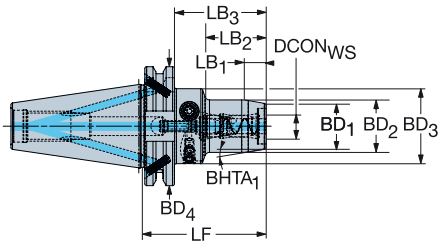
ISO 7388-1 to CoroChuck™ 930

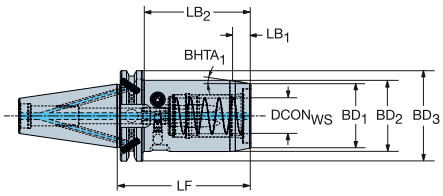
Machine side interface compatible with DIN 69871-ADB

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

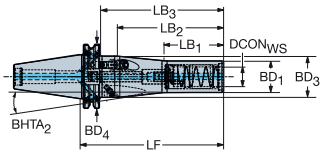
ISO 7388-1 to CoroChuck™ 930

Machine side interface compatible with DIN 69871-ADB

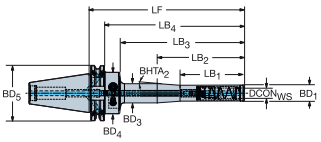
Metric bore

DSGN 11

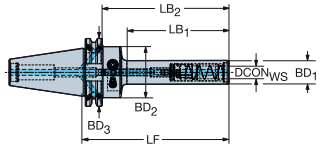




DSGN 17



DSGN 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

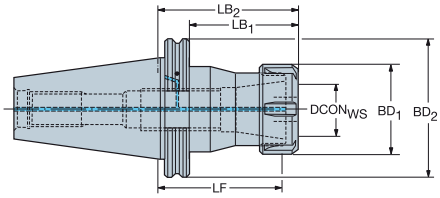
M1 N22 N6 N15 N4

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

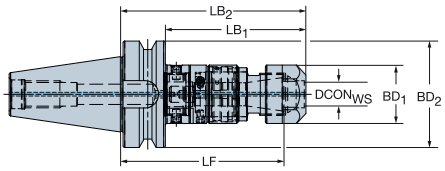
ISO 7388.1 to CoroChuck™ 970

Machine side interface compatible with DIN 69871-AD

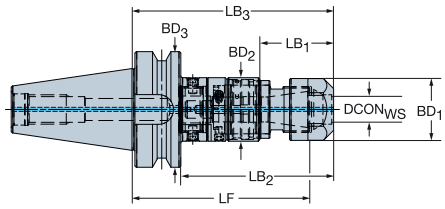
Workpiece side interface DIN 6499-B



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



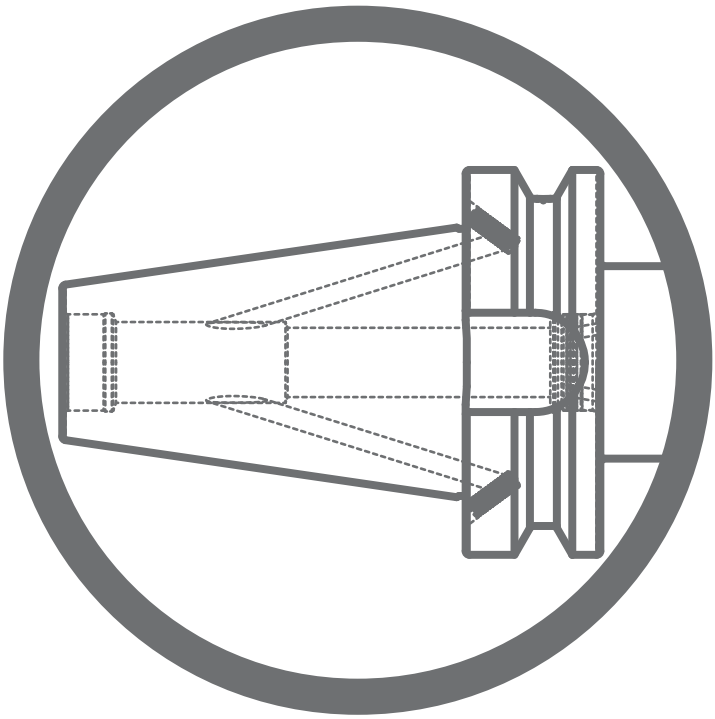
N22



N15

 N5

Machine side interface MAS-BT

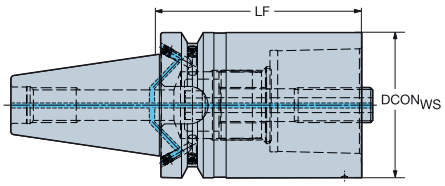


MAS-BT 403 to Coromant Capto® adapter

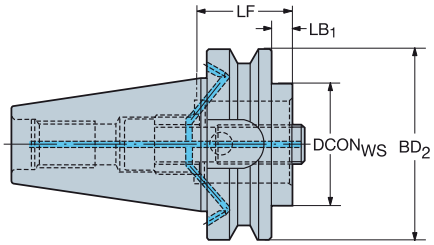
Machine side interface compatible with JIS B 6339



DSGN 1



DSGN 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

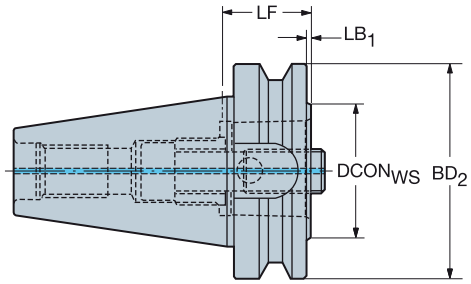
M1 N22 N15

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



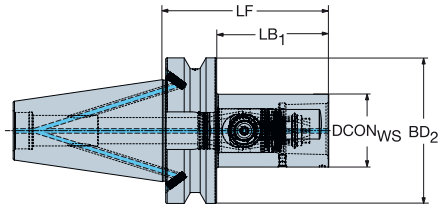


					Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LF	LB_1	BD_2	BAR PSI	NM	KG
40.0	C5	1	1	**C5-390.605-40 030**	50.0	M16	30.0	3.0	63.0	80	95.0	0.88
					1.969		*1.181*	*.118*	*2.480*	*1160*		
50.0	C6	1	1	**C6-390.605-50 040**	63.0	M24	40.0	2.0	100.0	80	170.0	3.26
					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

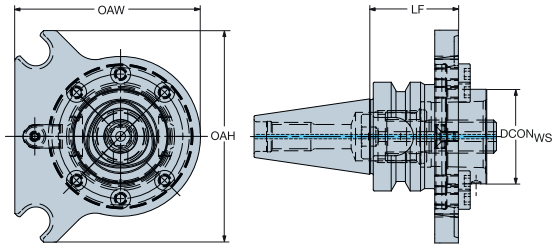
M1 N22 N15

MAS-BT 403 to Coromant Capto® turning adapter

For Brother Speedio mill-turn

Internal coolant supply

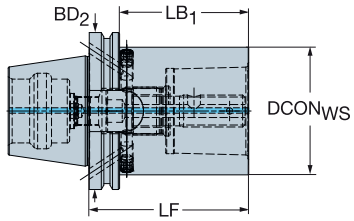




					Dimensions, mm, inch						
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	LF	OAW	OAH	BAR PSI	NM	KG
30	C4	1	1	**C4-390.680-30 050Y**	40	50	77	90	80	55	1.013
					1.575	1.969	3.032	3.543	1160		

MAS-BT short cone to Coromant Capto® adapter





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

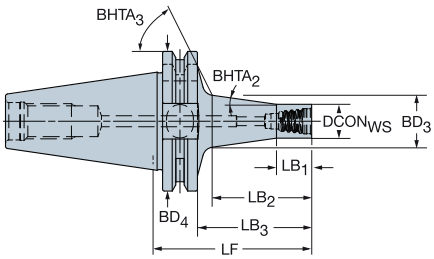
M1 N22 N15

MAS-BT 403 to Coromant EH adapter

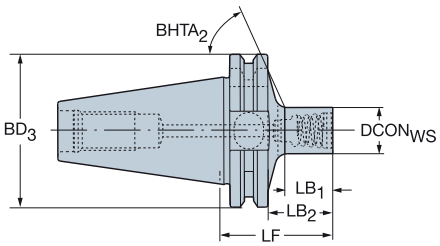
Machine side interface compatible with JIS B 6339



DSGN 15



DSGN 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*			

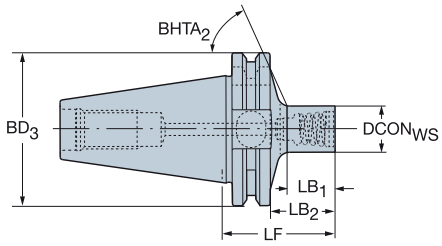
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15 N3

MAS-BT 403 to Coromant EH adapter

Machine side interface compatible with JIS B 6339





					Dimensions, mm, inch										
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LF	LB_1	LB_2	BD_3	$BHTA_2$	BAR PSI	NM	KG	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			

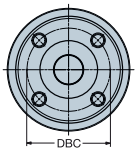
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15 N3

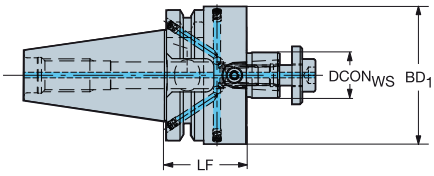
MAS-BT 403 to arbor adapter

Machine side interface compatible with JIS B 6339

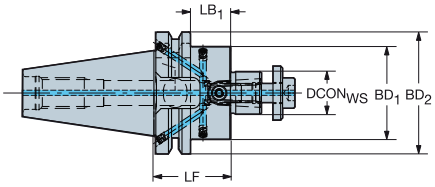




DSGN 1



DSGN 2



Metric pilot

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	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

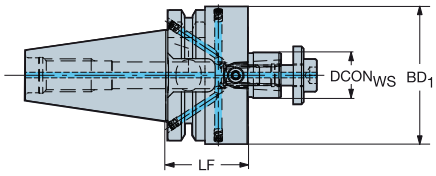
M1 N22 N15

MAS-BT 403 to arbor adapter

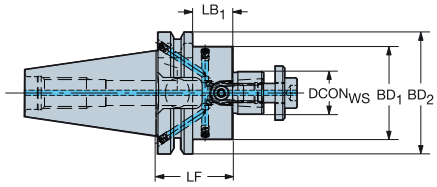
Machine side interface compatible with JIS B 6339



DSGN 1



2



Inch pilot

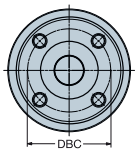
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm, inch DCON$_{WS}$	CRKS	LF	LB$_1$	LB$_2$	BD$_1$	BD$_2$	BAR PSI	NM	KG	RPMX
30.0	3/4	1	1	2	AA205-30 19 030	19.1	M12	30.2	8.1	30.1	44.5	46.0	80	25.0	0.58	25000
						.750		*1.190*	*.322*	*1.187*	*1.750*	*1.811*	*1160*			
	1	1	1	1	AA205-30 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

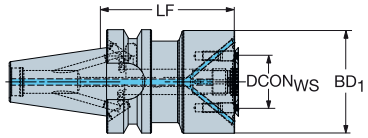
Machine side interface compatible with JIS B 6339

For CoroMill® QD with internal coolant supply

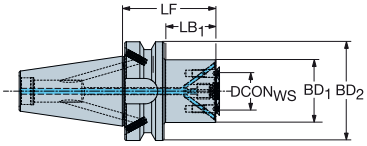




DSGN 1



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

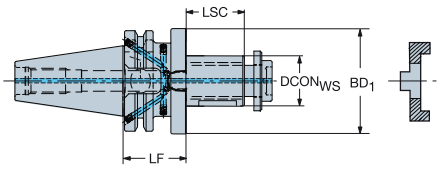
M1 N22 N15

MAS-BT 403 to side and face-mill arbor adapter

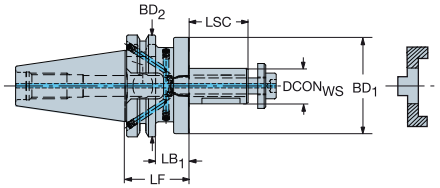
Machine side interface compatible with JIS B 6339



DSGN 1



2



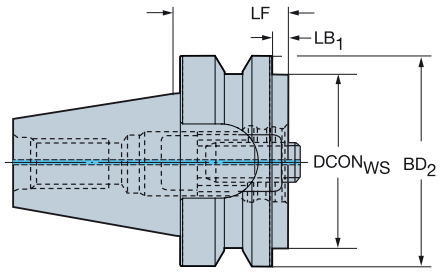
Metric pilot

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

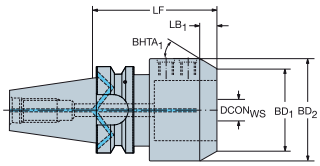
MAS-BT 403 to Weldon adapter

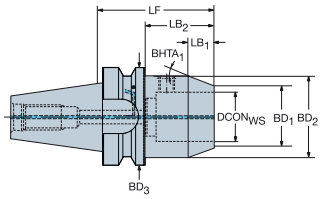
Machine side interface compatible with JIS B 6339

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

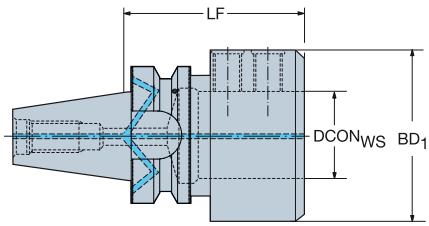
M1 N22 N15

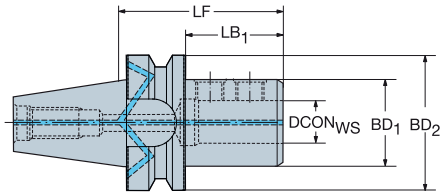
MAS-BT 403 to ISO 9766 adapter

Machine side interface compatible with JIS B 6339

DSGN 1 2







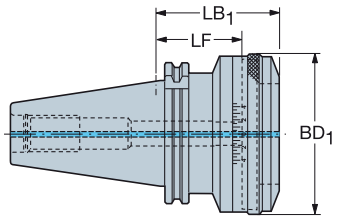
Metric bore

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

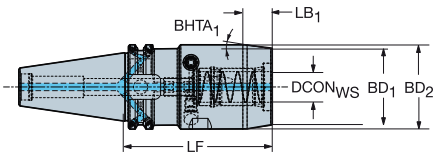
MAS-BT 403 to CoroChuck™ 930

Machine side interface compatible with JIS B 6339

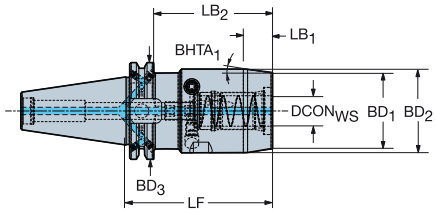
Heavy-duty design



DSGN 3



DSGN 6



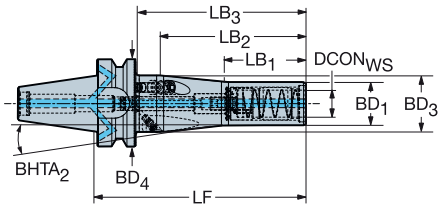
Metric bore

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-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*			

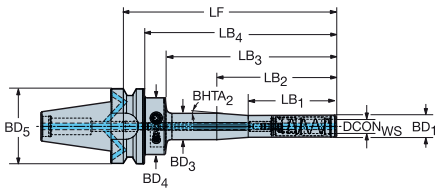
Pencil design



DSGN 11



DSGN 17



Metric bore

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$_3$	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*			

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M1 N22 N6 N15 N4

SANDVIK Coromant

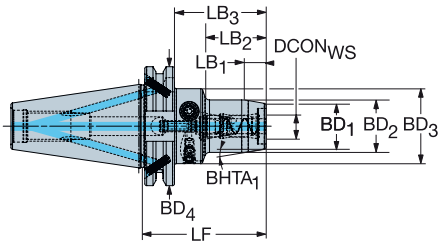
MAS-BT 403 to CoroChuck™ 930

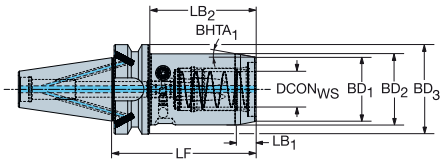
Machine side interface compatible with JIS B 6339

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*			

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M1 N22 N6 N15 N4

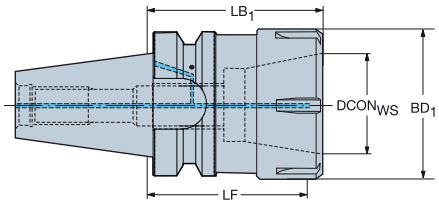
MAS-BT 403 to ER collet chuck

Machine side interface compatible with JIS B 6339

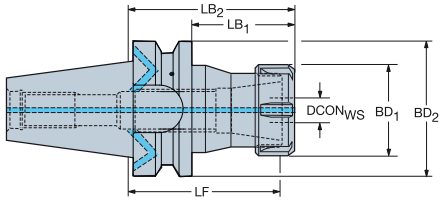
Workpiece side interface DIN 6499-B



DSGN 1



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	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		

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M1 N22 N15

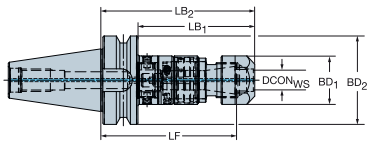
MAS-BT 403 to CoroChuck™ 970

Machine side interface compatible with JIS B 6339

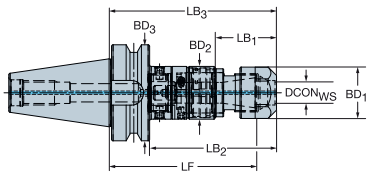
Workpiece side interface DIN 6499-B



DSGN 2



DSGN 5

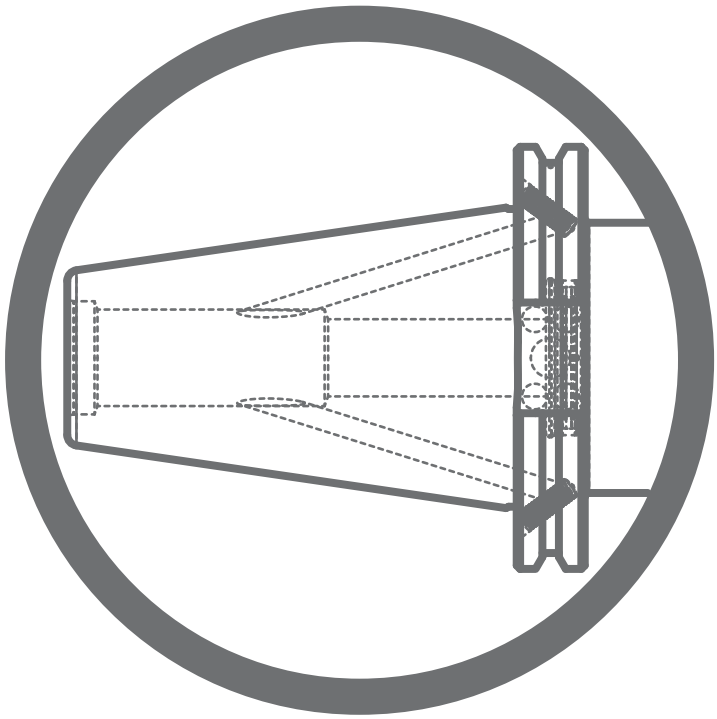


CZC$_{MS}$	CZC$_{WS}$	TRMAX	CNSC	CXSC	DSGN	Ordering code	Dimensions, mm, inch DCON$_{WS}$	CRKS	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_2$	BD$_3$	BAR PSI	KG	RPMX
30.0	ER11	M5	1	1	5	**970-B30-11-082**	11.3	M12	78.2	24.1	60.0	82.0	18.7	23.5	46.0	80	0.55	8000
							.445		*3.079*	*.949*	*2.362*	*3.228*	*.736*	*.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

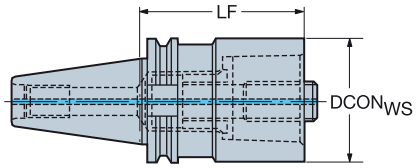


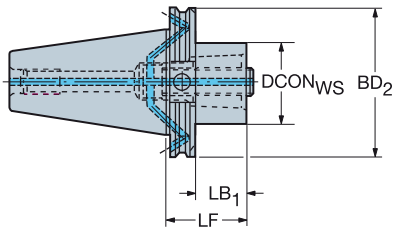
CAT-V to Coromant Capto® adapter

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*		

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

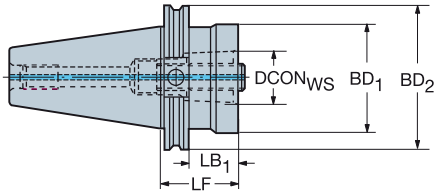
M1 N22 N15

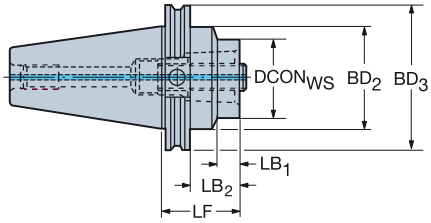
CAT-V to Coromant Capto® adapter

Machine side interface ASME B5.50-1985

DSGN 2 5





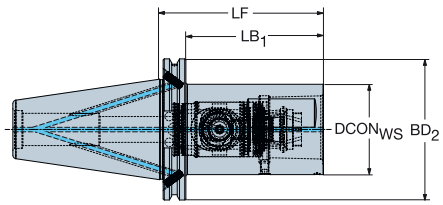


						Dimensions, mm, inch								BAR PSI	NM	KG
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{WS}$	CRKS	LF	LB_1	LB_2	LB_3	BD_2	BD_3			
45.0	C5	1	1	5	C5-A390.45-45 040	50.0	3/4"-10	40.0	2.8	20.9	40.0	57.4	82.6	80	45.0	1.86
						1.969		*1.575*	*.110*	*.823*	*1.575*	*2.260*	*3.252*	*1160*		
	C6	1	1	2	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



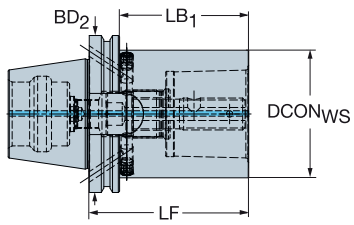


Metric bore

					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

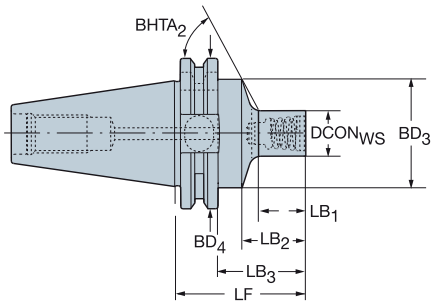
M1 N22 N6 N15

CAT-V to Coromant EH adapter

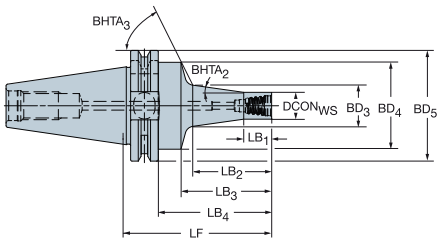
Machine side interface compatible with ASME B5.50-1985

DSGN 11





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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

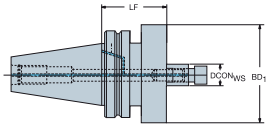
Machine side interface compatible with ASME B5.50-1985



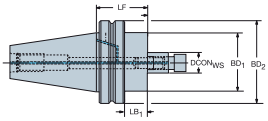
DSGN



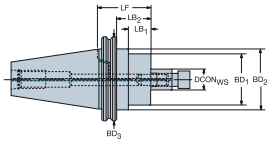
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Metric pilot

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

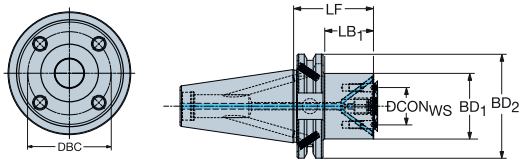
M1 N22 N15

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*			

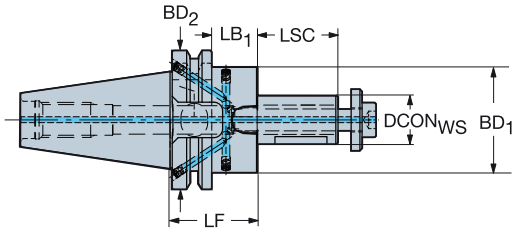
Inch pilot

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*			

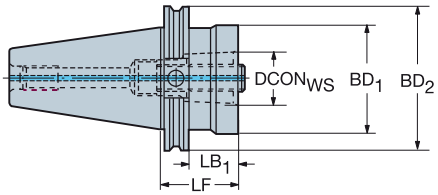
For spare parts, visit www.sandvik.coromant.com

M1 N22 N15

CAT-V to VL adapter

Machine side interface compatible with ASME B5.50-1985





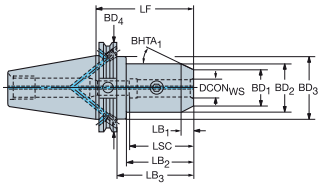
					Dimensions, mm, inch								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{WS}$	CRKS	LF	LB_1	LB_2	BD_2	BAR PSI	NM	KG
50.0	80	1	1	A390.45-50 80 050M	80.0	1"-8	50.0	30.9	50.0	98.4	20	180.0	3.68
					3.150		*1.969*	*1.217*	*1.969*	*3.874*	*290*		

CAT-V to Weldon adapter

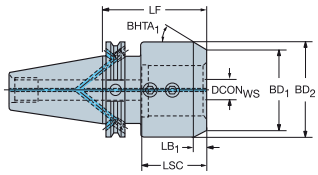
Machine side interface compatible with ASME B5.50-1985



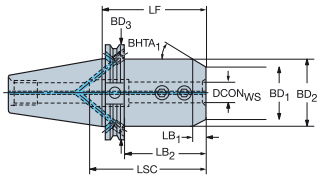
DSGN 10



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

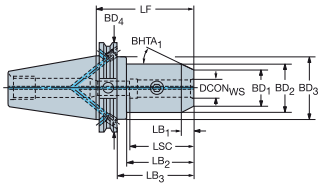
Machine side interface compatible with ASME B5.50-1985

Workpiece side interface ANSI B94.19

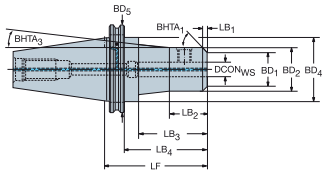
DSGN



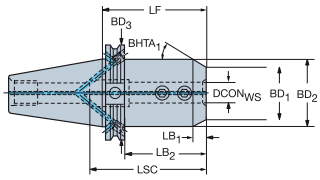
10



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

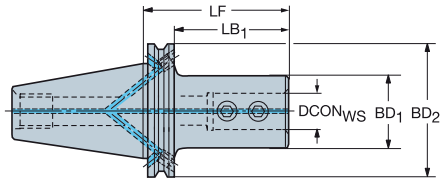


N15

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*			

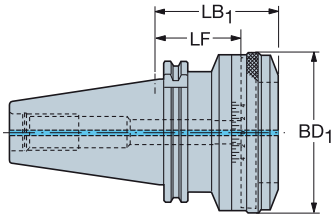
For spare parts, visit www.sandvik.coromant.com

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

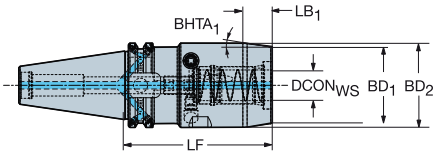
CAT-V to CoroChuck™ 930

Heavy-duty design

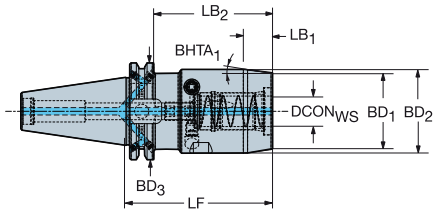
Machine side interface ASME B5.50-2009



DSGN 3



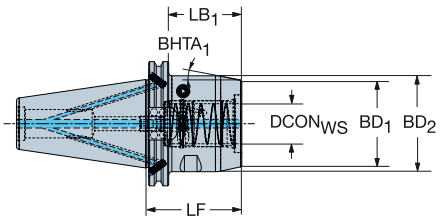
6



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-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*			

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

M1 N22 N6 N15 N4

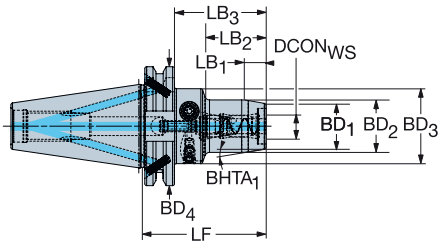
CAT-V to CoroChuck™ 930

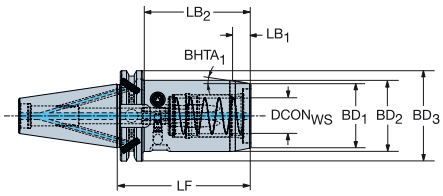
Slender design

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*			

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

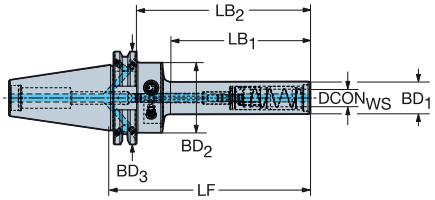
M1 N22 N6 N15 N4

CAT-V to CoroChuck™ 930

Pencil design

Machine side interface ASME B5.50-2009

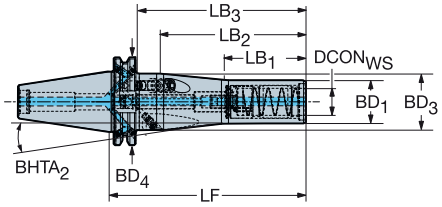




Metric bore

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*			

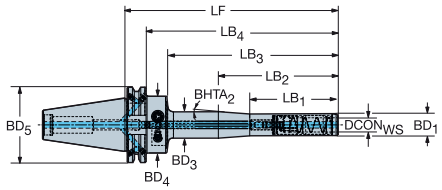




Metric bore

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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M1 N22 N6 N15 N4

SANDVIK Coromant

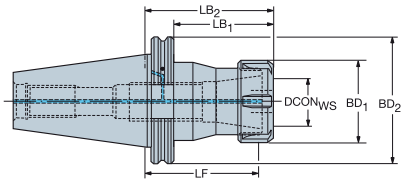
CAT-V to ER collet chuck

Machine side interface compatible with ASME B5.50-1985

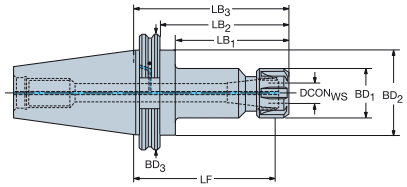
Workpiece side interface DIN 6499-B



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

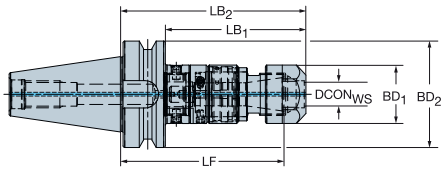
CAT-V to CoroChuck™ 970

Machine side interface ASME B5.50-2009

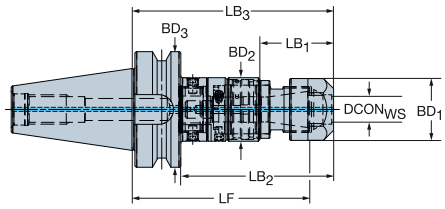
Workpiece side interface DIN 6499-B



DSGN 2



5

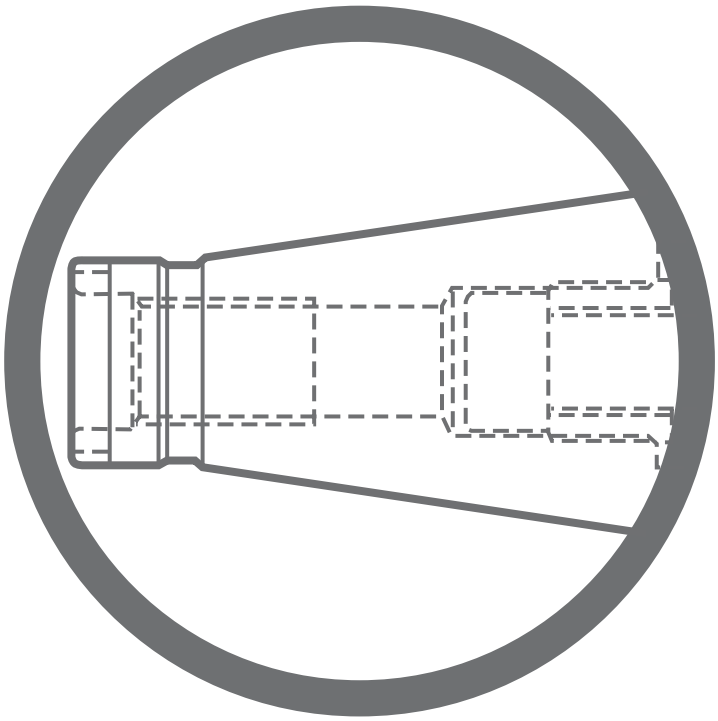


							Dimensions, mm, inch										
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	DSGN	**Ordering code**	$DCON_{WS}$	CRKS	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BD_3	BAR PSI	KG	RPMX
40.0	ER20	M12	1	1	2	**970-V40-20-102**	20.8	5/8"-11	89.2	35.3	78.2	97.2	33.7	35.0	63.5	80	1.27	8000
							.819		*3.512*	*1.390*	*3.079*	*3.827*	*1.327*	*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

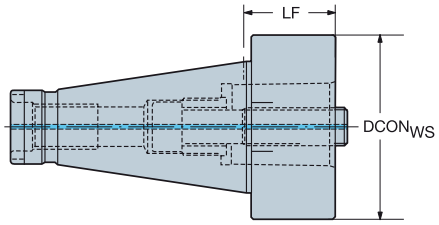
Machine side interface DIN 2080

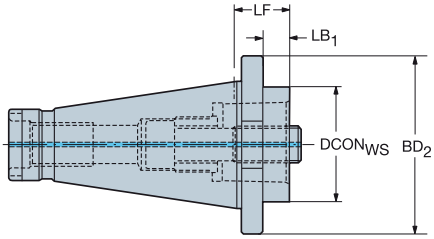


DIN 2080 to Coromant Capto® adapter

DSGN 1 2







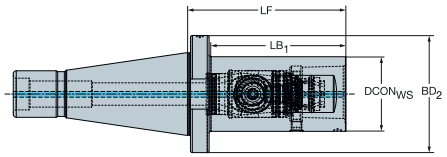
						Dimensions, mm, inch						BAR PSI	NM	KG
CZC_{MS}	CZC_{WS}	CNSC	CXSC	DSGN	Ordering code	$DCON_{WS}$	CRKS	LF	LB_1	LB_2	BD_2			
40.0	C3	1	1	2	C3-390.00-40 030	32.0	M16	30.0	18.4	30.0	63.0	80	45.0	0.86
						1.260		*1.181*	*.724*	*1.181*	*2.480*	*1160*		
	C4	1	1	2	C4-390.00-40 030	40.0	M16	30.0	18.4	30.0	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*		

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N22 N15

DIN 2080 to Coromant Capto® adapter with Quick change



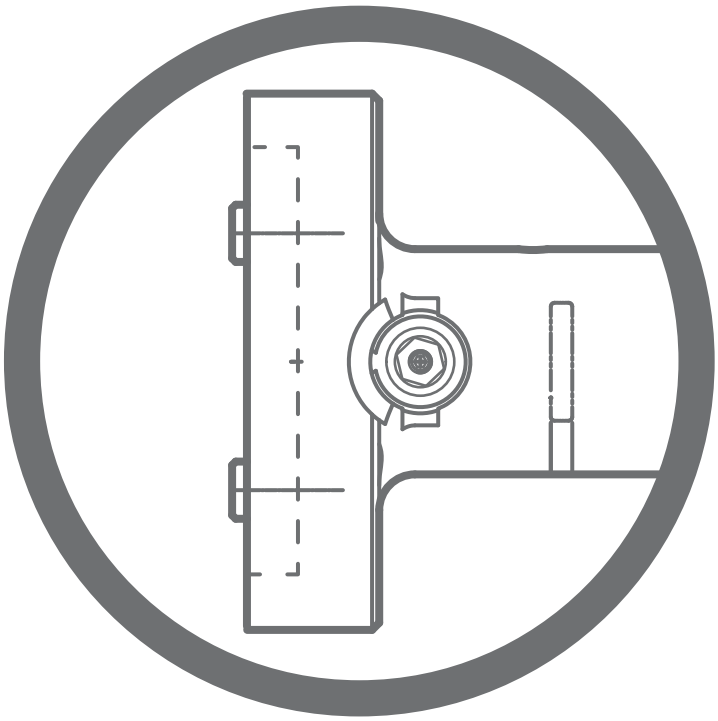


					Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{WS}$	CRKS	LF	LB_1	BD_2	BAR PSI	NM	KG
40.0	C5	1	1	**DN40-QC-C5-095**	50.0	M16	95.0	83.4	62.8	80	70.0	1.70
					1.969		*3.740*	*3.283*	*2.472*	*1160*		
50.0	C8	1	1	**DN50-QC-C8-140**	80.0	M24	140.0	124.8	97.3	80	130.0	6.30
					3.150		*5.512*	*4.913*	*3.831*	*1160*		

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

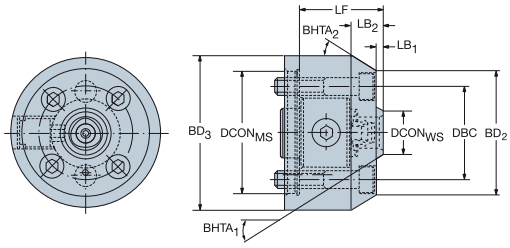
N22 N15

Machine side interface DIN 2079



DIN 2079 to Coromant Capto® adapter

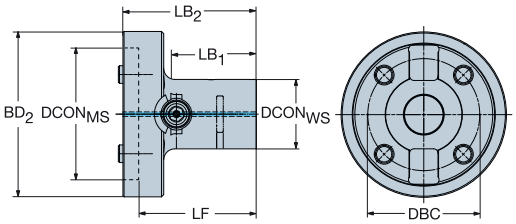




			Dimensions, mm, inch											
CZC_{MS}	CZC_{WS}	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	DBC	LF	LB_1	LB_2	BD_2	BD_3	$BHTA_1$	$BHTA_2$	NM	KG
40.0	C3	**C3-390.34705-40 060**	88.9	32.0	66.7	60.0	5.0	22.3	90.0	110.0	30°	30°	35.0	3.99
			3.499	*1.260*	*2.626*	*2.362*	*.197*	*.878*	*3.543*	*4.331*				
	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





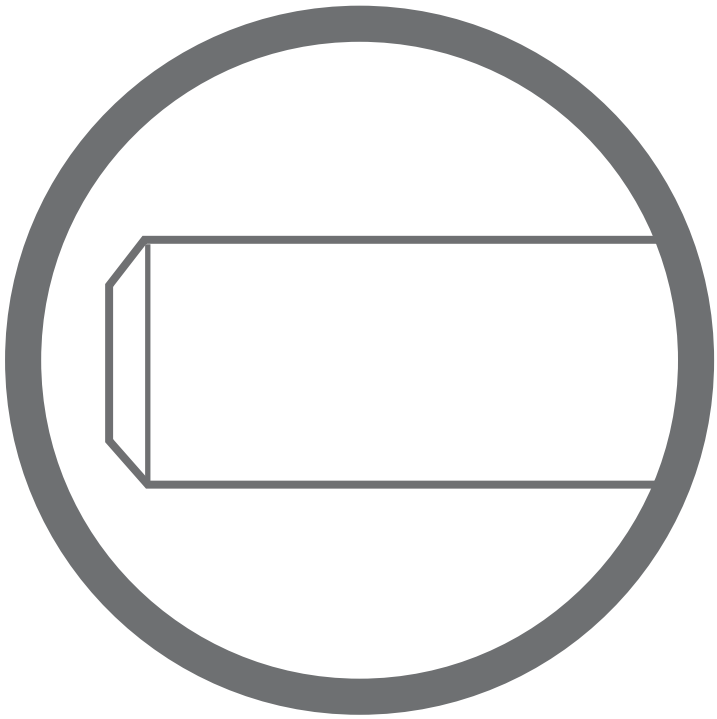
Metric version

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

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N22 N15

Machine-side interface cylindrical shank

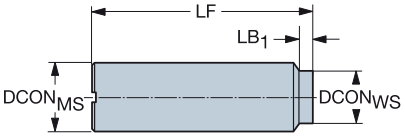


Cylindrical shank to Coromant EH adapter

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

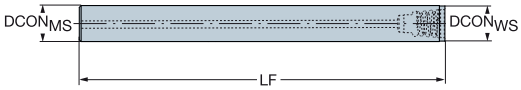
N22 N6 N15 N3

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

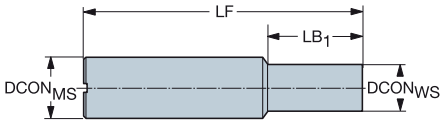
N22 N6 N15 N3

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

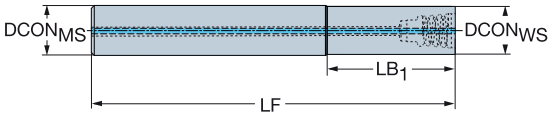
N22 N6 N15 N3

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

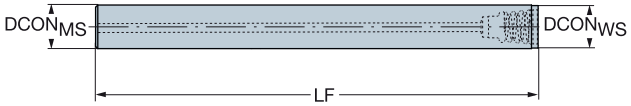
N22 N6 N15 N3

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

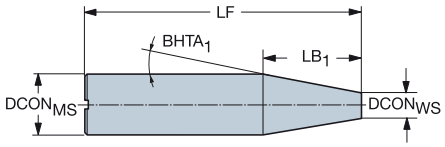
N22 N6 N15 N3

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

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

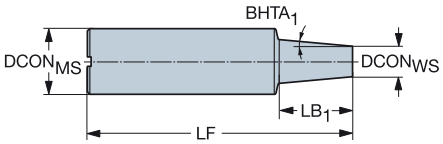
N22 N6 N15 N3

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

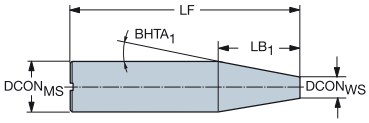
N22 N6 N15 N3

Cylindrical shank to Coromant EH adapter

Conical design

Inch version





Steel shank

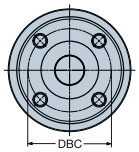
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LSC	LF	LB$_1$	BD$_2$	BHTA$_1$	BAR PSI	NM	KG	RPMX
5/8	E10	1	1	**AE10-A16-CS-055**	15.9	9.2	101	139.7	38.5	15.9	5°	80	12.0	0.23	17000
					.625	*.360*	*3.976*	*5.500*	*1.516*	*.625*		*1160*			
	E10	1	1	**AE10-A16-CS-065**	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*			

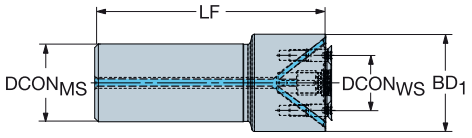
N22 N6 N15 N3

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*			

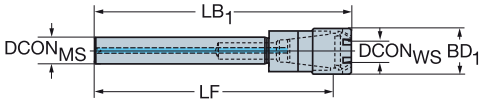
For spare parts, visit www.sandvik.coromant.com

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

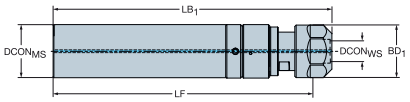
Cylindrical shank to CoroChuck™ 970

For synchronized tapping operations

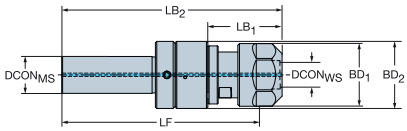
Workpiece side interface DIN 6499-B



DSGN 1



2



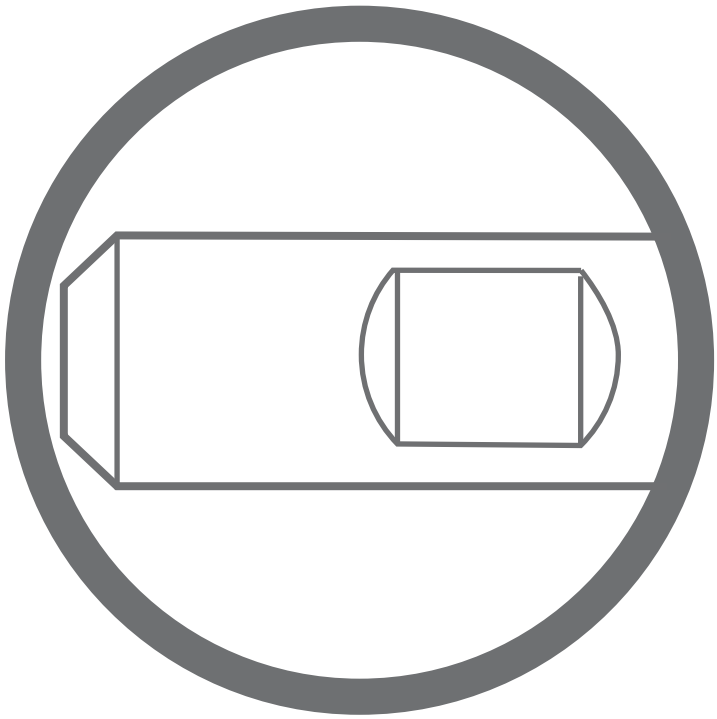
Metric version

							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

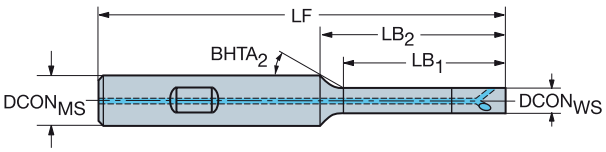
M1 N22 N15 N5

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

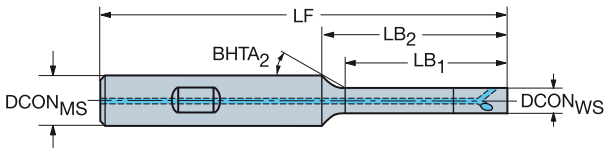
E = Cemented carbide shank

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

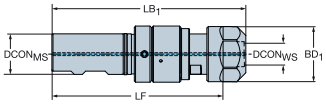
Weldon to CoroChuck™ 970

For synchronized tapping operations

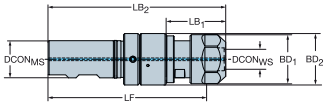
Workpiece side interface DIN 6499-B



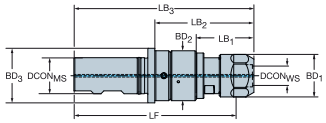
DSGN 1



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*		

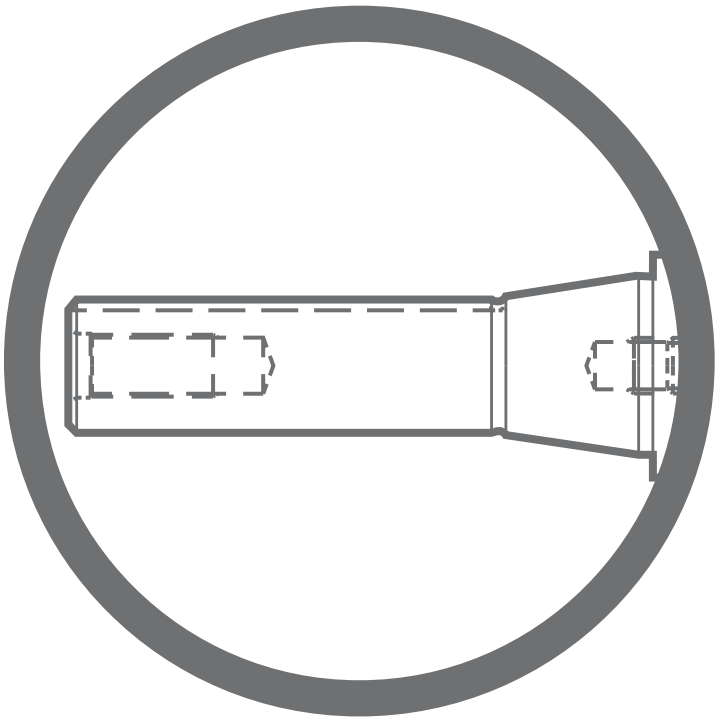
Inch version

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

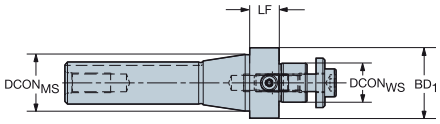
M1 N22 N15 N5

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*		

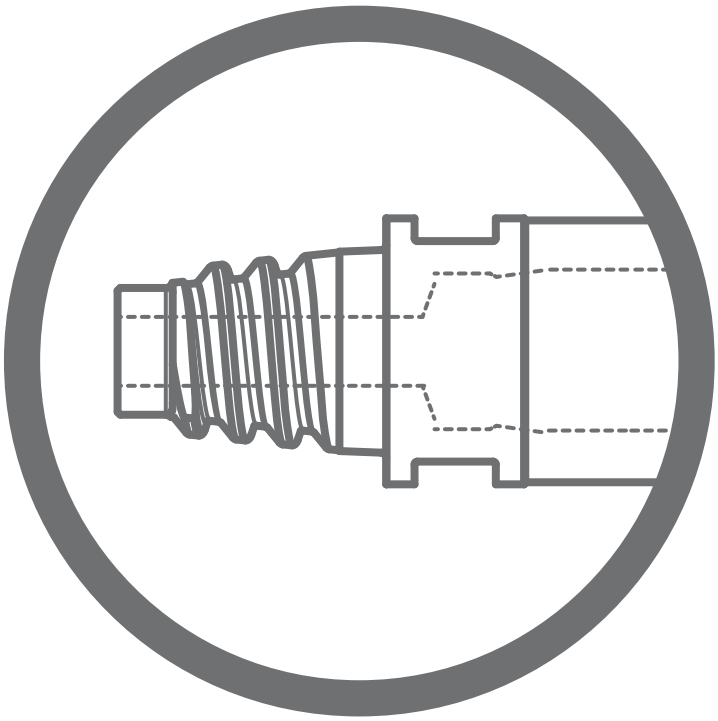
Inch pilot

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

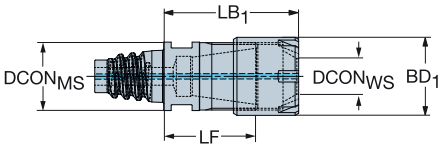
M1 N22 N15

Machine side interface Coromant EH



Coromant EH to ER adapter

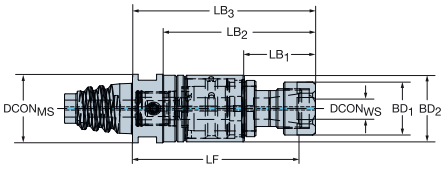




					Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	BD_1	BAR PSI	KG	RPMX
E12	ER8	1	1	**ER-EH12-08-024**	11.7	8.5	18.0	24.0	12.0	80	0.03	40000
					.461	*.335*	*.709*	*.945*	*.472*	*1160*		
E16	ER11	1	1	**ER-EH16-11-028**	15.5	11.4	20.5	28.0	16.0	80	0.04	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

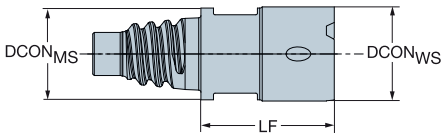




						Dimensions, mm, inch										
CZC_{MS}	CZC_{WS}	TRMAX	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	LB_2	LB_3	BD_1	BD_2	BAR PSI	KG	RPMX
E25	ER11	M5	1	1	**970-EH25-11-065**	24.2	11.3	59.8	25.1	53.6	64.6	18.7	23.5	80	0.16	8000
						.953	*.445*	*2.354*	*.988*	*2.110*	*2.543*	*.736*	*.925*	*1160*		

Coromant EH to CoroMill® 327 adapter



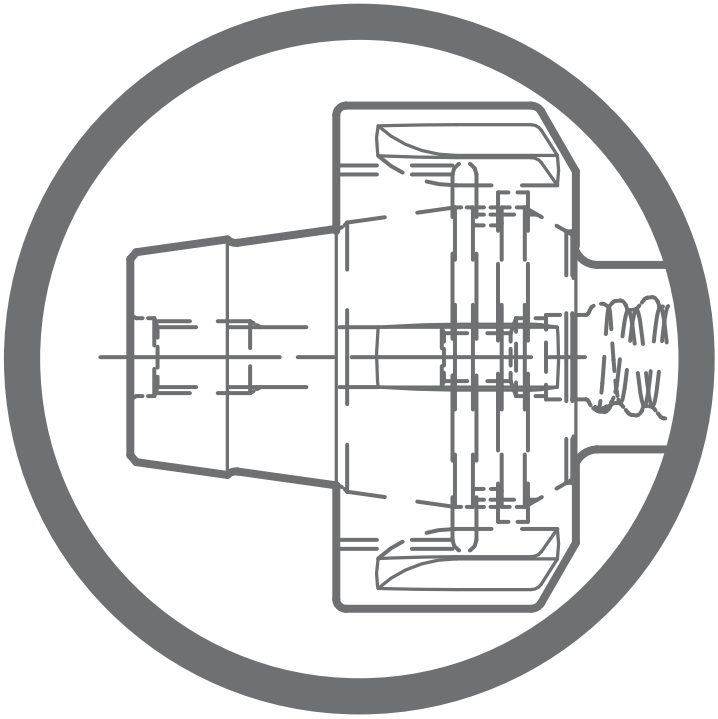


					Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	BD_1	BAR PSI	NM	KG	RPMX
E10	09	1	3	**327-EH10-09-015**	9.7	9.0	15.0	10.0	20	4.3	0.02	40000
					.382	*.354*	*.591*	*.394*	*290*			
E12	12	1	3	**327-EH12-12-017**	11.7	12.0	17.0	12.0	20	6.5	0.02	40000
					.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

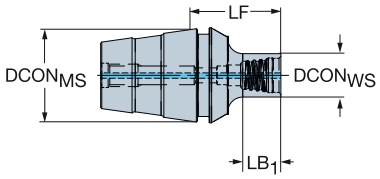
Machine side interface ER



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*			

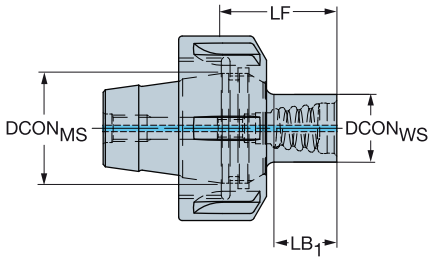
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15 N3

ER to Coromant EH adapter

Machine side interface DIN 6499-B





Metric version

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

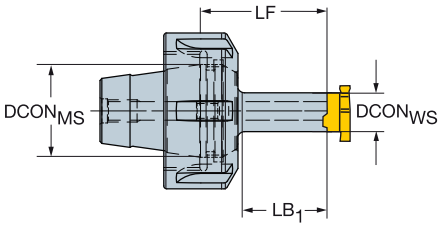
For spare parts, visit www.sandvik.coromant.com

M1 N22 N6 N15 N3

ER to CoroMill® 327 adapter

Machine side interface DIN 6499-B



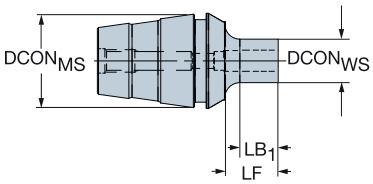


			Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	BD_1	NM	KG	RPMX
ER11	09	392.ER327-11 09 022	11.4	9.0	25.0	16.0	9.0	4.3	0.07	40000
			.449	*.354*	*.983*	*.632*	*.354*			
ER16	09	392.ER327-16 09 022	17.0	9.0	26.8	16.2	9.0	4.3	0.15	40000
			.669	*.354*	*1.054*	*.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!



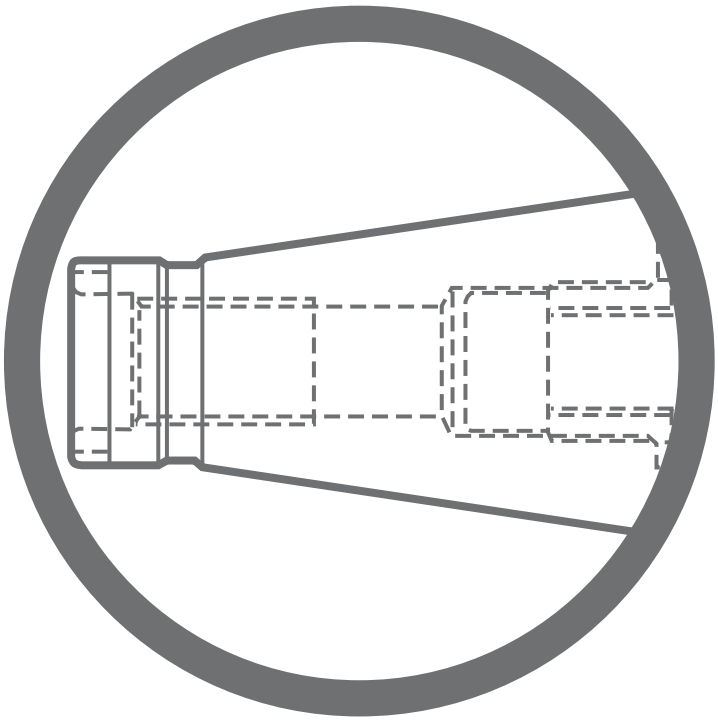


			Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	Ordering code	$DCON_{MS}$	$DCON_{WS}$	LF	LB_1	BD_1	NM	KG	RPMX
ER11	06	327-ER11-06-016	11.4	6.0	17.5	12.8	6.0	1.8	0.03	40000
			.449	*.236*	*.689*	*.504*	*.236*			
ER20	09	327-ER20-09-022	21.0	9.0	24.7	16.5	9.0	4.3	0.09	40000
			.827	*.354*	*.970*	*.652*	*.354*			
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

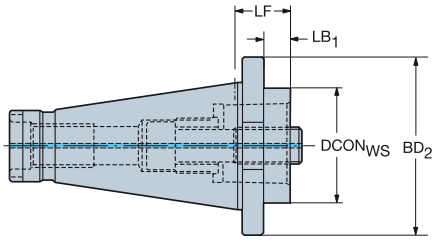
M1 N22

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*		

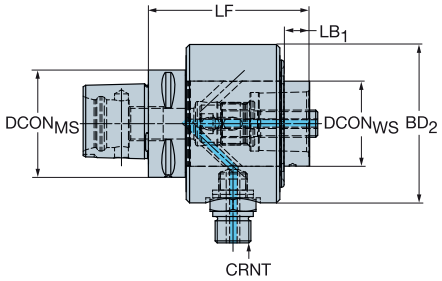
For spare parts, visit www.sandvik.coromant.com

N22 N15

Coromant Capto® reduction adapter

Coolant inducer



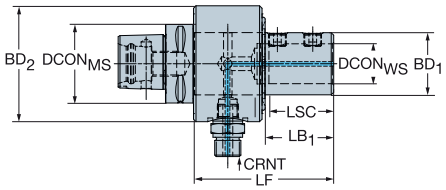


CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	BD$_2$	CRNT	BAR PSI	NM	KG	RPMX
C5	C4	2	1	C5-391.02CCH-40 090	50.0	40.0	90.0	16.5	78.0	G 3/8"	18	55.0	1.96	6300
					1.969	*1.575*	*3.543*	*.650*	*3.071*		*261*			
C6	C5	2	1	C6-391.02CCH-50 095	63.0	50.0	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.



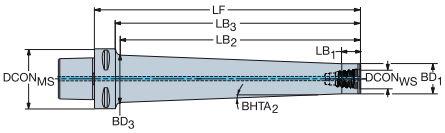
www.sandvik.coromant.com/silenttools



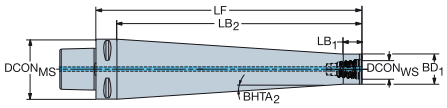
The dampening system consists of a heavy mass supported on rubber spring elements

Coromant Capto® to Coromant EH damped adapter

DSGN 12



DSGN 7





SilentTools®

						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_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

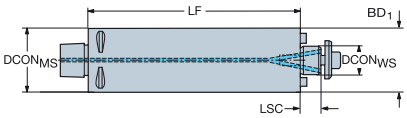
N22 N6 N15 N3

Coromant Capto® to arbor damped adapter

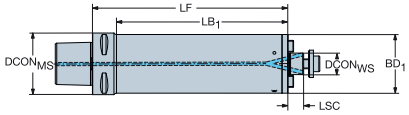
DSGN



1



2



SilentTools®

Metric pilot

						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	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*			

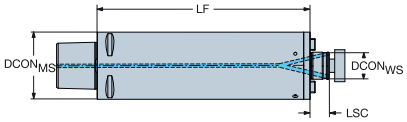
For spare parts, visit www.sandvik.coromant.com

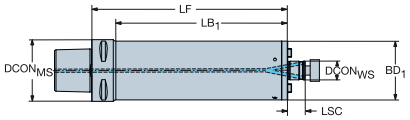
M1 N22 N15

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*			

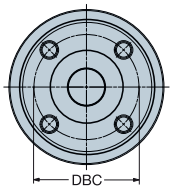
For spare parts, visit www.sandvik.coromant.com

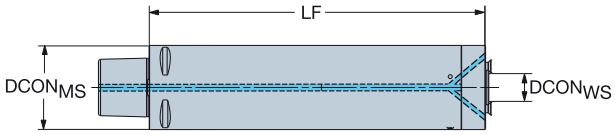
M1 N22 N15

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

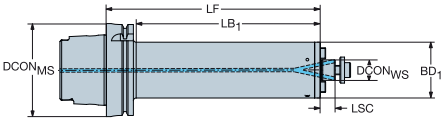
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	DBC	LSC	LF	BAR PSI	NM	KG	RPMX
C5	Y25	3	3	C5-Y25D-050-200	50.0	25.4	36.0	2	200.0	70	3.9	3.67	12000
					1.969	*1.000*	*1.417*	*.094*	*7.874*	*1015*			
C6	Y31	3	3	C6-Y31D-063-252	63.0	31.8	45.0	2	252.0	70	6.4	9.27	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

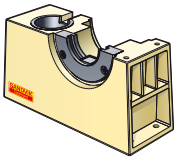
Coromant Capto program includes machine interface adapters, clamping units, tool holders, integrated cutting tools, adapters, and chucks.



Assembly fixture

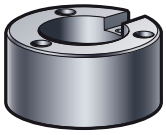
Fixture body
Ordering code:

391.500



Fixture body for sleeves
Ordering code:

391.501



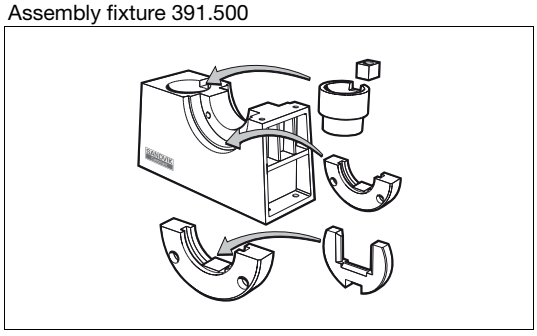
Ordering code	
	
Sleeve	**For holder type, size**
391.540-C3	Coromant Capto Size C3
391.540-C4	Coromant Capto Size C4
391.540-C5	Coromant Capto Size C5
391.540-C6	Coromant Capto Size C6
391.540-C8	Coromant Capto Size C8
391.540-C10	Coromant Capto Size C10
391.540-HA04	HSK 40 Form A/C
391.540-HA05	HSK 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.

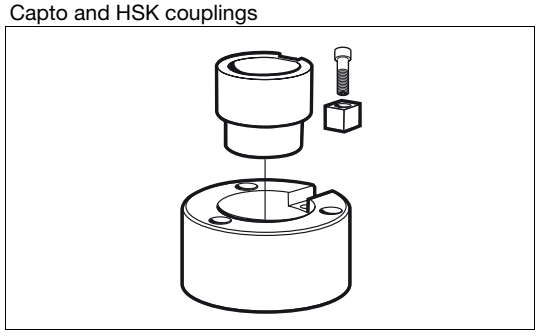
* Combined collar and flange

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.

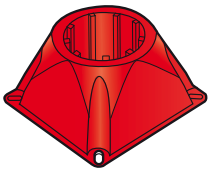
Molded tool holders - to be ordered separately

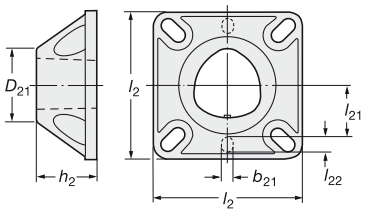


Ordering code	Width (B)	Max. number of coupling sizes
C3-IC-1	58	C3 = 9
C4-IC-1	58	C4 = 9
C5-IC-1	65.5	C5 = 8
C6-IC-1	81.5	C6 = 6
C8-IC-1	105	C8 = 5
C10-IC-1	120	C10 = 4

Cassettes (polygon seating)

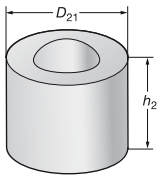
Coromant Capto®



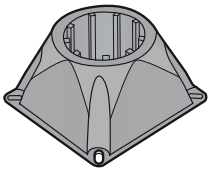


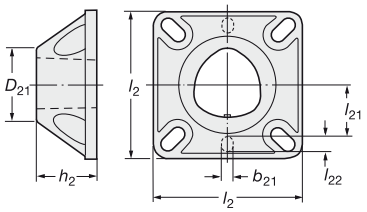
-4000
Plastic storage cassettes (red)

-6000-B



Aluminum cassette blanks



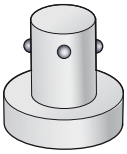


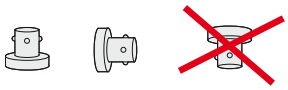
-5000
High grade plastic in-machine tool storage (black)

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

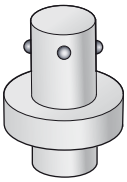


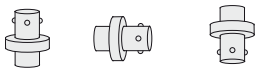


Passive locking mechanism

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	

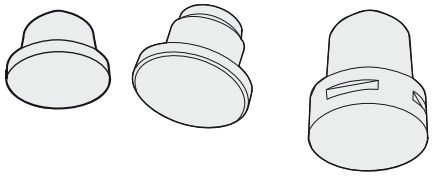
CZC	**Ordering code**	Rec. max. tool weight, Kg	Rec. max. tool weight lbs	
C4	**C4-AL-01**	40	88	Active locking mechanism – mechanical push action. Fits directly into all cassettes type 5000/6000.
C5	**C5-AL-01**	60	132	
C6	**C6-AL-01**	75	165	
C8	**C8-AL-01**	110	243	
C10	**C10-AL-01**	150	330.7	

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

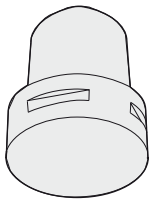
CP-11 CP-01 CPA-01



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



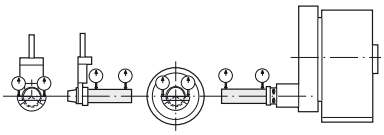
Coupling size	**Ordering code**
C3	**C3 - BAT - 01**
C4	**C4 - BAT - 01**
C5	**C5 - BAT - 01**
C6	**C6 - BAT - 01**
C8	**C8 - BAT - 01**
C10	**C10 - BAT - 01**

Assembly item

Master setting gauges

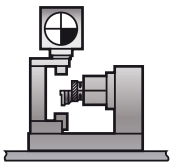
Checking position for grippers

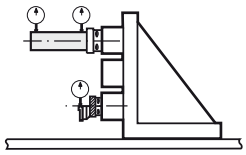
Spindle orientation



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





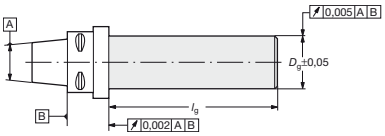
- The centerline of the tool post Spindle orientation The position of the tool for grippers Tool center height and cutting edge position (f1 and l1 dimensions). Gauges can be used in a pre-measuring fixture. Component fixtures

Tool presetting

Component fixture geometric control

Axial gauge

Master setting gauges MAS-11

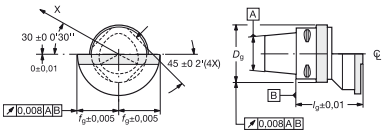


Coupling size	Ordering code	Dimensions, mm (inch) D_g	l_g
C3	**C3-MAS-11**	25 (.98)	160 (6.30)
C4	**C4-MAS-11**	25 (.98)	160 (6.30)
C5	**C5-MAS-11**	32 (1.26)	210 (8.27)
C6	**C6-MAS-11**	40 (1.57)	315 (12.40)
C8	**C8-MAS-11**	40 (1.57)	315 (12.40)
C10	**C10-MAS-11**	60 (2.362)	420 (16.535)

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)

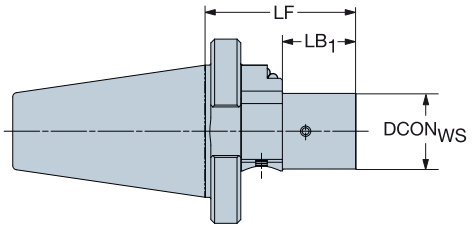
Center height gauge

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

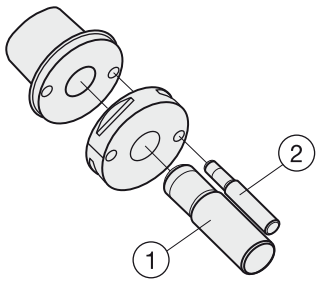




CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	**Ordering code**	Dimensions, mm, inch DCON$_{WS}$	LF	LB$_1$
50	C3	0	0	**C3-PMU-I50**	32	75	36
					1.260	2.953	1.417
	C4	0	0	**C4-PMU-I50**	40	80	39
					1.575	3.150	1.535
	C5	0	0	**C5-PMU-I50**	50	90	45
					1.969	3.543	1.772
	C6	0	0	**C6-PMU-I50**	63	107	56
					2.480	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

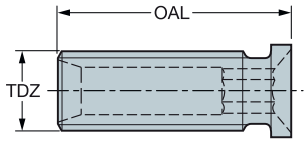
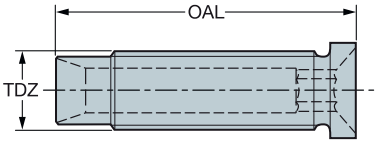


Fig. 2



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

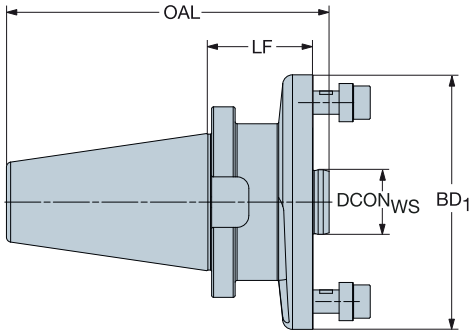
Adjustment screws for MQL tap holder Corochuck 970-HAxxQ-xx-xxx

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

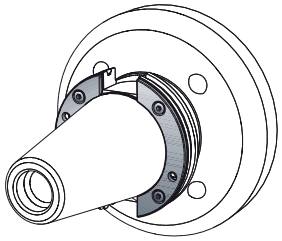
CoroBore® XL pre-measuring unit

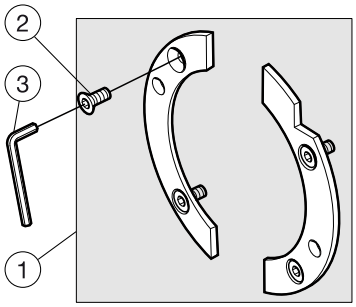




				Dimensions, mm, inch				
CZC_{MS}	CZC_{WS}	CNSC	**Ordering code**	OAL	DCON	LF	BD_1	KG
50	33	0	**I50-PMU-A33**	178.30	33	50.0	130.0	5.59
				7.019	*1.299*	*1.969*	*5.118*	

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



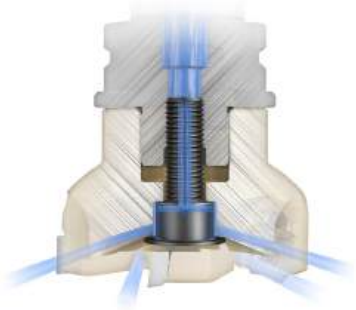


Metric

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) 3021 010-120 (12.0)
40	5512 098-03	(M20)	3021 010-060 (6.0) 3021 010-120 (12.0)

Inch

Arbor size	Screw		Key
1.250	5512 099-05	(5/8"-18UNF)	3021 010-060 (6mm) 3021 011-916 (9/16")
1.500	5512 099-03	(3/4"-16UNF)	3021 011-140 (1/4") 3021 011-916 (9/16")

Coolant screw and washer to CoroMill® 331



Metric

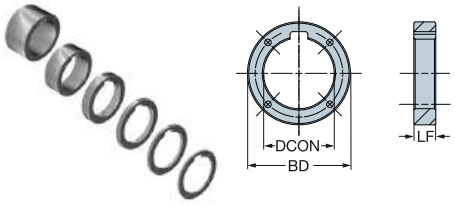
Set code	Screw	Washer code	Arbor size
5512 076-101	5512 076-01	5549 210-01	27
5512 076-102	5512 076-02	5549 210-02	32
5512 076-103	5512 076-03	5549 210-03	40

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



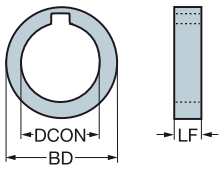
Metric, mm	LF	0.5	1	1.5	2	3	4	5	6	10	20	30
Set code	DCON	BD	BD	BD	BD	BD	BD	BD	BD	BD	BD	BD
5549 091-032	27	39	39	39	41	41	41	41	41	41	41	41
5549 091-042	32	45	45	45	47	47	47	47	47	47	47	47
5549 091-052	40	54	54	54	55	55	55	55	55	55	55	55

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

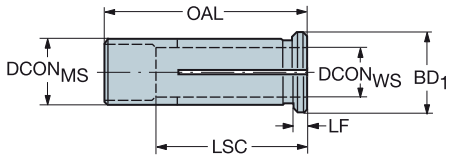
Set without hole

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	

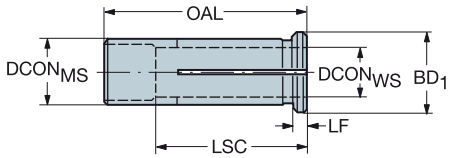
LSC Clamping length required to achieve sealing effect.
For extractors for cylindrical collets, see page M21.

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	

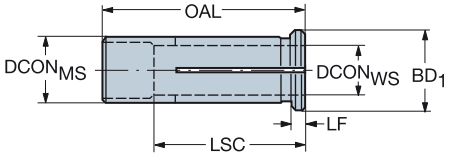
LSC Clamping length required to achieve sealing effect.
For extractors for cylindrical collets, see page M21.

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

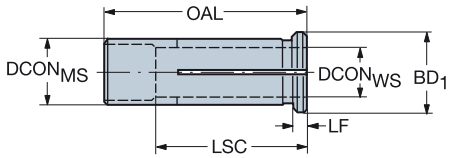
For extractors for cylindrical collets, see page M21.

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

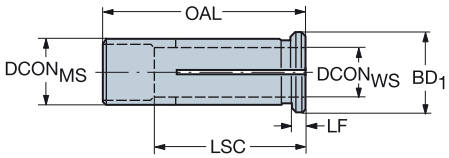
For extractors for cylindrical collets, see page M21.

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	

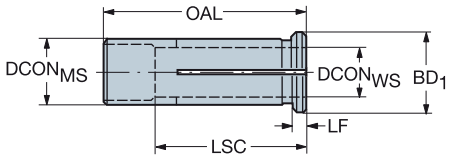
For extractors for cylindrical collets, see page M21.

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	

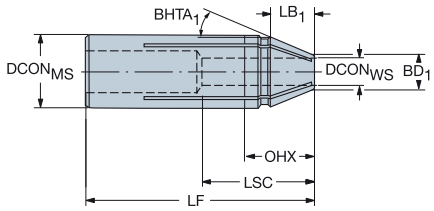
For extractors for cylindrical collets, see page M21.

N22 N15

Cylindrical sleeves

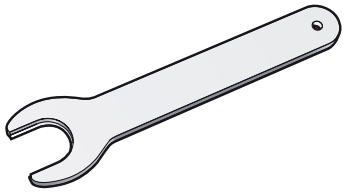
Pencil type





					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



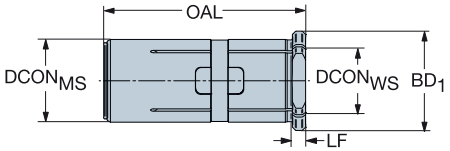
	For collet size	
Ordering code	Metric	Inch
5680 061-01	12	13 (1/2")
5680 061-02	16	15 (5/8")
5680 061-03	20	19 (3/4")
5680 061-04	25	26 (1")
5680 061-05	32	31 (1 1/4")

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

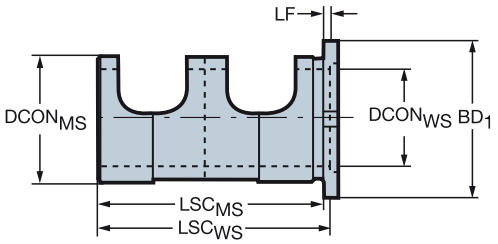
Application	Ordering code	Dimensions, inch					Accessories	
		$DCON_{WS}$	$DCON_{MS}$	BD_1	LF	OAL	Anchor screw	Assembly tool
CoroChuck™ 930 HD32	A393.CLF-321060	5/8	1.260	1.417	.157	2.559	5519 140-02	5680 140-02
	A393.CLF-321260	3/4	1.260	1.417	.157	2.559		
	A393.CLF-321660	1	1.260	1.417	.157	2.559		
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

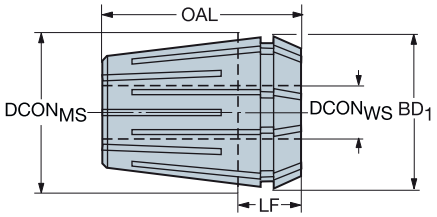
N22 N15

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*	

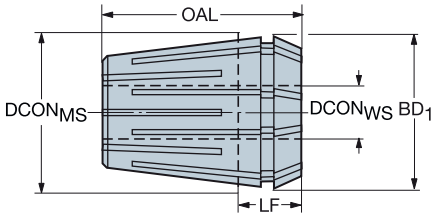
N22 N15

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*	

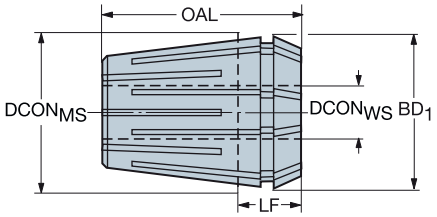
N22 N15

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

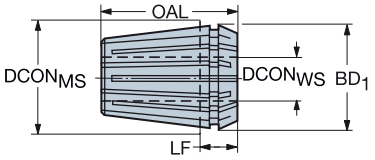
N22 N15

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*	

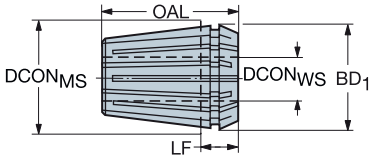
N22 N15

ER collet

Coolant through collet

Compatible with DIN 6499-B





					Dimensions, mm, inch								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	Ordering code	$DCON_{MS}$	$DCONN_{WS}$	$DCONX_{WS}$	BD	LSC	OAL	LF	BAR PSI	KG
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*	

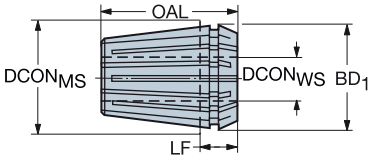
N22 N15

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



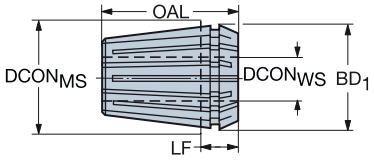
N15

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*	

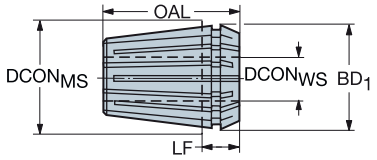
N22 N15

ER collet

Coolant through collet

Compatible with DIN 6499-B





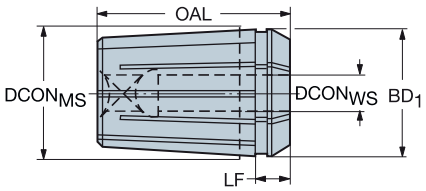
					Dimensions, mm, inch								
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCONN_{WS}$	$DCONX_{WS}$	BD	LSC	OAL	LF	BAR PSI	KG
ER50	26.0 - 24.0	1	4	**393.14-50 260**	52	24.0	26.0	52	60.0	60	21	300	0.478
					2.047	*.945*	*1.024*	*2.047*	*2.362*	*2.362*	*.830*	*4351*	
	28.0 - 26.0	1	4	**393.14-50 280**	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





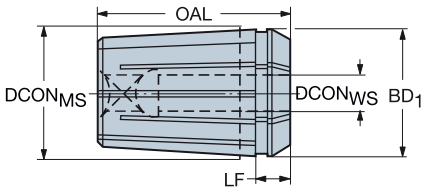
					Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	BD	LSC	OAL	LF	BAR PSI	KG
ER11	4.00 x 3.15	1	4	393.14-11 D040X0315	11	4	11	14.0	18	4	300	0.009
					.445	*.157*	*.449*	*.551*	*.709*	*.177*	*4351*	
	2.50 x 2.00	1	4	393.14-11 D025X021	11	2	11	12.0	18	4	300	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*	

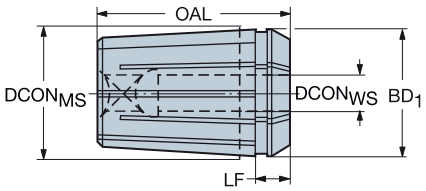
N22 N15

ER Collet for tap shank

For inch standard taps

Compatible with DIN 6499-B





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

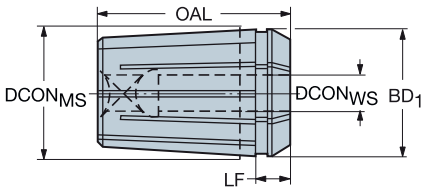
N22 N15

ER Collet for tap shank

For inch standard taps

Compatible with DIN 6499-B

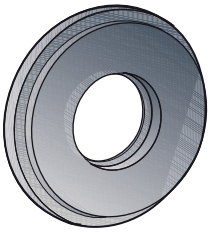


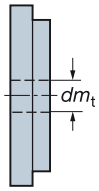


					Dimensions, mm, inch							
CZC_{MS}	CZC_{WS}	CNSC	CXSC	**Ordering code**	$DCON_{MS}$	$DCON_{WS}$	BD	LSC	OAL	LF	BAR PSI	KG
ER40	.480 x .360	1	4	**A393.14-40-5/8**	40	12	41	25.0	46	11	300	0.280
					1.606	.480	1.614	.984	1.811	.437	4351	
	.542 x .406	1	4	**A393.14-40-M18**	40	13	41	25.0	46	11	300	0.275
					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	

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ER Collet sealing discs



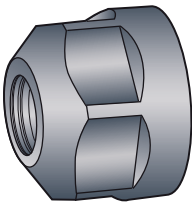


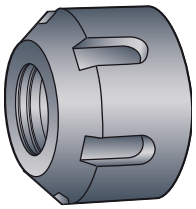
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Range, mm (inch) dm_t		Ordering code	Range, mm (inch) dm_t		Ordering code	Range, mm (inch) dm_t		Ordering code	Range, mm (inch) dm_t		Ordering code
3.0-2.5	(.118-.098)	3916.00300	6.0-5.5	(.236-.217)	3925.00600	3.0-2.5	(.118-.098)	3932.00300	6.0-5.5	(.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
						20.0-19.5	(.787-.768)	3932.02000	25.0-24.5	(.984-.965)	3940.02500

Size 20		
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

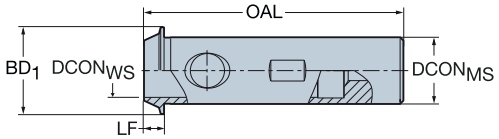




CZC	Ordering code	TDZ	Wrench	
ER16	5533 051-01	M22 x 1.5	5680 091-01	
ER20	5533 051-02	M25 x 1.5	5680 091-02	
ER25	5533 051-03	M32 x 1.5	5680 096-02	
ER32	5533 051-04	M40 x 1.5	5680 096-03	
ER40	5533 051-05	M50 x 1.5	5680 096-04	

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*	

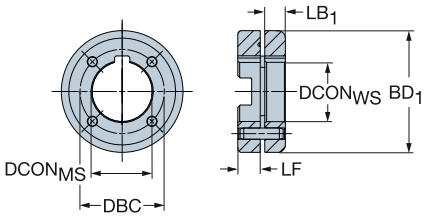
To be used with R429U/R429.90 boring bars

L2 N22 N15

Assembly item

Driving collar for CoroMill® QD





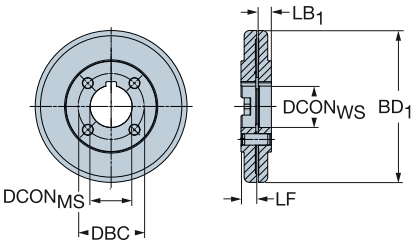
Metric version

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

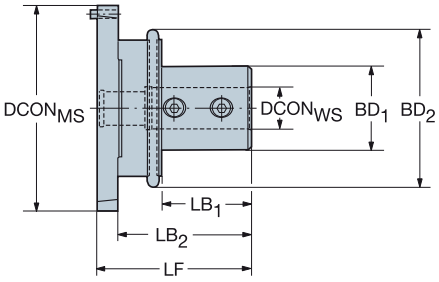
Inch version

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

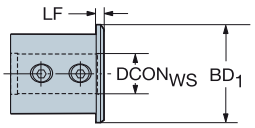
CZC$_{MS}$	CZC$_{WS}$	CNSC	CXSC	Ordering code	Dimensions, mm, inch DCON$_{MS}$	DCON$_{WS}$	LF	LB$_1$	LB$_2$	LB$_3$	BD$_1$	BD$_2$	BD$_3$	BAR PSI	NM	KG
1.0	20	1	1	393.277-20 01 075A	78.0	20.0	75.0	44.0	65.0	75.0	40.0	55.2	78.0	20	12.0	0.85
					3.071	*.787*	*2.953*	*1.732*	*2.559*	*2.953*	*1.575*	*2.173*	*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

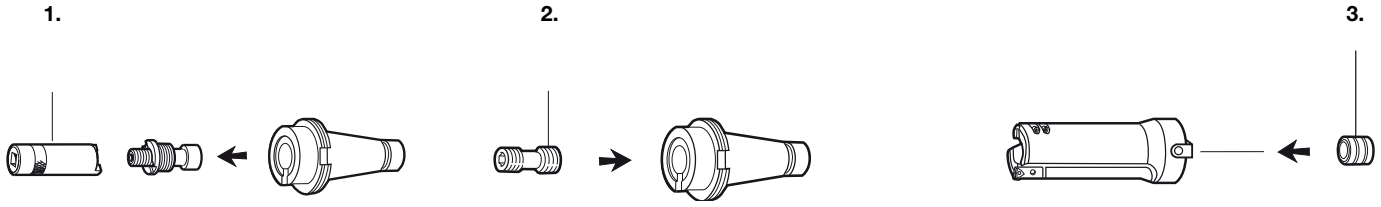
Sleeve



					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



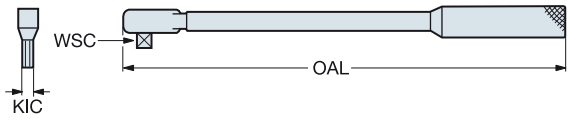
1. Ordering code Key	2. Ordering code Screw	3. Ordering code Centering sleeve
5680 065-02	5516 030-01	5638 030-01

N22 N15

Assembly tools

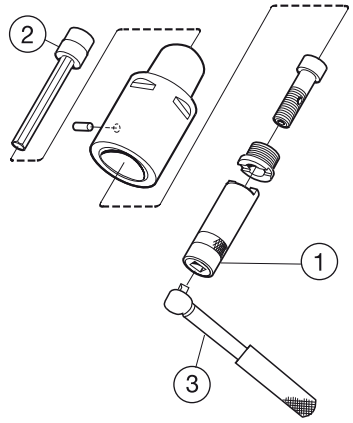
Coromant Capto®

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



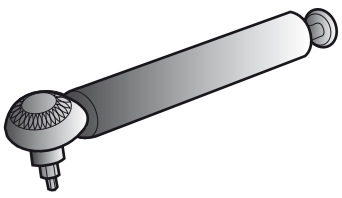
Ordering code	ER size	MDI size	Bits interface
5680 103-04	ER 25		16
5680 103-05	ER 32	20	16
5680 103-06	ER 40	25	16
5680 103-07		32	16
5680 103-08		40	16
5680 103-09		50	16

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



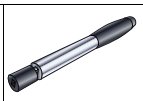
Ordering code
5680 099-01

Assembly tools

Coromant EH

Main spare parts





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

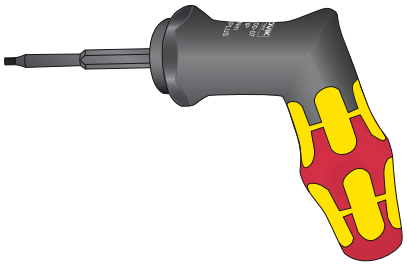
Correct torque when mounting the inserts in milling cutters is a prerequisite for a well functioning tool. Together with the Torx Plus screws, the new wrench guarantees improved and secure insert clamping.

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

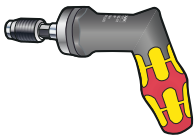
Torque wrench	Size	Torque in.lbs	Torque Nm	
5680 100-01	6IP	4	0.6	
5680 100-02	7IP	8	0.9	
5680 100-03	8IP	10	1.2	
5680 100-04	9IP	12	1.4	
5680 100-05	10IP	18	2.0	
5680 100-06	15IP	26	3.0	
5680 100-07	20IP	44	5.0	
5680 100-08	25IP	66	7.5	
5680 100-09	HEX 5	53	6.0	
5680 100-10	20IP	53	6.0	

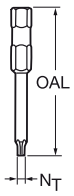
Torque wrench and bits

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

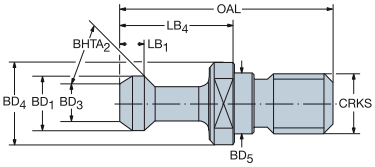
Bit	OAL mm	OAL inch	N_T Torx Plus
5680 084-01	50	1.969	8IP
5680 084-02	50	1.969	15IP
5680 084-03	89	3.504	15IP
5680 084-04	50	1.969	7IP
5680 084-05	50	1.969	9IP
5680 084-06	50	1.969	10IP
5680 084-07	50	1.969	20IP
5680 084-08	89	3.504	20IP
5680 084-09	89	3.504	25IP
5680 084-10	89	3.504	30IP
5680 084-11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

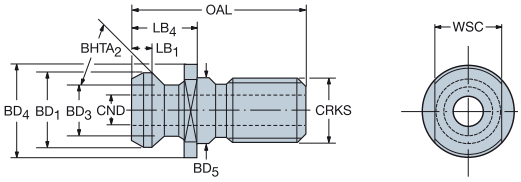
Pull stud



PS-Vxx



PS-VxxC



CAT-V

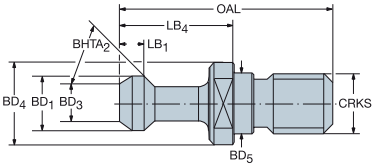
CZC	CRKS	CNSC	CXSC	Ordering code	Dimensions, mm, inch WSC	LB_1	LB_4	CND	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	OAL	KG	Machine
40	5/8-11 UNC	0	0	PS-V40-45-001	19	7.2	32.3		15.0	10.0	23.8	15	45°	57	0.08	
					.750	*.283*	*1.272*		*.590*	*.394*	*.940*	*.614*		*2.252*		
	5/8-11 UNC	0	0	PS-V40-45-002	19	7.0	32.1		15.0	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

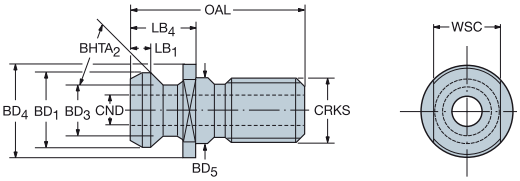
Pull stud



PS-Vxx



PS-VxxC



CAT-V

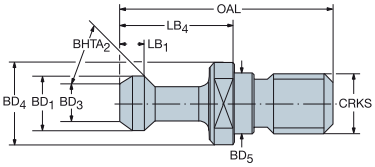
CZC	CRKS	CNSC	CXSC	Ordering code	Dimensions, mm, inch WSC	LB_1	LB_4	CND	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	OAL	KG	Machine
50	1-8 UNC	0	0	**PS-V50-90-001**	30	10.0	44.9		22.9	17.0	34.7	26	90°	84	0.30	
					1.190	*.394*	*1.770*		*.902*	*.670*	*1.370*	*1.031*		*3.310*		
	M24	1	1	**PS-V50C-45-001**	30	7.7	25.5	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

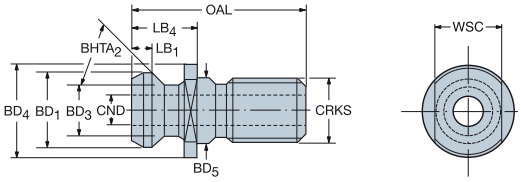
Pull stud



PS-Ixx



PS-IxxC



ISO

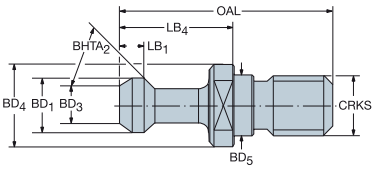
CZC	CRKS	CNSC	CXSC	Ordering code	Dimensions, mm, inch WSC	LB_1	LB_4	CND	BD_1	BD_3	BD_4	BD_5	$BHTA_2$	OAL	KG	BSG	Machine
30	M12	0	0	PS-I30-75-001	14	5.0	24.0		13.0	9.0	17.0	13	75°	44	0.04		
					.551	*.197*	*.945*		*.512*	*.354*	*.669*	*.512*		*1.732*			
40	M16	0	0	PS-I40-75-001	19	6.0	26.0		19.0	14.0	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

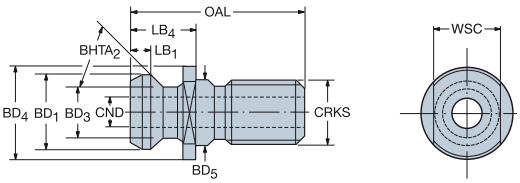
Pull stud



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



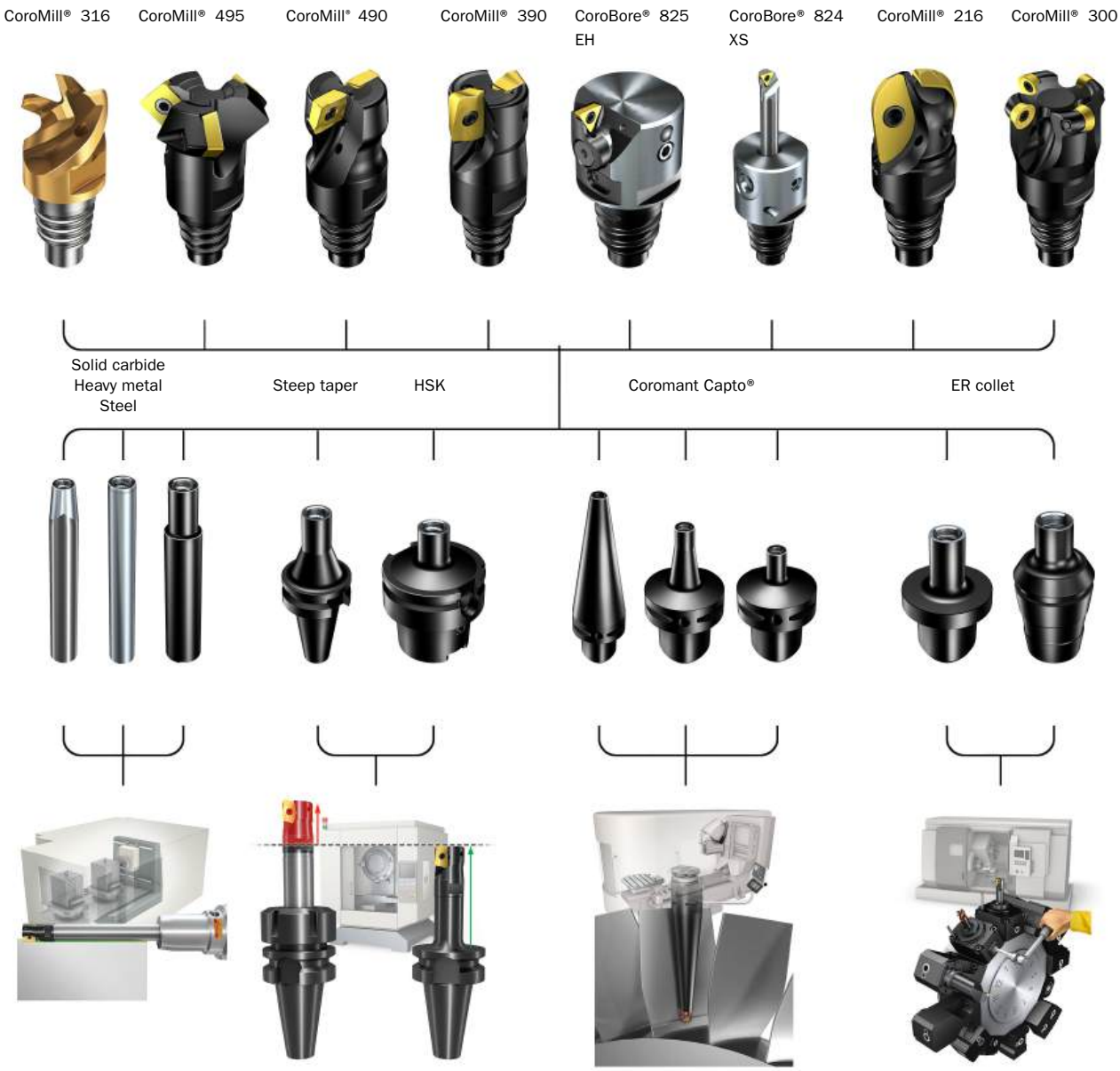






Modular system - Coromant EH

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

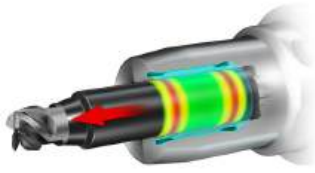
www.sandvik.coromant.com/corochuck930

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.

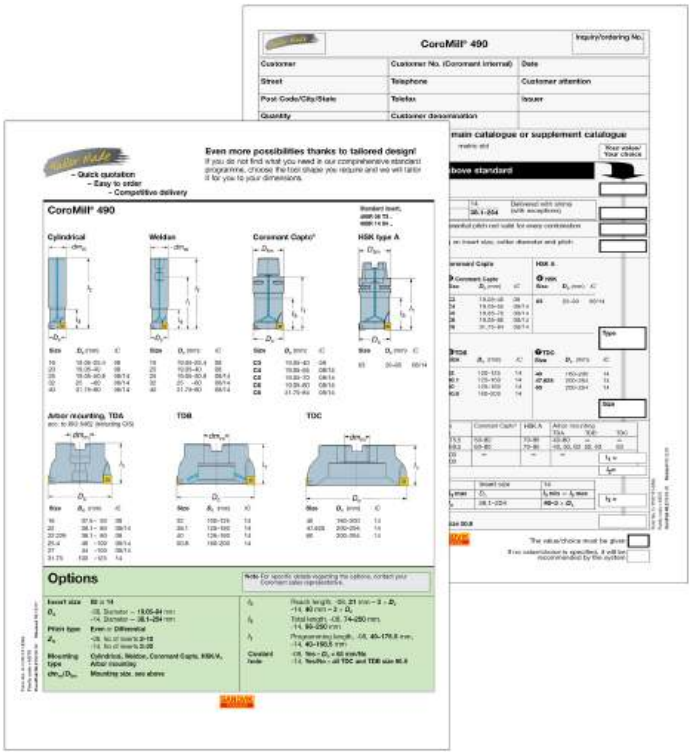
Product range

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°

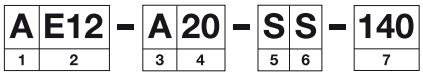
CoroMill® 328 cutters

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

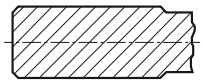
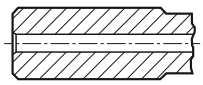
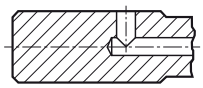
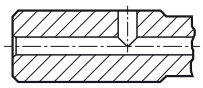
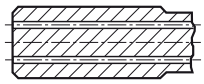
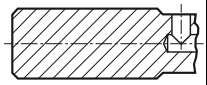
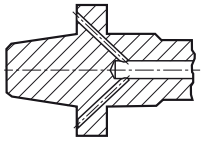
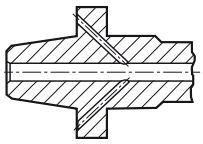
09 (0.375)	19 (0.750)	38 (1.500)
13 (0.500)	25 (1.000)	51 (2.000)
16 (0.625)	32 (1.250)	63 (2.500)

8 Programming length, mm

060 = 60 mm (2.362 inch)

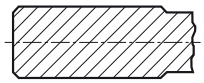
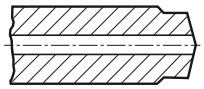
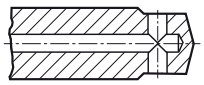
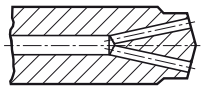
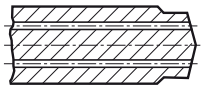
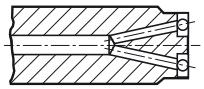
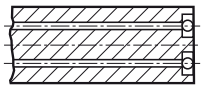
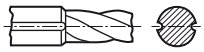
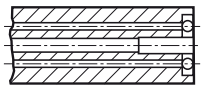
CNSC

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 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 Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan
			Standard DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
P	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	105WCr6	1.2419	-	-	2140	-	105WC13	10WCr6	105WCr5	SKS31
	P2.3.Z.AN/H1.2.Z.HA	-	-	-	-	-	-	-	-	107WCr5KU	-	SKS2, SKS3
	P2.3.Z.AN/H1.2.Z.HA	02.1/02.2	-	1.2714	-	-	-	L6	55NCDV7	-	F.520.S	SKT4
	P2.3.Z.AN/H1.3.Z.HA	02.1/02.2	100Cr6	1.2067	BL3	-	-	L3	Y100C6	-	100Cr6	-
	P2.4.Z.AN	02.1	16MnCr5	1.7139	-	-	2127	-	-	-	-	-
	P2.5.Z.HT	02.1	16Mo5	1.5423	1503-245-420	-	-	4520	-	16Mo5	16Mo5	-
	P2.5.Z.HT	02.1	40NiCrMo8-4	1.6562	311-Type 7	-	-	8740	-	40NiCrMo2(KB)	40NiCrMo2	SNCM240
	P2.5.Z.HT	02.1	42Cr4	1.7045	-	-	2245	5140	-	-	42Cr4	SCr440
	P2.5.Z.HT	02.1	31NiCrMo14	1.5755	830 M 31	-	2534	-	-	-	F-1270	-
	P2.5.Z.HT	02.2	36NiCr6	1.5710	640A35	111A	-	3135	35NC6	-	-	SNC236
	P2.6.C.UT	02.1	22Mo4	1.5419	605A32	-	2108	8620	-	-	F520.S	-
	P2.6.C.UT	02.1/02.2	25CrMo4	1.7218	1717CDS110	-	2225	4130	25CD4	25CrMo4(KB)	AM26CrMo4	SCM420;SCM430
	P2.6.C.UT	06.2	-	-	-	-	2223	-	-	-	-	-
	High-alloy steel											
	P3.0.Z.AN	03.11	X210Cr12	1.2080	BD3	-	-	D3	Z200C12	X210Cr13KU X250Cr12KU	X210Cr12	SKD1
	P3.0.Z.AN	03.11	X43Cr13	1.2083	-	-	2314	-	-	-	-	-
	P3.0.Z.AN	03.11	X40CrMoV5 1	1.2344	BH13	-	2242	H13	Z40CDV5	X35CrMoV05KU X40CrMoV511KU	X40CrMoV5	SKD61
	P3.0.Z.AN	03.11	X100CrMoV5 1	1.2363	BA2	-	2260	A2	Z100CDV5	X100CrMoV51KU	X100CrMoV5	SKD12
	P3.0.Z.AN	03.11	X210CrW12	1.2436	-	-	2312	-	-	X215CrW12 1KU	X210CrW12	SKD2
	P3.0.Z.AN	03.11	X30WCrV9 3	1.2581	BH21	-	-	H21	Z30WCV9	X28W09KU X30WCrV9 3KU	X30WCrV9	SKD5
	P3.0.Z.AN	03.11	X165CrMoV 12	1.2601	-	-	2310	-	-	X165CrMoW12KU	X160CrMoV12	-
	P3.0.Z.AN	03.21	X155CrMoV12-1	1.2379	-	-	2736	HNV3	-	-	-	-
	P3.0.Z.HT	03.11	X8Ni9	1.5662	1501-509;510	-	-	ASTM A353	-	X10Ni9	XBNi09	-
	P3.0.Z.HT	03.11	12Ni19	1.5680	-	-	-	2515	Z18N5	-	-	-
	P3.1.Z.AN	03.11	S6-5-2	1.3343	4959BA2	-	2715	D3	Z40CSD10	15NiCrMo13	-	SUH3
	P3.1.Z.AN	03.13	-	-	BM 2	-	2722	M 2	Z85WDCV	HS 6-5-2-2	F-5603.	SKH 51
	P3.1.Z.AN	03.13	HS 6-5-2-5	1.3243	BM 35	-	2723	M 35	6-5-2-5	HS 6-5-2-5	F-5613	SKH 55
	P3.1.Z.AN	03.13	HS 2-9-2	1.3348	-	-	2782	M 7	-	HS 2-9-2	F-5607	-
	P3.2.C.AQ	06.33	G-X120Mn12	1.3401	Z120M12	-	2183	L3	Z120M12	XG120Mn12	X120Mn12	SCMnH/1
	Ferritic/martensitic stainless steel											
Steel	P5.0.Z.AN	05.11/15.11	X10CrAL13	1.4724	403S17	-	-	405	Z10C13	X10CrAl12	F.311	SUS405
	P5.0.Z.AN	05.11/15.11	X10CrAL18	1.4742	430S15	60	-	430	Z10CAS18	X8Cr17	F.3113	SUS430
	P5.0.Z.AN	05.11/15.11	X10CrAL2-4	1.4762	-	-	2322	446	Z10CAS24	X16Cr26	-	SUH446
	P5.0.Z.AN	05.11/15.11	X1CrMoTi18-2	1.4521	-	-	2326	S44400	-	-	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr13	1.4000	403S17	-	2301	403	Z6C13	X6Cr13	F.3110	SUS403
	P5.0.Z.AN/P5.0.Z.HT	-	X7Cr14	1.4001	-	-	-	-	-	-	F.8401	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X10Cr13	1.4006	410S21	56A	2302	410	Z10C14	X12Cr13	F.3401	SUS410
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6Cr17	1.4016	430S15	960	2320	430	Z8C17	X8Cr17	F3113	SUS430
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrAL13	1.4002	405S17	-	-	405	Z8CA12	X6CrAl13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X20Cr13	1.4021	420S37	-	2303	420	Z20C13	X20Cr13	-	-
	P5.0.Z.AN/P5.0.Z.HT	05.11/15.11	X6CrMo17-1	1.4113	434S17	-	2325	434	Z8CD17.01	X8CrMo17	-	SUS434
	P5.0.Z.HT	03.11	X45CrS9-3-1	1.4718	401S45	52	-	HW3	Z45CS9	X45GrSi8	F322	SUH1
	P5.0.Z.HT	05.11/15.11	X85CrMoV18-2	1.4748	443S65	59	-	HNV6	Z80CSN20.02	X80CrSiNi20	F.320B	SUH4
	P5.0.Z.HT	05.11/15.11	X20CrMoV12-1	1.4922	-	-	2317	-	-	X20CrMoNi 12 01	-	-
	P5.0.Z.PH	05.11/15.11	X12CrS13	1.4005	416 S 21	-	2380	416	Z11CF13	X12 CrS 13	F-3411	SUS 416
	P5.0.Z.PH	05.11/15.11	X46Cr13	1.4034	420S45	56D	2304	-	Z40CM	X40Cr14	F.3405	SUS420J2
	P5.0.Z.PH	05.11/15.11	X19CrNi17-2	1.4057	431S29	57	2321	431	Z15CNi6.02	X16CrNi16	F.3427	SUS431
	P5.0.Z.PH	05.12/15.12	X5CrNiCuNb16-4	1.4542 1.4548	-	-	-	630	Z7CNU17-04	-	-	-
	P5.0.Z.PH	15.21	X4 CrNiMo16-5	1.4418	-	-	2387	-	Z6CND16-04-01	-	-	-
	P5.1.Z.AN/P5.0.Z.HT	05.11/15.11	X14CrMoS17	1.4104	-	-	2383	430F	Z10CF17	X10CrS17	F.3117	SUS430F

			Trade names
P2.1.Z.AN	02.1		OVAKO 520M (Ovako Steel)
P2.2.Z.AN	02.1	1.0045	FORMAX (Uddeholm Tooling)
P2.2.Z.AN	02.1		IMACRO NIT (Imatra Steel)
P2.5.Z.HT	02.2		INEXA 482 (XM) (Inexa Profil)
P1.2.Z.AN			S355J2G3(XM)
P1.2.Z.AN			C45(XM)
P1.2.Z.AN			16MnCrS5(XM)
P2.5.Z.HT			INEXA280(XM)
P2.5.Z.HT	02.2		070M20(XM)
P2.5.Z.HT	02.2		HARDOX 500 (SSAB – Swedish Steel Corp.)
P2.5.Z.HT			WELDOX 700 (SSAB – Swedish Steel Corp.)

SANDVIK Coromant

Material cross reference list

ISO	MC	CMC	Country Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan
			Standard DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
M	**Austenitic stainless steel**											
	M1.0.Z.AQ	05.11/15.11	X3CrNiMo13-4	1.4313	425C11	-	2385	CA6-NM	Z4CND13.4M Z38C13M	(G)X6CrNi304	-	SCS5
	M1.0.Z.AQ/M1.0.C.UT	05.11/15.11	X53CrMnNiN21-9	1.4871	349S54	-	-	EV8	Z52CMN21.09	X53CrMnNiN21 9	-	SUH35, SUH36
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiN18-10	1.4311	304S62	-	2371	304LN	Z2CN18.10	-	-	SUS304LN
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-13-3	1.4429	-	-	2375	316LN	Z2CND17.13	-	-	SUS316LN
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo17-12-2	1.4404	316S13	-	2348	316L	Z2CND17-12	X2CrNiMo1712	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-14-3	1.4435	316S13	-	2353	316L	Z2CND17.12	X2CrNiMo17 12	-	SCS16, SUS316L
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X3CrNiMo17-3-3	1.4436	316S33	-	2343, 2347	316	Z6CND18-12-03	X8CrNiMo1713	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMo18-15-4	1.4438	317S12	-	2367	317L	Z2CND19.15	X2CrNiMo18 16	-	SUS317L
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiNb18-10	1.4550	347S17	58F	2338	347	Z6CNNb18.10	X6CrNiNb18 11	F.3552 F.3524	SUS347
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X6CrNiMoTi17-12-2	1.4571	320S17	58J	2350	316Ti	Z6NDT17.12	X6CrNiMoTi17 12	F.3535	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X10CrNiMoNb 18-12	1.4583	-	-	-	318	Z6CNDNb17 13B	X6CrNiMoNb17 13	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X15CrNiSi20-12	1.4828	309S24	-	-	309	Z15CNS20.12	-	-	SUH309
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNiMoN17-11-2	1.4406	301S21	58C	2370	308	Z1NCDU25.20	-	F.8414	SCS17
	M1.0.Z.AQ	05.21/15.21	X1CrNiMoCuN20-18-7	1.4547	-	-	2378	S31254	Z1CNDU20-18-06AZ	-	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X9CrNi18-8	1.4310	-	-	2331	301	Z12CN17.07	X12CrNi17 07	F.3517	SUS301
	M1.0.Z.PH	05.22/15.22	X7CrNiAL17-7	1.4568 1.4504	316S111	-	-	17-7PH	Z8CNA17-07	X2CrNiMo1712	-	-
	M1.0.Z.AQ/M1.0.C.UT	05.21/15.21	X2CrNi19-11	1.4306	304S11 304S12	-	2352	304L	Z2CN18-10	X2CrNi18 11	-	-
	M1.1.Z.AQ	05.21/15.21	-	-	304S31	58E	2332, 2333	304	Z6CN18.09	X5CrNi18 10	F.3504 F.3541	SUS304
	M1.1.Z.AQ	05.21/15.21	X5CrNi18-10	1.4301	304S15	58E	2332	304	Z6CN18.09	X5CrNi18 10	F.3551	SUS304
	M1.1.Z.AQ	05.21/15.21	X5CrNiMo17-2-2	1.4401	316S16	58J	2347	316	Z6CND17.11	X5CrNiMo17 12	F.3543	SUS316
	M1.1.Z.AQ	05.21/15.21	X6CrNiTi18-10	1.4541	321S12	58B	2337	321	Z6CNT18.10	X6CrNiTi18 11	F.3553 F.3523	SUS321
	M1.2.Z.AQ	05.21/15.21	X8CrNiS18-9	1.4305	303S21	58M	2346	303	Z10CNF 18.09	X10CrNiS 18.09	F.3508	SUS303
	Super austenitic (Ni>20%) stainless steel											
	M2.0.C.AQ	20.11	G-X40NiCrSi36-18	1.4865	330C11	-	-	-	-	XG50NiCr39 19	-	SCH15
	M2.0.Z.AQ	05.21/15.21	X1NiCrMoCu25-20-5	1.4539	-	-	2562	UNS V 0890A	Z2 NCDU25-20	-	-	-
	M2.0.Z.AQ	05.21/15.21	X8CrNi25-21	1.4845	310S24	-	2361	310S	Z12CN25 20	X6CrNi25 20	F.331	SUH310
	M2.0.Z.AQ	20.11	X12NiCrSi36 16	1.4864	-	-	-	330	Z12NCS35.16	F-3313	-	SUH330
	M2.0.Z.AQ	05.23/15.23	X1NiCrMoCu31-27-4	1.4563	-	-	2584	NO8028	Z1NCDU31-27-03	-	-	-
	Duplex (austenitic/ferritic) stainless steel											
	M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X2CrNiN23-4	1.4362	-	-	2376	S31500	-	-	-	-
	M3.1.Z.AQ/M3.1.C.AQ	05.51/15.51	X8CrNiMo27-5	-	-	-	2324	S32900	-	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiN23-4	-	-	-	2327	S32304	Z2CN23-04AZ	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	-	-	-	-	2328	-	-	-	-	-
	M3.2.Z.AQ/M3.2.C.AQ	05.52/15.52	X2CrNiMoN22-53	-	-	-	2377	S31803	Z2CND22-05-03	-	-	-
					Trade names							
	M1.1.Z.AQ	05.21/15.21			SANMAC 304 (Sandvik Steel)							
	M1.1.Z.AQ	05.21/15.21		1.0045	SANMAC 304L (Sandvik Steel)							
	M1.1.Z.AQ	05.21/15.21			SANMAC 316 (Sandvik Steel)							
	M1.1.Z.AQ	05.21/15.21			SANMAC 316L (Sandvik Steel)							
	M1.0.Z.AQ	05.23/15.23			254 SMO							
	M2.0.Z.AQ	05.23/15.23			654 SMO							
	M3.2.Z.AQ	05.52/15.52			SANMAC SAF 2205 (Sandvik Steel)							
	M3.2.Z.AQ	05.52/15.52			SANMAC SAF 2507 (Sandvik Steel)							

Stainless steel

Material cross reference list

ISO	MC	CMC	Country Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan
			Standard DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
K	**Malleable cast iron**											
	K1.1.C.NS	07.1	-	-	8 290/6	-	0814	-	MN 32-8	-	-	FCMB310
	K1.1.C.NS	07.1	EN-GJMB350-10	0.8135	B 340/12	-	0815	32510	MN 35-10	-	-	FCMW330
	K1.1.C.NS	07.2	EN-GJMB450-6	0.8145	P 440/7	-	0852	40010	Mn 450	GMN 45	-	FCMW370
	K1.1.C.NS	07.2	EN-GJMB550-4	0.8155	P 510/4	-	0854	50005	MP 50-5	GMN 55	-	FCMP490
					P 570/3		0858	70003	MP 60-3			FCMP540
	K1.1.C.NS	07.2	EN-GJMB650-2	0.8165	P570/3	-	0856	A220-70003	Mn 650-3	GMN 65	-	FCMP590
	K1.1.C.NS	07.3	EN-GJMB700-2	0.8170	P690/2	-	0862	A220-80002	Mn700-2	GMN 70	-	FCMP690
	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 Europe	Germany	Great Britain		Sweden	USA	France	Italy	Spain	Japan
			Standard DIN EN	W.-nr.	BS	EN	SS	AISI/SAE/ASTM	AFNOR	UNI	UNE	JIS
N	**Aluminum based alloys**											
Non-ferrous metals	N1.3.C.AG	30.21	G-AlSI9MGWA	3.2373	-	-	4251	SC64D	A-S7G	-	-	C4BS
	N1.3.C.UT	30.21	G-ALMG5	-	LM5	-	4252	GD-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	**Nickel based alloys**											
Heat resistant super alloys	S2.0.Z.AG	20.22	S-NiCr13A16MoNb	LW2 4670	mar-46	-	-	5391	NC12AD	-	-	-
	S2.0.C.UT	20.24	NiCo15Cr10MoAlTi	LW2 4674	-	-	-	AMS 5397	-	-	-	-
	S2.0.Z.AG	20.22	NiFe35Cr14MoTi	LW2.4662	-	-	-	5660	ZSNCDT42	-	-	-
	S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	HR8	-	-	5383	NC19eNB	-	-	-
	S2.0.Z.AG	20.22	NiCr20TiAk	2.4631	Hr401.601	-	-	-	NC20TA	-	-	-
	S2.0.Z.AG	20.22	NiCr19Co11MoTi	2.4973	-	-	-	AMS 5399	NC19KDT	-	-	-
	S2.0.Z.AG	20.22	NiCr19Fe19NbMo	LW2.4668	-	-	-	AMS 5544	NC20K14	-	-	-
	S2.0.Z.AN	20.21	-	2.4603	-	-	-	5390A	NC22FeD	-	-	-
	S2.0.Z.AN	20.21	NiCr22Mo9Nb	2.4856	-	-	-	5666	NC22FeDNB	-	-	-
	S2.0.Z.AN	20.21	NiCr20Ti	2.4630	HR5.203-4	-	-	-	NC20T	-	-	-
	S2.0.Z.AG	20.22	NiCu30AL3Ti	2.4375	3072-76	-	-	4676	-	-	-	-
	Cobalt 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 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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