How to choose the right tool for parting and grooving

1 Define the type of operation and system to use

Identify your operation:

- Parting
- External or internal grooving, facegrooving, shallow grooving
- External or internal turning
- Undercutting, profiling

and choose the most suitable system for it. See overview.

2 Select the insert geometry and grade

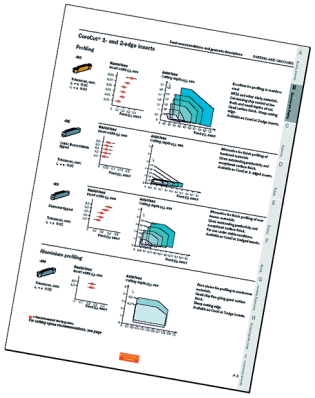
Choose the insert geometry and grade.

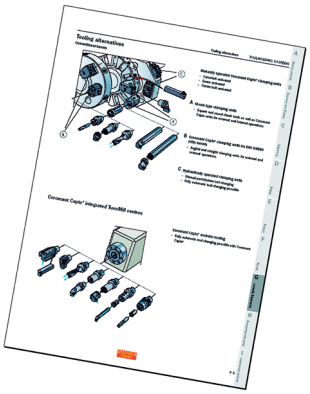
Choose the insert size on the corresponding ordering page.

3 Select the tooling system and type of holder

Choose Coromant Capto® or shank tool, depending on clamping possibilities in turret/spindle.

Choose the right holder size on the corresponding ordering page.
The insert seat must correspond to the size of the insert.





4 Select feed and cutting speed

Find the recommended feed for the insert.

Choose the recommended cutting speed.

Find starting values for cutting speeds and feeds for different

For more technical information, see our Metalcutting Technical Guide.

Symbols for page references:

External machining

Internal machining

CoroTurn® SL internal adapters

Tailor Made options

Conversion table, formulas and definitions

Coromant Capto® unit

Conventional holder

Conventional bar

Tooling systems

Inserts

Spare parts/ accessories

Sleeves

Holders for parting blades

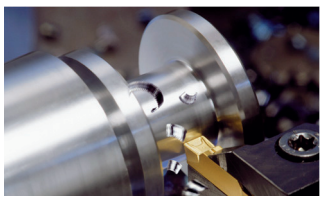
How to choose tool, overview

Grade descriptions

Cutting data, speed recommendations

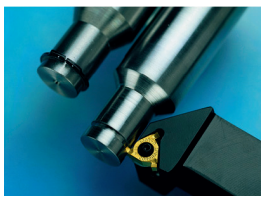
Cutting data, feed and cutting depth recommendations

PARTING AND GROOVING



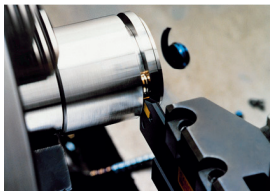
CoroCut® 1- and 2-edge

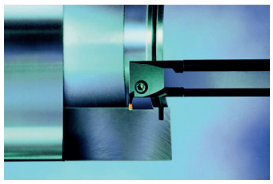
The first choice system for all parting and grooving



CoroThread®

For external and internal circlip grooving





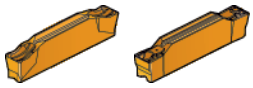
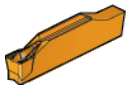
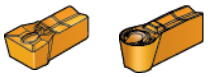
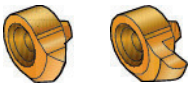
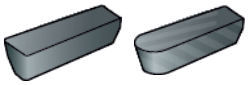
T-Max Q-Cut®

151.2
For deep parting

151.3
For internal machining and small diameter facegrooving

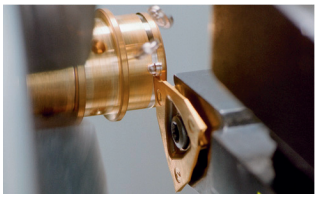
T-Max®

For grooving and profiling of heat resistant super alloys

		Parting off	General grooving	Circlip grooving
	**CoroCut® 2-edge** Cutting depths up to 20 mm (.787 inch) Page B14	• •	• •	•
	**CoroCut® 1-edge** Cutting depths up to 20 mm (.787 inch) Page B14	• •	• •	
	**CoroCut® 3** Cutting depths up to 6.4 mm (.252 inch) Page B52	• •	•	•
	**T-Max Q-Cut® 151.2** Page B59	•	•	
	**T-Max Q-Cut® 151.3** Page B78			
	**CoroThread®** Page B85			• •
	**CoroCut® XS** Page B88	• • Small part precision	• • Small part precision	
	**CoroCut® MB** Page B95			
	**CoroTurn® XS** Page A309			
	**T-Max® ceramic** Page B86		•	

• • = First choice • = Alternative

SANDVIK Coromant

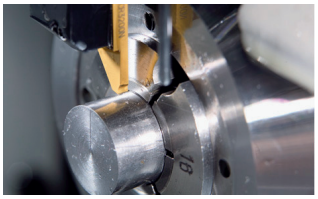


CoroCut® 3

For shallow parting, grooving and profiling.

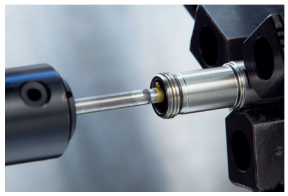
CoroTurn® XS

For internal precision grooving, turning and threading in small part machining



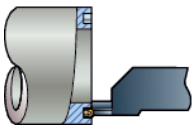
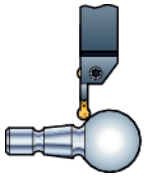
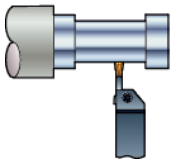
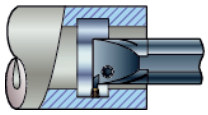
CoroCut® XS

For internal precision parting/grooving, turning and threading operations in small part machining



CoroCut® MB

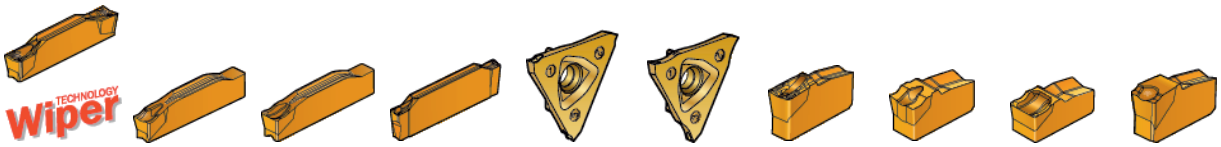
For internal precision grooving, threading and turning

 Face grooving	 Profiling	 Turning	 Internal machining
• • First cut diameter from 34 mm (1.339 inch)	• •	• •	• • Min bore 25 mm (.984 inch)
•	•	•	
	•		
			• Min bore 25 mm (.984 inch)
• •			• • Min bore 20 mm (.787 inch)
			• Circlip grooving. Min bore 12 mm (.472 inch)
		• • Small part machining	
			• • Min bore 10 mm (.394 inch)
•• First cut diameter from 12 mm (.472 inch)			• • Min bore 4.2 mm (.165 inch)
	•		• • Min bore 2.500 inch (63.5 mm)

Parting and grooving inserts

Parting

CoroCut® 1-2 | **CoroCut® 3** | **T-Max Q-Cut® 151.2**



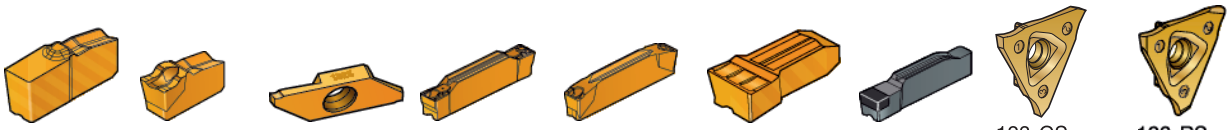
	123-CF	123-CM	123-CR	123-CS	123-CM	123-CS	151.2-4E	151.2-5E	151.2-7E	151.2-9E
Insert width, inch	2.50-4.00	1.50-5.00	2.50-6-00	1.50-3.00	1.00-2.00	1.00-2.00	2.50-8.00	2.00-6.00	2.50-4.00	2.50-4.00
Insert width, inch	.098-.157	.059-.197	.098-.236	.059-.118	.039-.079	.039-.079	.098-.315	.079-.236	.098-.157	.098-.157
Page	B16	B16	B16	B17	B53	B53	B60	B60	B60	B61

Parting

T-Max Q-Cut® | **CoroCut® XS**

Grooving

CoroCut® 1-2 | **CoroCut® 3**



	151.2-3F	151.2-5F	MACR/L	123-GF	123-GM	123-GR	123-CBN	123-GS	123-RS
Insert width, inch	1.87-3.12	2.00-5.00	0.70-2.50	1.50-8.00	2.00-11.00	15	3.00-8.00	0.50-3.18	0.50-3.00
Insert width, inch	.062-.188	.079-.197	.028-.098	.059-.315	.079-.433	.591	.118-.315	.020-.125	.020-.118
Page	B61	B61	B90	B18	B19	B90	B21	B54	B55

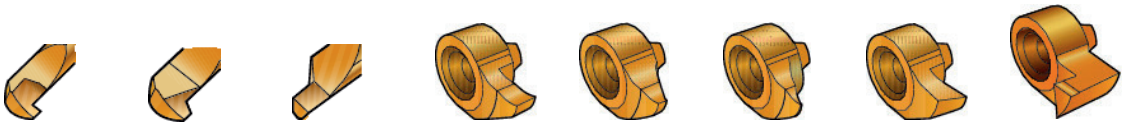
Grooving

T-Max Q-Cut® 151.2 | **T-Max Q-Cut® 151.3** | **CoroCut® XS**

	151.2-4G	151.2-5G	151.2-6G	151.2-CBN	151.2-4U	151.3-4G	151.3-7G	MAGR/L	MAFR/L	MABR/L
Insert width, inch	1.85-9.52	1.85-8.00	6.35-9.52	3.00-7.92	2.00-8.00	1.85-8.00	3.00-6.00	0.50-2.50	-	-
Insert width, inch	.073-.394	.073-.315	.250-.375	.125-.312	.079-.315	.073-.315	.118-.236	.020-.098	-	-
Page	B62	B62	B62	B62	B67	B78	B79	B91	B91	B91

Grooving, internal

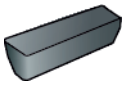
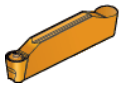
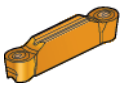
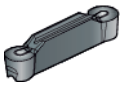
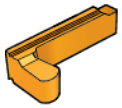
CoroTurn® XS | **CoroCut® MB**



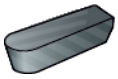
	CXS-..G	CXS-..GX	CXS-..F	MB-..G	MB-..GX	MB-..TE	MB-..B	MB-FA/FB
Insert width, inch	0.78-2.00	1.00	1.00-3.00	0.73-3.00	1.00	-	-	1.00-3.00
Insert width, inch	.031-.079	.039	.039-.118	.039-.118	.039	-	-	.039-.118
Page	A317	A321	A321	B97	B101	B99	B99	B99

Parting and grooving inserts

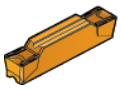
Grooving

	CoroThread® circlip	T-Max® ceramic	CoroCut® 1-2						
									
	254	150.22/CSG	123-RM	123-RO	123-RS	123-CBN	123-AM	123-GS	123-RS
Insert width, inch	1.10-4.15	3.17-9.52	3.00-8.00	2.00-8.00	3.00-8.00	3.00-8.00	6.00-8.00	2.00-4.00	2.00-4.00
Insert width, inch	.043-.163	.125-.375	.118-.315	.079-.315	.118-.315	.118-.315	.236-.315	.079-.157	.079-.157
Page	B85	B86	B22	B22	B23	B23	B23	B25	B25

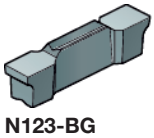
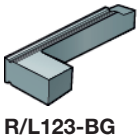
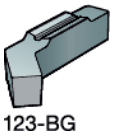
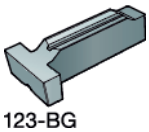
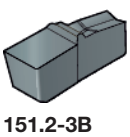
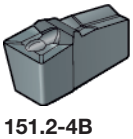
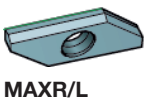
Profiling

	T-Max Q-Cut® 151.2				T-Max Q-Cut® 151.3	CoroTurn® XS	CoroCut® MB	T-Max® ceramic
								
	151.2-4P	151.2-5P	151.2-PCD	151.2-CBN	151.3-7P	CXS-..R	MB-..R	150.23
Insert width, inch	3.00-10.00	3.00-8.00	3.18-8.00	3.00-7.92	3.00-6.00	1.00-2.00	0.80-3.00	3,17-6.35
Insert width, inch	.118-.394	.118-.315	.125-.315	.118-.312	.118-.236	.039-.079	.012-.118	.125-.250
Page	B65	B65	B65	B65	B79	A320	B101	B86

Turning

	CoroCut® 1-2		T-Max Q-Cut® 151.2		CoroTurn® XS		CoroCut® MB	
								
	123-TF	123-TM	151.2-4T	151.2-5T	CXS-..T98	CXS-..TE	MB-..T45	MB-..T93
Insert width, inch	3.00-8.00	3.00-8.00	3.00-6.00	3.00-6.00	-	-	-	-
Insert width, inch	.118-.315	.118-.315	.118-.236	.118-.236	-	-	-	-
Page	B24	B24	B67	B67	A313	A316	B99	B99

Blanks

	CoroCut® 1-2				CoroCut® 3	T-Max Q-Cut® 151.2		CoroCut® XS
								
	N123-BG	R/L123-BG	123-BG	123-BG	N123-BG	151.2-3B	151.2-4B	MAXR/L
Insert width, inch	2.30-8.40	6.00	6.03	4.04	3.40	2.40-8.50	2.60-11.45	3.18
Insert width, inch	.091-.331	.236	.237	.159	.134	.094-.335	.102-.451	.125
Page	B26	B26	B26	B26	B56	B68	B68	B93

CoroCut® and T-Max Q-Cut®

Insert geometries

The CoroCut® family offers many insert geometries in a variety of styles, all designed to increase productivity in parting and grooving operations. The program includes the extremely strong -CR geometries; -4E which can withstand interrupted cuts; and the very sharp -RS and the -F-P diamond tipped insert for non-ferrous materials.

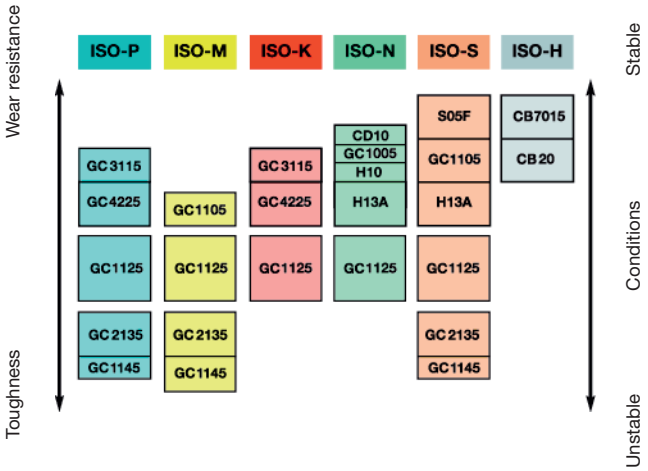
The last two digits in the ordering code guide you to the right insert. See table below.

Application	Low feed			Medium feed			High feed		Optimizing			
	CoroCut® 1-2	Q-Cut® 151.2	Q-Cut® 151.3	CoroCut® 1-2	Q-Cut® 151.2	Q-Cut® 151.3	CoroCut® 1-2	Q-Cut® 151.2	CoroCut® 1-2	CoroCut® 3	Q-Cut® 151.2	Q-Cut® 151.3
Parting off	CF	7E		CM	5E		CR	4E	CS	CS CM	9E 5F 3F[1]	
Turning	TF		7G	TM	5T			4T				
Profiling For hardened materials	CB20 7015	CB20		RM	5P				RO		4P	7P
Grooving For hardened materials	GF CB20 7015	4G CB20	4G	GM	5G	7G		6G				
Aluminum profiling	CD10	CD10		AM								
Undercutting					4U							
Face grooving	TF		7G	CM	5E				RM			7P

[1] Parting in Multi-Spindle Automatics

Grades

The CoroCut® family is available in a selection of carbide grades to cover all types of workpiece material, from the very wear resistant grade GC3115 to the toughest grade on the market, GC1145. Cubic boron nitride and diamond tipped inserts are also available.



ISO P = Steel

ISO M = Stainless steel

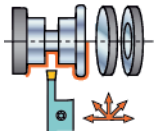
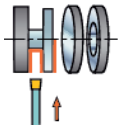
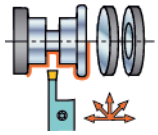
ISO K = Cast iron

ISO N = Aluminum and non-ferrous materials

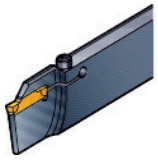
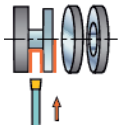
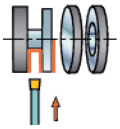
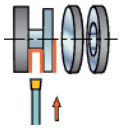
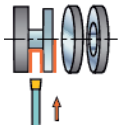
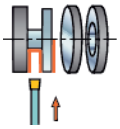
ISO S = Heat resistant super alloys

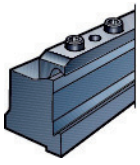
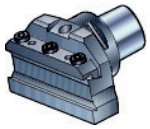
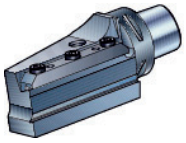
ISO H = Hardened materials

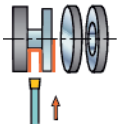
Coromant Capto® cutting units for parting and grooving

CoroCut® 1-2	Grooving, parting off, profiling and turning	Grooving and profiling	**CoroCut® 3**	Parting off tubes and small diameters, grooving	**T-Max Q-Cut®**	**Grooving, parting off, profiling and turning**
						
	Cx-R/LF123	**Cx-NF123**		**Cx-RF123T/U**		**Cx-R/LF151.23**
Insert width, inch	1.49-8.00	2.39-5.56	Insert width, inch	0.99-2.01	Insert width, inch	1.85-10.0
Insert width, inch	.059-.315	.094-.219	Insert width, inch	.039-.079	Insert width, inch	.073-.394
Coupling size	C3-C8	C3-C6	Coupling size	C3-C4	Coupling size	C3-C8
Page	B28	B28	Page	B57	Page	B69

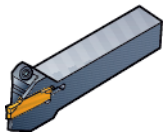
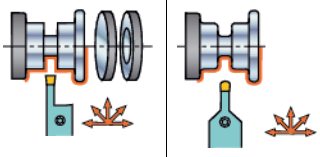
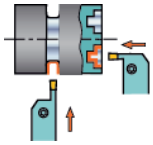
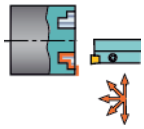
Parting blades

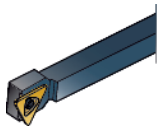
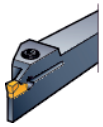
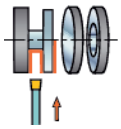
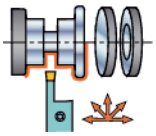
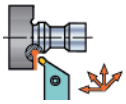
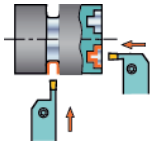
CoroCut® 1-2	**Parting off**		**T-Max Q-Cut®**	**Parting off**	**Parting off Blades for Manchester holders**		**Parting off Blades for HSS holders**	**Cartridges for Multi-spindles**
								
	N123	**R/LF123**		**151.2**	**151.2**	**R/L151.2**	**151.2**	
Insert width, inch	1.50-7.14	1.50-7.14	Insert width, inch	1.85-10.00	2.01-5.99	3.00	2.01-5.99	1.57-3.96
Insert width, inch	.059-.281	.059-.281	Insert width, inch	.073-.394	.079-.236	.118	.079-.236	.062-.156
Max a_p, mm	5.00-54.99	5.00-32.00	Max a_p, mm	34.80-100.00	38.10-63.50	19.05	25.40-57.15	13-34
Max a_p, inch	.197-2.165	.197-1.260	Max a_p, inch	1.370-3.937	1.500-2.500	.750	1.000-2.250	.510-1.340
Page	B30	B31	Page	B70	B74		B75	B75

Toolblock for parting blades	**Coromant Capto® adaptor for parting blades**	
	Radial mounting	**Axial mounting**
		
151.2	**Cx-APBA**	**Cx-APBR/L**
Page	B33	B34

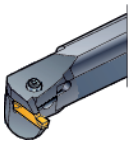
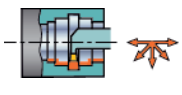
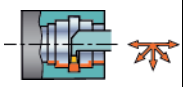
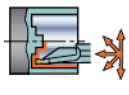
T-Max Q-Cut®	**Cartridges for Multi-spindles**
	
Insert width, inch	1.57 - 3.96
Insert width, inch	.062-.156
Max a_p, mm	13-34
Max a_p, inch	.510 - 1.340
Page	B77

Shank tools for parting and grooving

CoroCut® 1-2	Grooving, parting off, profiling and turning	Profiling				Shallow grooving and face grooving	Face grooving
		0°	7°	45°	70°	0°/90°	0°/90°
							
	R/LF123/-S	**NF123**	**R/LX123-...007**	**R/LX123-...045**	**R/LX123-...070**	**R/LF123 R/LG123**	**R/LF123 R/LG123**
Insert width, inch	1.50-15.00	5.00-15.00	8.00	3.00-5.99	5.00-6.00	3.00-7.13	3.00-8.00
Insert width, inch	.059-.591	.197-.591	.315	.118-.236	.197-.236	.118-.281	.118-.315
Shank dim., mm	1010-3232	2525-3232	2525-3232	2020-2525	2525-3232	2525	2020-2525
Shank size, inch	.375-1.500		1.00-1.250	.750-1.250	1.00-1.250	1.00	.750-1.250
Page	B35	B42	B42	B42	B42	B44	B45

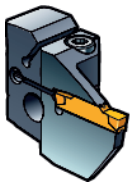
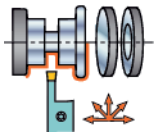
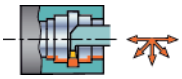
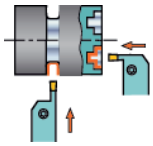
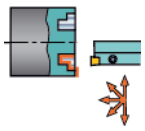
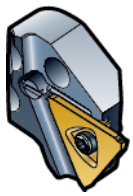
CoroCut® 3	Parting off tubes and small diameters	**T-Max Q-Cut®**	Parting off	Grooving, parting off, profiling and turning	Undercutting	Face grooving (For 151.3 inserts)	
						0°	90°
							
	RF123T RF123U		**R/L151.20 R/L151.21**	**R/L151.23**	**R/LS151.22**	**R/LF151.37**	**R/LG151.37**
Insert width, inch	0.99-1.98	Insert width, inch	1.85-8.00	1.85-8.00	1.85-8.00	2.39-5.97	2.39-5.97
Insert width, inch	.039-.078	Insert width, inch	.073-.315	.073-.315	.073-.315	.094-.236	.094-236
Shank dim., mm	1010-3232	Shank dim., mm	0808-3232	1616-3232	2525-3232	2525	2525
Shank size, inch	.375-1.260	Shank size, inch	.375-1.250	.625-1.250	.500-1.250	1.000	1.000
Page	B58	Page	B70	B72	B73	B80	B80

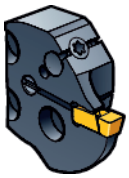
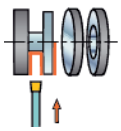
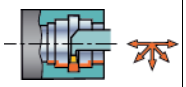
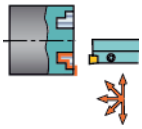
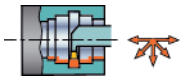
Boring bars for parting and grooving

CoroCut® 1-2	Grooving, profiling and turning	Profiling	**T-Max Q-Cut®**	Grooving, profiling and (For 151.3 inserts)	Face grooving (For 151.3 inserts)
					
	R/LAG123	**R/LAX123**		**R/LAG151.32**	**R/LAF151.37**
Insert width, inch	3.00-6.00	5.00-8.00	Insert width, inch	1.85-8.00	2.39-6.00
Insert width, inch	.118-.236	.197-.315	Insert width, inch	.073-.315	094-.236
Min. bore, mm	25.00-60.00	64.23	Min. bore, mm	15.01-50.03	26.00-42.01
Min. bore, inch	.984-2.362	2.529	Min. bore, inch	.591-1.970	1.024-1.654
Bar diameter, mm	16-50	40	Bar diameter, mm	16-40	25-40
Bar diameter, inch	.625-2.000	1.500	Bar diameter, inch	.625-1.500	.984-1.575
Page	B49	B50	Page	B82	B84

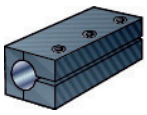
Shank holders for QS-holding system, see page A217.

Cutting heads with CoroTurn® SL coupling for parting and grooving

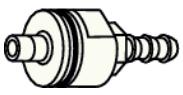
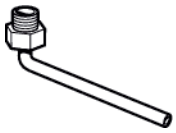
CoroCut® SL	Grooving, parting off, profiling and turning	Internal grooving and profiling	Shallow grooving and face grooving	Face grooving	**CoroCut® 3 SL**	Shallow grooving
						
	R/L123-B		**R/L123-C**	**R/L123-A**		**R/L 123 T/U**
Insert width, inch	1.50-7.14		3.00-7.14	2.49-7.14	Insert width, inch	0.99-2.01
Insert width, inch	.059-.281		.118-.281	.098-.281	Insert width, inch	.039-.079
SL coupling size, mm	25-40		25-40	32	Coupling size,	25-40
Page	I42		I43	I44	Page	I46

T-Max Q-Cut® SL	Grooving and parting (For 151.2 inserts)	Internal grooving and profiling (For 151.3 inserts)	Face grooving (For 151.3 inserts)	Grooving and profiling (For 151.3 inserts)	**CoroCut® XS SL** Small part precision
					
	R/L151.21	**R/L151.3**	**R/L151.3 A/B**	**R/LAG 551.31**	**R/L SMAL**
Insert width, inch	3.00-6.00	2.00-7.92	3.00-5.56	1.85-8.00	
Insert width, inch	.118-.236	.079-.312	.118-.219	.073-.315	-
SL coupling size, mm	25-40	25-40	32	16-40	25-32
Page	I47	I48	I49	I50	I51

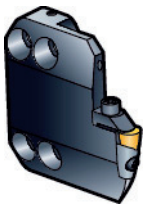
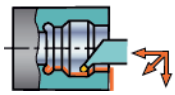
Accessories

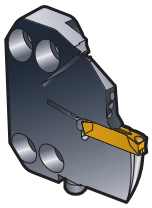
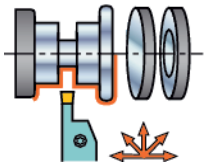
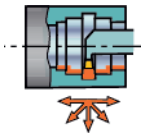
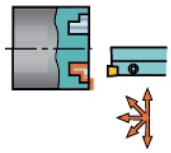
Sleeves for cylindrical boring bars	**EasyFix**	
		
	131	**132**
For bar diameter, mm	5-20	5-25
For bar diameter, inch	.197-.787	.197-.984
Page	A305	A305

Accessories for cutting fluid supply

	Coolant nozzle	**Coolant connector**	**Coolant tube**
			
	For Coromant Capto® cutting units	For boring bar	For SL cutting blades
Page	A308	A308	I118

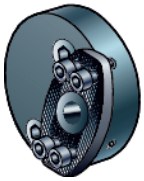
Cutting heads with CoroTurn® SL70 coupling

CoroTurn® SL70	Grooving, parting off, profiling and turning	Internal grooving and profiling
		
	SL70-CRDCR / SL70-CRSCR / SL70-SRDCR	
Insert size, mm (*iC*, inch)	09-12 (3/8-1/2)	
SL70 coupling size	70	
Page	I99	

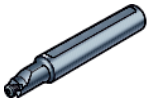
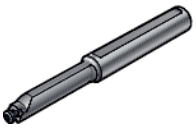
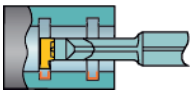
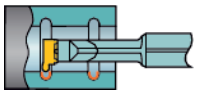
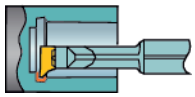
CoroCut® SL70	Grooving and parting	Internal grooving and profiling	Face grooving
			
	SL70-R/L123		**SL70-R/L123**
Insert width, inch	3-16		4-6
Insert width, inch	.118-.590		.157-.236
SL70 coupling size	70		70
Page	I101		I102

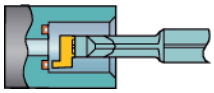
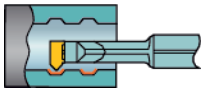
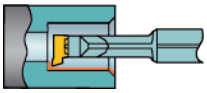
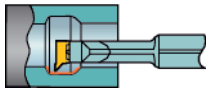
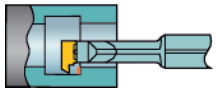
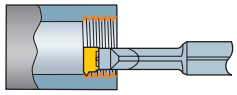
Adapters

Coromant Capto® adapters	0°	5°	45°	90°
				
Coromant Capto® size	C5-C8	C6	C6	C5-C8
SL70 coupling size	70	70	70	70
Page	I103	I103	I103	I103

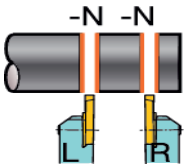
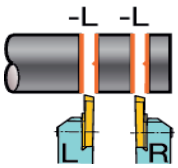
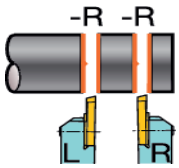
CoroTurn SL® quick change adapter for SL70 cutting heads		
		
Coupling size		
Machine side	80	80
Tool side	70	70
Page	I92	I92

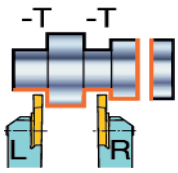
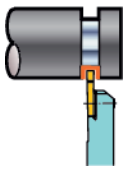
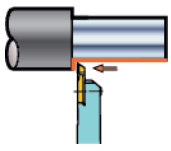
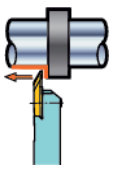
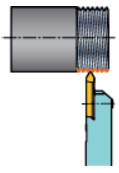
CoroCut® MB boring bars/inserts

CoroCut® MB	Steel shank boring bar	Carbide shank boring bar	Inserts Grooving	Profiling	Pre-parting
					
	MB-A	**MB-E**	**MB G**	**MB R**	**MB GX**
Bar diameter, mm	16	12-16			
Bar diameter, inch	.625	.500-.625			
Insert size	07-09	07-09	07-09	07-09	07-09
Page	B107	B107	B97	B101	B101

Inserts Entering angle/Lead angle	κ_r 45°/45°	κ_r 93°/-3°	κ_r 93°/-3°	κ_r 117.5° / -27.5°	
Face grooving	**Turning/profiling**	**Turning**	**Copying**	**Back boring**	**Threading**
					
MB-FA/FB	**MB T045**	**MB T093**	**MB TE 93**	**MB B030**	**MB TH**
09	07	07	07	07	07
B102	B99	B99	B99	B99	B103

CoroCut® XS shank tools for small part machining/inserts

CoroCut® XS	Shank holders	SL cutting head	Inserts for Parting off	Parting off	Parting off
	 Cut off holder 				
	SMALR/L/SMALR/L-X	**R/L SMAL**	**MACR/L-N**	**MACR/L-R**	**MACR/L-L**
Insert size			3	3	3
SL coupling size, mm		25-32			
Shank dim., mm	1010-1616				
Shank size, inch	.500-.625				
Page	B94	I51	B90	B90	B90

CoroCut® XS	Inserts for Grooving Profiling	Grooving	Turning	Back turning	Threading
					
	MACR/L-T	**MAGR/L**	**MAFR/L**	**MABR/L**	**MATR/L**
Insert size	3	3	3	3	3
Page	B90	B91	B92	B92	B93

CoroTurn® XS boring bars
For complete assortment for parting, grooving, threading and turning, see page A325.

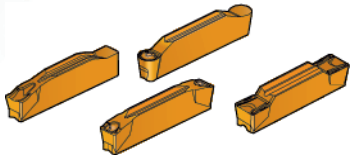
CoroCut® 1-2 system

System with 1 or 2 cutting edges

The first choice system for all parting, profiling and grooving operations.

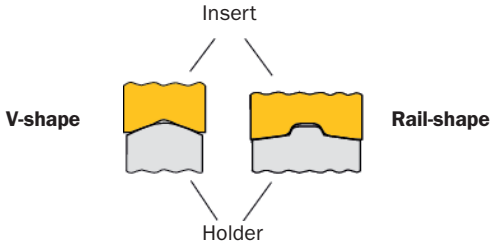
Toolholder assortment

A wide range of toolholders is available for CoroCut® 1-2 edge inserts.



Insert geometries

A large variety of geometries are available, dedicated to different applications and feed areas.



Insert clamping

The system is based on a patented Rail and V-shaped design that counteracts high axial forces from both sides. This, combined with a long insert, gives exceptional stability.

Insert versions

CoroCut® 1-2 insert are available in widths from 1.5 mm (.059 inch) up to 15 mm (.591 inch).

- CoroCut® 2-edge for the most economical machining.
- CoroCut® 1-edge version for cutting depths deeper than 50 mm (1.969 inch)

CoroCut® SL - Flexible tool solution

By using CoroTurn® SL adapters and CoroCut® SL cutting blades, a large number of tooling solutions, both external and internal, can be achieved with a limited number of items. See page I2.

Insert grades

To cover all types of workpiece materials the CoroCut® inserts are available in a variety of specially developed grades:

- Cemented carbide
- Polycrystalline diamond
- Cubic boron nitride
- Cermet

Tailor Made

Even more possibilities with tailored design. For more information on our Tailor Made program see page J3.

ISO application areas:

P M K N S H

Code key for CoroCut® 1-2-3 edge inserts

N	123	H	2	–	0400	–	00	04	–	TF
1	2	3	4		5		6	7		8

1 Hand of insert

R

N

L

2 Main code

123

3 Insert seat size *

CoroCut® 1-2

D	G	K
E	H	L
F	J	M
		R

CoroCut® 3

T = Right hand cutting
U = Left hand cutting

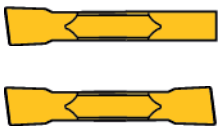
To correspond with seat size on holder.

* Insert seat interchangeability:

Insert seat size	Size, mm	Holder	Insert seat size	Size, mm	Holder
D	1.5	D	H	4.0	H
E	2.0	E	J	5.0	J, H
F	2.5	F, E	K	6.0	K, J, H
G	3.0	G, F, E	L	8.0	L
			M	9.0	M
			R	1.5	R

4 Number of edges

1 or 2



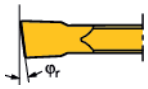
3

5 Insert width

E.g.: 0400 = .157 inch (4 mm)

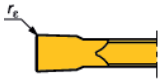
6 Front angle

E.g.: 00 = 0°
05 = 5°



7 Corner radius

E.g.: 04 = .016 inch (0.4 mm)
08 = .031 inch (0.8 mm)



8 Geometry designation

First digit: Type of operation

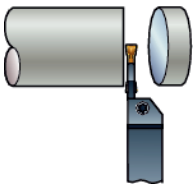
A = Aluminum/profiling
C = Cut off
T = Turning
G = Grooving
R = Profiling
B = Blank

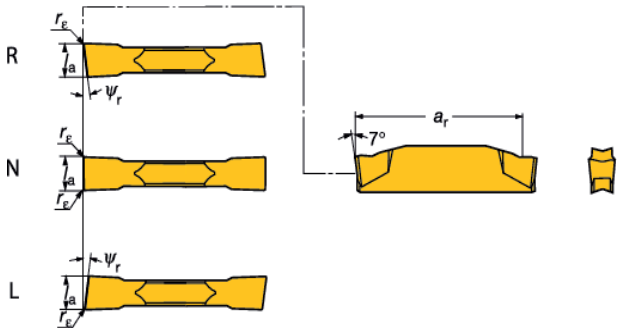
Second digit:

E = ER treated cutting edge
F = Low feed
M = Medium feed
R = High feed
O = Optimized for special areas
S = Sharp cutting edge
G = Blank

CoroCut® 1- and 2-edge

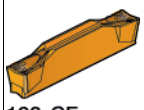
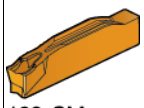
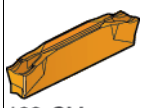
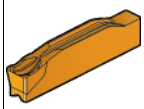
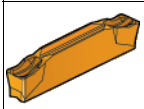
Parting





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = +0.10/0 (+.004/0)
r_ε = ±0.10 (±.004)

		Selection criteria, millimeter, inch (mm, in.)										P						M				K			S			
												GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
		l_a mm	l_a in.	ψ_r	α_f	r_ε mm	r_ε in.	a_r max mm[1]	a_r max in.[1]	Seat size[2]	Ordering code	1125	1145	2135	3115	4225	525	1105	1125	1145	2135	1125	3115	4225	1105	1125	1145	2135
											CoroCut® 2-edge																	
Low feed	 123-CF	2.5	.098	0°	6.5°	0.1	.004	18.4	.724	F	N123F2-0250-0001-CF	★	☆	☆		☆			☆	☆	★	★		☆				
		2.5	.098	5°	5°	0.2	.006	18.4	.724		R123F2-0250-0501-CF	★	☆	☆					☆	☆	★	★						
		2.5	.098	5°	5°	0.2	.006	18.4	.724		L123F2-0250-0501-CF	★	☆						☆	★		★						
		3.0	.118	0°	6.83°	0.1	.004	18.4	.724	G	N123G2-0300-0001-CF	★	☆	☆		☆	☆		☆	☆	★	★		☆				
		3.0	.118	5°	6.83°	0.2	.006	18.3	.720		R/L123G2-0300-0501-CF	★	☆	☆					☆	☆	★	★						
		4.0	.157	0°	6.67°	0.2	.006	23.3	.917		N123H2-0400-0001-CF	★	☆	☆	☆	☆			☆	☆	★	★	☆	☆				
		4.0	.157	5°	6.67°	0.2	.006	25.3	.996		R123H2-0400-0501-CF	★	☆	☆					☆	☆	★	★						
		4.0	.157	5°	6.67°	0.2	.006	25.3	.996	H	L123H2-0400-0501-CF	★							★			★						
											CoroCut® 1-edge																	
Medium feed	 123-CM	2.0	.079	0°	5°	0.2	.008			E	N123E1-0200-0002-CM	☆	☆	★					☆	☆	★	★				★	☆	☆
		2.5	.098	0°	5°	0.2	.008			F	N123F1-0250-0002-CM	☆	☆	★					☆	☆	★	★				★	☆	☆
		3.0	.118	0°	7°	0.2	.008			G	N123G1-0300-0002-CM	☆	☆	★					☆	☆	★	★				★	☆	☆
		4.0	.157	0°	6°	0.2	.008			H	N123H1-0400-0002-CM	☆	☆	★					☆	☆	★	★				★	☆	☆
		5.0	.197	0°	6.25°	0.2	.008			J	N123J1-0500-0002-CM	☆	☆	★					☆	☆	★	★				★	☆	☆
											CoroCut® 2-edge																	
	 123-CM	1.5	.059	0°	5°	0.2	.008	12.9	.508	D	N123D2-0150-0002-CM	☆	☆	★			☆		☆	☆	★	★				★	☆	☆
		2.0	.079	0°	5°	0.2	.008	19	.748	E	N123E2-0200-0002-CM	☆	☆	★	☆	☆	☆	☆	☆	☆	★	☆	☆	★	☆	★	☆	☆
		2.0	.079	5°	5°	0.2	.008	19	.748		R/L123E2-0200-0502-CM	☆	☆	★					☆	☆	★	★					★	☆	☆
		2.5	.098	0°	5°	0.2	.008	18.9	.744	F	N123F2-0250-0002-CM	☆	☆	★	☆	☆		☆	☆	☆	★	☆	☆	★	☆	★	☆	☆
		2.5	.098	5°	5°	0.2	.008	18.9	.744		R/L123F2-0250-0502-CM	☆	☆	★					☆	☆	★	★					★	☆	☆
		3.0	.118	0°	7°	0.2	.008	18.9	.744	G	N123G2-0300-0002-CM	☆	☆	★	☆	☆	☆	☆	☆	☆	★	☆	☆	★	☆	★	☆	☆
		3.0	.118	5°	6.83°	0.2	.008	18.8	.740		R/L123G2-0300-0502-CM	☆	☆	★	☆	☆			☆	☆	★	☆	☆	★		★	☆	☆
		4.0	.157	0°	6°	0.2	.008	24.1	.949	H	N123H2-0400-0002-CM	☆	☆	★	☆	☆	☆	☆	☆	☆	★	☆	☆	★	☆	★	☆	☆
		4.0	.157	5°	6°	0.2	.008	24.1	.949		R/L123H2-0400-0502-CM	☆	☆	★					☆	☆	★	★					★	☆	☆
		5.0	.197	0°	6.25°	0.2	.008	24.1	.949		N123J2-0500-0002-CM	☆	☆	★					☆	☆	★	★					★	☆	☆
		5.0	.197	5°	6.25°	0.2	.008	24.1	.949		R123J2-0500-0502-CM	☆	☆	★					☆	☆	★	★					★	☆	☆
		5.0	.197	5°	6.25°	0.2	.008	24.1	.949	J	L123J2-0500-0502-CM	☆		★					☆		★	★					★		☆
											CoroCut® 1-edge																	
High feed	 123-CR	2.5	.098	0°	5°	0.3	.012			F	N123F1-0250-0003-CR	★	☆	☆					☆	☆	★	★						
		3.0	.118	0°	6.25°	0.3	.012			G	N123G1-0300-0003-CR	★	☆	☆					☆	☆	★	★						
		4.0	.157	0°	7°	0.3	.012			H	N123H1-0400-0003-CR	★	☆	☆					☆	☆	★	★						
		5.0	.197	0°	7°	0.4	.016			J	N123J1-0500-0004-CR	★	☆	☆					☆	☆	★	★						
											CoroCut® 2-edge																	
	 123-CR	2.5	.098	0°	6.25°	0.3	.012	18.9	.744	F	N123F2-0250-0003-CR	★	☆	☆	☆	☆	☆		☆	☆	★	☆	☆	★				
		2.5	.098	5°	5°	0.3	.012	18.9	.744		R123F2-0250-0503-CR	★	☆	☆					☆	☆	★	★						
		2.5	.098	5°	5°	0.3	.012	18.9	.744		L123F2-0250-0503-CR	★		☆					☆		★	★						
		3.0	.118	0°	6.25°	0.3	.012	18.9	.744	G	N123G2-0300-0003-CR	★	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	★	☆			
		3.0	.118	5°	5°	0.3	.012	18.8	.740		R/L123G2-0300-0503-CR	★	☆	☆					☆	☆	★	★						
		4.0	.157	0°	7°	0.3	.012	23.7	.933	H	N123H2-0400-0003-CR	★	☆	☆	☆	☆		☆	☆	☆	★	☆	☆	★	☆			
		4.0	.157	5°	6.25°	0.3	.012	23.7	.933		R/L123H2-0400-0503-CR	★	☆	☆					☆	☆	★	★						
		5.0	.197	0°	6.25°	0.4	.016	23.7	.933	J	N123J2-0500-0004-CR	★	☆	☆	☆	☆			☆	☆	★	☆	☆	★				
		5.0	.197	5°	6.25°	0.4	.016	23.6	.929		R123J2-0500-0504-CR	★		☆					☆		★	★						
		5.0	.197	5°	6.25°	0.4	.016	23.6	.929		L123J2-0500-0504-CR	★		☆					☆		★	★						
		6.0	.236	0°	6.25°	0.4	.016	23.5	.925	K	N123K2-0600-0004-CR	★	☆	☆	☆	☆			☆	☆	★	☆	☆	★				
												P30	P45	P35	P15	P20	P10	M15	M25	M40	M30	K30	K15	K25	S15	S25	S40	S30

1) When using CoroCut® "1"-edge inserts, the a_r of the toolholder gives the maximum depth of cut.
2) To correspond with seat size on holder.

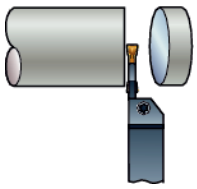
N = Neutral, R = Right hand, L = Left hand
★= First choice

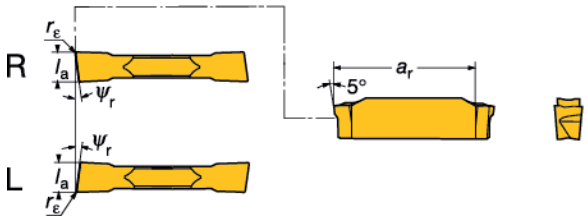
For geometry description, see page B124.

B9 B10 B138 B124 B146 B2 I8

CoroCut® 1- and 2-edge

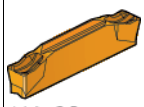
Parting





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = ±0.02 (±.0008)
r_ε = ±0.05 (±.002)

		Selection criteria, millimeter, inch (mm, in.)										P						M				K			S			
												GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
		l_a mm	l_a in.	ψ_r	α_f	r_ε mm	r_ε in.	a_r max mm	a_r max in.	Seat size[1]	Ordering code	1125	1145	2135	3115	4225	525	1105	1125	1145	2135	1125	3115	4225	1105	1125	1145	2135
											CoroCut® 2-edge																	
Low feed	 123-CS	1.5	.059	10°	2.5°	0.1	.004	13.4	.528	D	R/L123D2-0150-1001-CS	☆							☆			☆				☆		
		1.5	.059	15°	2.5°	0.1	.004	13.4	.528		R/L123D2-0150-1501-CS	☆							☆			☆				☆		
		2.0	.079	10°	2.5°	0.1	.004	19.4	.764	E	R/L123E2-0200-1001-CS	☆							☆			☆				☆		
		2.0	.079	15°	2.5°	0.1	.004	19.4	.764		R/L123E2-0200-1501-CS	☆							☆			☆				☆		
		2.5	.098	10°	2.5°	0.1	.004	19.4	.764	F	R/L123F2-0250-1001-CS	☆							☆			☆				☆		
		2.5	.098	15°	2.5°	0.1	.004	19.4	.764		R/L123F2-0250-1501-CS	☆							☆			☆				☆		
		3.0	.118	10°	2.5°	0.1	.004	19.4	.764	G	R/L123G2-0300-1001-CS	☆							☆			☆				☆		
		3.0	.118	15°	2.5°	0.1	.004	19.4	.764		R/L123G2-0300-1501-CS	☆							☆			☆				☆		
												P30	P45	P35	P15	P20	P10	M15	M25	M40	M30	K30	K15	K25	S15	S25	S40	S30

[1] To correspond with seat size on holder.

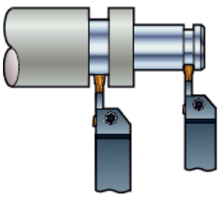
R = Right hand, L = Left hand
★= First choice

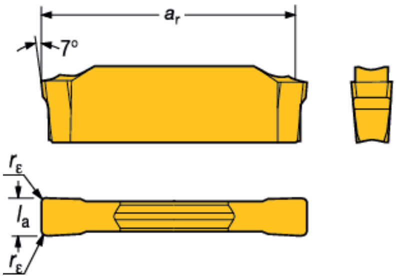
For geometry description, see page B124.

B9 B10 B138 B124 B146 B2 I8

CoroCut® 1- and 2-edge

Grooving

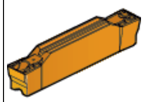




For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = ±0.02 (±.0008)
$r_ε$ = ±0.05 (±.002)
For circlip grooves
l_a = +0.10 (+.004)
+0.13 (+.005)
$r_ε$ = ±0.05 (±.002)

Low feed



123-GF

Selection criteria, millimeter, inch (mm, in.)

l_a mm	l_a in.	$r_ε$ mm	$r_ε$ in.	$α_f$	a_r max mm	a_r max in.	Seat size[1]	Ordering code	P GC 1125	P GC 2135	P CT 525	M GC 1005	M GC 1105	M GC 1125	M GC 2135	M - H13A	K GC 1125	K - H13A	N - H13A	S GC 1005	S GC 1105	S GC 1125	S GC 2135	S - H13A
								CoroCut® 2-edge																
1.50	.059	0.1	.004	2.5°	13.3	.524	D	N123D2-0150-0001-GF	★		☆			★			★					★		
1.98	.078	0.2	.008	3°	19.2	.756	E	N123E2-0198-0002-GF	★					★			★					★		
2.00	.079	0.2	.008	3°	19.2	.756		N123E2-0200-0002-GF	★	☆	☆	☆	☆	★	☆	☆	★	☆	★	☆	★	☆	☆	☆
2.00	.079	0.4	.016	3°	19.2	.756		N123E2-0200-0004-GF	★			☆		★		☆	★	☆	★	★		☆		☆
2.24	.088	0.2	.008	3°	19.2	.756		N123E2-0224-0002-GF	★					★			★					★		
2.39	.094	0.2	.008	3°	19.2	.756	F	N123F2-0239-0002-GF	★			☆	☆	★		☆	★	☆	★	☆	★	☆		☆
2.39	.094	0.4	.016	3°	19.2	.756		N123F2-0239-0004-GF	★			☆		★			★			★		☆		
2.46	.097	0.3	.012	3°	19.1	.752		N123F2-0246-0003-GF	★		☆			★		☆	★	☆	★			★		☆
2.67	.105	0.2	.008	3°	19.2	.756		N123F2-0267-0002-GF	★					★			★					★		
2.79	.110	0.3	.012	3°	19.1	.752		N123F2-0279-0003-GF	★					★			★					★		
3.00	.118	0.2	.008	3°	19.2	.756	G	N123G2-0300-0002-GF	★	☆	☆	☆	☆	★	☆	☆	★	☆	★	☆	★	☆		☆
3.00	.118	0.4	.016	3°	19.2	.756		N123G2-0300-0004-GF	★			☆		★		☆	★	☆	★	★		☆		☆
3.10	.122	0.2	.008	3°	19.2	.756		N123G2-0310-0002-GF	★					★			★					★		
3.18	.125	0.2	.008	3°	19.2	.756		N123G2-0318-0002-GF	★		☆	☆	☆	★		☆	★	☆	★	☆	★	☆		☆
3.18	.125	0.4	.016	3°	19.2	.756		N123G2-0318-0004-GF	★			☆		★			★			★		☆		
3.18	.125	0.8	.032	3°	19.2	.756		N123G2-0318-0008-GF	★			☆		★			★			★		☆		
3.61	.142	0.3	.012	3°	19.1	.752		N123G2-0361-0003-GF	★					★		☆	★	☆	★			★		☆
3.96	.156	0.2	.008	3°	24.4	.961	H	N123H2-0396-0002-GF	★			☆	☆	★			★			☆	★	☆		
3.96	.156	0.4	.016	3°	24.4	.961		N123H2-0396-0004-GF	★			☆		★			★			★		☆		
3.96	.156	0.8	.032	3°	24.4	.961		N123H2-0396-0008-GF	★			☆		★			★			★		☆		
4.00	.157	0.2	.008	3°	24.4	.961		N123H2-0400-0002-GF	★	☆		☆	☆	★	☆	☆	★	☆	★	☆	★	☆		☆
4.00	.157	0.4	.016	3°	24.4	.961		N123H2-0400-0004-GF	★			☆	☆	★		☆	★	☆	★	☆	★	☆		☆
4.52	.178	0.2	.008	3°	24.4	.961		N123H2-0452-0002-GF	★					★		☆	★	☆	★			★		☆
4.70	.185	0.5	.020	3°	24.1	.949		N123H2-0470-0005-GF	★			☆		★			★			★		☆		
4.75	.187	0.4	.016	3°	24.1	.949		N123H2-0475-0004-GF	★			☆		★			★			★		☆		
4.75	.187	0.8	.032	3°	24.1	.949		N123H2-0475-0008-GF	★			☆		★			★			★		☆		
4.80	.189	0.5	.020	3°	24.1	.949		N123H2-0480-0005-GF	★					★		☆	★	☆	★			★		☆
5.00	.197	0.2	.008	3°	24.4	.961		N123H2-0500-0002-GF	★	☆		☆	☆	★	☆	☆	★	☆	★	☆	★	☆		☆
5.00	.197	0.4	.016	3°	24.4	.961		N123H2-0500-0004-GF	★			☆		★			★			★		★		
5.41	.213	0.2	.008	3°	24.4	.961	J	N123J2-0541-0002-GF	★					★			★					★		
5.56	.219	0.5	.020	3°	24.1	.949		N123J2-0556-0005-GF	★					★			★					★		
6.00	.236	0.2	.008	3°	24.4	.961	K	N123K2-0600-0002-GF	★	☆				★	☆	☆	★	☆	★			★		☆
6.35	.250	0.4	.016	3°	24.1	.949		N123K2-0635-0004-GF	★			☆		★			★			★		☆		
6.35	.250	0.5	.020	3°	24.1	.949		N123K2-0635-0005-GF	★					★		☆	★	☆	★			★		☆
6.35	.250	0.8	.032	3°	24.1	.949		N123K2-0635-0008-GF	★			☆		★			★			★		☆		
7.14	.281	0.8	.032	3°	23.8	.937		N123K2-0714-0008-GF	★					★			★					★		
7.92	.312	0.8	.032	3°	29	1.142	L	N123L2-0792-0008-GF	★					★			★					★		
8.00	.315	0.2	.008	7°	29.6	1.165		N123L2-0800-0002-GF	★	☆				★	☆	☆	★	☆	★			★		☆
1.85	.073	0.1	.004	3°	19.3	.760	E	N123E2-0185-0001-GF	★					★		☆	★	☆	★			★		☆
2.15	.085	0.1	.004	3°	19.3	.760		N123E2-0215-0001-GF	★					★		☆	★	☆	★			★		☆
2.65	.104	0.2	.008	3°	19.2	.756	F	N123F2-0265-0002-GF	★					★		☆	★	☆	★			★		☆
3.15	.124	0.2	.008	3°	19.2	.756	G	N123G2-0315-0002-GF	★					★			★					★		
4.15	.163	0.2	.008	3°	24.4	.961	H	N123H2-0415-0002-GF	★					★			★					★		
5.15	.203	0.2	.008	3°	24.4	.961	J	N123J2-0515-0002-GF	★					★			★					★		
									P30	P35	P10	M10	M15	M25	M30	M15	K30	K20	N20	S15	S15	S25	S30	S15

1) To correspond with seat size on holder.

N = Neutral
★= First choice

For geometry description, see page B124.

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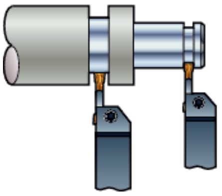
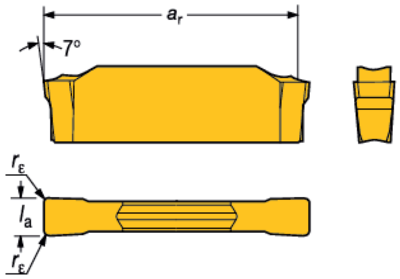
SANDVIK Coromant

CoroCut® 1- and 2-edge

Grooving





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = +0.10/0 (+.004/0)
$r_ε$ = ±0.10 (±.004)

Selection criteria, millimeter, inch (mm, in.)

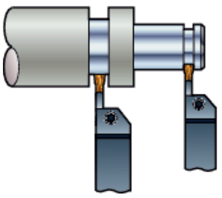
	l_a mm	l_a in.	$r_ε$ mm	$r_ε$ in.	$α_f$	a_r max mm	a_r max in.	Seat size[1]	Ordering code	P GC 1125	P GC 1145	P GC 2135	P GC 3115	P GC 4225	P CT 525	M GC 1005	M GC 1105	M GC 1125	M GC 1145	M GC 2135	M - H13A	K GC 1125	K GC 3115	K GC 4225	K - H13A	N - H13A	S GC 1005	S GC 1105	S GC 1125	S GC 1145	S GC 2135	S - H13A
Medium feed 123-GM									**CoroCut® 2-edge**																							
	2.00	.079	0.2	.008	4°	18.80	.740	E	N123E2-0200-0002-GM	☆	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	☆	★						
	2.39	.094	0.2	.008	7°	18.40	.724		N123E2-0239-0002-GM	☆	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	☆	★						
	3.00	.118	0.3	.012	6°	18.20	.716	G	N123G2-0300-0003-GM	☆	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	☆	★						
	3.18	.125	0.3	.012	7°	18.00	.709		N123G2-0318-0003-GM	☆	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	☆	★						
	4.00	.157	0.3	.012	6.5°	23.00	.906	H	N123H2-0400-0003-GM	☆	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	☆	★						
	4.75	.187	0.3	.012	5°	22.60	.890	J	N123J2-0475-0003-GM	☆		☆	☆	★				★		☆	☆	☆	★	☆	☆	★						
	5.00	.197	0.4	.016	6°	22.90	.902		N123J2-0500-0004-GM	☆	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	☆	★						
	6.00	.236	0.4	.016	6°	22.70	.894	K	N123K2-0600-0004-GM	☆	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	☆	★						
	6.35	.250	0.3	.012	7°	22.60	.890		N123K2-0635-0003-GM	☆	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	☆	★						
	7.92	.312	0.3	.012	7°	28.70	1.130	L	N123L2-0792-0003-GM	☆		☆	☆	★				★		☆	☆	☆	★	☆	☆	★						
	8.00	.315	0.5	.020	7°	28.40	1.118		N123L2-0800-0005-GM	☆		☆	☆	★				★		☆	☆	☆	★	☆	☆	★						
										P30	P45	P35	P15	P20	P10	M10	M15	M25	M40	M30	M15	K30	K15	K25	K20	N20	S15	S15	S25	S40	S30	S15

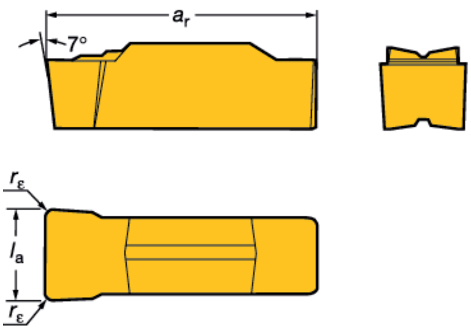
1) To correspond with seat size on holder.

For geometry description, see page B124.

N = Neutral
★= First choice

Grooving





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = ±0.03 (±.001)
$r_ε$= ±0.10 (±.004)

Selection criteria, millimeter, inch (mm, in.)

	l_a mm	l_a in.	$r_ε$ mm	$r_ε$ in.	$α_f$	a_r max[1]	Seat size[2]	Ordering code	P GC 1125	P GC 1145	P GC 2135	P GC 3115	P GC 4225	P CT 525	M GC 1005	M GC 1105	M GC 1125	M GC 1145	M GC 2135	M - H13A	K GC 1125	K GC 3115	K GC 4225	K - H13A	N - H13A	S GC 1005	S GC 1105	S GC 1125	S GC 1145	S GC 2135	S - H13A
Medium feed 123-GM								**CoroCut® 1-edge**																							
	9.00	.354	0.80	.032	3°		M	N123M1-0900-0008-GM	☆	☆			★			☆	★	☆		☆	☆		★	☆	★		★	☆	☆		☆
	9.52	.375	0.80	.032	3°			N123M1-0953-0008-GM	☆	☆			★			☆	★	☆		☆	☆		★	☆	★		★	☆	☆		☆
	10.00	.394	0.80	.032	3°			N123M1-1000-0008-GM	☆	☆			★			☆	★	☆		☆	☆		★	☆	★		★	☆	☆		☆
	11.00	.433	0.80	.032	3°			N123M1-1100-0008-GM	☆	☆			★			☆	★	☆		☆	☆		★	☆	★		★	☆	☆		☆
									P30	P45	P35	P15	P20	P10	M10	M15	M25	M40	M30	M15	K30	K15	K25	K20	N20	S15	S15	S25	S40	S30	S15

1) When using CoroCut® "1"-edge inserts, the a_r of the toolholder gives the maximum depth of cut.

2) To correspond with seat size on holder.

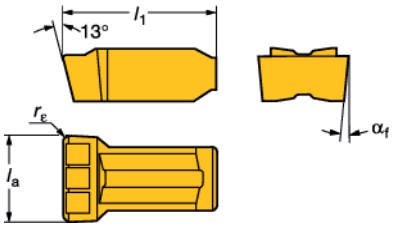
For geometry description, see page B124.

N = Neutral
★= First choice

B9 B10 B138 B124 B146 B2 J3 I8

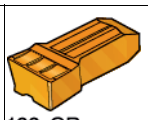
CoroCut® 1- and 2-edge

Grooving



For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = ±0.08 (±.003)
r_ε = ±0.10 (±.004)

		Selection criteria, millimeter, inch (mm, in.)							P			M			K		N	S		
									GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
		l_a mm	l_a in.	r_ε mm	r_ε in.	α_f	Seat size[1]	Ordering code	1125	2135	4225	1105	1125	2135	1125	4225	1125	1105	1125	2135
								CoroCut® 1-edge												
High feed	 123-GR	15.00	.591	1.2	.047	5°	R	N123R1-1500-0010-GR	☆	☆	★		☆	★	☆	★			★	☆
Medium feed	 123-GM							**CoroCut® 1-edge**												
		12.00	.472	0.80	.032	3°	R	N123R1-1200-0008-GM	☆		★	☆	★		☆	★	☆	★	☆	
		12.70	.500	0.80	.032	3°		N123R1-1270-0008-GM	☆		★	☆	★		☆	★	☆	★	☆	
		15.00	.591	0.80	.032	3°		N123R1-1500-0008-GM	☆		★	☆	★		☆	★	☆	★	☆	
									P30	P35	P20	M15	M25	M30	K30	K25	N25	S15	S25	S30

[1] To correspond with seat size on holder.

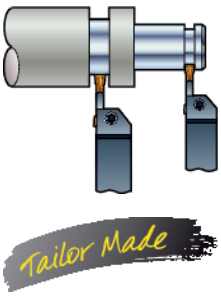
N = Neutral
★= First choice

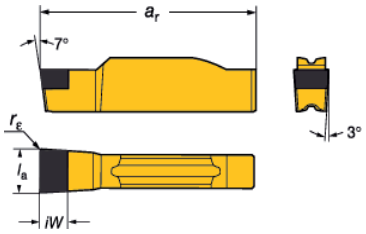
For geometry description, see page B124.

B9 B10 B138 B124 B146 B2 J3 I8

CoroCut® 1- and 2-edge

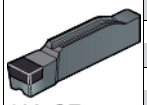
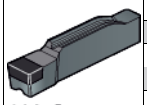
For grooving of hardened materials





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = ±0.02 (±.0008)
r_ε = ±0.05 (±.002)

		Selection criteria, millimeter, inch (mm, in.)									H	
		l_a mm	l_a in.	r_ε mm	r_ε in.	α_f	a_r max[1]	iW	Seat size[2]	Ordering code	CB 7015	CB CB20
Low feed	 123-GE									**CoroCut® 1-edge**		
		3.00	.118	0.20	.008	7°	∞	3.1	G	**N123G1-0300-0002-GE**		★
		3.18	.125	0.20	.008	7°	∞	3.1		**N123G1-0318-0002-GE**		★
		4.00	.157	0.20	.008	7°	∞	3.1	H	**N123H1-0400-0002-GE**		★
		4.70	.185	0.20	.008	7°	∞	3.1		**N123H1-0470-0002-GE**		★
		5.00	.197	0.20	.008	7°	∞	3.1		**N123H1-0500-0002-GE**		★
		6.00	.236	0.20	.008	7°	∞	3.1	J	**N123J1-0600-0002-GE**		★
		6.35	.250	0.20	.008	7°	∞	3.1	K	**N123K1-0635-0002-GE**		★
		8.00	.315	0.20	.008	7°	∞	2.6	L	**N123L1-0800-0002-GE**		★
	 123-S									**CoroCut® 1-edge**		
		3.00	.118	0.40	.016	7°	∞	3.1	G	**N123G1-030004S01025**	★	
		4.00	.157	0.40	.016	7°	∞	3.1	H	**N123H1-040004S01025**	★	
		5.00	.197	0.40	.016	7°	∞	3.1		**N123H1-050004S01025**	★	
		6.00	.236	0.40	.016	7°	∞	3.1	J	**N123J1-060004S01025**	★	
		8.00	.315	0.80	.032	7°	∞	3.1	L	**N123L1-080008S01025**	★	
											H15	H01

1) When using CoroCut® "1"-edge inserts, the a_r of the toolholder gives the maximum depth of cut.

2) To correspond with seat size on holder.

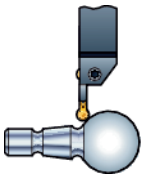
N = Neutral
★= First choice

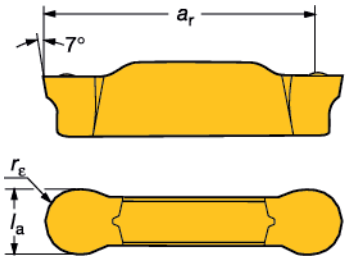
For geometry description, see page B124.

B9 B10 B138 B124 B146 B2 J3 I8

CoroCut® 1- and 2-edge

Profiling





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
-RM
l_a = +0.10/0 (+.004/0)
r_ε = ±0.10 (±.004)
-RO
l_a = ±0.02 (±.0008)
r_ε = ±0.10 (±.0004)

		Selection criteria, millimeter, inch (mm, in.)									P					M					K				N	S					
											GC	GC	GC	GC	CT	GC	GC	GC	GC	-	GC	GC	GC	-	-	GC	GC	GC	-	GC
		l_a mm	l_a in.	r_ε mm	r_ε in.	α_f	a_r max mm[1]	a_r max in.[1]	Seat size[2]	Ordering code	1125	2135	3115	4225	525	1005	1105	1125	2135	H13A	1125	3115	4225	H13A	H13A	1005	1105	1125	H13A	S05F
Low feed										**CoroCut® 2-edge**																					
	123-RO	2.00	.079	1.00	.039	7°	19.20	.756	E	N123E2-0200-RO	★	☆				☆	☆	★	☆	☆	★			☆	★	☆	☆	☆	☆	★
		2.39	.094	1.20	.047	7°	19.00	.748		N123E2-0239-RO	★					☆		★			★					☆		☆		★
		3.00	.118	1.50	.059	7°	18.70	.736	F	N123F2-0300-RO	★	☆				☆	☆	★	☆	☆	★			☆	★	☆	☆	☆	☆	★
		3.18	.125	1.59	.063	7°	18.60	.732		N123F2-0318-RO	★					☆	☆	★		☆	★			☆	★	☆	☆	☆	☆	★
		3.96	.156	1.98	.078	7°	23.30	.917	H	N123H2-0396-RO	★					☆		★		☆	★			☆	★	☆		☆	☆	★
		4.00	.157	2.00	.079	7°	23.30	.917		N123H2-0400-RO	★	☆				☆	☆	★	☆	☆	★			☆	★	☆	☆	☆	☆	★
		4.50	.177	2.25	.089	7°	23.00	.906		N123H2-0450-RO	★							★		☆	★			☆	★			☆	★	
		4.75	.187	2.38	.094	7°	22.90	.902		N123H2-0475-RO	★					☆	☆	★		☆	★			☆	★	★	☆	☆	☆	★
		5.00	.197	2.50	.098	7°	22.80	.898		N123H2-0500-RO	★	☆				☆	☆	★	☆	☆	★			☆	★	☆	☆	☆	☆	★
		6.00	.236	3.00	.118	7°	22.20	.874	J	N123J2-0600-RO	★	☆				☆	☆	★	☆	☆	★			☆	★	☆	☆	☆	☆	★
		6.35	.250	3.18	.125	7°	22.00	.866		N123J2-0635-RO	★					☆		★		☆	★			☆	★	☆		☆	☆	★
		7.14	.281	3.57	.141	7°	21.60	.850	K	N123K2-0714-RO	★					☆		★			★					★		☆		
		8.00	.315	4.00	.157	7°	27.30	1.075	L	N123L2-0800-RO	★	☆				☆	☆	★	☆	☆	★			☆	★	☆	☆	☆	☆	★
Medium feed										**CoroCut® 1-edge**																					
	123-RM	4.00	.157	2.00	.079	7°			G	N123G1-0400-	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
		6.00	.236	3.00	.118	7°			J	N123J1-0600-RM	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
		8.00	.315	4.00	.157	7°			L	N123L1-0800-RM	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
	123-RM									**CoroCut® 2-edge**																					
		3.00	.118	1.50	.059	7°	18.60	.732	F	N123F2-0300-RM	☆	☆	☆	★	☆			★	☆	☆	☆	☆	★	☆	★						
		3.18	.125	1.59	.063	7°	18.60	.732		N123F2-0318-RM	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
		4.00	.157	2.00	.079	7°	18.10	.713	G	N123G2-0400-RM	☆	☆	☆	★	☆			★	☆	☆	☆	☆	★	☆	★						
		4.00	.157	2.00	.079	7°	23.10	.909	H	N123H2-0400-RM	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
		4.75	.187	2.38	.094	7°	22.90	.902		N123H2-0475-RM	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
		5.00	.197	2.50	.098	7°	22.70	.894		N123H2-0500-RM	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
		6.00	.236	3.00	.118	7°	22.20	.874	J	N123J2-0600-RM	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
		6.35	.250	3.18	.125	7°	22.00	.866		N123J2-0635-RM	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
		8.00	.315	4.00	.157	7°	27.00	1.063	L	N123L2-0800-RM	☆	☆	☆	★				★	☆	☆	☆	☆	★	☆	★						
											P30	P35	P15	P20	P10	M10	M15	M25	M30	M15	K30	K15	K25	K20	N20	S15	S15	S25	S15	S10

[1] When using CoroCut® "1"-edge inserts, the a_r of the toolholder gives the maximum depth of cut.

[2] To correspond with seat size on holder.

N = Neutral
★= First choice

For geometry description, see page B124.

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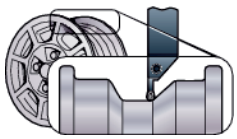
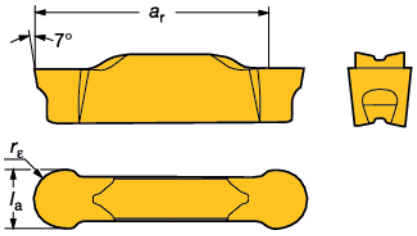
CoroCut® 1- and 2-edge

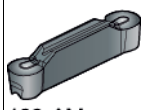
Aluminum profiling





For ISO application areas, see bottom of the table.

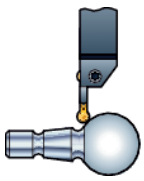
Tolerances, mm (inch):
l_a = ±0.02 (±.0008)

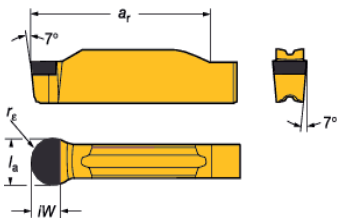
		Selection criteria, millimeter, inch (mm, in.)									N	
		l_a mm	l_a in.	r_ε mm	r_ε in.	α_f	a_r max mm[1]	a_r max in.[1]	Seat size[2]	Ordering code	GC 1005	- H10
										CoroCut® 2-edge		
Medium feed	 123-AM	6.00	.236	3.00	.118	7°	22.2	.874	J	N123J2-0600-AM	★	☆
		8.00	.315	4.00	.157	7°	27.3	1.075	L	N123L2-0800-AM	★	☆
											N10	N10

[1] When using CoroCut® "1"-edge inserts, the a_r of the toolholder gives the maximum depth of cut.

[2] To correspond with seat size on holder.

Profiling non-ferrous and hardened materials





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
±0.02 (±.0008)

		Selection criteria, millimeter, inch (mm, in.)									N	S	H	
		l_a mm	l_a in.	r_ε mm	r_ε in.	α_f	a_r max[1]	iW	Seat size[2]	Ordering code	CD CD10	CB 7015	CB 7015	CB CB20
										CoroCut® 1-edge				
Low feed	 123-S	3	.118	1.5	.059	7°	∞	2.7	F	N123F1-0300S01025			★	
		4	.157	2	.079	7°	∞	3.6	H	N123H1-0400S01025			★	
		5	.197	2.5	.098	7°	∞	4.7		N123H1-0500S01025			★	
		6	.236	3	.118	7°	∞	5.5	J	N123J1-0600S01025			★	
										CoroCut® 1-edge				
	 123-RS	3	.118	1.5	.059	7°	∞	2.7	F	N123F1-0300-RS	★			
		4	.157	2	.079	7°	∞	3.6	H	N123H1-0400-RS	★			
		5	.197	2.5	.098	7°	∞	4.7		N123H1-0500-RS	★			
		6	.236	3	.118	7°	∞	6.6	J	N123J1-0600-RS	★			
		8	.315	4	.157	7°	∞	7	L	N123L1-0800-RS	★			
										CoroCut® 1-edge				
	 123-RE	3	.118	1.5	.059	7°	∞	2.7	F	N123F1-0300-RE		★	★	☆
		3.18	.125	1.59	.063	7°	∞	2.7		N123F1-0318-RE		★	★	☆
		4	.157	2	.079	7°	∞	3.6	H	N123H1-0400-RE		★	★	☆
		5	.197	2.5	.098	7°	∞	4.7		N123H1-0500-RE		★	★	☆
		6	.236	3	.118	7°	∞	5.5	J	N123J1-0600-RE		★	★	☆
		6.35	.250	3.17	.125	7°	∞	5.5		N123J1-0635-RE		★	★	☆
		8	.315	4	.157	7°	∞	7	L	N123L1-0800-RE		★	★	☆
											N01	S15	H15	H01

[1] When using CoroCut® "1"-edge inserts, the a_r of the toolholder gives the maximum depth of cut.

[2] To correspond with seat size on holder.

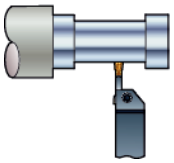
N = Neutral
★= First choice

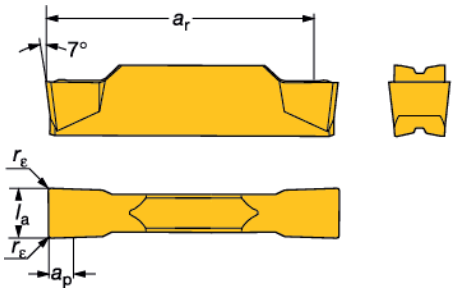
For geometry description, see page B124.

B9 B10 B138 B124 B146 B2 I8

CoroCut® 1- and 2-edge

Turning





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = +0.10/0 (+.004/0)
r_ε = ±0.10 (±.004)

		Selection criteria, mm, inch					Seat size[2]	Ordering code	P						M						K				N	S				
									GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	-	GC	GC	GC	-	-	GC	GC	GC	GC	-
		l_a	r_ε	α_f	a_r max[1]	a_p max			1125	1145	2135	3115	4225	525	1005	1105	1125	1145	2135	H13A	1125	3115	4225	H13A	H13A	1005	1105	1125	2135	H13A
Low feed								**CoroCut® 2-edge**																						
	123-TF	3.00	0.30	7°	18.50	2.60	G	N123G2-0300-0003-TF	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	★	☆	★	☆	★	☆	☆	★	☆	☆
		.118	.012		.728	.102																								
		4.00	0.40	6.5°	23.30	3.50	H	N123H2-0400-0004-TF	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	★	☆	★	☆	★	☆	☆	★	☆	☆
		.157	.016		.917	.138																								
		5.00	0.40		23.30	3.50	J	N123J2-0500-0004-TF	★	☆	☆	☆	☆		☆	☆	☆	☆	★	☆	☆	☆	★	☆	★	☆	☆	☆	☆	★	☆	☆
		.197	.016		.917	.138																								
		6.00	0.40	6°	23.30	3.80	K	N123K2-0600-0004-TF	★	☆	☆	☆	☆		☆	☆	☆	☆	★	☆	☆	☆	★	☆	★	☆	☆	☆	☆	★	☆	☆
		.236	.016		.917	.150																								
		8.00	0.80	7°	28.00	4.00	L	N123L2-0800-0008-TF	★		☆	☆	☆		☆	☆	☆		★	☆	☆	☆	★	☆	★	☆	★	☆		★	☆	☆
		.315	.032		1.102	.157																								
	123-TF							**CoroCut® 1-edge**																						
		3.00	0.30	7°		2.60	G	N123G1-0300-0003-TF	★	☆	☆	☆	☆				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.118	.012			.102																								
		4.00	0.40	6°		3.50	H	N123H1-0400-0004-TF	★	☆	☆	☆	☆				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.157	.016			.138																								
		6.00	0.40			3.80	K	N123K1-0600-0004-TF	★	☆	☆	☆	☆				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.236	.016			.150																								
Medium feed								**CoroCut® 2-edge**																						
	123-TM	3.00	0.40	6°	18.40	3.50	G	N123G2-0300-0004-TM	☆	☆	☆	☆	★				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.118	.016		.724	.138																								
		4.00	0.40	5.5°	23.40	4.60	H	N123H2-0400-0004-TM	☆	☆	☆	☆	★				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.157	.016		.921	.181																								
		4.00	0.80	6°	23.40	4.60		N123H2-0400-0008-TM	☆	☆	☆	☆	★	☆			☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.157	.032		.921	.181																								
		5.00	0.40	5.5°	23.40	4.60	J	N123J2-0500-0004-TM	☆	☆	☆	☆	★				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.197	.016		.921	.181																								
		5.00	0.80		23.00	4.60		N123J2-0500-0008-TM	☆	☆	☆	☆	★				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.197	.032		.906	.181																								
		6.00	0.40	7°	23.40	4.50	K	N123K2-0600-0004-TM	☆	☆	☆	☆	★				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.236	.016		.921	.177																								
		6.00	0.80		23.00	4.50		N123K2-0600-0008-TM	☆	☆	☆	☆	★				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.236	.032		.906	.177																								
		8.00	0.80		28.00	7.00	L	N123L2-0800-0008-TM	☆	☆	☆	☆	★				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.315	.032		1.102	.276																								
		8.00	1.20		27.60	7.00		N123L2-0800-0012-TM	☆	☆	☆	☆	★				☆	☆	★	☆	☆	☆	★	☆	★			☆		★	☆	☆
		.315	.047		1.087	.276																								
									P30	P45	P35	P15	P20	P10	M10	M15	M25	M40	M30	M15	K30	K15	K25	K20	N20	S15	S15	S25	S30	S15

[1] When using CoroCut® "1"-edge inserts, the a_r of the toolholder gives the maximum depth of cut.

[2] To correspond with seat size on holder.

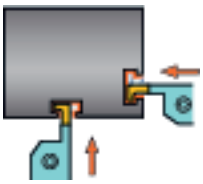
N = Neutral
★= First choice

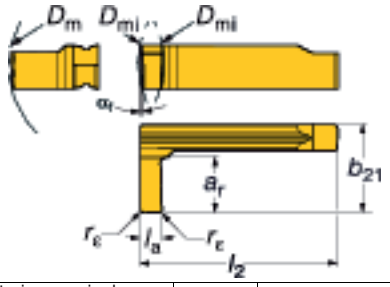
For geometry description, see page B124.

B9 B10 B138 B124 B146 B2 I8

CoroCut® 1-edge inserts

Grooving





For ISO application areas, see bottom of the table.

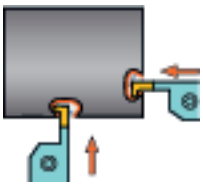
Tolerances, mm (inch):
l_a = ±0.02 (±.001)
r_ε = ±0.05 (±.002)

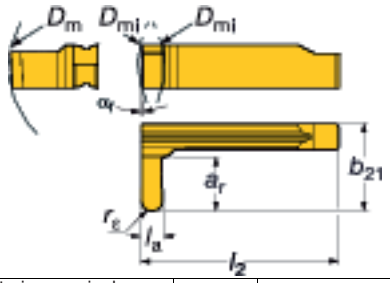
		Selection criteria, mm, inch						Dimensions, mm, inch				P	M	K	N	S
												GC	GC	GC	GC	GC
		l_a	r_ε	α_f	a_r max	Seat size[1]	Ordering code	b_{21}	l_2	D_m	D_{mi}[2]	1115	1115	1115	1115	1115
Low feed	123-GS						**CoroCut® 1-edge**									
		2.0	0.2	6°	4.0	H	R/LG123H1-0200-0002-GS	8.0	25.6	44.0	104.0	☆	★	☆	☆	★
		.079	*.008*		*.157*			*.315*	*1.006*	*1.732*	*4.094*					
		3.0	0.2	6°	5.0		R/LG123H1-0300-0002-GS	9.0	25.6	44.0	104.0	☆	★	☆	☆	★
		.118	*.008*		*.197*			*.354*	*1.006*	*1.732*	*4.094*					
		4.0	0.4	6°	6.0		R/LG123H1-0400-0004-GS	10.0	25.6	44.0	104.0	☆	★	☆	☆	★
		.157	*.016*		*.236*			*.394*	*1.006*	*1.732*	*4.094*					
		2.0	0.2	6°	6.0	L	R/LG123L1-0200-0002-GS	14.0	30.9	62.0	147.0	☆	★	☆	☆	★
		.079	*.008*		*.236*			*.551*	*1.216*	*2.441*	*5.787*					
		3.0	0.2	6°	9.0		R/LG123L1-0300-0002-GS	17.0	30.9	62.0	147.0	☆	★	☆	☆	★
		.118	*.008*		*.354*			*.669*	*1.216*	*2.441*	*5.787*					
		4.0	0.4	6°	9.0		R/LG123L1-0400-0004-GS	17.0	30.9	62.0	147.0	☆	★	☆	☆	★
		.157	*.016*		*.354*			*.669*	*1.216*	*2.441*	*5.787*					
												P15	M15	K15	N15	S20

[1] To correspond with seat size on holder.
[2] Facegrooving minimum first cut diameter.

R = Right hand, L = Left hand
★= First choice

Profiling





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = ±0.02 (±.0008)
r_ε = ±0.05 (±.002)

		Selection criteria, mm, inch						Dimensions, mm, inch				P	M	K	N	S
												GC	GC	GC	GC	GC
		l_a	r_ε	α_f	a_r max	Seat size[1]	Ordering code	b_{21}	l_2	D_m	D_{mi}[2]	1115	1115	1115	1115	1115
Low feed	123-RS						**CoroCut® 1-edge**									
		2.0	1.0	6°	4.0	H	R/LG123H1-0200-0010-RS	8.0	25.6	44.0	104.0	☆	★	☆	☆	★
		.079	*.039*		*.157*			*.315*	*1.006*	*1.732*	*4.094*					
		3.0	1.5	6°	5.0		R/LG123H1-0300-0015-RS	9.0	25.6	44.0	104.0	☆	★	☆	☆	★
		.118	*.059*		*.197*			*.354*	*1.006*	*1.732*	*4.094*					
		4.0	2.0	6°	6.0		R/LG123H1-0400-0020-RS	10.0	25.6	44.0	104.0	☆	★	☆	☆	★
		.157	*.079*		*.236*			*.394*	*1.006*	*1.732*	*4.094*					
		2.0	1.0	6°	6.0	L	R/LG123L1-0200-0010-RS	14.0	30.9	62.0	147.0	☆	★	☆	☆	★
		.079	*.039*		*.236*			*.551*	*1.216*	*2.441*	*5.787*					
		3.0	1.5	6°	9.0		R/LG123L1-0300-0015-RS	17.0	30.9	62.0	147.0	☆	★	☆	☆	★
		.118	*.059*		*.354*			*.669*	*1.216*	*2.441*	*5.787*					
		4.0	2.0	6°	9.0		R/LG123L1-0400-0020-RS	17.0	30.9	62.0	147.0	☆	★	☆	☆	★
		.157	*.079*		*.354*			*.669*	*1.216*	*2.441*	*5.787*					
												P15	M15	K15	N15	S20

[1] To correspond with seat size on holder.
[2] Facegrooving minimum first cut diameter.

R = Right hand, L = Left hand
★= First choice

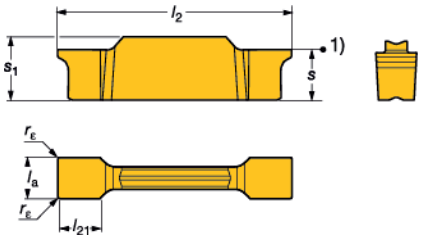
For geometry description, see page B124.

B9 B10 B138 B124 B146 B2 I8

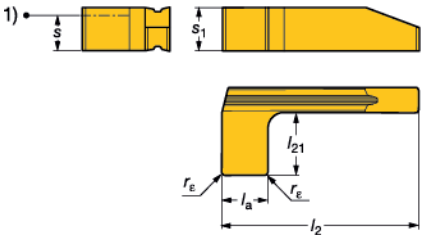
CoroCut® 1- and 2-edge

Blanks

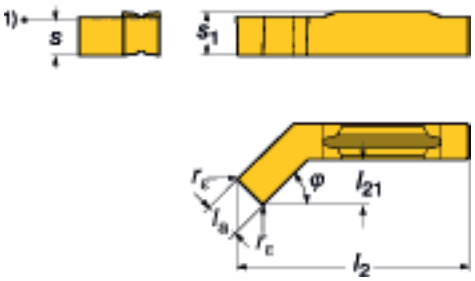
0° blanks



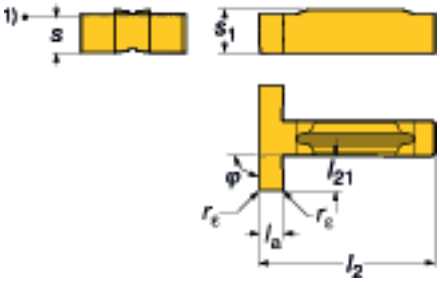
90° blanks



45° blanks



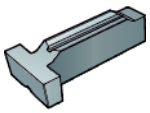
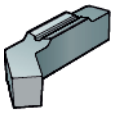
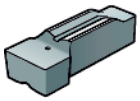
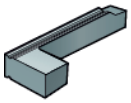
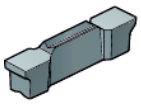
T-shape



1) Cutting edge height
Right hand style shown

Dimension $l_a \times l_{21}$ is grinding area for specific profiles.

Tolerances, mm (inch):
l_a ±0-10 (±.004)
l_2 ±0.30 (±.012)
l_{21} ±0.30 (±.012)
For T-shape:
l_a +0.15/-0.05 (+.006/-.002)
l_2 ±0.30 (±.012)
l_{21} ±0.30 (±.012)

	Selection criteria, mm, inch						Dimensions, mm, inch				P			M			K			N			S		
	l_a	ψ_r	r_ε	Width range min	Width range max	Seat size[1]	Ordering code	l_2	l_{21}	s	s_1	H10	H10F	H13A	H10	H10F	H13A	H10	H10F	H13A	H10	H10F	H13A	H10	H10F	H13A
							CoroCut® 2-edge																			
 123-BG	4.0	90°	0.2		3.9	L	NX123L2-0400-BG	31.21	5.01	6.05	7.40	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	.157		.008		.154			1.229	.197	.238	.291															
							CoroCut® 1-edge																			
 123-BG	6.0	45°	0.2		5.9	L	R/LX123L1-0600-4500-BG	40.19	7.59	6.05	7.40	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	.236		.008		.232			1.582	.299	.238	.291															
							CoroCut® 1-edge																			
 123-BG	11.6		0.2	8	11.2	L	N123L1-1160-0002-BG	30.50	7.8	6.05	7.40		☆			☆	☆		☆	☆	☆	☆	☆	☆		☆
	.457		.008	.315	.441			1.201	.307	.238	.291															
							CoroCut® 1-edge																			
 123-BG	6.0		0.2		5.9	H	R/LG123H1-0600-BG	25.65	8	4.35	5.50	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	.236		.008		.232			1.010	.315	.171	.216															
	6.0		0.2		5.9	L	R/LG123L1-0600-BG	31.00	12	6.05	7.40	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	.236		.008		.232			1.220	.472	.238	.291															
							CoroCut® 2-edge																			
 123-BG	2.3		0.2	1.5	1.9	D	N123D2-0230-0002-BG	15.00	2.8	4.10	4.60		★			★	☆		★	☆	☆	★	☆	☆		☆
	.091		.008	.059	.075			.591	.110	.161	.181															
	2.7		0.2	1.9	2.3	E	N123E2-0270-0002-BG	21.60	3.8	4.30	5.20		★			★	☆		★	☆	☆	★	☆	☆		☆
	.106		.008	.075	.091			.850	.150	.169	.205															
	3.8		0.2	2.3	3.4	F	N123F2-0380-0002-BG	21.60	4	4.30	5.20		★			★	☆		★	☆	☆	★	☆	☆		☆
	.150		.008	.091	.134			.850	.157	.169	.205															
	4.2		0.2	2.6	3.8	G	N123G2-0420-0002-BG	21.60	4.7	4.30	5.20		★			★	☆		★	☆	☆	★	☆	☆		☆
	.165		.008	.102	.150			.850	.185	.169	.205															
	5.2		0.2	3.2	4.8	H	N123H2-0520-0002-BG	26.20	6	4.35	5.50		★			★	☆		★	☆	☆	★	☆	☆		☆
	.205		.008	.126	.189			1.032	.236	.171	.216															
	6.2		0.2	4.5	6.8	J	N123J2-0620-0002-BG	26.20	6	4.35	5.50		★			★	☆		★	☆	☆	★	☆	☆		☆
	.244		.008	.177	.268			1.032	.236	.171	.216															
	7.2		0.2	5.5	6.8	K	N123K2-0720-0002-BG	26.20	6	4.35	5.50		★			★	☆		★	☆	☆	★	☆	☆		☆
	.284		.008	.216	.268			1.032	.236	.171	.216															
	8.4		0.2	6.5	8	L	N123L2-0840-0002-BG	31.50	7	6.05	7.40		★			★	☆		★	☆	☆	★	☆	☆		☆
	.331		.008	.256	.315			1.240	.276	.238	.291															
													P20			M10	M15			K20	N10	N20	N20	S15	S15	S15

1) To correspond with seat size on holder.
Note: Precaution should be taken when grinding cemented carbide products. See page J7 for safety information.

R = Right hand, L = Left hand
★= First choice

B9 B10 B138 B124 B146 B2 J3 I8

Code key for CoroCut® holders

Coromant Capto®

C4	–	R	F	123	E	15	–	27055	B
1		2	3	4	5	6		7	8

Shank holder **Metric**

R	F	123	E	08	–	1616	B	–	007	064	B
2	3	4	5	6		7	8		10	12	13

Inch

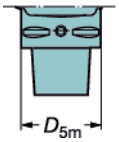
R	F	123	E	059	–	08	B	–	S
2	3	4	5	6		7	8		11

Blade

N	123	F	55	–	25	A	2
2	4	5	6		7	8	9

1 Coupling size

C = Coromant Capto®
D_{5m} = Coupling size

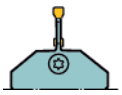


	D_{5m} mm	Inch
C3	32	(1.260)
C4	40	(1.575)
C5	50	(1.968)
C6	63	(2.480)
C8	80	(3.150)

2 Hand of tool

R

N

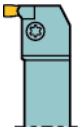


L

3 Holder style

F 0°

G 90°



X 1-70°

4 Main code

123

5 Insert seat size

CoroCut® 1-2

D	G	K
E	H	L
F	J	M
		R

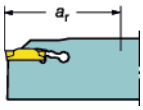
CoroCut® 3

T = Right hand cutting

U = Left hand cutting

To correspond with seat size on insert.

6 Machining limitations

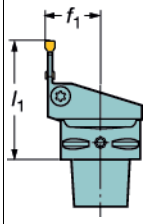


Max cutting depth a_r in mm

Metric 08 = 8 mm
Inch 059 = .590 inch

7 Shank/cutting unit dimension

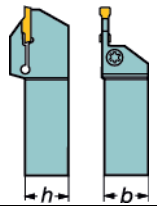
Coromant Capto®

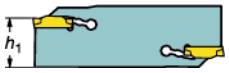


For example:

f_1	l_1
27 mm	055 mm
1.063 inch	2.165 inch

Shank tool





Blade
Dimensions in mm.

Inch
Shank size in 1/16 inch

eg. 08 = 8/16 = 1/2 inch

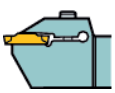
h* x *b
08

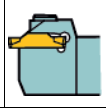
Metric
Integers to be preceded by 0, e.g., b = 8 mm indicated by 08

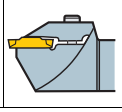
h	b
16	16

8 Clamping system

A	B	C	D
Spring clamp	Screw clamp	Shallow grooving	Screw clamp reinforced







9 Number of insert seats

1 One insert seat

2 Two insert seats

10 Holder angle

007 = 7°
045 = 45°
070 = 70°

Valid for holder style = X

11 Special application

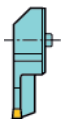
S = Holder for small part machines

12 Min. diameter for first cut, for facegrooving

Min. diameter for first cut in mm.

13 Type of curve, for facegrooving

B = B curve



A = A curve

CoroCut® 1- and 2-edge

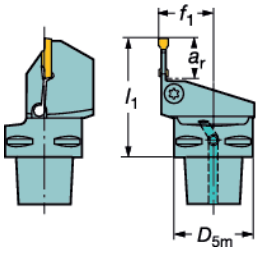
Coromant Capto® cutting units with short a_r

Screw clamp

Tailor Made

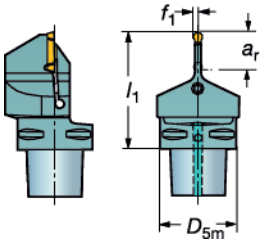
Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

Cx-R/LF123



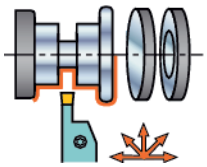
Right hand

Cx-NF123



Neutral

Coolant inlet: Radial through the taper

Main application	a_r max mm[1]	a_r max inch[1]	Seat size[2]	Ordering code	Dimensions, millimeter, inch (mm, in.) D_{5m} mm	D_{5m} in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[3]
	8	.315	D	C3-R/LF123D08-22050B	32	1.260	22	.866	50	1.968	N123D2-0150- CM	2.0
	8	.315		C4-R/LF123D08-27050B	40	1.575	27	1.063	50	1.968	N123D2-0150- CM	3.0
	8	.315		C5-R/LF123D08-35055B	50	1.968	35	1.378	55	2.165	N123D2-0150- CM	2.0
	15	.591		C3-R/LF123D15-22050B	32	1.260	22	.866	50	1.968	N123D2-0150- CM	3.5
	15	.591		C4-R/LF123D15-27055B	40	1.575	27	1.063	55	2.165	N123D2-0150- CM	3.5
	15	.591		C5-R/LF123D15-35055B	50	1.968	35	1.378	55	2.165	N123D2-0150- CM	3.5
	8	.591	E	C3-R/LF123E08-22050B	32	1.260	22	.866	50	1.968	N123E2-0200- CM	2.0
	8	.315		C4-R/LF123E08-27050B	40	1.575	27	1.063	50	1.968	N123E2-0200- CM	3.7
	8	.315		C5-R/LF123E08-35060B	50	1.968	35	1.378	60	2.362	N123E2-0200- CM	2.0
	15	.591		C3-R/LF123E15-22055B	32	1.260	22	.866	55	2.165	N123E2-0200- CM	4.0
	15	.591		C4-R/LF123E15-27055B	40	1.575	27	1.063	55	2.165	N123E2-0200- CM	4.0
	15	.591		C5-R/LF123E15-35060B	50	1.968	35	1.378	60	2.362	N123E2-0200- CM	4.0
	10	.394	F	C3-R/LF123F10-22050B	32	1.260	22	.866	50	1.968	N123F2-0250- CM	3.0
	10	.394		C4-R/LF123F10-27050B	40	1.575	27	1.063	50	1.968	N123F2-0250- CM	5.0
	10	.394		C5-R/LF123F10-35060B	50	1.968	35	1.378	60	2.362	N123F2-0250- CM	2.5
	20	.787		C3-R/LF123F20-22055B	32	1.260	22	.866	55	2.165	N123F2-0250- CM	4.0
	20	.787		C4-R/LF123F20-27060B	40	1.575	27	1.063	60	2.362	N123F2-0250- CM	4.0
	20	.787		C5-R/LF123F20-35060B	50	1.968	35	1.378	60	2.362	N123F2-0250- CM	4.0
	10	.394	G	C3-R/LF123G10-22050B	32	1.260	22	.866	50	1.968	N123G2-0300-CM	4.5
	10	.394		C4-R/LF123G10-27055B	40	1.575	27	1.063	55	2.165	N123G2-0300-CM	4.0
	10	.394		C5-R/LF123G10-35060B	50	1.968	35	1.378	60	2.362	N123G2-0300-CM	4.5
	10	.394		C6-R/LF123G10-45065B	63	2.480	45	1.772	65	2.559	N123G2-0300-CM	3.0
	20	.787		C3-R/LF123G20-22055B	32	1.260	22	.866	55	2.165	N123G2-0300-CM	5.0
	20	.787		C4-R/LF123G20-27060B	40	1.575	27	1.063	60	2.362	N123G2-0300-CM	5.0
	20	.787		C5-R/LF123G20-35060B	50	1.968	35	1.378	60	2.362	N123G2-0300-CM	5.0
	20	.787		C6-R/LF123G20-45065B	63	2.480	45	1.772	65	2.559	N123G2-0300-CM	5.0
	13	.512	H	C3-R/LF123H13-22055B	32	1.260	22	.866	55	2.165	N123H2-0400- CM	4.5
	13	.512		C4-R/LF123H13-27055B	40	1.575	27	1.063	55	2.165	N123H2-0400- CM	7.5
	13	.512		C5-R/LF123H13-35060B	50	1.968	35	1.378	60	2.362	N123H2-0400- CM	5.0
	13	.512		C6-R/LF123H13-45065B	63	2.480	45	1.772	65	2.559	N123H2-0400- CM	4.0
	20	.787		C3-R/LF123H20-22060B	32	1.260	22	.866	60	2.362	N123H2-0400- CM	7.0
	25	.984		C4-R/LF123H25-27067B	40	1.575	27	1.063	67	2.638	N123H2-0400- CM	7.0
	25	.984		C5-R/LF123H25-35067B	50	1.968	35	1.378	67	2.638	N123H2-0400- CM	7.0
	25	.984		C6-R/LF123H25-45070B	63	2.480	45	1.772	70	2.756	N123H2-0400- CM	7.0
	13	.512	J	C4-R/LF123J13-27055B	40	1.575	27	1.063	55	2.165	N123J2-0500- CM	7.5
	13	.512		C5-R/LF123J13-35060B	50	1.968	35	1.378	60	2.362	N123J2-0500- CM	5.0
	13	.512		C6-R/LF123J13-45065B	63	2.480	45	1.772	65	2.559	N123J2-0500- CM	4.0
	13	.512		C8-R/LF123J13-42080B	80	3.150	42	1.654	80	3.150	N123J2-0500- GM	3.5
	25	.984		C4-R/LF123J25-27067B	40	1.575	27	1.063	67	2.638	N123J2-0500- CM	6.0
	25	.984		C5-R/LF123J25-35067B	50	1.968	35	1.378	67	2.638	N123J2-0500- CM	6.0
	25	.984		C6-R/LF123J25-45070B	63	2.480	45	1.772	70	2.756	N123J2-0500- CM	6.0

1) a_r max. for holder. For max stability choose a holder with shortest possible a_r.
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.

N = Neutral, R = Right hand, L = Left hand

 B6
 B111
 G6
 B2
 B35
 J3
 J2

SANDVIK Coromant

CoroCut® 1- and 2-edge

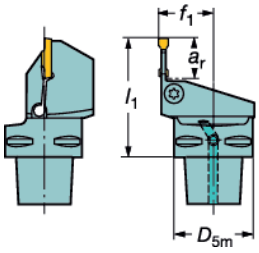
Coromant Capto® cutting units with short a_r

Screw clamp

Tailor Made

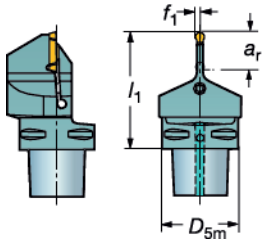
Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

Cx-R/LF123



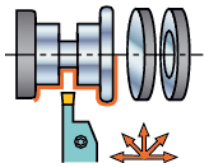
Right hand

Cx-NF123



Neutral

Coolant inlet: Radial through the taper

Main application	a_r max mm[1]	a_r max inch[1]	Seat size[2]	Ordering code	Dimensions, millimeter, inch (mm, in.) D_{5m} mm	D_{5m} in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[3]
	16	.630	K	**C4-R/LF123K16-27060B**	40	1.575	27	1.063	60	2.362	N123K2-0600-CR	6.5
	16	.630		**C5-R/LF123K16-35060B**	50	1.968	35	1.378	60	2.362	N123K2-0600-CR	7.0
	16	.630		**C6-R/LF123K16-45065B**	63	2.480	45	1.772	65	2.559	N123K2-0600-CR	5.2
	16	.630		**C8-R/LF123K16-42080B**	80	3.150	42	1.654	80	3.150	N123K2-0600-GM	4.0
	25	.984		**C4-R/LF123K25-27070B**	40	1.575	27	1.063	70	2.756	N123K2-0600-CR	6.0
	25	.984		**C5-R/LF123K25-35070B**	50	1.968	35	1.378	70	2.756	N123K2-0600-CR	6.0
	25	.984		**C6-R/LF123K25-45075B**	63	2.480	45	1.772	75	2.953	N123K2-0600-CR	6.0
	13	.512	L	**C5-R/LF123L13-35060B**	50	1.968	35	1.378	60	2.362	N123L2-0800- GM	5.5
	16	.630		**C6-R/LF123L16-45065B**	63	2.480	45	1.772	65	2.559	N123L2-0800- GM	5.5
	25	.984		**C5-R/LF123L25-35070B**	50	1.968	35	1.378	70	2.756	N123L2-0800- GM	7.0
	25	.984		**C6-R/LF123L25-45075B**	63	2.480	45	1.772	75	2.953	N123L2-0800- GM	7.0
	25	.984		**C8-R/LF123L25-42080B**	80	3.150	42	1.654	80	3.150	N123L2-0800- GM	8.0

1) a_r max. for holder. For max stability choose a holder with shortest possible a_r.

N = Neutral, R = Right hand, L = Left hand

2) To correspond with seat size on insert.

3) Insert tightening torque, Nm. Use torque wrench, see page B110.

Main spare parts

Seat size	Cutting unit size	Screw	Key (Torx Plus)
D, E, F	C3-C5	3212 012-259	5680 043-14 (20IP)
G	C3-C6	3212 012-310	5680 043-15 (25IP)
H, J, K, L	C4-C6	3212 012-360	5680 043-17 (30IP)

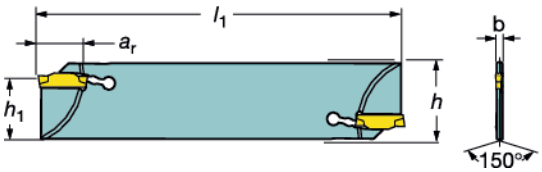
 B6
 B111
 G6
 B2
 B35
 J3
 J2

CoroCut® 1- and 2-edge

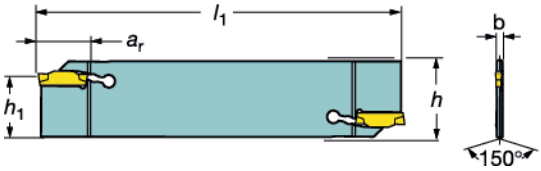
Double ended parting blade

Spring clamp

Design 1 Blades with curved reinforcement
N123

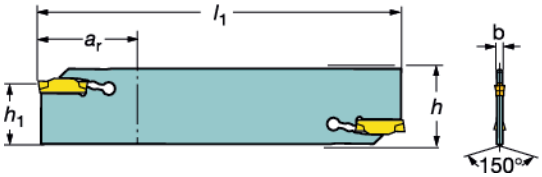


Design 2 Blades with straight reinforcement
N123

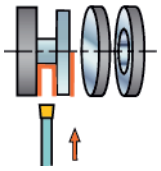


Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

Design 3 Blades without reinforcement
N123



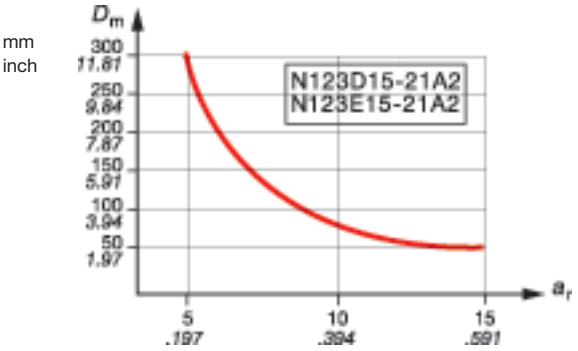
Neutral style

Main application	Design	a_r min mm[1]	a_r min inch[1]	a_r max mm[1]	a_r max inch[1]	Seat size[2]	Ordering code	Dimensions, millimeter, inch (mm, in.) b mm	b in.	h mm	h in.	h_1 mm	h_1 in.	l_1 mm	l_1 in.	Gauge inserts
	1	5	.197	15	.591	D	**N123D15-21A2**[3]	1	.039	25.9	1.020	21.4	.842	110	4.331	N123D2-0150- CM
	1	5	.197	15	.591	E	**N123E15-21A2**[3]	1.5	.059	25.9	1.020	21.4	.842	110	4.331	N123E2-0200- CM
	2			15	.591	D	**N123D15-25A2**	1	.039	31.9	1.256	25	.984	150	5.906	N123D2-0150- CM
	2			20	.787	E	**N123E20-25A2**	1.5	.059	31.9	1.256	25	.984	150	5.906	N123E2-0200- CM
	3			30	1.181	F	**N123F30-21A2**	2	.080	25.9	1.020	21.4	.842	110	4.331	N123F2-0250- CM
	3			55	2.165		**N123F55-25A2**	2	.080	31.9	1.256	25	.984	150	5.906	N123F2-0250- CM
	3			30	1.181	G	**N123G30-21A2**	2.3	.090	25.9	1.020	21.4	.842	110	4.331	N123G2-0300-CM
	3			55	2.165		**N123G55-25A2**	2.3	.090	31.9	1.256	25	.984	150	5.906	N123G2-0300-CM
	3			55	2.165	H	**N123H55-25A2**	3.3	.130	31.9	1.256	25	.984	150	5.906	N123H2-0400- CM
	3			55	2.165	J	**N123J55-25A2**	4.5	.177	31.9	1.256	25	.984	150	5.906	N123J2-0500- CM
	3			55	2.165	K	**N123K55-25A2**	5.5	.216	31.9	1.256	25	.984	150	5.906	N123K2-0600-CR

1) For max stability adjust to shortest position
2) To correspond with seat size on insert.
3) For min. and max. a_r at respective workpiece diameters (D_m), see diagrams below for cutting depth limitation.

Cutting depth limitation for reinforced CoroCut® blades

Due to re-inforcement of the blade the max. cutting depth is dependent on the work piece diameter. (inch)



Max. cutting depth
mm
inch

Main spare parts

Seat size	Insert key[1]
D-K	5680 058-01

1) Must be ordered separately.

 B6
 B115
 G6
 B2
 B32
 J2

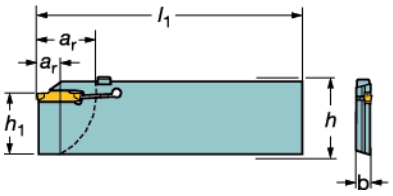
CoroCut® 1- and 2-edge

Single ended parting blade

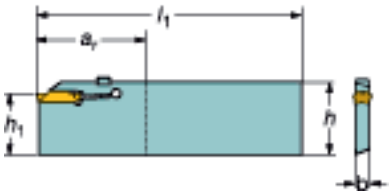
Screw clamp

Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

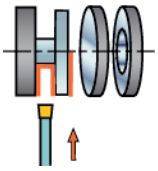
Blades with curved reinforcement
R/LF123



R/LF123M
R/LF123R



Right hand style shown

Main application	a_r min mm[1]	a_r min inch[1]	a_r max mm[1]	a_r max inch[1]	Seat size[2]	Ordering code	Dimensions, millimeter, inch (mm, in.) b mm	b in.	h mm	h in.	h_1 mm	h_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[3]
	5	.197	25	.984	E	**R/LF123E25-25B1**	8	.315	31.9	1.256	25	.984	150	5.906	N123E2-0200- CM	3.3
	5	.197	25	.984	F	**R/LF123F25-25B1**	8	.315	31.9	1.256	25	.984	150	5.906	N123F2-0250- CM	3.6
	5	.197	25	.984	G	**R/LF123G25-25B1**	8	.315	31.9	1.256	25	.984	150	5.906	N123G2-0300-CM	4.5
	25	.906	32	1.260	H	**R/LF123H32-25B1**	8	.315	31.9	1.256	25	.984	150	5.906	N123H2-0400- CM	4.9
			100	3.937	M	**R/LF123M100-45B1**	8.15	.231	50.8	2.000	45	1.772	250	9.842	N123M1-1100-GM	4.5
			120	4.724		**R/LF123M120-93B1**	8.15	.231	101.6	4.000	93	3.680	300	11.811	N123M1-1100-GM	4.5
			120	4.724	R	**R/LF123R120-93B1**	11.10	.457	101.6	4.000	93	3.680	300	11.811	N123R1-1500-GR	4.5

R = Right hand, L = Left hand

1) For min. and max. a_r at respective workpiece diameters (D_m), see diagrams below for cutting depth limitation.
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.

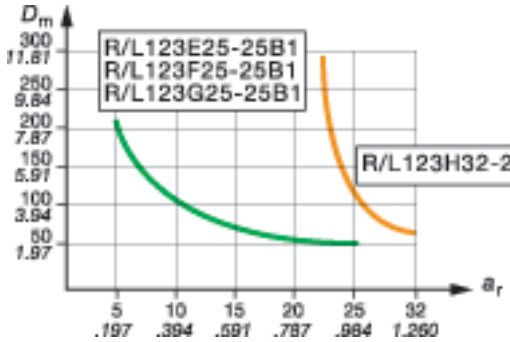
Cutting depth limitation for reinforced CoroCut® blades

Due to reinforcement of the blade, the max. cutting depth is dependent on the workpiece diameter.

Screw clamp blades

Workpiece diameter, inch

mm
inch



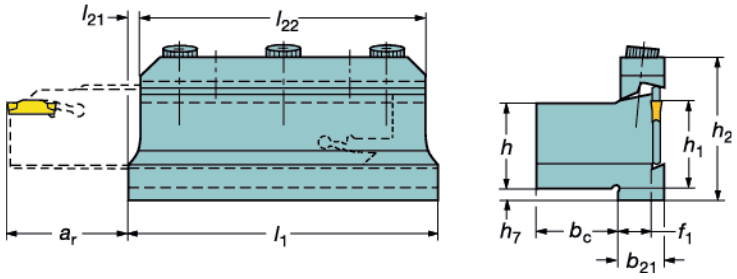
Max. cutting depth
mm
inch

Main spare parts

Seat size	Screw	Key (Torx Plus)
E-H	3212 012 259	5680 043-14 (20IP)
M	5512 046-01	5680 043-15 (25IP)
R	3212 012-311	5680 043-15 (25IP)

 B6
 B115
 G6
 B2
 B32
 J2

Toolblock for parting blades



Metric version

Cutting edge height on blades	a_r max	Ordering code	Dimensions									
			b_{21}	b_c	f_1	h	h_1	h_2	h_7	l_1	l_{21}	l_{22}
21	35	**151.2-2020-21M**	18.0	20.0	13.4	20	20	45.5	10.0	80	5	70
21	35	**151.2-2520-21**	18.0	20.0	13.4	25	25	45.5	10.0	80	5	70
25	60	**151.2-2020-25**	18.0	20.0	13.4	20	25	52.5	10.0	120	5	110
25	60	**151.2-2520-25**	18.0	20.0	13.4	25	25	52.5	10.0	120	5	110
25	60	**151.2-3232-25**	18.0	32.0	13.4	32	32	54.5	5.0	120	5	110
45	100	**151.2-3232-45**	20.4	31.6	13.4	32	32	82.5	29.7	160	5	150
45	100	**151.2-4040-45**	20.4	39.6	13.4	40	40	82.5	21.7	160	5	150
93		**151.2-5050-93**	29.1	49.0	19.7	50	50.5	152.3	68.4	178	-	-

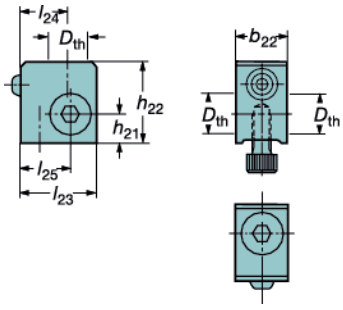
Inch version

Cutting edge height on blades	a_r max	Ordering code	Dimensions, inch									
			b_{21}	b_c	f_1	h	h_1	h_2	h_7	l_1	l_{21}	l_{22}
21	1.38	**151.2-12-21M**	.730	.730	.5299	.750	.750	1.790	.430	3.150	.197	2.756
25	2.36	**151.2-16-25M**	.730	.980	.5299	1.000	1.000	1.790	.430	4.720	.197	4.331
25	2.36	**151.2-20-25M**	.730	1.230	.5299	1.250	1.250	2.150	.210	4.720	.197	4.331
25	2.36	**151.2-24-25M**	.730	1.480	.5299	1.500	1.500	2.400	.200	4.720	.197	4.331
45	3.93	**151.2-20-45**	.800	1.230	.5299	1.250	1.250	3.250	1.181	6.299	.197	5.906
45	3.93	**151.2-24-45**	.800	1.480	.5299	1.500	1.500	3.250	1.929	6.299	.197	5.906
93		**151.2-32-93**	1.146	1.929	.7717	1.969	.2.000	5.996	2.693	7.008	-	-

Main spare parts

Tool block mm	Tool block Inch	Clamp	Clamp screw	Key (mm)
151.2-2020-21M	151.2-12-21M	5412 120-01	3212 010-410	3021 010-060 (6.0)
151.2-2520-21		5412 120-01	3212 010-410	3021 010-060 (6.0)
151.2-2020-25	151.2-16-25M	5412 120-02	3212 010-411	3021 010-060 (6.0)
151.2-2520-25	151.2-20-25M	5412 120-02	3212 010-411	3021 010-060 (6.0)
151.2-3232-25	151.2-24-25M	5412 120-02	3212 010-411	3021 010-060 (6.0)
151.2-3232-45	151.2-20-45	5412 120-03	3212 010-412	3021 010-060 (6.0)
151.2-4040-45	151.2-24-45	5412 120-03	3212 010-412	3021 010-060 (6.0)
151.2-5050-93	151.2-32-93	5412 120-04	3212 010-464	3021 010-080 (8.0)

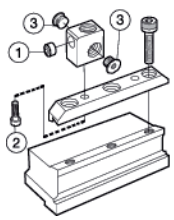
Coolant adapter for tool blocks and adapters



Cutting edge height on blades	Ordering code	Dimensions, mm, inch						
		b_{22}	h_{21}	h_{22}	l_{23}	l_{24}	l_{25}	D_{th}
21, 25, 45	5691 050-011	17	10	28	26	16.2	17.2	G¼"
		.669	*.394*	1.102	1.024	*.638*	*.677*	*G¼"*

Ordering example: 2 pieces 5691 050-011

Assembling



Main spare parts

1	2	3		
Nozzle	Mounting screw	Plug	Key (mm) for plug	Key (mm) for mounting screw
5691 029-02	3212 010-358	5519 055-01	3021 010-060 (6.0)	3021 010-050 (5.0)


B122

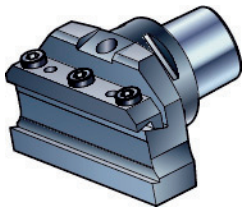

B2

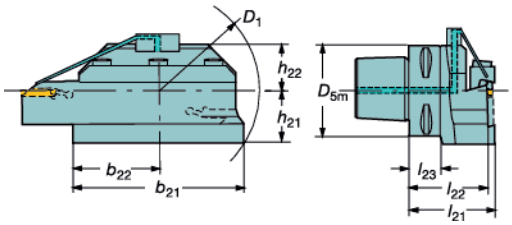

J2

Adapter for CoroCut® and T-Max Q-Cut® parting blades

Coromant Capto®

Radial mounting





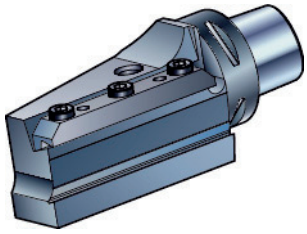
Neutral style shown

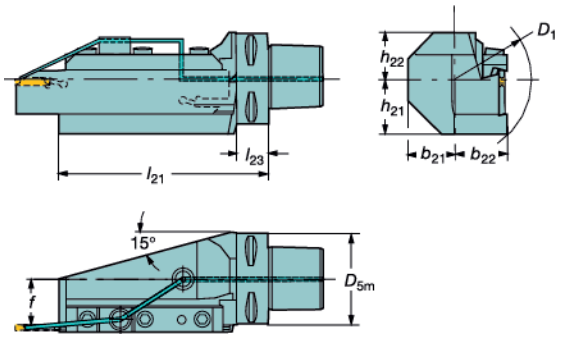
For blade size	Coupling size	Ordering code	Dimensions, mm, inch									
			D_{5m}	b_{21}	b_{22}	D_1	h_{21}	h_{22}	l_{21}	l_{22}	l_{23}	kg
21	C5	C5-APBA-40058-21	50	80	40	100	30	25.2	58	53	20	1.32
			1.968	*3.150*	*1.575*	*3.937*	*1.181*	*.992*	*2.284*	*2.087*	*.787*	
25	C6	C6-APBA-60060-25	63	120	60	141	37	32	60	55	22	2.34
			2.480	*4.724*	*2.362*	*5.551*	*1.457*	*1.260*	*2.362*	*2.165*	*.866*	
	C8	C8-APBA-60068-25	80	120	60	145	40.5	40	68	63	30	3.47
			3.150	*4.724*	*2.362*	*5.709*	*1.594*	*1.575*	*2.677*	*2.480*	*1.181*	
45	C6	C6-APBA-80068-45	63	160	80	198	72	42	68	60.5	23.2	5.42
			2.480	*6.299*	*3.150*	*7.795*	*2.835*	*1.654*	*2.677*	*2.382*	*.913*	
	C8	C8-APBA-80068-45	80	160	80	198	72	42	68	60.5	31.2	
			3.150	*6.299*	*3.150*	*7.795*	*2.835*	*1.654*	*2.677*	*2.382*	*1.228*	

Adapter for CoroCut® and T-Max Q-Cut® parting blades

Coromant Capto®

Axial mounting





Right hand style shown

For blade size	Coupling size	Ordering code	Dimensions, mm, inch									
			D_{5m}	b_{21}	b_{22}	D_1	f	h_{21}	h_{22}	l_{21}	l_{23}	kg
21	C5	C5-APBR/L-31095-21	50	25.5	31	87	26	30	26	95	20	1.64
			1.968	*1.004*	*1.220*	*3.425*	*1.024*	*1.181*	*1.024*	*3.740*	*.787*	
25	C6	C6-APBR/L-37147-25	63	32	37	106	32	38	32	147	22	3.34
			2.480	*1.260*	*1.457*	*4.173*	*1.260*	*1.496*	*1.260*	*5.787*	*.866*	
25	C8	C8-APBR/L-46155-25	80	40	45.5	122	40.5	40.5	40.5	155	30	5.18
			3.150	*1.575*	*1.791*	*4.803*	*1.594*	*1.594*	*1.594*	*6.102*	*1.181*	

R = Right hand, L = Left hand

Warning!
The adapters are designed for automatic tool change.
Make sure that there is no risk of interference in the magazine and tool changing cycle.

Coolant adapter ordered separately. See page B32

Main spare parts

Adapters	Screw	Clamp	Plug	Key (mm)
C5-APBA-40058-21	3212 010-410	5412 120-01	5519 055-01	3021 010-060 (6.0)
C6-APBA-60060-25	3212 010-411	5412 120-02	5519 055-01	3021 010-060 (6.0)
C8-APBA-60068-25	3212 010-411	5412 120-02	5519 055-01	3021 010-060 (6.0)
C6-APBA-80068-45	3212 010-412	5412 120-03	5519 055-01	3021 010-060 (6.0)
C8-APBA-80068-45	3212 010-412	5412 120-03	5519 055-01	3021 010-060 (6.0)
C5-APBR/L-31095-21	3212 010-410	5412 120-01	5519 055-01	3021 010-060 (6.0)
C6-APBR/L-37147-25	3212 010-411	5412 120-02	5519 055-01	3021 010-060 (6.0)
C8-APBR/L-46155-25	3212 010-411	5412 120-02	5519 055-01	3021 010-060 (6.0)

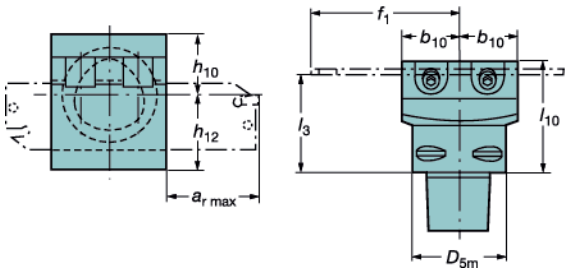

B121


G6


B2


J2

Adapter for CoroCut® and T-Max Q-Cut® parting blades



For blade size	Coupling size	Ordering code	Dimensions, mm, inch							
			a_r max	b_{10}	D_{5m}	f_1	h_{10}	h_{12}	l_3	l_{10}
21	C4	**C4-151.2-25040-21**	44.45	24.89	40	69.34	24.89	29.97	40.13	45.21
			1.750	*.980*	*1.575*	*2.730*	*.980*	*1.180*	*1.580*	*1.780*
21	C5	**C5-151.2-33040-21**	44.45	33.02	50	77.47	32	35.05	40.13	45.21
			1.750	*1.300*	*1.968*	*3.050*	*1.260*	*1.380*	*1.580*	*1.780*
25		**C5-151.2-33040-25**	76.2	33.02	50	109.22	32	35.05	40.13	45.21
			3.000	*1.300*	*1.968*	*4.300*	*1.260*	*1.380*	*1.580*	*1.780*


B121

G6

B2

J2

CoroCut® 1- and 2-edge

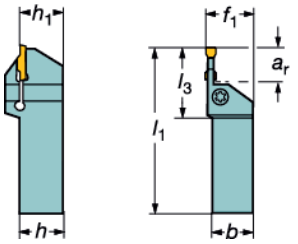
Shank tools

Screw clamp

Tailor Made

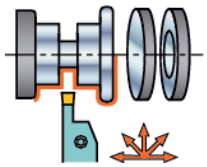
Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

R/L123



Right hand style shown

Metric version

Main application	a_r max[1]	Seat size[2]	Ordering code	Dimensions b	f1	h	h1	l1	l3	Gauge inserts	Nm[3]
	8	D	R/LF123D08-1212B	12	13	12	12	125	25.5	N123D2-0150- CM	2.5
	8		R/LF123D08-1616B	16	17	16	16	100	25.5	N123D2-0150- CM	2.5
	8		R/LF123D08-2020B	20	21	20	20	125	25.5	N123D2-0150- CM	2.5
	8		R/LF123D08-2525B	25	26	25	25	150	25.5	N123D2-0150- CM	2.5
	15		R/LF123D15-1616B	16	17	16	16	100	33.5	N123D2-0150- CM	3.5
	15		R/LF123D15-2020B	20	21	20	20	125	33.5	N123D2-0150- CM	3.5
	15		R/LF123D15-2525B	25	26	25	25	150	33.5	N123D2-0150- CM	3.5
	8	E	R/LF123E08-1212B	12	13	12	12	125	25.5	N123E2-0200- CM	2.5
	8		R/LF123E08-1616B	16	17	16	16	125	25.5	N123E2-0200- CM	2.5
	8		R/LF123E08-2020B	20	21	20	20	125	25.5	N123E2-0200- CM	2.5
	8		R/LF123E08-2525B	25	26	25	25	150	25.5	N123E2-0200- CM	2.5
	12		R/LF123E12-1212B	12	13	12	12	125	30.5	N123E2-0200- CM	3.5
	15		R/LF123E15-1616B	16	17	16	16	125	33.5	N123E2-0200- CM	4.0
	15		R/LF123E15-2020B	20	21	20	20	125	33.5	N123E2-0200- CM	4.0
	15		R/LF123E15-2525B	25	26	25	25	150	33.5	N123E2-0200- CM	4.0
	10	F	R/LF123F10-1212B	12	13	12	12	125	29	N123F2-0250- CM	3.0
	10		R/LF123F10-1616B	16	17	16	16	125	29	N123F2-0250- CM	3.0
	10		R/LF123F10-2020B	20	21	20	20	125	29	N123F2-0250- CM	3.0
	10		R/LF123F10-2525B	25	26	25	25	150	29	N123F2-0250- CM	3.0
	20		R/LF123F20-1616B	16	17	16	16	125	40	N123F2-0250- CM	4.0
	20		R/LF123F20-2020B	20	21	20	20	125	40	N123F2-0250- CM	4.0
	20		R/LF123F20-2525B	25	26	25	25	150	40	N123F2-0250- CM	4.0
	20		R/LF123F20-3225B	25	26	32	32	170	40	N123F2-0250- CM	4.0
	10	G	R/LF123G10-1616B	16	17	16	16	125	30	N123G2-0300-CM	3.5
	10		R/LF123G10-2020B	20	21	20	20	125	30	N123G2-0300-CM	3.5
	10		R/LF123G10-2525B	25	26	25	25	150	30	N123G2-0300-CM	3.5
	10		R/LF123G10-3225B	25	26	32	32	170	30	N123G2-0300-CM	3.5
	12		R/LF123G12-1212B	12	13	12	12	125	32	N123G2-0300-CM	3.5
	20		R/LF123G20-1616B	16	17	16	16	125	41	N123G2-0300-CM	5.0
	20		R/LF123G20-2020B	20	21	20	20	125	41	N123G2-0300-CM	5.0
	20		R/LF123G20-2525B	25	26	25	25	150	41	N123G2-0300-CM	5.0
	20		R/LF123G20-3225B	25	26	32	32	170	41	N123G2-0300-CM	5.0
	20		R/LF123G20-3232B	32	33	32	32	170	41	N123G2-0300-CM	5.0

1) a_r max. for holder. For max stability choose a holder with shortest possible a_r.
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.

R = Right hand, L = Left hand
N = Neutral

Continued ...

CoroCut® 1- and 2-edge

Shank tools

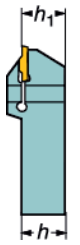
Screw clamp

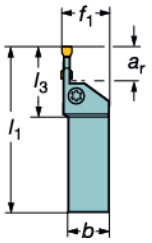
Tailor Made

Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

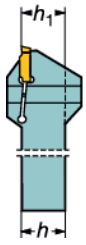
... Continued

R/L123

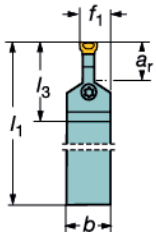




N123

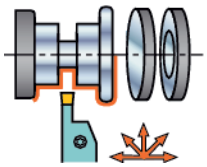
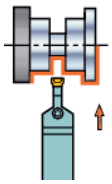


Neutral



Right hand style shown

Metric version

Main application	a_r max[1]	Seat size[2]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	13	H	R/LF123H13-1616B	16	17	16	16	125	34	N123H2-0400- CM	4.5
	13		R/LF123H13-2020BM	20	21	20	20	125	34	N123H2-0400- CM	4.5
	13		R/LF123H13-2525BM	25	26	25	25	150	34	N123H2-0400- CM	4.5
	13		R/LF123H13-3225BM	25	26	32	32	170	34	N123H2-0400- CM	4.5
	13		R/LF123H13-3232BM	32	33	32	32	170	34	N123H2-0400- CM	4.5
	25		R/LF123H25-1616B	16	17	16	16	125	47	N123H2-0400- CM	7.0
	25		R/LF123H25-2020BM	20	21	20	20	125	47	N123H2-0400- CM	7.0
	25		R/LF123H25-2525BM	25	26	25	25	150	47	N123H2-0400- CM	7.0
	25		R/LF123H25-3225BM	25	26	32	32	170	47	N123H2-0400- CM	7.0
	25		R/LF123H25-3232BM	32	33	32	32	170	47	N123H2-0400- CM	7.0
	13	J	R/LF123J13-2020BM	20	21	20	20	125	34	N123J2-0500- CM	5.0
	13		R/LF123J13-2525BM	25	26	25	25	150	34	N123J2-0500- CM	5.0
	13		R/LF123J13-3225BM	25	26	32	32	170	34	N123J2-0500- CM	5.0
	13		R/LF123J13-3232BM	32	33	32	32	170	34	N123J2-0500- CM	5.0
	32		R/LF123J32-2525BM	25	26	25	25	150	57	N123J2-0500- CM	7.5
	32		R/LF123J32-3225BM	25	26	32	32	170	57	N123J2-0500- CM	7.5
	32		R/LF123J32-3232BM	32	33	32	32	170	57	N123J2-0500- CM	7.5
	16	K	R/LF123K16-2525BM	25	26	25	25	150	39	N123K2-0600-CR	5.5
	16		R/LF123K16-3225BM	25	26	32	32	170	39	N123K2-0600-CR	5.5
	16		R/LF123K16-3232BM	32	33	32	32	170	39	N123K2-0600-CR	5.5
	32		R/LF123K32-2525BM	25	26	25	25	150	58	N123K2-0600-CR	7.5
	32		R/LF123K32-3225BM	25	26	32	32	170	58	N123K2-0600-CR	7.5
	32		R/LF123K32-3232BM	32	33	32	32	170	58	N123K2-0600-CR	7.5
	16	L	R/LF123L16-2525BM	25	26	25	25	150	41	N123L2-0800- GM	6.5
	25		R/LF123L25-2525BM	25	26	25	25	150	52	N123L2-0800- GM	7.0
	25		R/LF123L25-3225BM	25	26	32	32	170	52	N123L2-0800- GM	7.0
	32		R/LF123L32-3225BM	25	26	32	32	170	60	N123L2-0800- GM	7.5
	32		R/LF123L32-3232BM	32	33	32	32	170	60	N123L2-0800- GM	7.5
	32	M	R/LF123M32-3232B	32	34	32	32	250	63.9	N123M1-1100-GM	9.0
	32		NF123M32-4040B	40	25.7	40	40	250	63.9	N123M1-1100-GM	9.0
	32		R/LF123M32-4040B	40	42.2	40	40	250	63.9	N123M1-1100-GM	9.0
	50		R/LF123M50-4040B	40	42	40	40	250	63.9	N123M1-1100-GM	4.5

1) a_r max. for holder. For max stability choose a holder with shortest possible a_r.
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.

R = Right hand, L = Left hand
N = Neutral

Main spare parts

Seat size	Shank holder size metric	inch	a_r mm	a_r inch	Screw	Key (Torx Plus)
D, E, F, G	1212	08			3212 012-257	5680 043-14 (20IP)
D, E, F	1616-3225	10-20			3212 012-259	5680 043-14 (20IP)
G	1616	-			3212 012-309	5680 043-15 (25IP)
G	2020-3232	12-20			3212 012-310	5680 043-15 (25IP)
H	1616	-			3212 012-309	5680 043-15 (25IP)
H, J, K, L	2020-3232	12-24			5512 044-01	5680 043-17 (30IP)
M	3232-4040	20-24	32	1.260	5512 044-01	5680 048-07 (30IP)
M	4040	24	50	2.000	5512 046-01	5680 043-15 (25IP)

 B6
 B28
 B111
 G6
 B2
 J3
 J2

SANDVIK Coromant

CoroCut® 1- and 2-edge

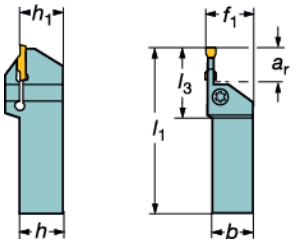
Shank tools

Screw clamp

Tailor Made

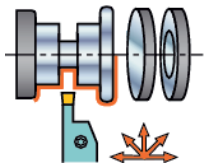
Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

R/L123



Right hand style shown

Inch version

Main application	a_r max[1]	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[3]
	.315	D	**R/LF123D032-08B**	.500	.512	.500	.500	4.500	1.000	N123D2-0150- CM	1.8
	.320		**RF123D032-10B**	.625	.670	.625	.625	4.500	1.000	N123D2-0150- CM	1.8
	.320		**R/LF123D032-12B**	.750	.825	.750	.750	4.500	1.000	N123D2-0150- CM	1.8
	.320		**R/LF123D032-16B**	1.000	1.028	1.000	1.000	5.000	1.000	N123D2-0150- CM	1.8
	.590		**R/LF123D059-12B**	.750	.827	.750	.750	4.500	1.320	N123D2-0150- CM	2.6
	.590		**R/LF123D059-16B**	1.000	1.028	1.000	1.000	6.000	1.320	N123D2-0150- CM	2.6
	.590		**RF123D059-10B**	.625	.670	.625	.625	4.500	1.320	N123D2-0150- CM	2.6
	.320	E	**R/LF123E032-08B**	.500	.512	.500	.500	4.500	1.004	N123E2-0200- CM	1.8
	.320		**R/LF123E032-10B**	.625	.669	.625	.625	4.500	1.004	N123E2-0200- CM	1.8
	.320		**R/LF123E032-12B**	.750	.827	.750	.750	4.500	1.004	N123E2-0200- CM	1.8
	.320		**R/LF123E032-16B**	1.000	1.024	1.000	1.000	5.000	1.004	N123E2-0200- CM	1.8
	.590		**R/LF123E059-08B**	.500	.512	.500	.500	4.500	1.319	N123E2-0200- CM	3.0
	.590		**R/LF123E059-10B**	.625	.669	.625	.625	4.500	1.319	N123E2-0200- CM	3.0
	.590		**R/LF123E059-12B**	.750	.827	.750	.750	5.000	1.319	N123E2-0200- CM	3.0
	.590		**R/LF123E059-16B**	1.000	1.024	1.000	1.000	6.000	1.319	N123E2-0200- CM	3.0
	.400	F	**R/LF123F040-10B**	.625	.669	.625	.625	4.500	1.142	N123F2-0250- CM	2.2
	.790		**R/LF123F079-10B**	.625	.669	.625	.625	4.500	1.575	N123F2-0250- CM	3.0
	.400		**R/LF123F040-12B**	.750	.827	.750	.750	4.500	1.142	N123F2-0250- CM	2.2
	.400		**R/LF123F040-16B**	1.000	1.024	1.000	1.000	5.000	1.142	N123F2-0250- CM	2.2
	.400		**R/LF123F040-20B**	1.250	1.299	1.250	1.250	6.000	1.142	N123F2-0250- CM	2.2
	.790		**R/LF123F079-12B**	.750	.827	.750	.750	5.000	1.575	N123F2-0250- CM	3.0
	.790		**R/LF123F079-16B**	1.000	1.024	1.000	1.000	6.000	1.575	N123F2-0250- CM	3.0
	.790		**R/LF123F079-20B**	1.250	1.299	1.250	1.250	6.000	1.575	N123F2-0250- CM	3.0
	.400	G	**R/LF123G040-12B**	.750	.827	.750	.750	4.500	1.181	N123G2-0300-CM	2.6
	.400		**R/LF123G040-16B**	1.000	1.024	1.000	1.000	5.000	1.181	N123G2-0300-CM	2.6
	.400		**R/LF123G040-20B**	1.250	1.299	1.250	1.250	6.000	1.181	N123G2-0300-CM	2.6
	.790		**R/LF123G079-12B**	.750	.827	.750	.750	5.000	1.614	N123G2-0300-CM	3.7
	.790		**R/LF123G079-20B**	1.250	1.299	1.250	1.250	6.000	1.614	N123G2-0300-CM	3.7
	.790		**R/LF123G079-16B**	1.000	1.024	1.000	1.000	6.000	1.614	N123G2-0300-CM	3.7
	.510	H	**R/LF123H051-12BM**	.750	.827	.750	.750	4.500	1.338	N123H2-0400- CM	3.3
	.510		**R/LF123H051-16BM**	1.000	1.024	1.000	1.000	5.000	1.338	N123H2-0400- CM	3.7
	.510		**R/LF123H051-20BM**	1.250	1.299	1.250	1.250	6.000	1.338	N123H2-0400- CM	3.7
	.980		**R/LF123H098-12BM**	.750	.827	.750	.750	5.000	1.850	N123H2-0400- CM	4.1
	.980		**R/LF123H098-16BM**	1.000	1.024	1.000	1.000	6.000	1.850	N123H2-0400- CM	5.2
	.980		**R/LF123H098-20BM**	1.250	1.299	1.250	1.250	6.000	1.850	N123H2-0400- CM	5.2

[1] a_r max. for holder. For max stability choose a holder with reinforced design.
[2] To correspond with seat size on insert.
[3] Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand
N = Neutral

Continued ...

 B6
 B28
 B111
 G6
 B2
 J3
 J2

CoroCut® 1- and 2-edge

Shank tools

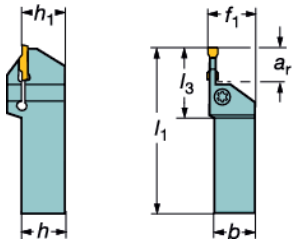
Screw clamp

Tailor Made

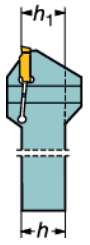
Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

... Continued

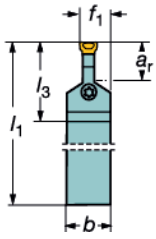
R/L123



N123

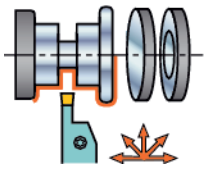
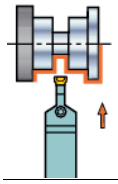


Neutral



Right hand style shown

Inch version

Main application	a_r max[1]	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[3]
	.510	J	R/LF123J051-16BM	1.000	1.024	1.000	1.000	5.000	1.338	N123J2-0500- CM	3.7
	.510		R/LF123J051-20BM	1.250	1.299	1.250	1.250	6.000	1.338	N123J2-0500- CM	3.7
	1.260		R/LF123J126-16BM	1.000	1.024	1.000	1.000	6.000	2.244	N123J2-0500- CM	5.5
	1.260		R/LF123J126-20BM	1.250	1.299	1.250	1.250	6.000	2.244	N123J2-0500- CM	5.5
	1.260		R/LF123J126-24BM	1.500	1.614	1.500	1.500	8.000	2.244	N123J2-0500- CM	5.5
	.630	K	R/LF123K063-16BM	1.000	1.024	1.000	1.000	5.000	1.535	N123K2-0600-CR	4.1
	.630		R/LF123K063-20BM	1.250	1.299	1.250	1.250	6.000	1.535	N123K2-0600-CR	4.1
	1.260		R/LF123K126-16BM	1.000	1.024	1.000	1.000	6.000	2.283	N123K2-0600-CR	5.5
	1.260		R/LF123K126-20BM	1.250	1.299	1.250	1.250	6.000	2.283	N123K2-0600-CR	5.5
	1.260		R/LF123K126-24BM	1.500	1.614	1.500	1.500	8.000	2.283	N123K2-0600-CR	5.5
	.630	L	R/LF123L063-16BM	1.000	1.028	1.000	1.000	6.000	1.600	N123L2-0800- GM	4.8
	1.000		R/LF123L100-16BM	1.000	1.028	1.000	1.000	6.000	2.000	N123L2-0800- GM	5.2
	1.000		R/LF123L100-20BM	1.250	1.300	1.250	1.250	6.000	2.000	N123L2-0800- GM	5.2
	1.380		R/LF123L138-20BM	1.250	1.300	1.250	1.250	7.000	2.400	N123L2-0800- GM	5.5
	1.380		R/LF123L138-24BM	1.500	1.614	1.500	1.500	8.000	2.400	N123L2-0800- GM	5.5
	1.260	M	R/LF123M125-20B	1.250	1.339	1.250		10.00	2.516	N123M1-1100-GM	6.6
	1.260		NF123M125-24B	1.500	.972	1.500	1.500	10.00	2.516	N123M1-1100-GM	6.6
	1.260		R/LF123M125-24B	1.500	1.583	1.500	1.500	10.00	2.516	N123M1-1100-GM	6.6
	2.000		R/LF123M200-24B	1.500	1.575	1.500	1.500	10.00	2.516	N123M1-1100-GM	3.3

[1] a_r max. for holder. For max stability choose a holder with reinforced design.
[2] To correspond with seat size on insert.
[3] Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

Main spare parts

Seat size	Shank holder size metric	inch	a_r mm	a_r inch	Screw	Key (Torx Plus)
D, E, F, G	1212	08			3212 012-257	5680 043-14 (20IP)
D, E, F	1616-3225	10-20			3212 012-259	5680 043-14 (20IP)
G	1616	-			3212 012-309	5680 043-15 (25IP)
G	2020-3232	12-20			3212 012-310	5680 043-15 (25IP)
H	1616	-			3212 012-309	5680 043-15 (25IP)
H, J, K, L	2020-3232	12-24			5512 044-01	5680 043-17 (30IP)
M	3232-4040	20-24	32	1.260	5512 044-01	5680 048-07 (30IP)
M	4040	24	50	2.000	5512 046-01	5680 043-15 (25IP)

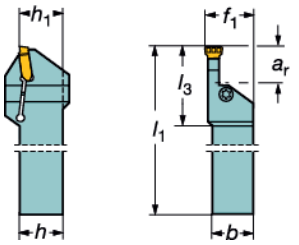
 B6
 B28
 B111
 G6
 B2
 J3
 J2

CoroCut® 1- and 2-edge

Shank tools

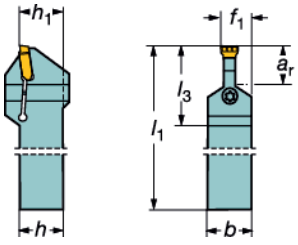
Screw design

R/LF123



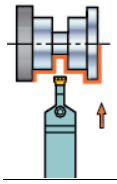
Right hand style

NF123

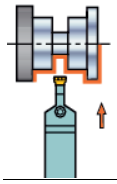


Neutral style

Metric dimensions

Main application	a_r max[1]	Seat size[2]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	32	R	**R/LF123R32-3232B**	32	34.5	32	32	250	71.3	N123R1-1500-GR	10.0
	32		**NF123R32-4040B**	40	27.5	40	40	250	71.3	N123R1-1500-GR	10.0
	32		**R/LF123R32-4040B**	40	42.5	40	40	250	71.3	N123R1-1500-GR	10.0
	50		**R/LF123R50-4040B**	40	42.5	40	40	250	71.3	N123R1-1500-GR	4.5

Inch dimensions

Main application	a_r max[1]	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[4]
	1.260	R	**R/LF123R125-20B**	1.250	1.346	1.250	1.250	10.000	2.807	N123R1-1500-GR	7.4
	1.260		**NF123R125-24B**	1.500	1.043	1.500	1.500	10.000	2.807	N123R1-1500-GR	7.4
	1.260		**R/LF123R125-24B**	1.500	1.602	1.500	1.500	10.000	2.807	N123R1-1500-GR	7.4
	2.000		**R/LF123R200-24B**	1.500	1.598	1.500	1.500	10.000	2.807	N123R1-1500-GR	3.3

1) a_r max. for holder. For max stability choose a holder with shortest possible a_r.

N = Neutral, R = Right hand, L = Left hand

2) To correspond with seat size on insert.

3) Insert tightening torque, Nm. Use torque wrench, see page B110.

4) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

Main spare parts

Seat size a_r max		Standard parts	
mm	inch	Screw	Key (Torx Plus)
32	1.260	5512 044-01	5680 048-07 (30IP)
50	2.000	3212 012-311	5680 043-15 (25IP)

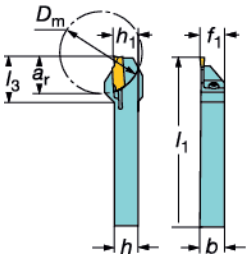
 B6
 B28
 B111
 G6
 B2
 J3
 J2

CoroCut® 1- and 2-edge

Swiss shank tools for small part machining

Screw clamp

R/LF123 -S

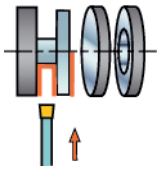


Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

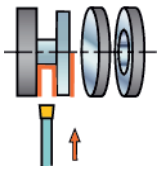
Shank holders for QS-holding system, see page A229.

Right hand style shown

Metric dimensions

Main application	D_m max	a_r max[1]	Seat size[2]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	20	10	D	**R/LF123D10-1010B-S**	10	10	10	10	125	21.6	N123D2-0150- CM	2.5
	22	11		**R/LF123D11-1212B-S**	12	12	12	12	125	22.6	N123D2-0150- CM	2.5
	16	8		**R/LF123D08-1616B-S**	16	16	16	16	125	19.6	N123D2-0150- CM	2.5
	34	17		**R/LF123D17-1616B-S**	16	16	16	16	125	28.6	N123D2-0150- CM	2.5
	20	10	E	**R/LF123E10-1010B-S**	10	10	10	10	125	21.6	N123E2-0200- CM	2.5
	22	11		**R/LF123E11-1212B-S**	12	12	12	12	125	22.6	N123E2-0200- CM	2.5
	22	11		**R/LF123E11-1616B-S**	16	16	16	16	125	22.6	N123E2-0200- CM	2.5
	34	17		**R/LF123E17-1616B-S**	16	16	16	16	125	28.6	N123E2-0200- CM	2.5
	20	10	F	**R/LF123F10-1010B-S**	10	10	10	10	125	21.6	N123F2-0250- CM	2.5
	30	15		**R/LF123F15-1212B-S**	12	12	12	12	125	20	N123F2-0250- CM	2.5
	34	17		**R/LF123F17-1616B-S**	16	16	16	16	125	28.6	N123F2-0250- CM	2.5
	34	17	G	**R/LF123G17-1616B-S**	16	16	16	16	125	28.6	N123G2-0300-CM	2.5

Inch dimensions

Main application	D_m max	a_r max[1]	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[4]
	.780	.390	D	**R/LF123D039-06B-S**	.375	.375	.375	.375	5.000	.847	N123D2-0150- CM	1.8
	.860	.430		**R/LF123D043-08B-S**	.500	.500	.500	.500	5.000	.887	N123D2-0150- CM	1.8
	.640	.320		**R/LF123D032-10B-S**	.625	.625	.625	.625	5.000	.777	N123D2-0150- CM	1.8
	1.340	.670		**R/LF123D067-10B-S**	.625	.625	.625	.625	5.000	1.127	N123D2-0150- CM	1.8
	.780	.390	E	**R/LF123E039-06B-S**	.375	.375	.375	.375	5.000	.847	N123E2-0200- CM	1.8
	.860	.430		**R/LF123E043-08B-S**	.500	.500	.500	.500	5.000	.887	N123E2-0200- CM	1.8
	.860	.430		**R/LF123E043-10B-S**	.625	.625	.625	.625	5.000	.887	N123E2-0200- CM	1.8
	1.340	.670		**R/LF123E067-10B-S**	.625	.625	.625	.625	5.000	1.127	N123E2-0200- CM	1.8
	.780	.390	F	**R/LF123F039-06B-S**	.375	.375	.375	.375	5.000	.847	N123F2-0250- CM	1.8
	1.180	.590		**R/LF123F059-08B-S**	.500	.500	.500	.500	5.000	1.047	N123F2-0250- CM	1.8
	1.340	.670		**R/LF123F067-10B-S**	.625	.625	.625	.625	5.000	1.127	N123F2-0250- CM	1.8
	1.340	.670	G	**R/LF123G067-10B-S**	.625	.625	.625	.625	5.000	1.127	N123G2-0300-CM	1.8

1) a_r max. for holder
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.
4) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

Main spare parts

Seat size	Shank holder size Metric	Inch	Screw	Key (Torx Plus)
D, E, F	1010	06	5513 021-07	5680 043-13 (15IP)
D, E, F	1212	08	5513 021-07	5680 043-13 (15IP)
D, E, F, G	1616	10	5513 021-04	5680 043-13 (15IP)

 B6
 B28
 B111
 G6
 B2
 J3
 J2

CoroCut® 1- and 2-edge

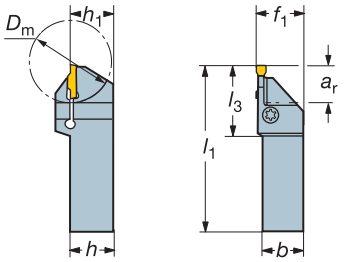
Reinforced shank tools for parting off, with reduced f_1 offset.

Screw clamp

Tailor Made

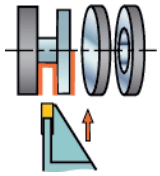
Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

R/LF123 Reinforced

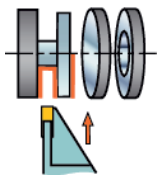


Right hand style shown

Metric dimensions

Main application	D_m max	a_r max[1]	Seat size[2]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	42.2	17	E	**R/LF123E17-2020D**	20	20.5	20	20	125	35.5	N123E2-0200- CM	4.0
	42.2	17	F	**R/LF123F17-2020D**	20	20.5	20	20	125	37	N123F2-0250- CM	4.0
	42.2	17		**R/LF123F17-2525D**	25	25.5	25	25	150	37	N123F2-0250- CM	4.0
	44	22	G	**R/LF123G22-2020D**	20	20.6	20	20	125	43	N123G2-0300-CM	5.0
	44	22		**R/LF123G22-2525D**	25	25.6	25	25	150	43	N123G2-0300-CM	5.0
	52.5	22	H	**R/LF123H22-2020D**	20	20.6	20	20	125	44	N123H2-0400- CM	6.0
	52.5	22		**R/LF123H22-2525D**	25	25.6	25	25	150	44	N123H2-0400- CM	6.0

Inch dimensions

Main application	D_m max	a_r max[1]	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[4]
	1.662	.670	E	**R/LF123E067-12D**	.750	.770	.750	.750	5.000	1.398	N123E2-0200- CM	3.0
	1.662	.670	F	**R/LF123F067-12D**	.750	.770	.750	.750	5.000	1.458	N123F2-0250- CM	3.0
	1.662	.670		**R/LF123F067-16D**	1.000	1.020	1.000	1.000	5.000	1.458	N123F2-0250- CM	3.0
	1.740	.870	G	**R/LF123G087-12D**	.750	.774	.750	.750	5.000	1.697	N123G2-0300-CM	3.7
	1.740	.870		**R/LF123G087-16D**	1.000	1.024	1.000	1.000	5.000	1.697	N123G2-0300-CM	3.7
	2.067	.870	H	**R/LF123H087-12D**	.750	.774	.750	.750	5.000	1.736	N123H2-0400- CM	4.4
	2.067	.870		**R/LF123H087-16D**	1.000	1.024	1.000	1.000	5.000	1.736	N123H2-0400- CM	4.4

1) a_r max. for holder
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.
4) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

Main spare parts

Seat size	Shank holder size Metric	Inch	Screw	Key (Torx Plus)
E, F	2020-2525	12-16	3212 012-257	5680 043-14 (20IP)
G	2020-2525	12-16	3212 012-310	5680 043-15 (25IP)
H	2020	12	5512 044-01	5680 043-15 (25IP)
H	2525	16	5512 044-01	5680 043-17 (30IP)

 B6
 B28
 B111
 G6
 B2
 J3
 J2

CoroCut® 1- and 2-edge

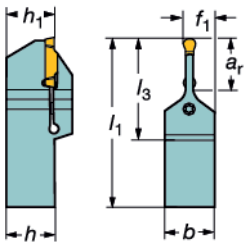
Shank tools for profiling

Screw clamp

Tailor Made

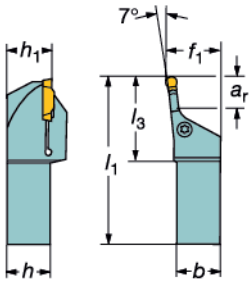
Note! When using CoroCut® 2-edged insert the a_r of the insert gives the maximum depth of cut.

Shank, 0° style
NF123



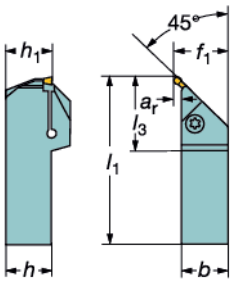
Neutral style

Shank, 7° style
RX123...-007

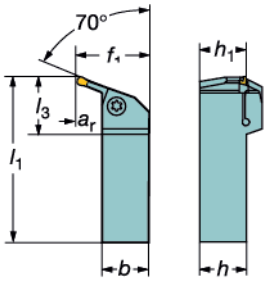


Right hand style shown

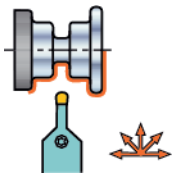
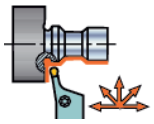
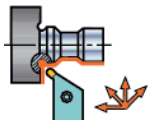
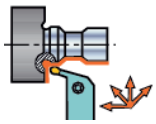
Shank, 45° style
RX123...-045



Shank, 70° style
RX123...-070



Metric version

Main application	a_r max[1]	Shank style	Seat size[2]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	25	0°	J	**NF123J25-2525BM**	25	15	25	25	150	52.2	N123J2-0600- RM	6.0
	25	0°		**NF123J25-3225BM**	25	15	32	32	170	52.2	N123J2-0600- RM	6.0
	25	7°	L	**R/LX123L25-2525B-007**	25	32	25	25	190	63.7	N123L2-0800- RM	6.5
	25	7°		**R/LX123L25-3232B-007**	32	40	32	32	190	63.7	N123L2-0800- RM	6.5
	4	45°	G	**R/LX123G04-2020B-045**	20	24	20	20	150	41.1	N123G2-0400- RM	4.5
	4	45°		**R/LX123G04-2525B-045**	25	29	25	25	150	41.1	N123G2-0400- RM	4.5
	5	45°	J	**R/LX123J05-2020B-045**	20	25	20	20	150	44.9	N123J2-0600- RM	5.0
	5	45°		**R/LX123J05-2525B-045**	25	30	25	25	170	44.9	N123J2-0600- RM	5.0
	5	45°		**R/LX123J05-3225B-045**	25	30	32	32	170	44.9	N123J2-0600- RM	5.0
	16	70°	J	**R/LX123J16-2525B-070**	25	41.7	25	25	190	40	N123J2-0600- RM	5.0
	16	70°		**R/LX123J16-3232B-070**	32	48.7	32	32	190	40	N123J2-0600- RM	5.0

1) a_r max. for holder

N = Neutral, R = Right hand, L = Left hand

2) To correspond with seat size on insert.

3) Insert tightening torque, Nm. Use torque wrench, see page B110.

Main spare parts

Seat size	Shank holder size	Screw	Key (Torx Plus)
G	2020-2525	3212 012-309	5680 043-15 (25IP)
J (NF)	2525-3225	5512 044-01	5680 043-17 (30IP)
J, L	2020-3232	3212 012-360	5680 043-17 (30IP)

 B6
 B111
 G6
 B2
 J3
 J2

SANDVIK Coromant

CoroCut® 1- and 2-edge

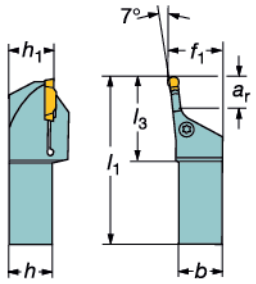
Shank tools for profiling

Screw clamp

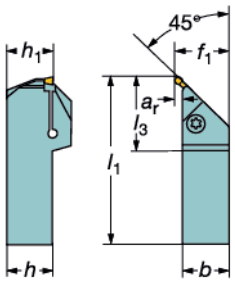
Tailor Made

Note! When using CoroCut® 2-edged insert the a_r of the insert gives the maximum depth of cut.

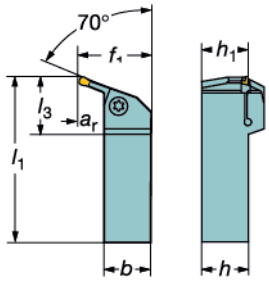
Shank, 7° style
RX123...-007



Shank, 45° style
RX123...-045

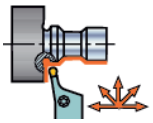
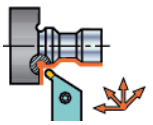
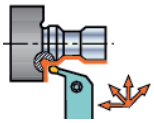


Shank, 70° style
RX123...-070



Right hand style shown

Inch version

Main application	a_r max[1]	Shank style	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[3]
	.945	7°	L	**R/LX123L095-16B-007**	1.000	1.252	1.000	1.000	7.480	2.500	N123L2-0800- RM	3.5
	.157	45°	G	**R/LX123G016-12B-045**	.750	.921	.750	.750	5.906	1.701	N123G2-0400- RM	3.3
	.157	45°		**R/LX123G016-16B-045**	1.000	1.173	1.000	1.000	5.906	1.701	N123G2-0400- RM	3.3
	.197	45°	J	**R/LX123J020-12B-045**	.750	.961	.750	.750	5.906	1.902	N123J2-0600- RM	3.7
	.197	45°		**R/LX123J020-16B-045**	1.000	1.213	1.000	1.000	6.693	1.902	N123J2-0600- RM	3.7
	.197	45°		**R/LX123J020-20B-045**	1.250	1.461	1.250	1.250	6.693	1.902	N123J2-0600- RM	3.7
	.630	70°	J	**R/LX123J062-16B-070**	1.000	1.669	1.000	1.000	7.480	1.575	N123J2-0600- RM	3.7
	.630	70°		**R/LX123J062-20B-070**	1.250	1.917	1.250	1.250	7.480	1.575	N123J2-0600- RM	3.7

[1] a_r max. for holder

[2] To correspond with seat size on insert.

[3] Insert tightening torque, Nm. Use torque wrench, see page B110.

N = Neutral, R = Right hand, L = Left hand

Main spare parts

Seat size	Shank holder size	Screw	Key (Torx Plus)
G	12-16	3212 012-309	5680 043-15 (25IP)
J, L	12-20	3212 012-360	5680 043-17 (30IP)

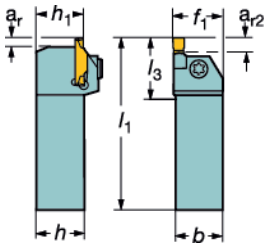
 B6
 B111
 G6
 B2
 J3
 J2

CoroCut® 1- and 2-edge

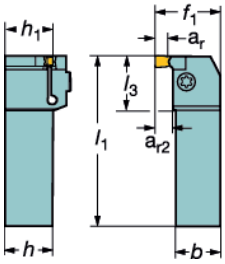
Shank tools for shallow grooving and face grooving

Screw clamp

Shank, 0° style
R/LF123

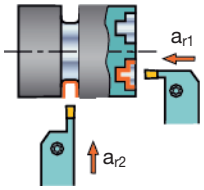


Shank, 90° style
R/LG123

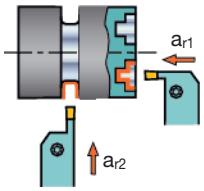


Right hand style shown

Metric version

Main application	a_r max	a_{r2}	Shank style	Seat size[1]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[2]
	3.5	7	0°	G	**R/LF123G07-1616C**	16	21	16	16	125	27	N123G2-0300-CM	3.5
	3.5	7	0°		**R/LF123G07-2020C**	20	21	20	20	125	27	N123G2-0300-CM	3.5
	3.5	7	0°		**R/LF123G07-2525C**	25	26	25	25	150	27	N123G2-0300-CM	3.5
	4.5	8	0°	K	**R/LF123K08-2020C**	20	21	20	20	125	30	N123K2-0600-CR	4.5
	4.5	8	0°		**R/LF123K08-2525CM**	25	26	25	25	150	30	N123K2-0600-CR	4.5
	3.5	7	90°	G	**R/LG123G07-1616C**	16	25	16	16	125	23.5	N123G2-0300-CM	3.5
	3.5	7	90°		**R/LG123G07-2020C**	20	29	20	20	125	23.5	N123G2-0300-CM	3.5
	3.5	7	90°		**R/LG123G07-2525C**	25	34	25	25	150	23.5	N123G2-0300-CM	3.5
	4.5	8	90°	K	**R/LG123K08-2020C**	20	30	20	20	125	28.7	N123K2-0600-CR	4.5
	4.5	8	90°		**R/LG123K08-2525CM**	25	34	25	25	150	28.7	N123K2-0600-CR	4.5

Inch version

Main application	a_r max	a_{r2}	Shank style	Seat size[1]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[3]
	.177	.276	0°	G	**R/LF123G028-10C**	.625	.669	.625	.625	5.000	1.063	N123G2-0300-CM	3.0
	.177	.276	0°		**R/LF123G028-12C**	.750	.787	.750	.750	5.000	1.063	N123G2-0300-CM	3.0
	.138	.276	0°		**R/LF123G028-16C**	1.000	1.024	1.000	1.000	6.000	1.063	N123G2-0300-CM	3.0
	.177	.315	0°	K	**R/LF123K032-12C**	.750	.787	.750	.750	5.000	1.181	N123K2-0600-CR	4.1
	.177	.315	0°		**R/LF123K032-16CM**	1.000	1.024	1.000	1.000	6.000	1.181	N123K2-0600-CR	4.1
	.138	.276	90°	G	**R/LG123G028-10C**	.625	.984	.625	.625	5.000	.925	N123G2-0300-CM	2.6
	.138	.276	90°		**R/LG123G028-12C**	.750	1.142	.750	.750	5.000	.925	N123G2-0300-CM	2.6
	.138	.276	90°		**R/LG123G028-16C**	1.000	1.339	1.000	1.000	6.000	.925	N123G2-0300-CM	2.6
	.177	.315	90°	K	**R/LG123K032-12C**	.750	1.142	.750	.750	5.000	1.130	N123K2-0600-CR	2.4
	.177	.315	90°		**R/LG123K032-16CM**	1.000	1.339	1.000	1.000	6.000	1.130	N123K2-0600-CR	2.4

R = Right hand, L = Left hand

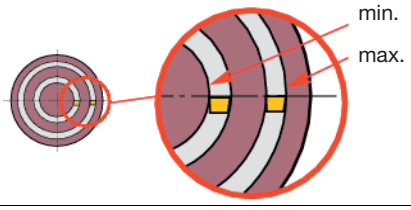
1) Shallow grooving holders can take several insert sizes. Holder with seat size G can take insert sizes E, F and G. Holders with seat size K can take insert sizes H, J and K. Please note f_1 and l_3 dimensions above are valid when using G resp. K insert size.
2) Insert tightening torque, Nm. Use torque wrench, see page B110.
3) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

Shallow grooving holder for face grooving

Holder seat size[1]	Insert seat size	First cut diameter Min – Max mm	inch	Max cutting depth mm	inch
G	E	100 – ∞	3.937 – ∞	3.5	.138
	F	83 – ∞	3.268 – ∞	3.5	.138
	G	57 – ∞	2.244 – ∞	3.5	.138
K	H	46 – ∞	1.811 – ∞	4.5	.177
	J	46 – ∞	1.811 – ∞	4.5	.177
	K	46 – ∞	1.811 – ∞	4.5	.177

First cut diameters

123-GM, -TF, -CM, -RM, -TM



Main spare parts

Seat size	Screw	Key (Torx Plus)
G	3212 012-310	5680 043-15 (25IP)
K	5512 044-01	5680 043-17 (30IP)

 B6
 B111
 G6
 B2
 J2

SANDVIK Coromant

CoroCut® 1- and 2-edge

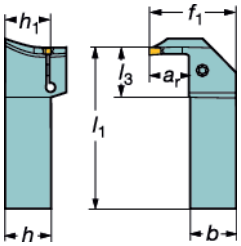
Shank tools for face grooving

Screw clamp

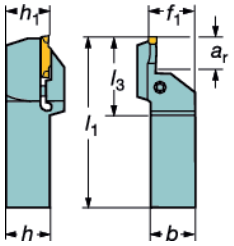
Tailor Made

Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

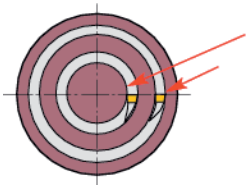
Shank, 90° style
R/LG123



Shank, 0° style
R/LF123

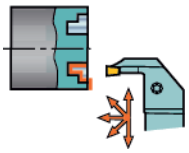
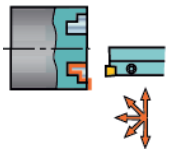


First cut diameters



Right hand style shown

Metric dimensions

Main application	First cut diameter, inch min	max	a_r max[1]	Shank style	Seat size[2]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	40	60	13	90°	H	R/LG123H13-2525B-040BM	25	40	25	25	150	25.9	N123H2-0400- TF	2.8
	52	72	13	90°		R/LG123H13-2525B-052BM	25	40	25	25	150	25.9	N123H2-0400- TF	4.3
	64	100	13	90°		R/LG123H13-2525B-064BM	25	40	25	25	150	25.9	N123H2-0400- TF	3.2
	92	140	13	90°		R/LG123H13-2525B-092BM	25	40	25	25	150	25.9	N123H2-0400- TF	3.7
	132	230	13	90°		R/LG123H13-2525B-132BM	25	40	25	25	150	25.9	N123H2-0400- TF	4.0
	220	500	13	90°		R/LG123H13-2525B-220BM	25	40	25	25	150	25.9	N123H2-0400- TF	4.3
	300	1100	13	90°		R/LG123H13-2525B-300BM	25	40	25	25	150	25.9	N123H2-0400- TF	4.3
	64	100	20	90°		R/LG123H20-2525B-064BM	25	47	25	25	150	26.9	N123H2-0400- TF	4.3
	92	140	20	90°		R/LG123H20-2525B-092BM	25	47	25	25	150	26.9	N123H2-0400- TF	5.0
	132	230	20	90°		R/LG123H20-2525B-132BM	25	47	25	25	150	26.9	N123H2-0400- TF	5.3
	58	100	20	90°	K	R/LG123K20-2525B-058BM	25	47	25	25	150	30.65	N123K2-0600- TF	4.1
	88	180	20	90°		R/LG123K20-2525B-088BM	25	47	25	25	150	30.65	N123K2-0600- TF	4.9
	168	400	20	90°		R/LG123K20-2525B-168BM	25	47	25	25	150	30.65	N123K2-0600- TF	5.3
	50	80	20	90°	L	R/LG123L20-2525B-050BM	25	47	25	25	150	41.4	N123L2-0800- TF	4.7
	75	150	20	90°		R/LG123L20-2525B-075BM	25	47	25	25	150	41.4	N123L2-0800- TF	5.4
	140	400	20	90°		R/LG123L20-2525B-140BM	25	47	25	25	150	41.4	N123L2-0800- TF	6.2
	34	44	12	0°	G	R/LF123G12-2020B-034B	20	21	20	20	125	32	N123G2-0300- TF	2.1
	38	48	12	0°		R/LF123G12-2020B-038B	20	21	20	20	125	32	N123G2-0300- TF	2.1
	42	60	13	0°		R/LF123G13-2020B-042B	20	21	20	20	125	33	N123G2-0300- TF	2.2
	54	75	13	0°		R/LF123G13-2020B-054B	20	21	20	20	125	33	N123G2-0300- TF	2.3
	67	100	13	0°		R/LF123G13-2020B-067B	20	21	20	20	125	33	N123G2-0300- TF	2.6
	90	160	13	0°		R/LF123G13-2020B-090B	20	21	20	20	125	33	N123G2-0300- TF	2.9
	130	300	13	0°		R/LF123G13-2020B-130B	20	21	20	20	125	33	N123G2-0300- TF	3.1
	34	44	12	0°		R/LF123G12-2525B-034B	25	26	25	25	150	32	N123G2-0300- TF	2.1
	38	48	12	0°		R/LF123G12-2525B-038B	25	26	25	25	150	32	N123G2-0300- TF	2.1
	42	60	19	0°		R/LF123G19-2525B-042B	25	26	25	25	150	40	N123G2-0300- TF	3.2
	54	75	19	0°		R/LF123G19-2525B-054B	25	26	25	25	150	40	N123G2-0300- TF	3.4
	67	100	22	0°		R/LF123G22-2525B-067B	25	26	25	25	150	43	N123G2-0300- TF	3.7
	90	160	22	0°		R/LF123G22-2525B-090B	25	26	25	25	150	43	N123G2-0300- TF	4.2
	130	300	22	0°		R/LF123G22-2525B-130B	25	26	25	25	150	43	N123G2-0300- TF	4.5
	40	60	13	0°	H	R/LF123H13-2020B-040BM	20	21	20	20	125	34	N123H2-0400- TF	2.8
	52	72	13	0°		R/LF123H13-2020B-052BM	20	21	20	20	125	34	N123H2-0400- TF	3.0
	64	100	13	0°		R/LF123H13-2020B-064BM	20	21	20	20	125	34	N123H2-0400- TF	3.2
	92	140	13	0°		R/LF123H13-2020B-092BM	20	21	20	20	125	34	N123H2-0400- TF	3.7
	132	230	13	0°		R/LF123H13-2020B-132BM	20	21	20	20	125	34	N123H2-0400- TF	4.0
	220	500	13	0°		R/LF123H13-2020B-220BM	20	21	20	20	125	34	N123H2-0400- TF	4.3
	40	60	13	0°		R/LF123H13-2525B-040BM	25	26	25	25	150	34	N123H2-0400- TF	2.8
	52	72	13	0°		R/LF123H13-2525B-052BM	25	26	25	25	150	34	N123H2-0400- TF	3.0
	64	100	13	0°		R/LF123H13-2525B-064BM	25	26	25	25	150	34	N123H2-0400- TF	3.2
	92	140	13	0°		R/LF123H13-2525B-092BM	25	26	25	25	150	34	N123H2-0400- TF	3.7
	132	230	13	0°		R/LF123H13-2525B-132BM	25	26	25	25	150	34	N123H2-0400- TF	4.0
	220	500	13	0°		R/LF123H13-2525B-220BM	25	26	25	25	150	34	N123H2-0400- TF	4.3
	300	1100	13	0°		R/LF123H13-2525B-300BM	25	26	25	25	150	34	N123H2-0400- TF	4.3
	40	60	20	0°		R/LF123H20-2525B-040BM	25	26	25	25	150	42	N123H2-0400- TF	3.8
	52	72	20	0°		R/LF123H20-2525B-052BM	25	26	25	25	150	42	N123H2-0400- TF	4.0
	64	100	25	0°		R/LF123H25-2525B-064BM	25	26	25	25	150	47	N123H2-0400- TF	4.3
	92	140	25	0°		R/LF123H25-2525B-092BM	25	26	25	25	150	47	N123H2-0400- TF	5.0
	132	230	25	0°		R/LF123H25-2525B-132BM	25	26	25	25	150	47	N123H2-0400- TF	5.3
	220	500	25	0°		R/LF123H25-2525B-220BM	25	26	25	25	150	47	N123H2-0400- TF	5.7
	300	800	25	0°		R/LF123H25-2525B-300BM	25	26	25	25	150	47	N123H2-0400- TF	5.7

1) a_r max. for holder. For max stability choose a holder with reinforced design.
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.

R = Right hand, L = Left hand

Continued ...

 B6
 B111
 G6
 B2
 J2

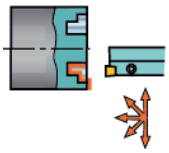
CoroCut® 1- and 2-edge

Shank tools for face grooving

Screw clamp

... Continued

Metric dimensions

Main application	First cut diameter, inch min	max	a_r max[1]	Shank style	Seat size[2]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	40	70	13	0°	J	**R/LF123J13-2525B-040BM**	25	26	25	25	150	34	N123J2-0500- TF	2.8
	60	95	13	0°		**R/LF123J13-2525B-060BM**	25	26	25	25	150	34	N123J2-0500- TF	3.2
	85	130	13	0°		**R/LF123J13-2525B-085BM**	25	26	25	25	150	34	N123J2-0500- TF	3.6
	120	180	13	0°		**R/LF123J13-2525B-120BM**	25	26	25	25	150	34	N123J2-0500- TF	4.0
	175	500	13	0°		**R/LF123J13-2525B-175BM**	25	26	25	25	150	34	N123J2-0500- TF	4.0
	40	70	20	0°		**R/LF123J20-2525B-040BM**	25	26	25	25	150	43	N123J2-0500- TF	3.8
	180	980	20	0°		**R/LF123J20-2525B-180BM**	25	26	25	25	150	43	N123J2-0500- TF	4.3
	60	95	25	0°		**R/LF123J25-2525B-060BM**	25	26	25	25	150	48	N123J2-0500- TF	4.9
	85	130	25	0°		**R/LF123J25-2525B-085BM**	25	26	25	25	150	48	N123J2-0500- TF	5.3
	120	180	25	0°		**R/LF123J25-2525B-120BM**	25	26	25	25	150	48	N123J2-0500- TF	5.3
	175	500	25	0°		**R/LF123J25-2525B-175BM**	25	26	25	25	150	48	N123J2-0500- TF	5.3
	40	70	13	0°	K	**R/LF123K13-2525B-040BM**	25	26	25	25	150	35	N123K2-0600- TF	3.2
	58	100	13	0°		**R/LF123K13-2525B-058BM**	25	26	25	25	150	35	N123K2-0600- TF	3.5
	88	180	13	0°		**R/LF123K13-2525B-088BM**	25	26	25	25	150	35	N123K2-0600- TF	4.1
	168	400	13	0°		**R/LF123K13-2525B-168BM**	25	26	25	25	150	35	N123K2-0600- TF	4.5
	40	70	20	0°		**R/LF123K20-2525B-040BM**	25	26	25	25	150	44	N123K2-0600- TF	3.8
	58	100	25	0°		**R/LF123K25-2525B-058BM**	25	26	25	25	150	49	N123K2-0600- TF	4.1
	88	180	25	0°		**R/LF123K25-2525B-088BM**	25	26	25	25	150	49	N123K2-0600- TF	4.9
	168	400	25	0°		**R/LF123K25-2525B-168BM**	25	26	25	25	150	49	N123K2-0600- TF	5.3
	220	1000	25	0°		**R/LF123K25-2525B-220BM**	25	26	25	25	150	49	N123K2-0600- TF	5.7
	88	180	25	0°		**R/LF123K25-3225B-088BM**	25	26	32	32	170	49	N123K2-0600- TF	4.9
	168	400	25	0°		**R/LF123K25-3225B-168BM**	25	26	32	32	170	49	N123K2-0600- TF	5.3
	220	1000	25	0°		**R/LF123K25-3225B-220BM**	25	26	32	32	170	49	N123K2-0600- TF	5.7
	75	150	15	0°	L	**R/LF123L15-2525B-075BM**	25	26	25	25	150	39	N123L2-0800- TF	4.6
	140	400	15	0°		**R/LF123L15-2525B-140BM**	25	26	25	25	150	39	N123L2-0800- TF	5.3
	50	80	25	0°		**R/LF123L25-2525B-050BM**	25	26	25	25	150	55	N123L2-0800- TF	4.7
	75	150	28	0°		**R/LF123L28-2525B-075BM**	25	26	25	25	150	56	N123L2-0800- TF	5.8
	140	400	28	0°		**R/LF123L28-2525B-140BM**	25	26	25	25	150	56	N123L2-0800- TF	6.7
	75	150	28	0°		**R/LF123L28-3225B-075BM**	25	26	32	32	170	56	N123L2-0800- TF	5.8
	140	400	28	0°		**R/LF123L28-3225B-140BM**	25	26	32	32	170	56	N123L2-0800- TF	6.7

1) a_r max. for holder. For max stability choose a holder with reinforced design.
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.

R = Right hand, L = Left hand

Main spare parts

Seat size	Screw	Key (Torx Plus)
G	3212 012-310	5680 043-15 (25IP)
H, J, K, L	5512 044-01	5680 043-17 (30IP)

 B6
 B111
 G6
 B2
 J2

CoroCut® 1- and 2-edge

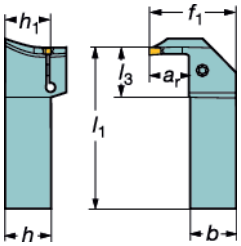
Shank tools for face grooving

Screw clamp

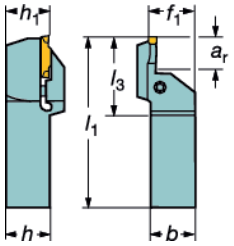
Tailor Made

Note!
When using CoroCut® 2-edged inserts, the a_r of the insert gives the maximum depth of cut.

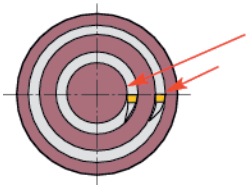
Shank, 90° style
R/LG123



Shank, 0° style
R/LF123

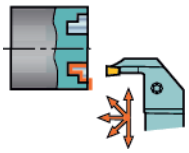
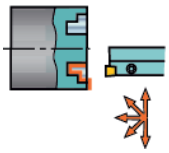


First cut diameters



Right hand style shown

Inch dimensions

Main application	First cut diameter, inch min	max	a_r max[1]	Shank style	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[3]
	1.575	2.362	.500	90°	H	**R/LG123H050-16B-040BM**	1.000	1.575	1.000	1.000	6.000	1.020	N123H2-0400- TF	2.1
	2.047	2.835	.500	90°		**R/LG123H050-16B-052BM**	1.000	1.575	1.000	1.000	6.000	1.020	N123H2-0400- TF	2.2
	2.520	3.937	.500	90°		**R/LG123H050-16B-064BM**	1.000	1.575	1.000	1.000	6.000	1.020	N123H2-0400- TF	2.3
	3.622	5.512	.500	90°		**R/LG123H050-16B-092BM**	1.000	1.575	1.000	1.000	6.000	1.020	N123H2-0400- TF	2.7
	5.197	9.055	.500	90°		**R/LG123H050-16B-132BM**	1.000	1.575	1.000	1.000	6.000	1.020	N123H2-0400- TF	2.9
	8.661	19.68	.500	90°		**R/LG123H050-16B-220BM**	1.000	1.575	1.000	1.000	6.000	1.020	N123H2-0400- TF	3.1
	11.81	43.30	.500	90°		**R/LG123H050-16B-300BM**	1.000	1.575	1.000	1.000	6.000	1.020	N123H2-0400- TF	3.1
	2.520	3.937	.790	90°		**R/LG123H079-16B-064BM**	1.000	1.850	1.000	1.000	6.000	1.060	N123H2-0400- TF	2.6
	3.622	5.512	.790	90°		**R/LG123H079-16B-092BM**	1.000	1.850	1.000	1.000	6.000	1.060	N123H2-0400- TF	2.6
	5.197	9.055	.790	90°		**R/LG123H079-16B-132BM**	1.000	1.850	1.000	1.000	6.000	1.060	N123H2-0400- TF	2.6
	2.284	3.937	.790	90°	K	**R/LG123K079-16B-058BM**	1.000	1.850	1.000	1.000	6.000	1.200	N123K2-0600- TF	3.3
	3.465	7.087	.790	90°		**R/LG123K079-16B-088BM**	1.000	1.850	1.000	1.000	6.000	1.200	N123K2-0600- TF	3.3
	6.614	15.74	.790	90°		**R/LG123K079-16B-168BM**	1.000	1.850	1.000	1.000	6.000	1.200	N123K2-0600- TF	3.3
	1.968	3.150	.790	90°	L	**R/LG123L079-16B-050BM**	1.000	1.850	1.000	1.000	6.000	1.630	N123L2-0800- TF	3.7
	2.953	5.906	.790	90°		**R/LG123L079-16B-075BM**	1.000	1.850	1.000	1.000	6.000	1.630	N123L2-0800- TF	3.7
	5.512	15.74	.790	90°		**R/LG123L079-16B-140BM**	1.000	1.850	1.000	1.000	6.000	1.630	N123L2-0800- TF	3.7
	1.339	1.732	.470	0°	G	**R/LF123G047-12B-034B**	.750	.827	.750	.750	5.000	1.260	N123G2-0300- TF	1.5
	1.496	1.890	.470	0°		**R/LF123G047-12B-038B**	.750	.827	.750	.750	5.000	1.260	N123G2-0300- TF	1.5
	1.654	2.362	.500	0°		**R/LF123G050-12B-042B**	.750	.827	.750	.750	5.000	1.287	N123G2-0300- TF	1.6
	2.126	2.953	.500	0°		**R/LF123G050-12B-054B**	.750	.827	.750	.750	5.000	1.287	N123G2-0300- TF	1.7
	2.638	3.937	.500	0°		**R/LF123G050-12B-067B**	.750	.827	.750	.750	5.000	1.287	N123G2-0300- TF	1.9
	3.543	6.299	.500	0°		**R/LF123G050-12B-090B**	.750	.827	.750	.750	5.000	1.287	N123G2-0300- TF	2.1
	5.118	11.81	.500	0°		**R/LF123G050-12B-130B**	.750	.827	.750	.750	5.000	1.287	N123G2-0300- TF	2.3
	1.339	1.575	.470	0°		**R/LF123G047-16B-034B**	1.000	1.039	1.000	1.000	6.000	1.257	N123G2-0300- TF	3.0
	1.654	2.362	.750	0°		**R/LF123G075-16B-042B**	1.000	1.039	1.000	1.000	6.000	1.577	N123G2-0300- TF	3.0
	2.126	2.953	.750	0°		**R/LF123G075-16B-054B**	1.000	1.039	1.000	1.000	6.000	1.577	N123G2-0300- TF	3.0
	2.638	3.937	.750	0°		**R/LF123G075-16B-067B**	1.000	1.039	1.000	1.000	6.000	1.577	N123G2-0300- TF	3.0
	3.543	6.299	.870	0°		**R/LF123G087-16B-090B**	1.000	1.039	1.000	1.000	6.000	1.697	N123G2-0300- TF	3.0
	5.118	11.81	.870	0°		**R/LF123G087-16B-130B**	1.000	1.039	1.000	1.000	6.000	1.697	N123G2-0300- TF	3.0
	1.496	1.890	.470	0°		**RF123G047-16B-038B**	1.000	1.039	1.000	1.000	6.000	1.257	N123G2-0300- TF	3.0
	1.575	2.362	.500	0°	H	**R/LF123H050-16B-040BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123H2-0400- TF	2.1
	2.047	2.835	.500	0°		**R/LF123H050-16B-052BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123H2-0400- TF	2.2
	2.520	3.937	.500	0°		**R/LF123H050-16B-064BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123H2-0400- TF	2.3
	3.622	5.512	.500	0°		**R/LF123H050-16B-092BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123H2-0400- TF	2.7
	5.197	9.055	.500	0°		**R/LF123H050-16B-132BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123H2-0400- TF	2.9
	8.661	19.68	.500	0°		**R/LF123H050-16B-220BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123H2-0400- TF	3.1
	11.81	43.30	.500	0°		**R/LF123H050-16B-300BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123H2-0400- TF	3.1
	1.575	2.362	.790	0°		**R/LF123H079-16B-040BM**	1.000	1.039	1.000	1.000	6.000	1.656	N123H2-0400- TF	3.0
	2.047	2.835	.790	0°		**R/LF123H079-16B-052BM**	1.000	1.039	1.000	1.000	6.000	1.656	N123H2-0400- TF	3.0
	2.520	3.937	1.000	0°		**R/LF123H100-16B-064BM**	1.000	1.039	1.000	1.000	6.000	1.888	N123H2-0400- TF	3.0
	3.622	5.512	1.000	0°		**R/LF123H100-16B-092BM**	1.000	1.039	1.000	1.000	6.000	1.888	N123H2-0400- TF	3.0
	5.197	9.055	1.000	0°		**R/LF123H100-16B-132BM**	1.000	1.039	1.000	1.000	6.000	1.888	N123H2-0400- TF	3.0
	8.661	19.68	1.000	0°		**R/LF123H100-16B-220BM**	1.000	1.039	1.000	1.000	6.000	1.888	N123H2-0400- TF	3.0
	11.81	31.49	1.000	0°		**R/LF123H100-16B-300BM**	1.000	1.039	1.000	1.000	6.000	1.888	N123H2-0400- TF	3.0

[1] a_r max. for holder. For max stability choose a holder with reinforced design.
[2] To correspond with seat size on insert.
[3] Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

Continued ...

 B6
 B111
 G6
 B2
 J2

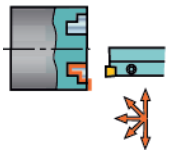
CoroCut® 1- and 2-edge

Shank tools for face grooving

Screw clamp

... Continued

Inch dimensions

Main application	First cut diameter, inch min	max	a_p max[1]	Shank style	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[3]
	1.575	2.756	.500	0°	J	**R/LF123J050-16B-040BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123J2-0500- TF	2.1
	2.362	3.740	.500	0°		**R/LF123J050-16B-060BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123J2-0500- TF	2.4
	3.346	5.118	.500	0°		**R/LF123J050-16B-085BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123J2-0500- TF	2.7
	4.724	7.087	.500	0°		**R/LF123J050-16B-120BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123J2-0500- TF	3.0
	6.890	19.68	.500	0°		**R/LF123J050-16B-175BM**	1.000	1.024	1.000	1.000	6.000	1.327	N123J2-0500- TF	3.0
	1.575	2.756	.790	0°		**R/LF123J079-16B-040BM**	1.000	1.039	1.000	1.000	6.000	1.696	N123J2-0500- TF	3.3
	7.087	38.58	.790	0°		**R/LF123J079-16B-180BM**	1.000	1.039	1.000	1.000	6.000	1.696	N123J2-0500- TF	3.3
	2.362	3.740	1.000	0°		**R/LF123J100-16B-060BM**	1.000	1.039	1.000	1.000	6.000	1.906	N123J2-0500- TF	3.3
	3.346	5.118	1.000	0°		**R/LF123J100-16B-085BM**	1.000	1.039	1.000	1.000	6.000	1.906	N123J2-0500- TF	3.3
	4.724	7.087	1.000	0°		**R/LF123J100-16B-120BM**	1.000	1.039	1.000	1.000	6.000	1.906	N123J2-0500- TF	3.3
	6.890	19.68	1.000	0°		**R/LF123J100-16B-175BM**	1.000	1.039	1.000	1.000	6.000	1.906	N123J2-0500- TF	3.3
	1.575	2.756	.500	0°	K	**R/LF123K050-16B-040BM**	1.000	1.024	1.000	1.000	6.000	1.366	N123K2-0600- TF	2.4
	2.284	3.937	.500	0°		**R/LF123K050-16B-058BM**	1.000	1.024	1.000	1.000	6.000	1.366	N123K2-0600- TF	2.6
	3.465	7.087	.500	0°		**R/LF123K050-16B-088BM**	1.000	1.024	1.000	1.000	6.000	1.366	N123K2-0600- TF	3.0
	6.614	15.74	.500	0°		**R/LF123K050-16B-168BM**	1.000	1.024	1.000	1.000	6.000	1.366	N123K2-0600- TF	3.3
	8.661	38.58	.500	0°		**R/LF123K050-16B-220BM**	1.000	1.024	1.000	1.000	6.000	1.366	N123K2-0600- TF	3.5
	1.575	2.756	.790	0°		**R/LF123K079-16B-040BM**	1.000	1.039	1.000	1.000	6.000	1.735	N123K2-0600- TF	3.7
	2.284	3.400	1.000	0°		**R/LF123K100-16B-058BM**	1.000	1.039	1.000	1.000	6.000	1.945	N123K2-0600- TF	3.7
	3.465	7.087	1.000	0°		**R/LF123K100-16B-088BM**	1.000	1.039	1.000	1.000	6.000	1.945	N123K2-0600- TF	3.7
	6.614	15.74	1.000	0°		**R/LF123K100-16B-168BM**	1.000	1.039	1.000	1.000	6.000	1.945	N123K2-0600- TF	3.7
	8.661	39.37	1.000	0°		**R/LF123K100-16B-220BM**	1.000	1.039	1.000	1.000	6.000	1.945	N123K2-0600- TF	3.7
	2.953	5.906	1.100	0°	L	**R/LF123L110-20B-075BM**	1.250	1.299	1.250	1.250	6.000	2.205	N123L2-0800- TF	4.2
	5.512	15.74	1.100	0°		**R/LF123L110-20B-140BM**	1.250	1.299	1.250	1.250	6.000	2.205	N123L2-0800- TF	4.9

1) a_p max. for holder. For max stability choose a holder with reinforced design.

2) To correspond with seat size on insert.

3) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

Main spare parts

Seat size	Shank holder size	Screw	Key (Torx Plus)
G	2525	3212 012-310	5680 043-15 (25IP)
H, J, K, L	2525	5512 044-01	5680 043-17 (30IP)

 B6
 B111
 G6
 B2
 J2

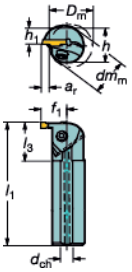
CoroCut® 1- and 2-edge

Boring bars

Screw clamp

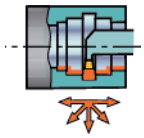
R/LAG 123
Cylindrical with flats

dmm = 32–50 mm (1.250–2.000 inch)

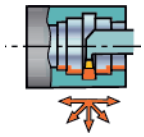


Right hand style shown

Metric version

Main application	D_m min	a_r max	Seat size[1]	Ordering code	Dimensions dm_m	f_1	h	h_1	l_1	l_3	d_{ch}	Gauge inserts	Nm[2]
	40	9.5	E	**R/LAG123E09-32B**	32	25.5	30	15	250	45	9	N123E2-0200- GM	4.0
	40	9	G	**R/LAG123G09-32B**	32	25.25	30	15	250	45	9	N123G2-0300- GM	4.5
	50	11		**R/LAG123G11-40B**	40	31	37	18.5	300	55	12	N123G2-0300- GM	4.5
	40	10	H	**R/LAG123H10-32B**	32	26.5	30	15	250	45	9	N123H2-0400- GM	4.5
	50	11		**R/LAG123H11-40B**	40	31	37	18.5	300	55	12	N123H2-0400- GM	5.0
	60	13		**R/LAG123H13-50B**	50	38.25	47	23.5	350	65	12	N123H2-0400- GM	5.0
	40	11	J	**R/LAG123J11-32B**	32	27	30	15	250	45	9	N123J2-0500- GM	5.0
	50	11		**R/LAG123J11-40B**	40	31	37	18.5	300	55	12	N123J2-0500- GM	5.5
	60	13		**R/LAG123J13-50B**	50	38.25	47	23.5	350	65	12	N123J2-0500- GM	5.5
	50	11	K	**R/LAG123K11-40B**	40	31	37	18.5	300	55	12	N123K2-0600-GM	5.5
	60	13		**R/LAG123K13-50B**	50	38.25	47	23.5	350	65	12	N123K2-0600-GM	5.5

Inch version

Main application	D_m min	a_r max	Seat size[1]	Ordering code	Dimensions, inch dm_m	f_1	h	h_1	l_1	l_3	d_{ch}	Gauge inserts	ft-lbs[3]
	1.575	.374	E	**R/LAG123E035-20B**	1.250	1.014	1.181	.591	9.842	1.772	.354	N123E2-0200- GM	3.0
	1.575	.354	G	**R/LAG123G037-20B**	1.250	.994	1.181	.591	9.842	1.772	.354	N123G2-0300- GM	3.3
	1.968	.433		**R/LAG123G043-24B**	1.500	1.220	1.457	.728	11.811	2.165	.472	N123G2-0300- GM	3.3
	1.575	.394	H	**R/LAG123H039-20B**	1.250	1.043	1.181	.591	9.842	1.772	.354	N123H2-0400- GM	3.3
	1.968	.433		**R/LAG123H043-24B**	1.500	1.220	1.457	.728	11.811	2.165	.472	N123H2-0400- GM	3.7
	2.362	.512		**R/LAG123H051-32B**	2.000	1.506	1.850	.925	13.780	2.559	.472	N123H2-0400- GM	3.7
	1.575	.433	J	**R/LAG123J045-20B**	1.250	1.063	1.181	.591	9.842	1.772	.354	N123J2-0500- GM	3.7
	1.968	.433		**R/LAG123J045-24B**	1.500	1.220	1.457	.728	11.811	2.165	.472	N123J2-0500- GM	4.1
	2.362	.512		**R/LAG123J051-32B**	2.000	1.506	1.850	.925	13.780	2.559	.472	N123J2-0500- GM	4.1
	1.968	.433	K	**R/LAG123K043-24B**	1.500	1.220	1.457	.728	11.811	2.165	.472	N123K2-0600-GM	4.1
	2.362	.512		**R/LAG123K053-32B**	2.000	1.506	1.850	.925	13.780	2.559	.472	N123K2-0600-GM	4.1

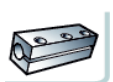
[1] To correspond with seat size on insert.
[2] Insert tightening torque, Nm. Use torque wrench, see page B110.
[3] Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

For coolant connector, see page A308.

Main spare parts

Seat size	Bar diameter, dm_m mm	inch	Screw	Key (Torx Plus)
D, E, G	16-20	.625- .750	5512 031-03	5680 043-13 (15IP)
E	25-32	1.000-1.250	3212 012-259	5680 043-14 (20IP)
G	25-32	1.000-1.500	3212 012-309	5680 043-15 (25IP)
G	40		3212 012-310	5680 043-15 (25IP)
H, J	25	1.000	3212 012-309	5680 043-15 (25IP)
H, J	32	1.250	3212 012-359	5680 143-17 (30IP)
H, J, K	40-50	1.500-2.000	3212 012-360	5680 043-17 (30IP)

 B6
 B115
 G6
 B2
 A304
 J2

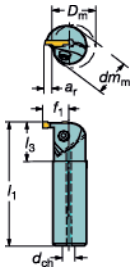
CoroCut® 1- and 2-edge

Boring bars

Screw clamp

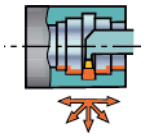
R/LAG 123
Cylindrical with groove for EasyFix sleeve

dmm = 16–25 mm (.625–1.000 inch)

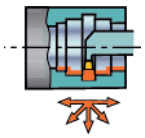


Right hand style shown

Metric version

Main application	D_m min	a_r max	Seat size[1]	Ordering code	Dimensions dm_m	f_1	l_1	l_3	d_{ch}	Gauge inserts	Nm[3]
	25	4.5	D	**R/LAG123D04-16B**	16	12.5	150	25	6	N123D2-0150- CM	3.0
	32	5		**R/LAG123D05-20B**	20	15.25	180	30	6	N123D2-0150- CM	3.0
	32	5	E	**R/LAG123E05-20B**[2]	20	15.25	180	30	6	N123E2-0200- GM	3.5
	32	7		**R/LAG123E07-25B**	25	19.75	200	35	9	N123E2-0200- GM	3.5
	32	6	G	**R/LAG123G06-20B**[2]	20	15.25	180	30	6	N123G2-0300- GM	4.0
	32	7		**R/LAG123G07-25B**	25	19.75	200	35	9	N123G2-0300- GM	4.0
	32	7	H	**R/LAG123H07-25B**	25	19.25	200	35	9	N123H2-0400- GM	4.5
	32	8	J	**R/LAG123J08-25B**	25	19.75	200	35	9	N123J2-0500- GM	5.0

Inch version

Main application	D_m min	a_r max	Seat size[1]	Ordering code	Dimensions, inch dm_m	f_1	l_1	l_3	d_{ch}	Gauge inserts	ft-lbs[4]
	.984	.177	D	**R/LAG123D016-10B**	.625	.489	5.906	.984	.236	N123D2-0150- CM	2.2
	1.260	.197		**R/LAG123D020-12B**	.750	.592	7.087	1.181	.236	N123D2-0150- CM	2.2
	1.260	.197	E	**R/LAG123E020-12B**[2]	.750	.592	7.087	1.181	.236	N123E2-0200- GM	2.6
	1.260	.276		**R/LAG123E028-16B**	1.000	.785	7.874	1.378	.354	N123E2-0200- GM	2.6
	1.260	.236	G	**R/LAG123G024-12B**[2]	.750	.600	7.087	1.181	.236	N123G2-0300- GM	3.0
	1.260	.276		**R/LAG123G030-16B**	1.000	.778	7.874	1.378	.354	N123G2-0300- GM	3.0
	1.260	.276	H	**R/LAG123H030-16B**	1.000	.758	7.874	1.378	.354	N123H2-0400- GM	3.3
	1.260	.315	J	**R/LAG123J031-16B**	1.000	.778	7.874	1.378	.354	N123J2-0500- GM	3.7

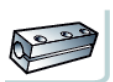
R = Right hand, L = Left hand

[1] To correspond with seat size on insert.
[2] When using an insert with -GF geometry, min. hole diameter (D_m) is .984 inch (25 mm).
[3] Insert tightening torque, Nm. Use torque wrench, see page B110.
[4] Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

For coolant connector, see page A308.

Main spare parts

Seat size	Bar diameter, dm_m mm	inch	Screw	Key (Torx Plus)
D, E, G	16-20	.625- .750	5512 031-03	5680 043-13 (15IP)
E	25-32	1.000-1.250	3212 012-259	5680 043-14 (20IP)
G	25-32	1.000-1.500	3212 012-309	5680 043-15 (25IP)
G	40		3212 012-310	5680 043-15 (25IP)
H, J	25	1.000	3212 012-309	5680 043-15 (25IP)
H, J	32	1.250	3212 012-359	5680 143-17 (30IP)
H, J, K	40-50	1.500-2.000	3212 012-360	5680 043-17 (30IP)

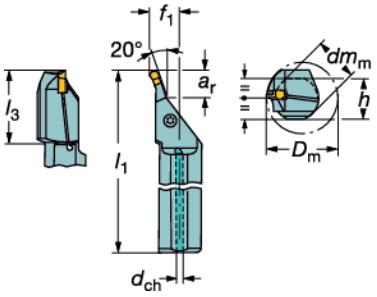
 B6
 B115
 G6
 B2
 A304
 J2

CoroCut® 1- and 2-edge

Boring bars for profiling

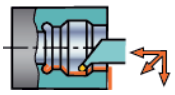
Screw clamp

With flats
R/LAX123

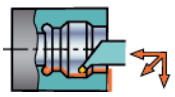


Right hand style shown

Metric version

Main application	D_m min	a_r max	Seat size[1]	Ordering code	Dimensions dm_m	f_1	h	h_1	l_1	l_3	d_{ch}	Gauge inserts	Nm[2]
	63.5	25	J	**R/LAX123J25-40B-020**	40	26	37	18.5	254	65.6	12	N123J2-0600- AM	3.0
	63.5	25	L	**R/LAX123L25-40B-020**	40	26	37	18.5	254	65.6	12	N123L2-0800- AM	3.0

Inch version

Main application	D_m min	a_r max	Seat size[1]	Ordering code	Dimensions, inch dm_m	f_1	h	h_1	l_1	l_3	d_{ch}	Gauge inserts	ft-lbs[3]
	2.500	.941	J	**R/LAX123J094-24B-020**	1.500	.961	1.374	.687	10.000	2.539	.472	N123J2-0600- AM	2.2
	2.500	.941	L	**R/LAX123L094-24B-020**	1.500	1.000	1.374	.687	10.000	2.571	.472	N123L2-0800- AM	2.2

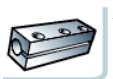
1) To correspond with seat size on insert.
2) Insert tightening torque, Nm. Use torque wrench, see page B110.
3) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

For coolant connector, see page A308.

Main spare parts

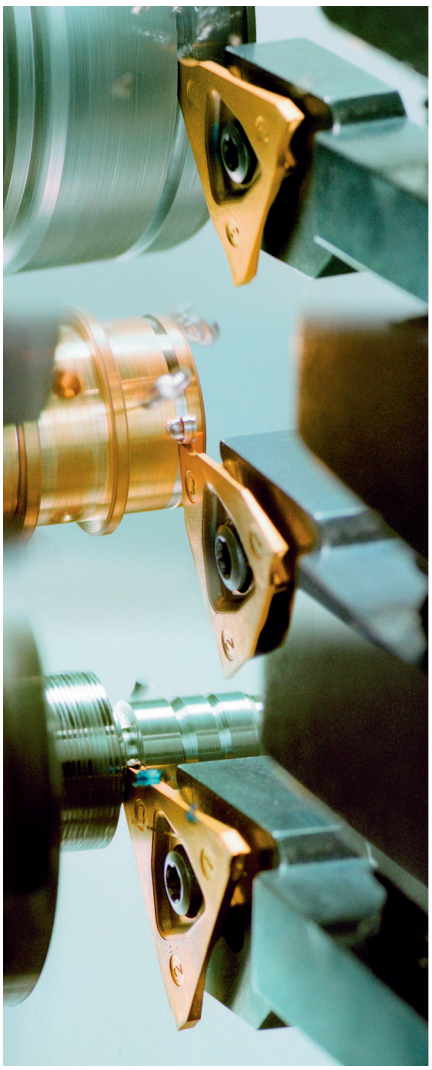
Seat size	Bar diameter, dm_m inch	mm	Screw	Key (Torx Plus)
J, L	1.500	40	5512 044-01	5680 043-17 (30IP)

 B6
 B115
 G6
 B2
 A304
 J2

CoroCut® 3

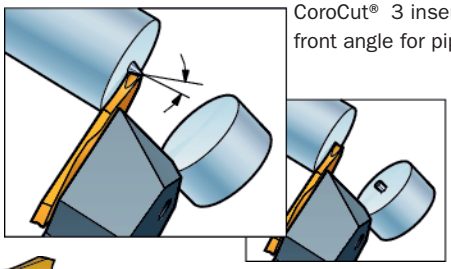
System with 3 cutting edges

The productive choice for shallow parting
Grooving and profiling



CoroCut® 3 system

Designed for economic shallow parting, grooving and profiling mass production, featuring:
Grooving widths 0.5 – 3.18 mm (0.020 – 0.125 inch)
Extremely small parting widths down to 1 mm (0.039 inch)
Cutting depths to 6.4 mm (0.252 inch)
Very close insert indexing tolerance
Maximum versatility – one holder for all insert widths
Tool holder assortment includes Coromant Capto® and shank holder in small to medium sizes



CoroCut® 3 inserts also available with front angle for pip and burr-free parting.

Insert geometries

123-CM

- CM, chipbreaking geometry for normal cutting conditions

123-CS

- CS, with extra sharp cutting edges to be used at very low cutting data and in sticky materials, such as low carbon.

123-RS

- RS, full radii, sharp edge

123-GS

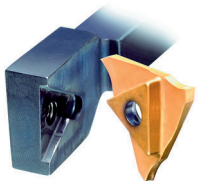
- GS, straight cutting, sharp edge

Unique clamping system

It is possible to index the insert directly on the machine by just undoing the screw a couple of turns. If insert breakage should occur, the clamping mechanism will not be affected - just index the insert and start the machine.

Tailor Made

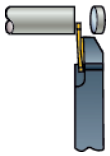
Even more possibilities with tailored design. For more information on our Tailor Made program see page J3.



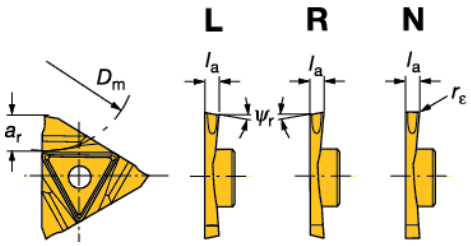
SANDVIK Coromant

CoroCut® 3

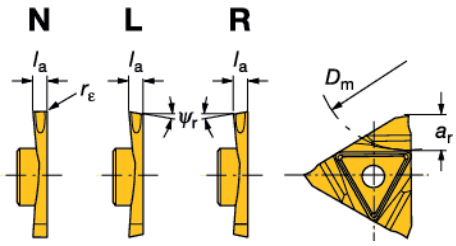
Shallow parting



N123T3/R123T3/L123T3



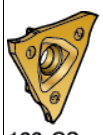
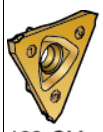
N123U3/R123U3/L123U3



Tolerances, mm (inch):

N123 -CM	l_a =	±0.03 (±.001)
	r_ε =	+0,-0.10 (+0,-.004)
N123 -CS	l_a =	±0.03 (±.001)
	r_ε =	+0.10, -0 (+.004,-0)
R/L123 -CS	l_a =	±0.07 (±.003)
	r_ε =	+0.10,-0 (+.004,-0)

For ISO application areas, see bottom of the table.

		Selection criteria, millimeter, inch (mm, in.)															
		l_a mm	l_a in.	ψ_r	r_ε mm	r_ε in.	a_r max mm	a_r max in.[1]	D_m max mm[1]	D_m max in.[1]	Seat size[2]	Ordering code	P GC 1125	M GC 1125	K GC 1125	N GC 1125	S GC 1125
Low feed	 123-CS	1.00	.039	0°	0	.000	4.30	.169	50	1.968	T	N123T3-0100-0000-CS	★	★	★	★	★
		1.50	.059	0°	0	.000	6.40	.252	100	3.937		N123T3-0150-0000-CS	★	★	★	★	★
		2.00	.079	0°	0	.000	6.40	.252	100	3.937		N123T3-0200-0000-CS	★	★	★	★	★
		1.00	.039	5°	0	.000	4.20	.165	50	1.968		R/L123T3-0100-0500-CS	★	★	★	★	★
		1.00	.039	10°	0	.000	4.20	.165	50	1.968		R/L123T3-0100-1000-CS	★	★	★	★	★
		1.00	.039	15°	0	.000	4.20	.165	50	1.968		R/L123T3-0100-1500-CS	★	★	★	★	★
		1.50	.059	5°	0	.000	6.30	.248	100	3.937		R/L123T3-0150-0500-CS	★	★	★	★	★
		1.50	.059	10°	0	.000	6.30	.248	100	3.937		R/L123T3-0150-1000-CS	★	★	★	★	★
		1.50	.059	15°	0	.000	6.30	.248	100	3.937		R/L123T3-0150-1500-CS	★	★	★	★	★
		2.00	.079	5°	0	.000	6.30	.248	100	3.937		R/L123T3-0200-0500-CS	★	★	★	★	★
		2.00	.079	10°	0	.000	6.30	.248	100	3.937		R/L123T3-0200-1000-CS	★	★	★	★	★
		2.00	.079	15°	0	.000	6.30	.248	100	3.937		R/L123T3-0200-1500-CS	★	★	★	★	★
		1.00	.039	0°	0	.000	4.30	.169	50	1.968	U	N123U3-0100-0000-CS	★	★	★	★	★
		1.50	.059	0°	0	.000	6.40	.252	100	3.937		N123U3-0150-0000-CS	★	★	★	★	★
		2.00	.079	0°	0	.000	6.40	.252	100	3.937		N123U3-0200-0000-CS	★	★	★	★	★
		1.00	.039	5°	0	.000	4.20	.165	50	1.968		R/L123U3-0100-0500-CS	★	★	★	★	★
		1.00	.039	10°	0	.000	4.20	.165	50	1.968		R/L123U3-0100-1000-CS	★	★	★	★	★
		1.00	.039	15°	0	.000	4.20	.165	50	1.968		R/L123U3-0100-1500-CS	★	★	★	★	★
		1.50	.059	5°	0	.000	6.30	.248	100	3.937		R/L123U3-0150-0500-CS	★	★	★	★	★
		1.50	.059	10°	0	.000	6.30	.248	100	3.937		R/L123U3-0150-1000-CS	★	★	★	★	★
		1.50	.059	15°	0	.000	6.30	.248	100	3.937		R/L123U3-0150-1500-CS	★	★	★	★	★
		2.00	.079	5°	0	.000	6.30	.248	100	3.937		R/L123U3-0200-0500-CS	★	★	★	★	★
		2.00	.079	10°	0	.000	6.30	.248	100	3.937		R/L123U3-0200-1000-CS	★	★	★	★	★
		2.00	.079	15°	0	.000	6.30	.248	100	3.937		R/L123U3-0200-1500-CS	★	★	★	★	★
Medium feed	 123-CM	1.00	.039	0°	0.1	.004	4.30	.169	50	1.968	T	N123T3-0100-0001-CM	☆	☆	☆		☆
		1.50	.059	0°	0.1	.004	6.40	.252	100	3.937		N123T3-0150-0001-CM	☆	☆	☆		☆
		2.00	.079	0°	0.1	.004	6.40	.252	100	3.937		N123T3-0200-0001-CM	☆	☆	☆		☆
		1.00	.039	0°	0.1	.004	4.30	.169	50	1.968	U	N123U3-0100-0001-CM	☆	☆	☆		☆
		1.50	.059	0°	0.1	.004	6.40	.252	100	3.937		N123U3-0150-0001-CM	☆	☆	☆		☆
		2.00	.079	0°	0.1	.004	6.40	.252	100	3.937		N123U3-0200-0001-CM	☆	☆	☆		☆
													P30	M25	K30	N25	S25

[1] D_m max = max bar or tube diameter

[2] To correspond with seat size on holder.

R = Right hand, L = Left hand

★= First choice

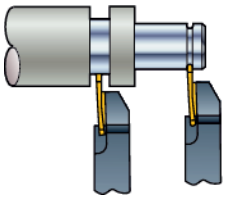
T = Right hand cutting insert, U = Left hand cutting insert.

Insert code key, see page B15

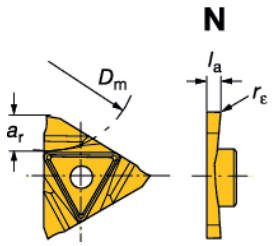
B57 B138 B124 B146 B2 J3 I8

CoroCut® 3

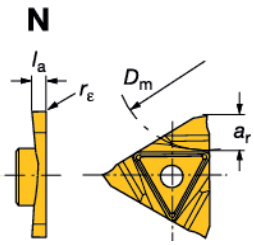
Grooving



N123T3



N123U3



For ISO application areas, see bottom of the table.

Tailor Made

Tolerances, mm (inch):
GS l_a = ±0.02 (±.0008)

		Selection criteria, millimeter, inch (mm, in.)								For circlip width				P	M	K	N	S
		l_a mm	l_a in.	r_ε mm	r_ε in.	a_r max mm	a_r max in.	D_m max mm[1]	D_m max in.[1]	mm	inch	Seat size[2]	Ordering code	GC 1125	GC 1125	GC 1125	GC 1125	GC 1125
Low feed	 123-GS	0.50	.020	0	.000	1.50	.059	100	3.937			T	N123T3-0050-0000-GS	★	★	★	★	★
		0.60	.024	0	.000	1.60	.063	100	3.937	0.50	.020		N123T3-0060-0000-GS	★	★	★	★	★
		0.70	.028	0	.000	1.70	.067	100	3.937				N123T3-0070-0000-GS	★	★	★	★	★
		0.80	.032	0	.000	1.80	.071	100	3.937	0.70	.028		N123T3-0080-0000-GS	★	★	★	★	★
		0.90	.035	0	.000	2.00	.079	100	3.937	0.80	.032		N123T3-0090-0000-GS	★	★	★	★	★
		1.00	.039	0	.000	2.20	.087	100	3.937	0.90	.035		N123T3-0100-0000-GS	★	★	★	★	★
		1.20	.047	0	.000	2.30	.091	100	3.937	1.10	.043		N123T3-0120-0000-GS	★	★	★	★	★
		1.40	.055	0	.000	2.70	.106	100	3.937	1.30	.051		N123T3-0140-0000-GS	★	★	★	★	★
		1.50	.059	0	.000	3.00	.118	100	3.937				N123T3-0150-0000-GS	★	★	★	★	★
		1.60	.063	0	.000	3.20	.126	100	3.937				N123T3-0160-0000-GS	★	★	★	★	★
		1.70	.067	0	.000	3.30	.130	100	3.937	1.60	.063		N123T3-0170-0000-GS	★	★	★	★	★
		1.95	.077	0	.000	3.90	.154	100	3.937	1.85	.073		N123T3-0195-0000-GS	★	★	★	★	★
		2.00	.079	0	.000	4.00	.157	100	3.937				N123T3-0200-0000-GS	★	★	★	★	★
		2.25	.089	0	.000	4.50	.177	100	3.937	2.15	.085		N123T3-0225-0000-GS	★	★	★	★	★
		2.50	.098	0	.000	5.00	.197	100	3.937				N123T3-0250-0000-GS	★	★	★	★	★
		2.75	.108	0	.000	5.50	.216	100	3.937	2.65	.104		N123T3-0275-0000-GS	★	★	★	★	★
		3.00	.118	0	.000	6.00	.236	100	3.937				N123T3-0300-0000-GS	★	★	★	★	★
		3.18	.125	0	.000	6.00	.236	100	3.937	3.15	.124		N123T3-0318-0000-GS	★	★	★	★	★
		0.50	.020	0	.000	1.50	.059	100	3.937			U	N123U3-0050-0000-GS	★	★	★	★	★
		0.60	.024	0	.000	1.60	.063	100	3.937	0.50	.020		N123U3-0060-0000-GS	★	★	★	★	★
		0.70	.028	0	.000	1.70	.067	100	3.937				N123U3-0070-0000-GS	★	★	★	★	★
		0.80	.032	0	.000	1.80	.071	100	3.937	0.70	.028		N123U3-0080-0000-GS	★	★	★	★	★
		0.90	.035	0	.000	2.00	.079	100	3.937	0.80	.032		N123U3-0090-0000-GS	★	★	★	★	★
		1.00	.039	0	.000	2.20	.087	100	3.937	0.90	.035		N123U3-0100-0000-GS	★	★	★	★	★
		1.20	.047	0	.000	2.30	.091	100	3.937	1.10	.043		N123U3-0120-0000-GS	★	★	★	★	★
		1.40	.055	0	.000	2.70	.106	100	3.937	1.30	.051		N123U3-0140-0000-GS	★	★	★	★	★
		1.50	.059	0	.000	3.00	.118	100	3.937				N123U3-0150-0000-GS	★	★	★	★	★
		1.60	.063	0	.000	3.20	.126	100	3.937				N123U3-0160-0000-GS	★	★	★	★	★
		1.70	.067	0	.000	3.30	.130	100	3.937	1.60	.063		N123U3-0170-0000-GS	★	★	★	★	★
		1.95	.077	0	.000	3.90	.154	100	3.937	1.85	.073		N123U3-0195-0000-GS	★	★	★	★	★
		2.00	.079	0	.000	4.00	.157	100	3.937				N123U3-0200-0000-GS	★	★	★	★	★
		2.25	.089	0	.000	4.50	.177	100	3.937	2.15	.085		N123U3-0225-0000-GS	★	★	★	★	★
		2.50	.098	0	.000	5.00	.197	100	3.937				N123U3-0250-0000-GS	★	★	★	★	★
		2.75	.108	0	.000	5.50	.216	100	3.937	2.65	.104		N123U3-0275-0000-GS	★	★	★	★	★
		3.00	.118	0	.000	6.00	.236	100	3.937				N123U3-0300-0000-GS	★	★	★	★	★
		3.18	.125	0	.000	6.00	.236	100	3.937	3.15	.124		N123U3-0318-0000-GS	★	★	★	★	★
														P30	M25	K30	N25	S25

1) D_m max = max bar or tube diameter
2) To correspond with seat size on holder.

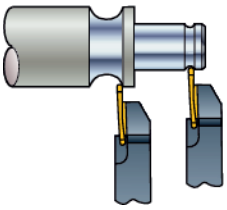
N = Neutral
★= First choice

T = Right hand cutting insert, U = Left hand cutting insert.
Insert code key, see page B15

B57 B138 B124 B146 B2 J3 I8

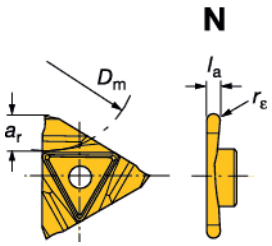
CoroCut® 3

Grooving/Profiling

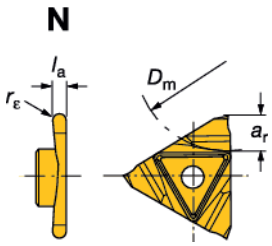


Tailor Made

N123T3



N123U3



For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
RS l_a = ±0.02 (±.0008)

		Selection criteria, millimeter, inch (mm, in.)										P	M	K	N	S
												GC	GC	GC	GC	GC
		l_a mm	l_a in.	r_ε mm	r_ε in.	a_r max mm	a_r max in.[1]	D_m max mm[1]	D_m max in.[1]	Seat size[2]	**Ordering code**	1125	1125	1125	1125	1125
Low feed	 123-RS	0.50	.020	0.25	.010	1.50	.059	100	3.937	T	**N123T3-0050-RS**	★	★	★	★	★
		0.80	.032	0.4	.016	1.80	.071	100	3.937		**N123T3-0080-RS**	★	★	★	★	★
		1.00	.039	0.5	.020	2.20	.087	100	3.937		**N123T3-0100-RS**	★	★	★	★	★
		1.50	.059	0.75	.030	3.30	.130	100	3.937		**N123T3-0150-RS**	★	★	★	★	★
		2.00	.079	1	.039	4.00	.157	100	3.937		**N123T3-0200-RS**	★	★	★	★	★
		2.50	.098	1.25	.049	5.00	.197	100	3.937		**N123T3-0250-RS**	★	★	★	★	★
		3.00	.118	1.5	.059	6.00	.236	100	3.937		**N123T3-0300-RS**	★	★	★	★	★
		0.50	.020	0.25	.010	1.50	.059	100	3.937	U	**N123U3-0050-RS**	★	★	★	★	★
		0.80	.032	0.4	.016	1.80	.071	100	3.937		**N123U3-0080-RS**	★	★	★	★	★
		1.00	.039	0.5	.020	2.20	.087	100	3.937		**N123U3-0100-RS**	★	★	★	★	★
		1.50	.059	0.75	.030	3.30	.130	100	3.937		**N123U3-0150-RS**	★	★	★	★	★
		2.00	.079	1	.039	4.00	.157	100	3.937		**N123U3-0200-RS**	★	★	★	★	★
		2.50	.098	1.25	.049	5.00	.197	100	3.937		**N123U3-0250-RS**	★	★	★	★	★
		3.00	.118	1.5	.059	6.00	.236	100	3.937		**N123U3-0300-RS**	★	★	★	★	★
												P30	M25	K30	N25	S25

1) D_m max = max bar or tube diameter
2) To correspond with seat size on holder.

N = Neutral
★= First choice

T = Right hand cutting insert, U = Left hand cutting insert.
Insert code key, see page B15

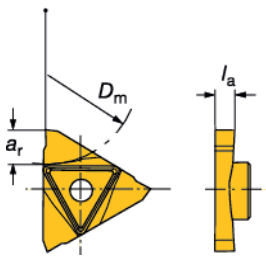
B57 B138 B124 B146 B2 J3 I8

CoroCut® 3

Blanks

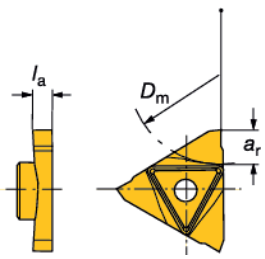
N123T3

Cutting edge height



N123U3

Cutting edge height



For ISO application areas, see bottom of the table.

For grinding instructions, see Metalcutting Technical guide.

Tolerances, mm (inch):
-BG l_a =± 0.05 mm (.002 inch)

	Selection criteria, millimeter, inch (mm, in.)									Ordering code	P	M	K	N
	l_a mm	l_a in.	Width range min	Width range max	a_r max mm	a_r max in.	D_m max mm	D_m max in.	Seat size		- H10F	- H10F	- H10F	- H10F
 123-BG	3.40	.134	0.5	3	6.4	.252	100	3.937	T	**N123T3-0340-BG**	★	★	★	★
	3.40	.134	0.5	3	6.4	.252	100	3.937	U	**N123U3-0340-BG**	★	★	★	★
											P20	M10		N20

T = Right hand cutting insert, U = Left hand cutting insert.
N = Neutral
Note: Precaution should be taken when grinding cemented carbide products. See page J7 for safety information.
★= First choice

Insert code key, see page B15

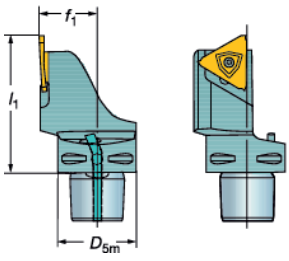
B57 B138 B124 B146 B2 J3 I8

CoroCut® 3

Coromant Capto® cutting units for shallow parting, grooving and profiling

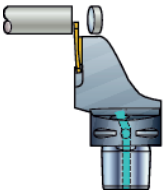
Screw clamp design

Cx-R/LF123



Right hand tool with right hand insert seat (T) shown.

Coolant inlet: Radial through the taper

Main application	a_r max mm	a_r max inch	Seat size[1]	Ordering code	Dimensions, millimeter, inch (mm, in.) f_1 mm[3]	f_1 in.[3]	D_{5m} mm	D_{5m} in.	l_1 mm	l_1 in.	Gauge inserts	Nm[2]
	6.4	.252	T	**C3-RF123T06-22045BM**	22	.866	32	1.260	45	1.772	N123T3-0150- CM	3.0
	6.4	.252		**C4-RF123T06-27060BM**	27	1.063	40	1.575	60	2.362	N123T3-0150- CM	3.0
	6.4	.252	U	**C3-LF123U06-22045BM**	22	.866	32	1.260	45	1.772	N123U3-0150- CM	3.0
	6.4	.252		**C4-LF123U06-27060BM**	27	1.063	40	1.575	60	2.362	N123U3-0150- CM	3.0

1) To correspond with seat size on insert.

2) Insert tightening torque, Nm. Use torque wrench, see page B110.

3) f_1, valid with gauge insert

T = Right hand cutting insert, U = Left hand cutting insert.

R = Right hand, L = Left hand

Note!
When using CoroCut3 inserts, the a_r of the insert gives the maximum depth of cut.
Cutting head for CoroTurn® SL, see page I46.

Main spare parts

Cutting unit size	Screw	Key (Torx Plus)	Screwdriver (Torx Plus)[1]
C3-C4	5513 020-62	5680 049-02 (15IP)	5680 046-01 (8IP)

1) Accessories, must be ordered separately.

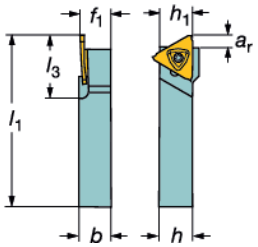
 B53
 B57
 B116
 G6
 B2
 J2

CoroCut® 3

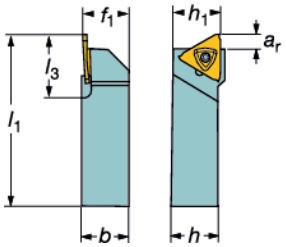
Shank tools for shallow parting, grooving and profiling

Screw clamp design

R/LF123
Shank size 1010 – 1616 (mm), 06 – 10 (inch)

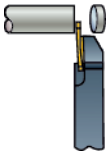


R/LF123
Shank size 2020 – 3232 (mm), 12 – 20 (inch)

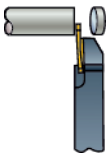


Right hand tool with right hand insert seat (T) shown.

Metric version

Main application	a_r max[1]	Seat size[2]	Ordering code	Dimensions b	f_1[3]	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	6.4	T	RF123T06-1010BM	10	10	10	10	125	23	N123T3-0150- CM	3.0
	6.4		RF123T06-1212BM	12	12	12	12	125	23	N123T3-0150- CM	3.0
	6.4		RF123T06-1616BM	16	16	16	16	125	23	N123T3-0150- CM	3.0
	6.4		RF123T06-2020BM	20	20	20	20	125	23	N123T3-0150- CM	3.0
	6.4		RF123T06-2525BM	25	25	25	25	150	23	N123T3-0150- CM	3.0
	6.4		RF123T06-3232BM	32	32	32	32	170	23	N123T3-0150- CM	3.0
	6.4	U	LF123U06-1010BM	10	10	10	10	125	23	N123U3-0150- CM	3.0
	6.4		LF123U06-1212BM	12	12	12	12	125	23	N123U3-0150- CM	3.0
	6.4		LF123U06-1616BM	16	16	16	16	125	23	N123U3-0150- CM	3.0
	6.4		LF123U06-2020BM	20	20	20	20	125	23	N123U3-0150- CM	3.0
	6.4		LF123U06-2525BM	25	25	25	25	150	23	N123U3-0150- CM	3.0
	6.4		LF123U06-3232BM	32	32	32	32	170	23	N123U3-0150- CM	3.0

Inch version

Main application	a_r max	Seat size	Ordering code	Dimensions, inch b	f_1[3]	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[2]
	.252	T	RF123T023-06BM	.375	.375	.375	.375	4.500	.906	N123T3-0150- CM	2.2
	.252		RF123T023-08BM	.500	.500	.500	.500	4.500	.906	N123T3-0150- CM	2.2
	.252		RF123T023-10BM	.625	.625	.625	.625	4.500	.906	N123T3-0150- CM	2.2
	.252		RF123T023-12BM	.750	.750	.750	.750	4.500	.906	N123T3-0150- CM	2.2
	.252		RF123T023-16BM	1.000	1.000	1.000	1.000	5.000	.906	N123T3-0150- CM	2.2
	.252		RF123T023-20BM	1.250	1.250	1.250	1.250	6.000	.906	N123T3-0150- CM	2.2
	.252	U	LF123U023-06BM	.375	.375	.375	.375	4.500	.906	N123U3-0150- CM	2.2
	.252		LF123U023-08BM	.500	.500	.500	.500	4.500	.906	N123U3-0150- CM	2.2
	.252		LF123U023-10BM	.625	.625	.625	.625	4.500	.906	N123U3-0150- CM	2.2
	.252		LF123U023-12BM	.750	.750	.750	.750	4.500	.906	N123U3-0150- CM	2.2
	.252		LF123U023-16BM	1.000	1.000	1.000	1.000	5.000	.906	N123U3-0150- CM	2.2
	.252		LF123U023-20BM	1.250	1.250	1.250	1.250	6.000	.906	N123U3-0150- CM	2.2

1) To correspond with seat size on holder.
2) Insert tightening torque, Nm. Use torque wrench, see page B110.
3) f_1, valid with gauge insert

R = Right hand, L = Left hand

T = Right hand cutting insert, U = Left hand cutting insert.

Note!
When using CoroCut3 inserts, the a_r of the insert gives the maximum depth of cut.
Cutting head for CoroTurn® SL, see page I46.

Main spare parts

Shank size mm	inch	Screw	For screw head Key (Torx Plus)	For screw bottom Screwdriver (Torx Plus)[1]
1010	06	5513 020-63	5680 049-02 (15IP)	5680 046-01(8IP)
1212 - 3232	08 - 20	5513 020-62	5680 049-02 (15IP)	5680 046-01(8IP)

1) Accessories, must be ordered separately.

 B53
 B57
 B116
 G6
 B2
 J2

T-Max Q-Cut®

System with 1 cutting edge

For deep parting, internal grooving and small diameter facegrooving

Toolholder assortment

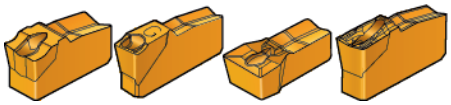
A wide range of toolholders is available for T-Max Q-Cut® inserts.

T-Max Q-Cut® options

- T-Max Q-Cut® 151.2 for deep parting
- T-Max Q-Cut® 151.3 for internal machining and small diameter facegrooving

T-Max Q-Cut® SL - Flexible tool solution

By using CoroTurn® SL adapters and T-Max Q-Cut® cutting blades for insert types 151.2 and 151.3, a large number of tooling solutions, both external and internal, can be made from a limited number of items. See page I2.



Insert geometries

A large variety of geometries are available, dedicated to different applications and feed areas.

Insert grades

To cover all types of workpiece materials, T-Max Q-Cut® inserts are available in a variety of specially developed grades:
- Cemented carbide
- Polycrystalline diamond
- Cubic boron nitride
- Cermet

Tailor Made

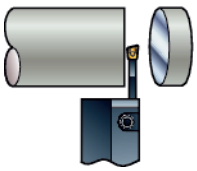
Even more possibilities with tailored design. For more information on our Tailor Made program see page J3.

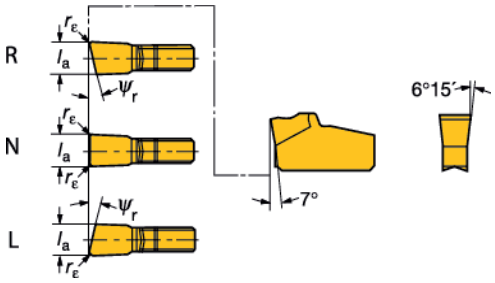
ISO application areas:

P M K N S H

T-Max Q-Cut®

Parting

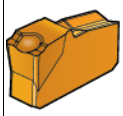
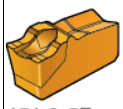




For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
5F
l_a = ±0.03 (±.001)
r_ε = ±0.03 (±.001)
7E
l_a = +0.10/0 (+.004/0)
r_ε = ±0.10 (±.004)
9E
Neutral
l_a = +0.10/0 (+.004/0)
r_ε = ±0.10 (±.004)

Right handed
l_a = +.004/0 (+.010/0)
r_ε = ±0.10 (±.004)

		Selection criteria, millimeter, inch (mm, in.)							P					M					K	S					
									GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
		l_a mm	l_a in.	ψ_r	r_ε mm	r_ε in.	Seat size[1]	Ordering code	1125	1145	2135	2145	235	1125	1145	2135	2145	235	1125	1005	1125	1145	2135	2145	235
	 151.2-9E	2.50	.098	1.5°	0.10	.004	25	R151.2-250 02-9E	★					★					★						
		3.00	.118	0°	0.35	.014	30	N151.2-300-9E	★					★					★						
		4.00	.157	1.5°	0.10	.004	40	R151.2-400 02-9E	★					★					★						
		4.00	.157	0°	0.35	.014		N151.2-400-9E	★					★					★						
	 151.2-7E 	2.50	.098	0°	0.10	.004	25	N151.2-250-7E	☆	★			☆	★	☆			☆	★						
		2.50	.098	5°	0.15	.006		R151.2-250 05-7E	☆	★			☆	★	☆			☆	★						
		3.00	.118	0°	0.10	.004	30	N151.2-300-7E	☆	★	☆		☆	★	☆	☆		☆	★						
		3.00	.118	5°	0.15	.006		R151.2-300 05-7E	☆	★			☆	★	☆			☆	★						
		3.00	.118	5°	0.15	.006		L151.2-300 05-7E	☆					★					★						
		4.00	.157	0°	0.15	.006	40	N151.2-400-7E	☆	★	☆		☆	★	☆	☆		☆	★						
		4.00	.157	5°	0.20	.008		R151.2-400 05-7E	☆	★				★	☆				★						
		4.00	.157	5°	0.20	.008		L151.2-400 05-7E	☆					★					★						
Low feed	 151.2-5F	2.00	.079	20°	0.10	.004	20	R151.2-200 20-5F	★		☆		☆	☆		★		☆	★		★		☆		
		2.00	.079	12°	0.10	.004		R151.2-200 12-5F	★		☆		☆	☆		★		☆	★		★		☆		
		2.00	.079	15°	0.10	.004		R/L151.2-200 15-5F	★		☆		☆	☆		★		☆	★		★		☆		
		2.00	.079	8°	0.10	.004		R/L151.2-200 08-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		2.00	.079	5°	0.10	.004		R/L151.2-200 05-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		2.00	.079	20°	0.10	.004		L151.2-200 20-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		2.00	.079	12°	0.10	.004		L151.2-200 12-5F			☆	☆				★	☆						☆	☆	
		2.00	.079	0°	0.20	.008		N151.2-200-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		2.50	.098	15°	0.10	.004	25	R151.2-250 15-5F	★		☆		☆	☆		★		☆	★		★		☆		
		2.50	.098	12°	0.10	.004		R151.2-250 12-5F	★		☆		☆	☆		★		☆	★		★		☆		
		2.50	.098	8°	0.10	.004		R/L151.2-250 08-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		2.50	.098	5°	0.10	.004		R/L151.2-250 05-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		2.50	.098	15°	0.10	.004		L151.2-250 15-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		2.50	.098	12°	0.10	.004		L151.2-250 12-5F	★					☆					★		★				
		2.50	.098	0°	0.20	.008		N151.2-250-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		3.00	.118	0°	0.20	.008	30	N151.2-300-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		3.00	.118	12°	0.10	.004		R/L151.2-300 12-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		3.00	.118	8°	0.10	.004		R/L151.2-300 08-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		3.00	.118	5°	0.10	.004		R/L151.2-300 05-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		4.00	.157	0°	0.20	.008	40	N151.2-400-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		4.00	.157	5°	0.10	.004		R151.2-400 05-5F	★		☆		☆	☆		★		☆	★		★		☆		
		4.00	.157	8°	0.10	.004		R/L151.2-400 08-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		4.00	.157	5°	0.10	.004		L151.2-400 05-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		5.00	.197	0°	0.20	.008	50	N151.2-500-5F	★		☆	☆	☆	☆		★	☆	☆	★		★		☆	☆	
		5.00	.197	5°	0.10	.004		R151.2-500 05-5F	★		☆			☆		★			★		★		☆		
		5.00	.197	5°	0.10	.004		L151.2-500 05-5F			☆					★							☆		
									P30	P45	P35	P45	P45	M25	M40	M30	M40	M35	K30	S15	S25	S40	S30	S40	S30

[1] To correspond with seat size on holder.

N = Neutral, R = Right hand, L = Left hand

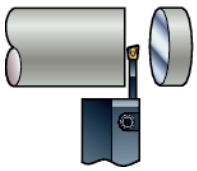
★= First choice

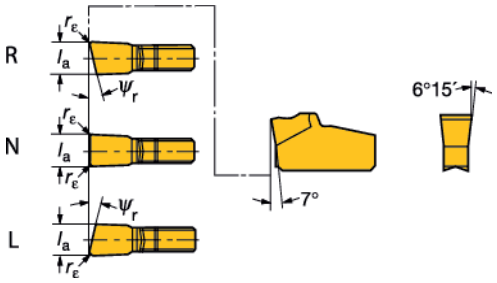
For geometry description, see page B124.

B9 B10 B124 B130 B146 B2 J3 I8

T-Max Q-Cut®

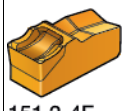
Parting





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
3F
l_a = ±0.03 (±.001)
r_ε = ±0.03 (±.001)
4E, 5E
l_a = +0.25/0 (+.010/0)
r_ε = ±0.10 (±.004)

		Selection criteria, millimeter, inch (mm, in.)							P					M					K				N	S					
									GC	GC	GC	GC	GC	GC	GC	GC	GC	-	GC	GC	GC	-	-	GC	GC	GC	GC	GC	-
		l_a mm	l_a in.	ψ_r	r_ε mm	r_ε in.	Seat size[1]	Ordering code	1125	1145	2135	235	4225	1125	1145	2135	235	H13A	1125	3020	4225	H13A	H13A	1005	1125	1145	2135	235	H13A
Low feed	 151.2-3F	1.57	.062	0°	0.08	.003	15	N151.2-A062-15-3F	☆					☆					☆						☆				
		2.39	.094	0°	0.08	.003	25	N151.2-A094-25-3F	☆					☆					☆						☆				
		2.39	.094	15°	0.08	.003		R151.2-A094-15-25-3F	☆					☆					☆						☆				
		2.39	.094	10°	0.08	.003		R151.2-A094-10-25-3F	☆					☆					☆						☆				
		2.39	.094	5°	0.08	.003		R151.2-A094-05-25-3F	☆					☆					☆						☆				
		3.17	.125	0°	0.08	.003	30	N151.2-A125-30-3F	☆					☆					☆						☆				
		3.17	.125	15°	0.08	.003		R151.2-A125-15-30-3F	☆					☆					☆						☆				
		3.17	.125	10°	0.08	.003		R151.2-A125-10-30-3F	☆					☆					☆						☆				
		3.17	.125	5°	0.08	.003		R151.2-A125-05-30-3F	☆					☆					☆						☆				
		3.96	.156	15°	0.08	.003	40	R151.2-A156-15-40-3F	☆					☆					☆						☆				
Medium feed	 151.2-5E	2.00	.079	0°	0.20	.008	20	N151.2-200-5E	★	☆	☆	☆	☆	☆	☆	★	☆		☆	☆	★	☆	★	★	☆	☆	☆		☆
		2.50	.098	0°	0.20	.008	25	N151.2-250-5E	★	☆	☆	☆	☆	☆	☆	★	☆		☆	☆	★	☆	★	★	☆	☆	☆		☆
		3.00	.118	0°	0.20	.008	30	N151.2-300-5E	★	☆	☆	☆	☆	☆	☆	★	☆		☆	☆	★	☆	★	★	☆	☆	☆		☆
		3.00	.118	5°	0.20	.008		R/L151.2-300 05-5E	★	☆	☆	☆	☆	☆	☆	★	☆		☆		★				★	☆	☆		
		4.00	.157	0°	0.20	.008	40	N151.2-400-5E	★	☆	☆	☆	☆	☆	☆	★	☆		☆	☆	★	☆	★	★	☆	☆	☆		☆
		4.00	.157	5°	0.20	.008		R/L151.2-400 05-5E	★	☆	☆	☆	☆	☆	☆	★	☆		☆		★				★	☆	☆		
		5.00	.197	0°	0.20	.008	50	N151.2-500-5E	★	☆	☆	☆	☆	☆	☆	★	☆		☆	☆	★	☆	★	★	☆	☆	☆		☆
		5.00	.197	5°	0.20	.008		R151.2-500 05-5E	★		☆	☆	☆	☆		★	☆		☆		★				★		☆		
		5.00	.197	5°	0.20	.008		L151.2-500 05-5E			☆	☆	★			★	☆				★						☆		
		6.00	.236	0°	0.20	.008	60	N151.2-600-5E	★	☆	☆	☆	☆	☆	☆	★	☆		☆		★	☆	★	★	☆	☆	☆		☆
		6.00	.236	5°	0.20	.008		R151.2-600 05-5E				☆					☆												
		6.00	.236	5°	0.20	.008		L151.2-600 05-5E				☆	★				☆				★								
High feed	 151.2-4E	2.50	.098	0°	0.30	.012	25	N151.2-250-4E	★	☆	☆	☆	☆	☆	☆	★	☆	☆	☆		★	☆	★		★	☆	☆		☆
		3.00	.118	0°	0.30	.012	30	N151.2-300-4E	★	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	★	☆	★		★	☆	☆		☆
		3.00	.118	5°	0.30	.012		R151.2-300 05-4E	★	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	★	☆	★		★	☆	☆		☆
		3.00	.118	5°	0.30	.012		L151.2-300 05-4E	★	☆	☆	☆	☆	☆	☆	★	☆	☆	☆		★	☆	★		★	☆	☆		☆
		4.00	.157	0°	0.30	.012	40	N151.2-400-4E	★	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	★	☆	★		★	☆	☆		☆
		4.00	.157	5°	0.30	.012		R151.2-400 05-4E	★	☆	☆	☆	☆	☆	☆	★	☆	☆	☆		★	☆	★		★	☆	☆		☆
		4.00	.157	5°	0.30	.012		L151.2-400 05-4E	★		☆	☆	☆	☆		★	☆	☆	☆		★	☆	★		★		☆		☆
		5.00	.197	0°	0.40	.016	50	N151.2-500-4E	★	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	★	☆	★		★	☆	☆		☆
		5.00	.197	5°	0.30	.012		R151.2-500 05-4E	★		☆	☆	☆	☆		★	☆	☆	☆		★	☆	★		★		☆		☆
		5.00	.197	5°	0.30	.012		L151.2-500 05-4E	★			☆	☆	☆			☆		☆		★				★				
		6.00	.236	0°	0.40	.016	60	N151.2-600-4E	★	☆	☆	☆	☆	☆	☆	★	☆	☆	☆		★	☆	★		★	☆	☆		☆
		6.00	.236	5°	0.30	.012		R151.2-600 05-4E	★			☆	☆	☆			☆	☆	☆		★	☆	★		★			☆	☆
		6.00	.236	5°	0.30	.012		L151.2-600 05-4E	★				☆	☆					☆		★				★				
		8.00	.315	0°	0.60	.024	80	N151.2-800-4E	★	☆	☆	☆	☆	☆	☆	★	☆	☆	☆		★	☆	★		★	☆	☆	☆	☆
									P30	P45	P35	P45	P20	M25	M40	M30	M35	M15	K30	K15	K25	K20	N20	S15	S25	S40	S30	S30	S15

[1] To correspond with seat size on holder.

N = Neutral, R = Right hand, L = Left hand

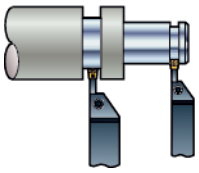
★= First choice

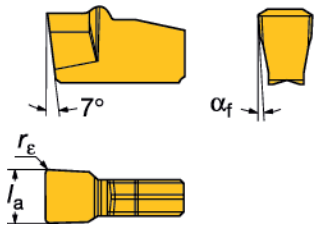
For geometry description, see page B124.

B9 B10 B124 B130 B146 B2 J3 I8

T-Max Q-Cut®

Grooving





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = ±0.02 (±.0008)
r_ε = ±0.05 (±.0020)
For circlip grooves
l_a = +0.13/+0.09 (+.005/+.0035)
r_ε = ±0.05 (±.002)

		Selection criteria, millimeter, inch (mm, in.)							P			M					K		N	S	
									GC	GC	CT	GC	GC	GC	CT	-	GC	-	-	GC	-
		l_a mm	l_a in.	r_ε mm	r_ε in.	α_f	Seat size	Ordering code	1125	235	525	1005	1125	235	525	H13A	1125	H13A	H13A	1005	H13A
Low feed	 151.2-4G	1.98	.078	0.19	.008	3°	20	N151.2-A078-20-4G		★	☆			★	☆	☆		★	★		★
		2.00	.079	0.20	.008	3°		N151.2-200-20-4G	★	☆	☆		★	☆	☆	☆	☆	★	★		★
		2.23	.088	0.19	.008	3°		N151.2-A088-20-4G		★				★		☆		★	★		★
		2.39	.094	0.19	.008	3°	25	N151.2-A094-25-4G	★	☆	☆		★	☆	☆	☆	☆	★	★		★
		2.46	.097	0.32	.013	3°		N151.2-A097-25-4G	★	☆	☆		★	☆	☆	☆	☆	★	★		★
		2.67	.105	0.19	.008	3°		N151.2-A105-25-4G		★				★		☆		★	★		★
		2.79	.110	0.32	.013	3°		N151.2-A110-25-4G	★	☆	☆		★	☆	☆	☆	☆	★	★		★
		3.00	.118	0.20	.008	3°		N151.2-300-25-4G	★	☆	☆	☆	★	☆	☆	☆	☆	★	★	★	☆
		3.10	.122	0.19	.008	3°		N151.2-A122-25-4G		★				★		☆		★	★		★
		3.17	.125	0.19	.008	3°		N151.2-A125-25-4G	★	☆	☆	☆	★	☆	☆	☆	☆	★	★	★	☆
		3.61	.142	0.32	.013	3°	30	N151.2-A142-30-4G	★	☆	☆		★	☆	☆	☆	☆	★	★		★
		3.96	.156	0.19	.008	3°		N151.2-A156-30-4G	★	☆	☆		★	☆	☆	☆	☆	★	★		☆
		4.00	.157	0.20	.008	3°		N151.2-400-30-4G	★	☆	☆	☆	★	☆	☆	☆	☆	★	★	★	☆
		4.52	.178	0.19	.008	3°	40	N151.2-A178-40-4G	★	☆	☆		★	☆	☆	☆	☆	★	★		★
		4.70	.185	0.57	.022	3°		N151.2-A185-40-4G	★	☆	☆		★	☆	☆	☆	☆	★	★		★
		4.80	.189	0.57	.022	3°		N151.2-A189-40-4G	★	☆	☆	☆	★	☆	☆	☆	☆	★	★	★	☆
		5.00	.197	0.20	.008	3°		N151.2-500-40-4G	★	☆	☆	☆	★	☆	☆	☆	☆	★	★	★	☆
		5.41	.213	0.19	.008	3°	50	N151.2-A213-50-4G		★				★		☆		★	★		★
		5.56	.219	0.57	.022	3°		N151.2-A219-50-4G	★	☆			★	☆		☆	☆	★	★		★
		6.00	.236	0.20	.008	3°		N151.2-600-50-4G	★	☆	☆	☆	★	☆	☆	☆	☆	★	★	★	☆
		6.35	.250	0.57	.022	3°	60	N151.2-A250-60-4G	★	☆	☆	☆	★	☆	☆	☆	☆	★	★	★	☆
		7.14	.281	0.83	.033	3°		N151.2-A281-60-4G		★				★		☆		★	★		★
		7.93	.312	0.83	.033	3°		N151.2-A312-60-4G	★	☆			★	☆		☆	☆	★	★		★
		8.00	.315	0.20	.008	3°		N151.2-800-60-4G	★	☆	☆		★	☆	☆	☆	☆	★	★		★
		9.52	.375	0.83	.033	3°	80	N151.2-A375-80-4G	★	☆			★	☆		☆	☆	★	★		★
		10.00	.394	0.30	.012	3°		N151.2-1000-80-4G	★	☆			★	☆		☆	☆	★	★		★
		For circlip grooves																				
		1.85	.073	0.10	.004	3°	20	N151.2-185-20-4G	★	☆	☆		★	☆	☆	☆	☆	★			★
		2.15	.085	0.15	.006	3°		N151.2-215-20-4G	★	☆	☆		★	☆	☆	☆	☆	★			★
		2.65	.104	0.15	.006	3°	25	N151.2-265-25-4G	★	☆	☆		★	☆	☆	☆	☆	★			★
		3.15	.124	0.15	.006	3°		N151.2-315-25-4G		★	☆			★	☆	☆		★			★
		4.15	.163	0.15	.006	3°	30	N151.2-415-30-4G		★				★		☆		★			★
		5.15	.203	0.15	.006	3°	40	N151.2-515-40-4G		★				★		☆		★			★
									P30	P45	P10	M10	M25	M35	M10	M15	K30	K20	N20	S15	S15

1) To correspond with seat size on holder.

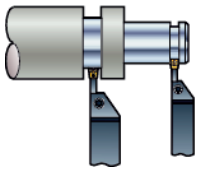
N = Neutral
★= First choice

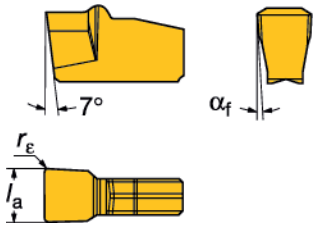
For geometry description, see page B124.

B9 B10 B124 B130 B146 B2 J3 I8

T-Max Q-Cut®

Grooving





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = +0.10/0 (+.004/0)
r_ε = ±0.10 (±.004)
151.2-A-5G
l_a = ±0.05 (±.002)
r_ε = ±0.05 (±.002)

151.2-A-6G
l_a = ±0.03 (±.001)
r_ε = ±0.05 (±.002)

For circlip grooves
l_a >3.00 +0.05/0.13 (>.118 +.002/.005)
l_a ≤3.00 +0.07/0.17 (≤0.118 +.003/.007)

		Selection criteria, mm, inch							P						M						K				N	
									GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	CT	-	GC	GC	GC	-	-	
		l_a mm	l_a in.	r_ε mm	r_ε in.	α_f	Seat size[1]	Ordering code	1125	1145	2135	235	3020	4225	525	1125	1145	2135	235	525	H13A	1125	3020	4225	H13A	H13A
High feed	 151.2-6G	6.35	.250	0.79	.031	3°	60	N151.2-A250-60-6G		☆		☆		★			★		☆					★		
		9.52	.375	0.79	.031	3°	80	N151.2-A375-80-6G		☆		☆		★			★		☆					★		
Medium feed	 151.2-5G	2.00	.079	0.20	.008	4°	20	N151.2-200-20-5G	☆		☆	☆	☆	★	☆	★		☆	☆	☆	☆	☆	★	☆	☆	★
		2.39	.094	0.18	.007	7°		N151.2-A094-20-5G				☆		★					★						★		
		3.00	.118	0.30	.012	4°	30	N151.2-300-30-5G	☆		☆	☆	☆	★	☆	★		☆	☆	☆	☆	☆	★	☆	☆	★
		3.17	.125	0.25	.01	5°		N151.2-A125-30-5G	☆			☆		★	☆	★			☆	☆	☆	☆		★	☆	★
		4.00	.157	0.30	.012	4°	40	N151.2-400-40-5G	☆		☆	☆	☆	★	☆	★		☆	☆	☆	☆	☆	★	☆	☆	★
		4.75	.187	0.25	.01	7°		N151.2-A187-40-5G	☆			☆		★	☆	★			☆	☆	☆	☆		★	☆	★
		5.00	.197	0.40	.016	5.75°	50	N151.2-500-50-5G	☆		☆	☆	☆	★	☆	★		☆	☆	☆	☆	☆	★	☆	☆	★
		6.00	.236	0.40	.016	6°	60	N151.2-600-60-5G	☆		☆	☆		★	☆	★		☆	☆	☆	☆	☆		★	☆	★
		6.35	.250	0.25	.01	6°		N151.2-A250-60-5G				☆		★	☆				★	☆	☆			★	☆	★
		7.93	.312	0.33	.013	4°	80	N151.2-A312-80-5G				☆		★					★					★		
		8.00	.315	0.50	.02	7°		N151.2-800-80-5G	☆		☆	☆		★		★		☆	☆		☆	☆		★	☆	★
		For circlip grooves																								
		1.85	.073	0.10	.004	4°	20	N151.2-185-20-5G				☆		★					★		☆			★	☆	★
		2.15	.085	0.15	.006	5.5°		N151.2-215-20-5G				☆		★	☆				★	☆				★		
		2.65	.104	0.15	.006	5°	25	N151.2-265-25-5G				☆		★	☆				★	☆	☆			★	☆	★
		3.15	.124	0.15	.006	5°	30	N151.2-315-30-5G				☆		★	☆				★	☆	☆			★	☆	★
		4.15	.163	0.15	.006	5°	40	N151.2-415-40-5G				☆		★	☆				★	☆	☆			★	☆	★
		5.15	.203	0.15	.006	4°	50	N151.2-515-50-5G				☆		★					★					★		
									P30	P45	P35	P45	P15	P20	P10	M25	M40	M30	M35	M10	M15	K30	K15	K25	K20	N20	

[1] To correspond with seat size on holder.

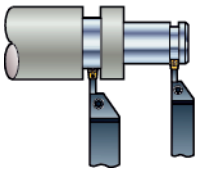
N = Neutral
★= First choice

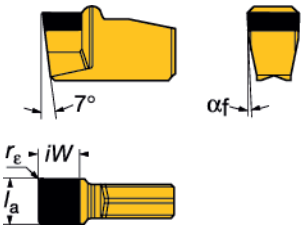
For geometry description, see page B124.

B9 B10 B124 B130 B146 B2 J3 I8

T-Max Q-Cut®

Grooving of hardened materials





For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
E-G
l_a = ±0.02 (±.0008)
r_ε = ±0.05 (±.002)

		Selection criteria, mm, inch								H
		l_a mm	l_a in.	r_ε mm	r_ε in.	α_f	iW	Seat size[1]	Ordering code	CB CB20
Low feed	 151.2-EG	3.00	.118	0.20	.008	3°	3	25	N151.2-300-25E-G	★
		3.17	.125	0.18	.007	3°	3		N151.2-A125-25E-G	★
		4.00	.157	0.20	.008	3°	3	30	N151.2-400-30E-G	★
		4.70	.185	0.56	.022	3°	3	40	N151.2-A185-40E-G	★
		5.00	.197	0.20	.008	3°	3		N151.2-500-40E-G	★
		6.00	.236	0.20	.008	3°	3	50	N151.2-600-50E-G	★
		6.35	.250	0.56	.022	3°	3	60	N151.2-A250-60E-G	★
		7.93	.312	0.84	.033	3°	3		N151.2-A312-60E-G	★
										H01

[1] To correspond with seat size on holder.

N = Neutral
★= First choice

For geometry description, see page B124.

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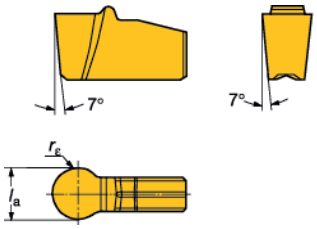
T-Max Q-Cut®

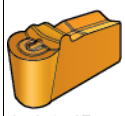
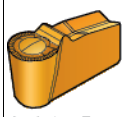
Profiling



-4P, -5P

For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
4P
l_a = ±0.02 (±.0008)
5P
l_a = ±0.05 (±.002)

		Selection criteria, inch, mm						P				M					K			N	S			
								GC	GC	GC	CT	GC	GC	GC	CT	-	GC	GC	-	-	GC	GC	-
		l_a mm	l_a in.	r_ε mm	r_ε in.	Seat size	Ordering code	1125	235	4225	525	1005	1125	235	525	H13A	1125	4225	H13A	H13A	1005	235	H13A
Low feed	 151.2-4P	3.00	.118	1.50	.059	30	N151.2-300-30-4P	★	☆		☆	☆	★	☆	☆	☆			★	★	★		☆
		3.17	.125	1.59	.062		N151.2-A125-30-4P	★	☆		☆	☆	★	☆	☆	☆			★	★	★		☆
		3.96	.156	1.98	.078	40	N151.2-A156-40-4P	★	☆		☆	☆	★	☆	☆	☆			★	★	★		☆
		4.00	.157	2.00	.079		N151.2-400-40-4P	★	☆		☆	☆	★	☆	☆	☆			★	★	★		☆
		4.50	.177	2.25	.089		N151.2-450-40-4P		★		☆			★	☆	☆			★	★			☆
		4.75	.187	2.38	.094		N151.2-A187-40-4P		★					★		☆			★	★			★
		5.00	.197	2.50	.098		N151.2-500-40-4P	★	☆		☆	☆	★	☆	☆	☆			★	★	★		☆
		5.56	.219	2.78	.110	50	N151.2-A219-50-4P		★			☆		★		☆			★	★			☆
		6.00	.236	3.00	.118		N151.2-600-50-4P	★	☆		☆	☆	★	☆	☆	☆			★	★	★		☆
		6.35	.250	3.17	.125		N151.2-A250-50-4P	★	☆		☆		★	☆	☆	☆			★	★		☆	★
		7.14	.281	3.57	.140	60	N151.2-A281-60-4P		★			☆		★		☆			★	★	★		☆
		7.93	.312	3.96	.156		N151.2-A312-60-4P		★					★									
		8.00	.315	4.00	.157		N151.2-800-60-4P	★	☆		☆	☆	★	☆	☆	☆			★	★	★		☆
		9.52	.375	4.76	.188	80	N151.2-A375-80-4P		★			☆		★							★		
		10.00	.394	5.00	.197		N151.2-1000-80-4P		★					★		☆			★	★			★
Medium feed	 151.2-5P	3.00	.118	1.50	.059	30	N151.2-300-30-5P	☆	☆	★	☆		★	☆	☆		☆	★					
		3.17	.125	1.59	.062		N151.2-A125-30-5P		☆	★	☆			★	☆			★					
		4.00	.157	2.00	.079	40	N151.2-400-40-5P	☆	☆	★	☆		★	☆	☆		☆	★					
		4.75	.187	2.37	.094		N151.2-A187-40-5P		☆	★				★				★					
		5.00	.197	2.50	.098		N151.2-500-40-5P	☆	☆	★	☆		★	☆	☆		☆	★					
		6.00	.236	3.00	.118	50	N151.2-600-50-5P	☆	☆	★			★	☆			☆	★					
		6.35	.250	3.17	.125		N151.2-A250-50-5P		☆	★				★				★					
		8.00	.315	4.00	.157	60	N151.2-800-60-5P	☆	☆	★			★	☆			☆	★					
								P30	P45	P20	P10	M10	M25	M35	M10	M15	K30	K25	K20	N20	S15	S30	S15

1) To correspond with seat size on holder.

N = Neutral
★= First choice

For geometry description, see page B124.

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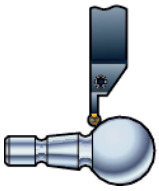
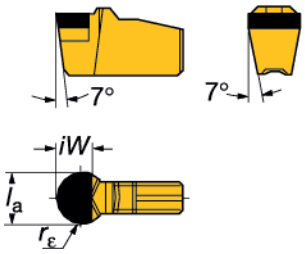
T-Max Q-Cut®

Profiling non-ferrous and hardened materials

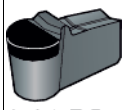
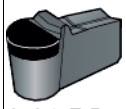




F-P, E-P

For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
F-P
l_a = ±0.02 (±.0008)
E-P
l_a = ±0.02 (±.0008)

		Selection criteria, inch, mm							N	H
		l_a mm	l_a in.	r_ε mm	r_ε in.	*iW*	Seat size	**Ordering code**	CD10	CB20
Low feed	 151.2-E-P	3.00	.118	1.50	.059	2.50	30	**N151.2-300-30E-P**		★
		3.17	.125	1.59	.062	2.60		**N151.2-A125-30E-P**		★
		4.00	.157	2.00	.079	3.00	40	**N151.2-400-40E-P**		★
		4.75	.187	2.37	.094	3.40		**N151.2-A187-40E-P**		★
		5.00	.197	2.50	.098	3.50		**N151.2-500-40E-P**		★
		6.00	.236	3.00	.118	4.00	50	**N151.2-600-50E-P**		★
		6.35	.250	3.17	.125	4.20		**N151.2-A250-50E-P**		★
		7.93	.312	3.96	.156	5.00	60	**N151.2-A312-60E-P**		★
	 151.2-F-P	3.17	.125	1.59	.062	2.60	30	**N151.2-A125-30F-P**	★	
		4.00	.157	2.00	.079	3.00	40	**N151.2-400-40F-P**	★	
		6.00	.236	3.00	.118	4.00	50	**N151.2-600-50F-P**	★	
		6.35	.250	3.17	.125	4.20		**N151.2-A250-50F-P**	★	
		7.93	.312	3.96	.156	5.00	60	**N151.2-A312-60F-P**	★	
		8.00	.315	4.00	.157	5.00		**N151.2-800-60F-P**	★	
									N01	H01

1) To correspond with seat size on holder.

N = Neutral
★= First choice

For geometry description, see page B124.

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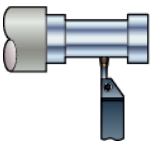
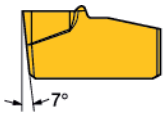
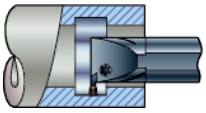
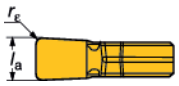
T-Max Q-Cut®

Turning and recessing



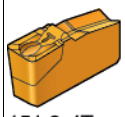






For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = +0.10/0 (+.004/0)
r_ε = ±0.10 (±.004)

		Selection criteria, inch, mm						P				M		K		
		l_a mm	l_a in.	r_ε mm	r_ε in.	Seat size[1]	Ordering code	GC 1125	GC 3020	GC 4225	CT 525	GC 1125	CT 525	GC 1125	GC 3020	GC 4225
Low feed	 151.2-5T	3.00	.118	0.40	.016	30	N151.2-3004-30-5T	☆	☆	★		★		☆	★	☆
		4.00	.157	0.40	.016	40	N151.2-4004-40-5T	☆	☆	★		★		☆	★	☆
		4.00	.157	0.80	.032		N151.2-4008-40-5T	☆	☆	★	☆	★	☆	☆	★	☆
		5.00	.197	0.40	.016	50	N151.2-5004-50-5T	☆	☆	★		★		☆	★	☆
		6.00	.236	0.80	.032	60	N151.2-6008-60-5T	☆		★	☆	★	☆	☆		★
Medium feed	 151.2-4T	3.00	.118	0.40	.016	30	N151.2-3004-30-4T			★						★
		4.00	.157	0.40	.016	40	N151.2-4004-40-4T			★						★
		4.00	.157	0.80	.032		N151.2-4008-40-4T			★	☆		☆			★
		5.00	.197	0.40	.016	50	N151.2-5004-50-4T			★						★
		6.00	.236	0.80	.032	60	N151.2-6008-60-4T			★						★
								P30	P15	P20	P10	M25	M10	K30	K15	K25

[1] To correspond with seat size on holder.

N = Neutral
★= First choice

For geometry description, see page B124.

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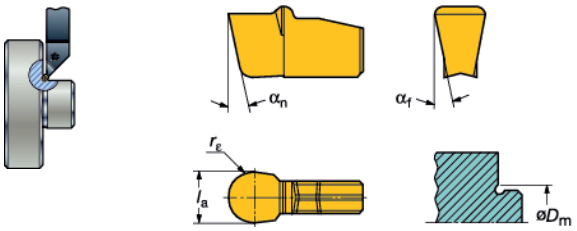
T-Max Q-Cut®

Undercutting



For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = ±0.02 (±.0008)

		Selection criteria, millimeter, inch (mm, in.)										P		M			K	N	S	
		l_a mm	l_a in.	r_ε mm	r_ε in.	D_m min, mm	D_m max in.	α_f	α_n	Seat size[1]	Ordering code	GC 235	CT 525	GC 235	CT 525	- H13A	- H13A	- H13A	GC 235	- H13A
Medium feed	 151.2-4U	2.00	.079	1.00	.039	30.00	1.181	5°	7°	20	N151.2-200-20-4U	★	☆	★	☆	☆	★	★	☆	★
		3.00	.118	1.50	.059	28.00	1.102	7°	7°	25	N151.2-300-25-4U	★		★		☆	★	★	☆	★
		4.00	.157	2.00	.079	23.00	.906	11°	7°	30	N151.2-400-30-4U	★	☆	★	☆	☆	★	★	☆	★
		5.00	.197	2.50	.098	27.00	1.063	11°	7°	40	N151.2-500-40-4U	★		★		☆	★	★	☆	★
		6.00	.236	3.00	.118	27.00	1.063	11°	7°	50	N151.2-600-50-4U	★		★		☆	★	★	☆	★
		8.00	.315	4.00	.157	30.00	1.181	11°	7°	60	N151.2-800-60-4U	★		★		☆	★	★	☆	★
												P45	P10	M35	M10	M15	K20	N20	S30	S15

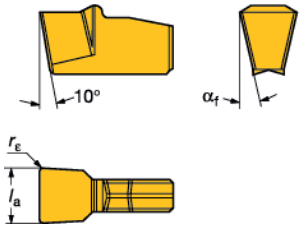
1) To correspond with seat size on holder.

N = Neutral

For geometry description, see page B124.

★= First choice

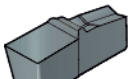
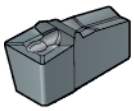
Blanks



For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
-3B l_a = ±0.05 (.002)
-4B l_a = ±0.04 (.002)

For grinding instructions, see Metalcutting Technical guide.

	Selection criteria, millimeter, inch (mm, in.)									M	K	N	S
	l_a mm	l_a in.	r_ε mm	r_ε in.	Width range min	Width range max	α_f	Seat size[1]	Ordering code	- H13A	- H13A	- H13A	- H13A
 151.2-3B	2.40	.094	0.10	.004	1.90	2.3	11°	20	N151.2-240-20-3B	☆	☆	☆	☆
	3.40	.134	0.10	.004	2.30	3.3	11°	25	N151.2-340-25-3B	☆	☆	☆	☆
	4.40	.173	0.20	.008	3.00	4.3	12°	30	N151.2-440-30-3B	☆	☆	☆	☆
	5.40	.213	0.20	.008	4.00	5.3	5°	40	N151.2-540-40-3B	☆	☆	☆	☆
	6.50	.256	0.20	.008	5.00	6.4	5°	50	N151.2-650-50-3B	☆	☆	☆	☆
	8.50	.335	0.30	.012	6.00	8.4	6°	60	N151.2-850-60-3B	☆	☆	☆	☆
 151.2-4B	2.60	.102	0.10	.004	1.90	2.3	11°	20	N151.2-260-20-4B	☆	☆	☆	☆
	3.65	.144	0.10	.004	2.30	3.3	11°	25	N151.2-365-25-4B	☆	☆	☆	☆
	4.65	.183	0.20	.008	3.00	4.3	12°	30	N151.2-465-30-4B	☆	☆	☆	☆
	5.60	.220	0.20	.008	4.00	5.3	5°	40	N151.2-560-40-4B	☆	☆	☆	☆
	6.75	.266	0.20	.008	5.00	6.4	5°	50	N151.2-675-50-4B	☆	☆	☆	☆
	8.80	.346	0.30	.012	6.00	8.4	6°	60	N151.2-880-60-4B	☆	☆	☆	☆
	11.45	.451	0.30	.012	8.00	11.2	10°	80	N151.2-1145-80-4B	☆	☆	☆	☆
										M15	K20	N20	S15

1) To correspond with seat size on holder.

N = Neutral

For geometry description, see page B124.

Note: Precaution should be taken when grinding cemented carbide products. See page J7 for safety information.

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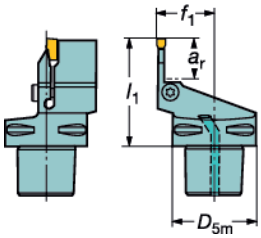
T-Max Q-Cut®

Coromant Capto® cutting units

Screw clamp

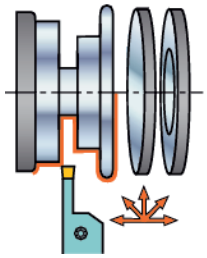
151.2

Cx-R/LF151.23



Coolant inlet: Radial through the taper

Right hand style shown

Main application	a_r max mm[1]	a_r max inch[1]	Seat size[1]	Ordering code	Dimensions, millimeter, inch (mm, in.) D_{5m} mm	D_{5m} in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[3]
	15.00	.591	20	**C3-RF151.23-22050-20**	32	1.260	22	.866	50	1.968	N151.2-200- 5E	2.5
	15.00	.591		**C4-R/LF151.23-27055-20**	40	1.575	27	1.063	55	2.165	N151.2-200- 5E	2.5
	15.00	.591		**C5-RF151.23-35060-20**	50	1.968	35	1.378	60	2.362	N151.2-200- 5E	2.5
	20.00	.787	25	**C4-R/LF151.23-27060-25**	40	1.575	27	1.063	60	2.362	N151.2-250- 5E	3.0
	20.00	.787	30	**C3-R/LF151.23-22055-30**	32	1.260	22	.866	55	2.165	N151.2-300- 5E	3.5
	20.00	.787		**C4-R/LF151.23-27060-30**	40	1.575	27	1.063	60	2.362	N151.2-300- 5E	3.5
	20.00	.787		**C5-R/LF151.23-35060-30**	50	1.968	35	1.378	60	2.362	N151.2-300- 5E	3.5
	20.00	.787		**C6-R/LF151.23-45065-30**	63	2.480	45	1.772	65	2.559	N151.2-300- 5E	3.5
	25.00	.984	40	**C4-R/LF151.23-27067-40**	40	1.575	27	1.063	67	2.638	N151.2-400- 5E	5.0
	25.00	.984		**C5-R/LF151.23-35067-40**	50	1.968	35	1.378	67	2.638	N151.2-400- 5E	5.0
	25.00	.984		**C6-R/LF151.23-45067-40**	63	2.480	45	1.772	67	2.638	N151.2-400- 5E	5.0
	32.00	1.260	50	**C5-R/LF151.23-35075-50**	50	1.968	35	1.378	75	2.953	N151.2-500- 5E	5.0
	32.00	1.260		**C6-R/LF151.23-45075-50**	63	2.480	45	1.772	75	2.953	N151.2-500- 5E	5.0
	32.00	1.260	60	**C5-R/LF151.23-35076-60**	50	1.968	35	1.378	76	2.953	N151.2-600- 5E	5.0
	32.00	1.260		**C6-R/LF151.23-45080-60**	63	2.480	45	1.772	80	3.150	N151.2-600- 5E	5.0

[1] a_r max. for holder. For max stability choose a holder with shortest possible a_r.

R = Right hand, L = Left hand

[2] To correspond with seat size on insert.

[3] Insert tightening torque, Nm. Use torque wrench, see page B110.

Main spare parts

Seat size	Screw	Key (Torx Plus)
20-30	3212 012-259	5680 043-14 (20IP)
40-80	3212 012-360	5680 043-17 (30IP)

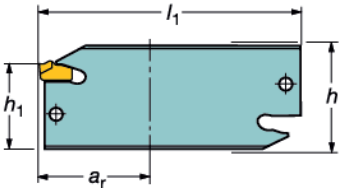
 B6
 B70
 B118
 G6
 B2
 J3
 J2

T-Max Q-Cut®

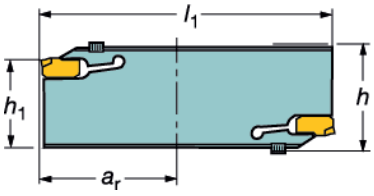
Double ended parting blade

151.2

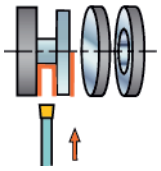
Spring clamp
Seat size 20–60



Screw clamp
Seat size 80



Neutral style

Main application	a_r max mm[1]	a_r max inch[1]	Seat size[2]	Ordering code	Dimensions, millimeter, inch (mm, in.) h mm	h in.	h_1 mm	h_1 in.	l_1 mm	l_1 in.	Gauge inserts	Nm[3]
	35	1.378	20	**151.2-21-20**	25.9	1.020	21.4	.842	110	4.331	N151.2-200- 5E	
	35	1.378	25	**151.2-21-25**	25.9	1.020	21.4	.842	110	4.331	N151.2-250- 5E	
	60	2.362		**151.2-25-25**	31.9	1.256	25	.984	150	5.906	N151.2-250- 5E	
	35	1.378	30	**151.2-21-30**	25.9	1.020	21.4	.842	110	4.331	N151.2-300- 5E	
	60	2.362		**151.2-25-30**	31.9	1.256	25	.984	150	5.906	N151.2-300- 5E	
	35	1.378	40	**151.2-21-40**	25.9	1.020	21.4	.842	110	4.331	N151.2-400- 5E	
	60	2.362		**151.2-25-40**	31.9	1.256	25	.984	150	5.906	N151.2-400- 5E	
	60	2.362	50	**151.2-25-50**	31.9	1.256	25	.984	150	5.906	N151.2-500- 5E	
	60	2.362	60	**151.2-25-60**	31.9	1.256	25	.984	150	5.906	N151.2-600- 5E	
	100	3.937	80	**151.2-45-80**	52.5	2.067	45	1.772	250	9.842	N151.2-800- 4E	3.5

[1] a_r max. for holder. For max stability choose a holder with shortest possible a_r.

R = Right hand, L = Left hand

[2] To correspond with seat size on insert.

[3] Insert tightening torque, Nm. Use torque wrench, see page B110.

Main spare parts

Seat size	Screw	Key (Torx Plus)
20-30	–	5680 057-021[4]
40-60	–	5680 057-011[4]
80	3212 012-259	5680 043-14 (20IP)

[4] Optional part to be ordered separately

 B6
 B32
 B117
 B2
 J2

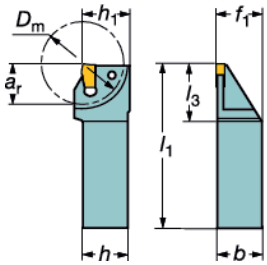
T-Max Q-Cut®

Shank tools for parting

Spring clamp

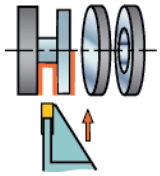
151.2

R/L151.20 Reinforced

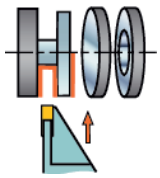


Right hand style shown

Metric version

Main application	D_m max	a_r max[1]	Seat size[2]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts
	13	6	20	**R/L151.20-0808-20**	8	8.25	8	12	120	11	N151.2-200- 5E
	20.6	10		**R/L151.20-1010-20**	10	10.25	10	12	120	13	N151.2-200- 5E
	30	15		**R/L151.20-1212-20**	12	12.25	12	12	150	20.5	N151.2-200- 5E
	30	15		**R/L151.20-1612-20**	12	12.25	16	16	150	20.5	N151.2-200- 5E
	30	15		**R/L151.20-1616-20**	16	16.25	16	16	150	20.5	N151.2-200- 5E
	30	15	25	**R/L151.20-1212-25**	12	12.25	12	12	150	20.5	N151.2-250- 5E
	30	15		**R151.20-1612-25**	12	12.25	16	12	150	20.5	N151.2-250- 5E
	30	15		**R/L151.20-1616-25**	16	16.25	16	16	150	20.5	N151.2-250- 5E
	35	17		**R/L151.20-2012-25**	12	12.25	20	20	125	26	N151.2-250- 5E
	35	17		**R/L151.20-2016-25**	16	16.25	20	20	125	26	N151.2-250- 5E
	35	17		**R/L151.20-2020-25**	20	20.25	20	20	125	26	N151.2-250- 5E
	35	17		**R/L151.20-2525-25**	25	25.3	25	25	150	31.8	N151.2-250- 5E
	35	17	30	**R/L151.20-1612-30**	12	12.3	16	16	100	26	N151.2-300- 5E
	35	17		**R/L151.20-2012-30**	12	12.3	20	20	125	26	N151.2-300- 5E
	35	17		**R/L151.20-1616-30**	16	16.3	16	16	100	26	N151.2-300- 5E
	35	17		**R/L151.20-2016-30**	16	16.3	20	20	125	26	N151.2-300- 5E
	35	17		**R/L151.20-2020-30**	20	20.3	20	20	125	26	N151.2-300- 5E
	45	22		**R/L151.20-2020-30A**	20	20.3	20	20	125	31.8	N151.2-300- 5E
	45	22		**R/L151.20-2525-30A**	25	25.3	25	25	150	31.8	N151.2-300- 5E
	45	22	40	**R/L151.20-2020-40**	20	20.3	20	20	125	31.8	N151.2-400- 5E
	45	22		**R/L151.20-2525-40**	25	25.3	25	25	150	31.8	N151.2-400- 5E

Inch version

Main application	D_m max	a_r max[1]	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts
	.760	.380	20	**R151.20-06-20**	.375	.385	.375	.375	4.720	.630	N151.2-200- 5E
	1.180	.591		**R/L151.20-08-20**	.500	.510	.500	.500	5.910		N151.2-200- 5E
	1.180	.591		**R/L151.20-10-20**	.625	.634	.625	.625	5.910	.810	N151.2-200- 5E
	1.180	.591	25	**R/L151.20-08-25**	.500	.510	.500	.500	5.910	.810	N151.2-250- 5E
	1.180	.591		**R/L151.20-10-25**	.625	.634	.625	.625	5.910	.810	N151.2-250- 5E
	1.380	.689		**R/L151.20-12-25**	.750	.760	.750	.750	4.500	1.050	N151.2-250- 5E
	1.380	.689	30	**R/L151.20-10-30**	.625	.638	.625	.625	4.000	1.020	N151.2-300- 5E
	1.380	.689		**R/L151.20-12-30**	.750	.764	.750	.750	4.500	1.020	N151.2-300- 5E
	1.770	.886		**R/L151.20-12-30A**	.750	.764	.750	.750	4.500	1.240	N151.2-300- 5E
	1.770	.886	40	**R/L151.20-12-40**	.750	.764	.750	.750	4.500	1.250	N151.2-400- 5E

[1] For max stability choose a holder with reinforced design

[2] To correspond with seat size on insert.

R = Right hand, L = Left hand

Main spare parts

Seat size	Insert key[1]
20-30	5680 057-021
40-60	5680 057-011

[1] To be ordered separately.

 B6

 B117

 G6

 B2

 J3

 J2

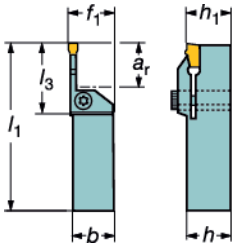
T-Max Q-Cut®

Shank tools

Screw clamp

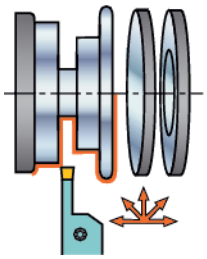
151.2

Deep a_r
R/L151.23

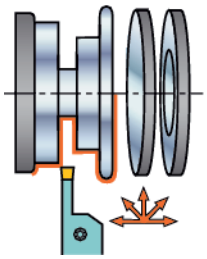


Right hand style shown

Metric version

Main application	a_r max[1]	Seat size[2]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	15	20	**R/LF151.23-1616-20M1**	16	17	16	16	100	33.5	N151.2-200- 5E	4.0
	15		**R/LF151.23-2020-20M1**	20	21	20	20	125	39	N151.2-200- 5E	4.0
	15		**R/LF151.23-2525-20M1**	25	26	25	25	150	39	N151.2-200- 5E	4.0
	20	25	**R/LF151.23-1616-25M1**	16	17	16	16	100	40	N151.2-250- 5E	4.0
	20		**R/LF151.23-2020-25M1**	20	21	20	20	125	40	N151.2-250- 5E	4.0
	20		**R/LF151.23-2525-25M1**	25	26	25	25	150	40	N151.2-250- 5E	4.0
	20	30	**R/LF151.23-1616-30M1**	16	17	16	16	100	41	N151.2-300- 5E	5.0
	20		**R/LF151.23-2020-30M1**	20	21	20	20	125	41	N151.2-300- 5E	5.0
	20		**R/LF151.23-2525-30M1**	25	26	25	25	150	41	N151.2-300- 5E	5.0
	20		**R/LF151.23-3225-30M1**	25	26	32	32	170	41	N151.2-300- 5E	5.0
	25	40	**R/LF151.23-2020-40M1**	20	21	20	20	125	47	N151.2-400- 5E	7.5
	25		**R/LF151.23-2525-40M1**	25	26	25	25	150	47	N151.2-400- 5E	7.5
	25		**R/LF151.23-3225-40M1**	25	26	32	32	170	47	N151.2-400- 5E	7.5
	32	50	**R/LF151.23-2525-50M1**	25	26	25	25	150	57	N151.2-500- 5E	7.5
	32		**R/LF151.23-3225-50M1**	25	26	32	32	170	57	N151.2-500- 5E	7.5
	32	60	**R/LF151.23-2525-60M1**	25	26	25	25	150	58	N151.2-600- 5E	7.5
	32		**R/LF151.23-3225-60M1**	25	26	32	32	170	57	N151.2-600- 5E	7.5

Inch version

Main application	a_r max[1]	Seat size[2]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[4]
	.590	20	**RF151.23-08-20**	.500	.750	.500	.500	4.500	1.319	N151.2-200- 5E	2.4
	.590		**R/LF151.23-10-20**	.625	.875	.625	.625	4.500	1.319	N151.2-200- 5E	2.4
	.790	25	**R/LF151.23-08-25**	.500	.750	.500	.500	4.500	1.575	N151.2-250- 5E	2.4
	.790		**R/LF151.23-10-25**	.625	.875	.625	.625	4.500	1.575	N151.2-250- 5E	2.4
	.790		**R/LF151.23-12-25**	.750	1.000	.750	.750	5.000	1.575	N151.2-250- 5E	2.4
	.790	30	**R/LF151.23-12-30**	.750	1.000	.750	.750	5.000	1.614	N151.2-300- 5E	3.2
	.790		**R/LF151.23-16-30**	1.000	1.250	1.000	1.000	6.000	1.614	N151.2-300- 5E	3.2
	.790		**R/LF151.23-20-30**	1.250	1.500	1.250	1.250	6.000	1.614	N151.2-300- 5E	3.2
	.980	40	**R/LF151.23-12-40**	.750	1.000	.750	.750	5.000	1.850	N151.2-400- 5E	5.0
	.980		**R/LF151.23-16-40**	1.000	1.250	1.000	1.000	6.000	1.850	N151.2-400- 5E	4.6
	.980		**R/LF151.23-20-40**	1.250	1.500	1.250	1.250	6.000	1.850	N151.2-400- 5E	4.6
	1.260	50	**R/LF151.23-16-50**	1.000	1.250	1.000	1.000	6.000	2.244	N151.2-500- 5E	4.6
	1.260		**R/LF151.23-20-50**	1.250	1.500	1.250	1.250	6.000	2.244	N151.2-500- 5E	4.6
	1.260	60	**R/LF151.23-16-60**	1.000	1.250	1.000	1.000	6.000	2.283	N151.2-600- 5E	4.6
	1.260		**R/LF151.23-20-60**	1.250	1.500	1.250	1.250	6.000	2.283	N151.2-600- 5E	4.6

1) a_r max. for holder. For max stability choose a holder with shortest possible a_r.
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.
4) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

Main spare parts

Seat size	Shank dim., mm	Screw	Key (Torx Plus)
20-25		3212 012-259	5680 043-14 (20IP)
30		3212 012-310	5680 043-15 (25IP)
30	1616	3212 012-309	5680 043-15 (25IP
40-60		3212 012-360	5680 043-17 (30IP)

 B6
 B118
 G6
 B2
 B53

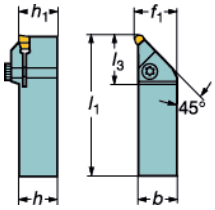
T-Max Q-Cut®

Shank tools for undercutting

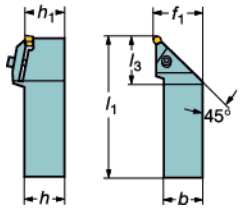
Screw clamp

151.2

R/LS151.22
Metric

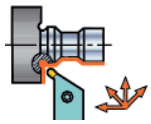


R/LS151.22
Inch

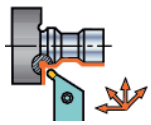


Right hand style shown

Metric version

Main application	Seat size[1]	Ordering code	Dimensions b	f1	h	h1	l1	l3	Gauge inserts	Nm[2]
	20	**R/LS151.22-2525-20**	25	25.3	25	25	150	24	N151.2-200-20- 4U	2.5
	25	**R/LS151.22-2525-25**	25	25.6	25	25	150	27	N151.2-300-25- 4U	3.0
	30	**R/LS151.22-2020-30**	20	20.8	20	20	125	28	N151.2-400-30- 4U	3.5
		R/LS151.22-2525-30	25	25.8	25	25	150	28	N151.2-400-30- 4U	3.5
	40	**R/LS151.22-2020-40**	20	21.1	20	20	125	31	N151.2-500-40- 4U	4.5
		R/LS151.22-2525-40	25	26.1	25	25	150	31	N151.2-500-40- 4U	4.5
	50	**R/LS151.22-2525-50**	25	26.1	25	25	150	32	N151.2-600-50- 4U	5.0
		R/LS151.22-3225-50	25	26.1	32	32	170	32	N151.2-600-50- 4U	5.0
	60	**R/LS151.22-2525-60**	25	26.4	25	25	150	37	N151.2-800-60- 4U	5.0
		R/LS151.22-3225-60	25	26.4	32	32	170	37	N151.2-800-60- 4U	5.0

Inch version

Main application	Seat size[1]	Ordering code	Dimensions, inch b	f1	h	h1	l1	l3	Gauge inserts	ft-lbs[3]
	20	**R/LS151.22-12-20**	.750	1.000	.750	.750	4.500	1.190	N151.2-200-20- 4U	1.4
	25	**R/LS151.22-16-25**	1.000	1.250	1.000	1.000	5.000	1.320	N151.2-300-25- 4U	1.6
	30	**RS151.22-12-30**	.750	1.000	.750	.750	4.500	1.360	N151.2-400-30- 4U	1.9
		R/LS151.22-16-30	1.000	1.250	1.000	1.000	5.000	1.360	N151.2-400-30- 4U	1.9
		LS151.22-20-30	1.250	1.500	1.250	1.250	6.000	1.360	N151.2-400-30- 4U	1.9
	40	**R/LS151.22-16-40**	1.000	1.250	1.000	1.000	5.000	1.430	N151.2-500-40- 4U	2.4
	50	**R/LS151.22-20-50**	1.250	1.500	1.250	1.250	6.000	1.490	N151.2-600-50- 4U	2.7

R = Right hand, L = Left hand

1) To correspond with seat size on insert.
2) Insert tightening torque, Nm. Use torque wrench, see page B110.
3) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

Main spare parts

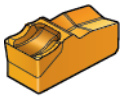
Seat size	Screw	Key (Torx Plus)
20-30	3212 012-259	5680 043-14 (20IP)
40-60	3212 012-360	5680 043-17 (30IP)

 B6
 G6
 G6
 B2
 B53

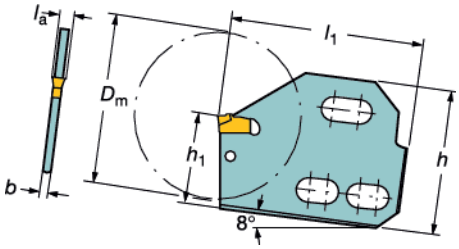
T-Max Q-Cut®

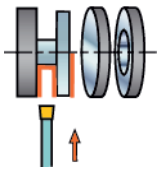
Blades for Manchester holders, for parting

Spring clamp



151.2-4E



Main application	D_m	Seat size[1]	Ordering code	Dimensions, mm, inch l_a	b	h	h_1	l_1	Gauge inserts	Manchester holder designation
	3.00	30	**151.2-40-30-8**	3.00	2.87	57.2	40.1	77.7	N151.2-300-4E	T-942, T-1305, T-1400, T-1401, 205-164, 205-171, 205-172, 205-174, 205-176, 205-182, 205-183, 205-185, 205-186, 205-194
				.118	*.090*	*2.250*	*1.580*	*3.060*		
		40	**151.2-40-40-8**	4.00	3.30	57.2	40.1	77.7	N151.2-400-4E	
				.157	*.130*	*2.250*	*1.580*	*3.060*		
		50	**151.2-40-50-8**	5.00	4.32	57.2	40.1	77.7	N151.2-500-4E	
				.197	*.170*	*2.250*	*1.580*	*3.060*		
	2.00	20	**151.2-27-20-8**	2.00	1.52	44.5	26.9	59.4	N151.2-200-5E	T-940, T-1303, T-1410, T-1411, 205-179, 205-280, 205-288, 206-108, 206-113, 206-114, 206-118, 206-123
				.079	*.060*	*1.750*	*1.060*	*2.340*		
		25	**151.2-27-25-8**	2.49	2.03	44.5	26.9	59.4	N151.2-250-4E	
				.098	*.080*	*1.750*	*1.060*	*2.340*		
		30	**151.2-27-30-8**	3.00	2.29	44.5	26.9	59.4	N151.2-300-4E	
				.118	*.090*	*1.750*	*1.060*	*2.340*		
		40	**151.2-27-40-8**	4.00	3.30	44.5	26.9	59.4	N151.2-400-4E	
				.157	*.130*	*1.750*	*1.060*	*2.340*		
		50	**151.2-27-50-8**	5.00	4.32	44.5	26.9	59.4	N151.2-500-4E	
				.197	*.170*	*1.750*	*1.060*	*2.340*		
	5.00	50	**151.2-56-50-8**	5.00	4.32	79.5	56.1	112.5	N151.2-500-4E	T-946, T-1430, T-1431, 205-167, 205-169, 205-170, 205-173, 205-177, 205-178, 205-192
				.197	*.170*	*3.130*	*2.210*	*4.430*		
		60	**151.2-56-60-8**	6.00	5.33	79.5	56.1	112.5	N151.2-600-4E	
				.236	*.210*	*3.130*	*2.210*	*4.430*		
	1.50	30	**R151.2-16-30-8**	3.00	2.29	28.2	1.52	29.7	N151.2-300-4E	206-141, 206-143, 206-142, 206-144
				.118	*.090*	*1.110*	*.660*	*1.770*		
	3.00	30	**151.2-36-30-8**	3.00	2.29	48.3	36.6	77.7	N151.2-300-4E	206-122, 206-110, 206-119, 206-120, 206-124, 206-115, 206-116, 206-121, 206-127
				.118	*.090*	*1.900*	*1.440*	*3.060*		

[1] To correspond with seat size on insert.

Main spare parts

Seat size	Insert key[1]
20-30	5680 057-021
40-60	5680 057-011

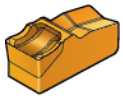
[1] Optional part to be ordered separately

 B117  B2  J2

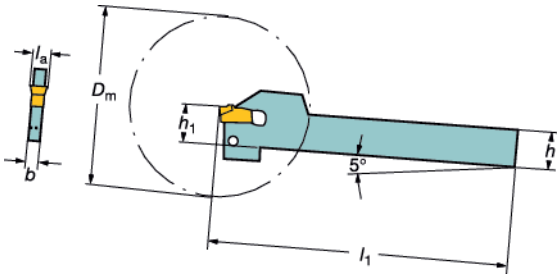
T-Max Q-Cut®

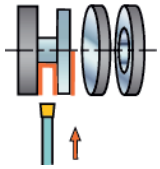
Blades for HSS holders, for parting

Spring clamp



151.2-4E



Main application	D_m	Seat size[1]	Ordering code	Dimensions, mm, inch l_a	b	h	h_1	l_1	Gauge inserts	HSS blade designation	
	2.00	20	**151.2-12-20-5**	2.00	1.52	12.7	12.7	114	N151.2-200-5E	P2N, P2, P35, T35	
				.079	*.060*	*.500*	*.500*	*4.500*			
	2.00	25	**151.2-12-25-5**	2.49	2.03	12.7	12.7	114	N151.2-250-4E		
				.098	*.080*	*.500*	*.500*	*4.500*			
	2.37	25	**151.2-17-25-5**	2.49	2.03	17.5	17.5	127	N151.2-250-4E	P3N, P3, P4, P5S, T3, T4, T5S	
				.098	*.080*	*.690*	*.690*	*5.000*			
	2.37	30	**151.2-17-30-5**	3.00	2.29	17.5	17.5	127	N151.2-300-4E		
				.118	*.090*	*.690*	*.690*	*5.000*			
	3.00	30	**151.2-22-30-5**	3.00	2.29	22.4	22.4	150	N151.2-300-4E	P5X, P5N, P5, P6, T5, T6	
				.118	*.090*	*.880*	*.880*	*5.900*			
	4.00	30	**151.2-28-30-5**	3.00	2.29	28.7	28.7	150	N151.2-300-4E	P8X, P8N, P8, P9, P10, T8, T9, T10	
				.118	*.090*	*1.130*	*1.130*	*5.900*			
	4.00	40	**151.2-28-40-5**	4.00	3.30	28.7	28.7	150	N151.2-400-4E		
				.157	*.130*	*1.130*	*1.130*	*5.900*			
	4.50	60	**151.2-28-60-5**	6.00	5.33	28.7	28.7	179	N151.2-600-4E	P8X, P8N, P8, P9, P10, T8, T9, T10	
				.236	*.210*	*1.130*	*1.130*	*7.000*			

[1] To correspond with seat size on insert.

Optional spare parts

Seat size	Insert key[1]
20-30	5680 057-021
40-60	5680 057-011

[1] Optional part to be ordered separately

 B117

 B2

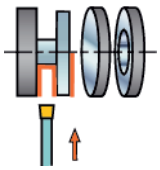
 B6

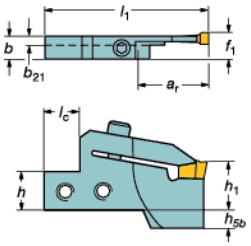
 J2

T-Max Q-Cut®

Replaceable cartridges for parting in Multi-Spindles

Spring clamp





Seat size[1]	Ordering code	Dimensions, mm, inch a_r	b	b_{21}	f_1	h	h_1	h_{5b}	l_1	l_c	Gauge inserts
15	**MS-RF151.23-13-15**	13.0	10.9		11.2	18.0	22.1		55.1	18.0	N151.2-A062-15- 3F
		.510	*.430*		*.441*	*.709*	*.870*		*2.170*	*.710*	
20	**MS-RF151.23-13-20**	13.0	10.9		11.2	18.0	22.1		55.1	18.0	N151.2-200- 5F
		.510	*.430*		*.441*	*.709*	*.870*		*2.170*	*.710*	
25	**MS-RF151.23-13-25**	13.0	10.9		11.2	18.0	22.1		55.1	18.0	N151.2-A094-25- 3F
		.510	*.430*		*.441*	*.709*	*.870*		*2.170*	*.710*	
	MS-RF151.23-20-25	20.1	10.9		11.2	18.0	22.1		62.0	18.0	N151.2-A094-25- 3F
		.790	*.430*		*.441*	*.709*	*.870*		*2.440*	*.710*	
30	**MS-RF151.23-13-30**	13.0	10.7		11.2	18.0	22.1		55.1	18.0	N151.2-A125-30- 3F
		.510	*.420*		*.441*	*.709*	*.870*		*2.170*	*.710*	
	MS-RF151.23-20-30	20.0	10.8		11.2	18.0	22		62.0	18.0	N151.2-A125-30- 3F
		.787	*.424*		*.441*	*.709*	*.866*		*2.441*	*.710*	
	MS-RF151.23-26-30	25.9	10.7		11.2	18.0	22.1		68.1	18.0	N151.2-A125-30- 3F
		1.020	*.420*		*.441*	*.709*	*.870*		*2.680*	*.710*	
	MS-RF151.23-34-30	34.0	10.7	6.6	11.2	18.0	22.1	30.0	75.9	18.0	N151.2-A125-30- 3F
		1.340	*.420*	*.260*	*.441*	*.709*	*.870*	*1.180*	*2.990*	*.710*	
40	**MS-RF151.23-26-40**	25.9	10.9		11.2	18.0	22.1		68.1	17.0	N151.2-A156-40- 3F
		1.020	*.430*		*.441*	*.709*	*.870*		*2.680*	*.670*	
	MS-RF151.23-34-40	34.0	10.9	6.6	11.2	18.0	22.1	30.0	75.9	17.0	N151.2-A156-40- 3F
		1.340	*.430*	*.260*	*.441*	*.709*	*.870*	*1.180*	*2.990*	*.670*	

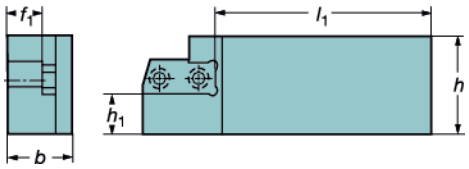
[1] To correspond with seat size on insert.

R = Right hand

Main spare parts

Seat size	Insert screw	Hex key (size)	
15 - 30	8 - 32 x $^5/_8$" SHCS	SMS 875-$^9/_{64}$	($^9/_{64}$)
40	1/4" - 20 x $^5/_8$" SHCS	174.1-872	($^3/_{16}$)

Machine adapted blocks for Acme-Gridley Multi-Spindles



Ordering code	Dimensions, mm, inch l_1	h	h_1	b	f_1	Comparable Acme Block Designation I = In-board position Model	Machines
MS-R151.2-4225	131	42.9	8.4	25.4	7.8	AZ-71479 (I)	1-1/4" RA6
	5.150	*1.690*	*.330*	*1.000*	*.309*		
MS-R151.2-4331	165	42.9	12.1	31.8	14.2	AZ-41483, AZ-41479 (I)	1-1/4" R8, 1-5/8" RBN8
	6.500	*1.690*	*.480*	*1.250*	*.559*		1-5/8" RB6, 2" RB6
MS-R151.2-4438	118	44.5	15.2	38.1	20.5	N/A	2" RA6, 2-1/4" RA6, 2-5/8"
	4.650	*1.750*	*.600*	*1.50*	*.809*		2-5/8" RA6, 3" RB6, 4" RA6,
							3-1/2" RA6, 3-1/2 RB6, 2-5/
							2-1/4" RA8/RB8, 3-1/2" RB8

R = Right hand

Main spare parts

Block type	Blade clamping screw	Key (Torx Plus)	Nozzle
MS-R151.2	3212 106-503	5680 043-16 (27IP)	5691 028-01

 B117

 B2

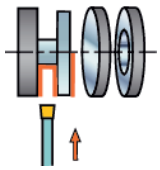
 B6

T-Max Q-Cut®

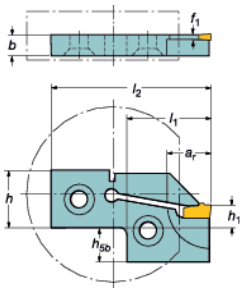
Replaceable cartridges

For parting in Multi-Spindle cartridges for Davenport blocks

Spring clamp



151.2-3F 151.2-5F
151.2-5E 151.2-5G

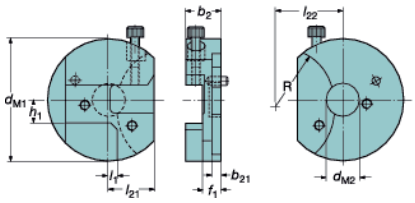


Seat size[1]	Ordering code	Dimensions, mm, inch a_r	b	f_1	h	h_1	h_{5b}	l_1	l_2	Gauge inserts
15	**MS-R151.20-13-15**	15.0	6.1	1.5	16.5	6.6	15.0	24.4	46.48	N151.2-A062-15- 3F
		.590	.240	.058	.650	.260	.590	.960	1.830	
25	**MS-R151.20-13-25**	15.0	6.1	2.3	16.5	6.6	15.0	24.4	46.48	N151.2-A094-25- 3F
		.590	.240	.090	.650	.260	.590	.960	1.830	
30	**MS-R151.20-13-30**	15.0	6.1	3.1	16.5	6.6	15.0	24.4	46.48	N151.2-A125-30- 3F
		.590	.240	.121	.650	.260	.590	.960	1.830	

[1] To correspond with seat size on insert.

R = Right hand

Adapter plate for Davenport blocks



Ordering code	Dimensions, inch b_2	b_{21}	D_{m1}	D_{m2}	f_1	l_1	l_{21}	l_{22}	r	h_1
MSLDAV-5014	14.2	3.3	50.8	14.2	7.0	4.0	19.05	28.5	25.4	9.7
	.560	*.130*	*2.000*	*.560*	*.276*	*.157*	*.750*	*1.122*	*1.000*	*.383*

Main spare parts

Screw	Key (Torx Plus)
3212 036-403	5680 043-15 (25IP)

Operational dimensions after assembling

Plate with blade

f_1 total = f_1 blade + f_1 plate
h_1 total = h_1 blade - h_1 plate
(neg h_1 total = below vertical center line)
l_1 total = l_1 blade + l_1 plate

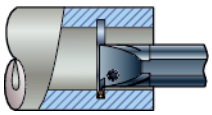

B117

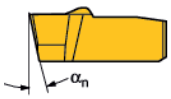

B2

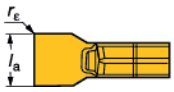

B6

T-Max Q-Cut® (Type 151.3)

Internal grooving







For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a = ±0.10 (±.004)
r_ε = ±0.05 (±.002)

For circlip grooves (151.3-A-46)
l_a = +0.13 (+.005) +0.09 (+.0035)
r_ε = ±0.05 (±.002)
l_a = ±0.02 (±.0008)
r_ε = ±0.05 (±.0020)

These inserts can only be used in 151.3x holders.

		Selection criteria, millimeter, inch (mm, in.)						Dimensions		P					M						K			N	S				
										GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	-	GC	GC	-	-	GC	GC	GC	-
		l_a mm	l_a in.	r_ε mm	r_ε in.	Seat size	Ordering code	α_n	α_f	1125	1145	2135	235	4125	1125	1145	2135	235	4125	H13A	1125	4125	H13A	H13A	1125	2135	4125	H13A
Low feed	 151.3-4G	1.98	.078	0.18	.007	20	N151.3-A078-20-4G	11°	3°		★		☆			★		☆		☆			★	★				★
		2.00	.079	0.20	.008		N151.3-200-20-4G	11°	3°	★	☆	☆	☆		☆	☆	★	☆		☆	☆		★	★	☆	☆		★
		2.23	.088	0.18	.007		N151.3-A088-20-4G	11°	3°		★		☆			★		☆		☆			★	★				★
		2.39	.094	0.18	.007	25	N151.3-A094-25-4G	11°	3°	★	☆		☆		★	☆		☆		☆	☆		★	★	☆			★
		2.46	.097	0.33	.013		N151.3-A097-25-4G	11°	3°	★	☆		☆		★	☆		☆		☆	☆		★	★	☆			★
		2.67	.105	0.18	.007		N151.3-A105-25-4G	11°	3°		★		☆			★		☆		☆			★	★				★
		2.79	.110	0.33	.013		N151.3-A110-25-4G	11°	3°	★	☆		☆		★	☆		☆		☆	☆		★	★	☆			★
		3.00	.118	0.20	.008	30	N151.3-300-30-4G	11°	3°	★	☆	☆	☆		☆	☆	★	☆		☆	☆		★	★	☆	☆		★
		3.10	.122	0.18	.007		N151.3-A122-30-4G	11°	3°		★		☆			★		☆		☆			★	★				★
		3.17	.125	0.18	.007		N151.3-A125-30-4G	11°	3°	★	☆		☆		★	☆		☆		☆	☆		★	★	☆			★
		3.61	.142	0.33	.013		N151.3-A142-30-4G	11°	3°	★	☆		☆		★	☆		☆		☆	☆		★	★	☆			★
		3.96	.156	0.18	.007	40	N151.3-A156-40-4G	11°	3°		★		☆			★		☆		☆			★	★				★
		4.00	.157	0.20	.008		N151.3-400-40-4G	11°	3°	★	☆	☆	☆		☆	☆	★	☆		☆	☆		★	★	☆	☆		★
		4.52	.178	0.18	.007		N151.3-A178-40-4G	11°	3°		★		☆			★		☆										
		4.70	.185	0.56	.022		N151.3-A185-40-4G	11°	3°	★	☆		☆		★	☆		☆			★				★			
		4.80	.189	0.56	.022		N151.3-A189-40-4G	11°	3°	★	☆		☆		★	☆		☆		☆	☆		★	★	☆			★
		5.00	.197	0.20	.008	50	N151.3-500-50-4G	11°	3°	★	☆	☆	☆		☆	☆	★	☆		☆	☆		★	★	☆	☆		★
		5.41	.213	0.18	.007		N151.3-A213-50-4G	11°	3°				★					★										
		5.56	.219	0.56	.022		N151.3-A219-50-4G	11°	3°				★					★		☆			★	★				★
		6.00	.236	0.20	.008	60	N151.3-600-60-4G	9°	3°				★	☆				★	☆			☆					☆	
		6.35	.250	0.56	.022		N151.3-A250-60-4G	9°	3°											★			★	★				★
		7.93	.312	0.84	.033		N151.3-A312-60-4G	9°	3°											★			★	★				★
		8.00	.315	0.20	.008		N151.3-800-60-4G	9°	3°		★		☆			★		☆		☆			★	★				★
		For circlip grooves																										
		1.85	.073	0.10	.004	20	N151.3-185-20-4G	11°	3°	★	☆		☆		★	☆		☆		☆	☆		★	★	☆			★
		2.15	.085	0.15	.006		N151.3-215-20-4G	11°	3°	★	☆		☆		★	☆		☆			★				★			
		2.65	.104	0.15	.006	25	N151.3-265-25-4G	11°	3°	★	☆		☆		★	☆		☆		☆	☆		★	★	☆			★
		3.15	.124	0.15	.006	30	N151.3-315-30-4G	11°	3°		★		☆			★		☆		☆			★	★				★
		4.15	.163	0.15	.006	40	N151.3-415-40-4G	11°	3°		★		☆			★		☆		☆			★	★				★
		5.15	.203	0.15	.006	50	N151.3-515-50-4G	11°	3°				★					★		☆			★	★				★
										P30	P45	P35	P45	P30	M25	M40	M30	M35	M25	M15	K30	K30	K20	N20	S25	S30	S25	S15

1) To correspond with seat size on holder.

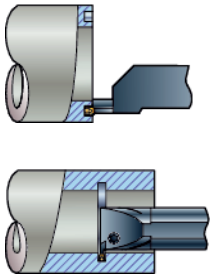
N = Neutral
★= First choice

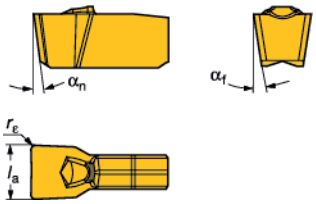
For geometry description, see page B124.

B10 B10 B124 B130 B146 B2 J3 I8

T-Max Q-Cut® (Type 151.3)

Face grooving, internal grooving and turning

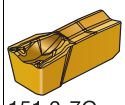




For ISO application areas, see bottom of the table.

These inserts can only be used in 151.3x holders.

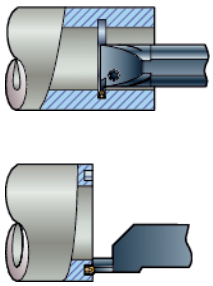
Tolerances, mm (inch):
l_a = +0.10/0 (+.004/0)
r_ε = ±0.10 (±.004)

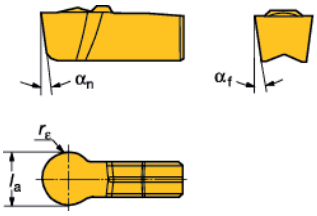
		Selection criteria, millimeter, inch (mm, in.)						Dimensions		P					M				K		S	
		l_a mm	l_a in.	r_ε mm	r_ε in.	Seat size	Ordering code	α_n	α_f	GC 1125	GC 1145	GC 2135	GC 235	GC 3020	GC 1125	GC 1145	GC 2135	GC 235	GC 1125	GC 3020	GC 1125	GC 2135
Low feed	 151.3-7G	3.00	.118	0.30	.012	25	N151.3-300-25-7G	11°	9°	★	☆	☆	☆	☆	☆	☆	★	☆	☆	★	★	☆
		4.00	.157	0.40	.016	30	N151.3-400-30-7G	11°	8.5°	★	☆	☆	☆	☆	☆	☆	★	☆	☆	★	★	☆
		5.00	.197	0.40	.016	40	N151.3-500-40-7G	11°	8.5°	★	☆	☆	☆	☆	☆	☆	★	☆	☆	★	★	☆
		6.00	.236	0.40	.016	50	N151.3-600-50-7G	11°	8.5°	★	☆	☆	☆		☆	☆	★	☆	★		★	☆
										P30	P45	P35	P45	P15	M25	M40	M30	M35	K30	K15	S25	S30

1) To correspond with seat size on holder.

N = Neutral
★= First choice

Internal profiling and face grooving

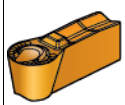




For ISO application areas, see bottom of the table.

These inserts can only be used in 151.3x holders.

Tolerances, mm (inch):
l_a = ±0.05 (±.002)

		Selection criteria, millimeter, inch (mm, in.)						Dimensions		P				M		K			S	
		l_a mm	l_a in.	r_ε mm	r_ε in.	Seat size	Ordering code	α_n	α_f	GC 1125	GC 2135	GC 3115	GC 4225	GC 1125	GC 2135	GC 1125	GC 3115	GC 4225	GC 1125	GC 2135
Low feed	 151.3-7P	3.00	.118	1.50	.059	25	N151.3-300-25-7P	11°	9°	★	☆	☆	☆	★	☆	☆	☆	★	★	☆
		4.00	.157	2.00	.079	30	N151.3-400-30-7P	11°	8.5°	★	☆	☆	☆	★	☆	☆	☆	★	★	☆
		5.00	.197	2.50	.098	40	N151.3-500-40-7P	11°	8.5°	★	☆	☆	☆	★	☆	☆	☆	★	★	☆
		6.00	.236	3.00	.118	50	N151.3-600-50-7P	11°	8.5°	★	☆	☆	☆	★	☆	☆	☆	★	★	☆
										P30	P35	P15	P20	M25	M30	K30	K15	K25	S25	S30

1) To correspond with seat size on holder.

N = Neutral
★= First choice

For geometry description, see page B124.

B10 B10 B124 B130 B146 B2 J3 I8

T-Max Q-Cut® (Type 151.3)

Shank tools for face grooving

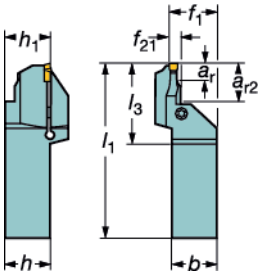
Screw clamp

151.3

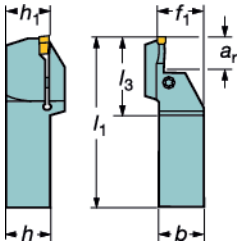
The 151.37 holder can only accept the 151.3 inserts

Reinforced

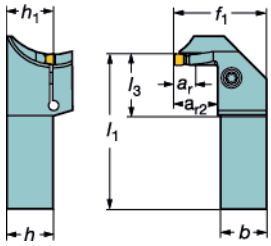
Shank, 0° style
R/LF 151.37



Shank, 0° style
R/LF 151.37

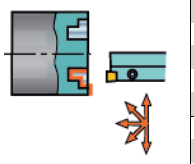
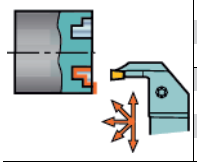


Shank, 90° style
R/LG 151.37



Right hand style shown

Metric version

Main application	First cut diameter, inch min	max	a_r max mm[1]	a_2	Shank style	Seat size[2]	Ordering code	Dimensions b	f_1	f_{21}	h	h_1	l_1	l_3	Gauge inserts	Nm[3]
	24	35	8.7	15	0°[4]	25	R/LF151.37-2525-024B25	25	26	4.8	25	25	150	37.7	N151.3-300-25- 7G	3.2
	29	40	8.7	15	0°[4]		R/LF151.37-2525-029B25	25	26	4.8	25	25	150	37.7	N151.3-300-25- 7G	3.2
	34	50	8.7	15	0°[4]		R/LF151.37-2525-034B25	25	26	4.8	25	25	150	37.7	N151.3-300-25- 7G	3.2
	44	70	15		0°		R/LF151.37-2525-044B25	25	26		25	25	150	37.7	N151.3-300-25- 7G	3.2
	64	100	15		0°		R/LF151.37-2525-064B25	25	26		25	25	150	37.7	N151.3-300-25- 7G	3.2
	27	45	8.7	20	0°[4]	30	R/LF151.37-2525-027B30	25	26	5.8	25	25	150	44.7	N151.3-400-30- 7G	3.3
	32	50	8.7	20	0°[4]		R/LF151.37-2525-032B30	25	26	5.8	25	25	150	44.7	N151.3-400-30- 7G	3.3
	42	70	20		0°		R/LF151.37-2525-042B30	25	26		25	25	150	44.7	N151.3-400-30- 7G	3.3
	62	120	20		0°		R/LF151.37-2525-062B30	25	26		25	25	150	44.7	N151.3-400-30- 7G	3.3
	112	200	20		0°		R/LF151.37-2525-112B30	25	26		25	25	150	44.7	N151.3-400-30- 7G	3.3
	25	45	10.7	20	0°[4]	40	R/LF151.37-2525-025B40	25	26	6.8	25	25	150	45.7	N151.3-500-40- 7G	3.4
	30	55	10.7	20	0°[4]		R/LF151.37-2525-030B40	25	26	6.8	25	25	150	45.7	N151.3-500-40- 7G	3.4
	45	80	20		0°		R/LF151.37-2525-045B40	25	26		25	25	150	45.7	N151.3-500-40- 7G	3.4
	70	120	20		0°		R/LF151.37-2525-070B40	25	26		25	25	150	45.7	N151.3-500-40- 7G	3.4
	90	200	20		0°		R/LF151.37-2525-090B40	25	26		25	25	150	45.7	N151.3-500-40- 7G	3.4
	23	45	10.7	20	0°[4]	50	R/LF151.37-2525-023B50	25	26	7.8	25	25	150	46.7	N151.3-600-50- 7G	3.8
	38	70	20		0°		R/LF151.37-2525-038B50	25	26		25	25	150	46.7	N151.3-600-50- 7G	3.8
	58	110	20		0°		R/LF151.37-2525-058B50	25	26		25	25	150	46.7	N151.3-600-50- 7G	3.8
	88	200	20		0°		R/LF151.37-2525-088B50	25	26		25	25	150	46.7	N151.3-600-50- 7G	3.8
	27	45	8.7	20	90°[4]	30	R/LG151.37-2525-027B30	25	47	5.8	25	25	150	26	N151.3-400-30- 7G	3.0
	32	50	20		90°		R/LG151.37-2525-032B30	25	47		25	25	150	26	N151.3-400-30- 7G	3.0
	42	70	20		90°		R/LG151.37-2525-042B30	25	47		25	25	150	26	N151.3-400-30- 7G	3.0
	23	45	10.7	20	90°[4]	50	R/LG151.37-2525-023B50	25	47	5.8	25	25	150	30.2	N151.3-600-50- 7G	3.0
	38	76	20		90°		R/LG151.37-2525-038B50	25	47		25	25	150	30.2	N151.3-600-50- 7G	3.5

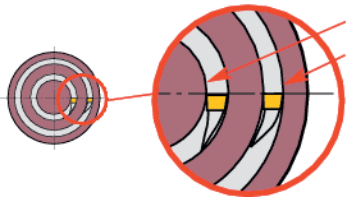
1) For max stability choose a holder with shortest possible a_r.
2) To correspond with seat size on insert.
3) Insert tightening torque, Nm. Use torque wrench, see page B110.
4) Reinforced blade.

R = Right hand, L = Left hand

Main spare parts

Seat size	Screw	Key (Torx Plus)
25-50	3212 012-360	5680 043-17 (30IP)

First cut diameters



 B6
 B118
 G6
 B2
 J3
 J2

SANDVIK Coromant

T-Max Q-Cut® (Type 151.3)

Shank tools for face grooving

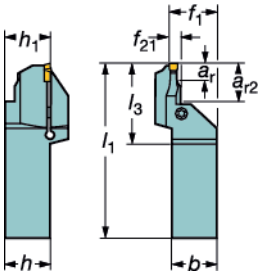
Screw clamp

151.3

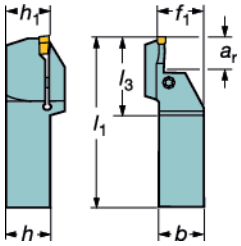
The 151.37 holder can only accept the 151.3 inserts

Reinforced

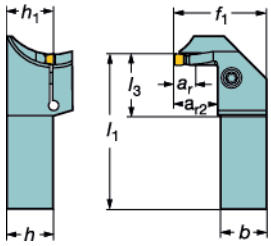
Shank style 0°
R/LF 151.37



Shank style 0°
R/LF 151.37

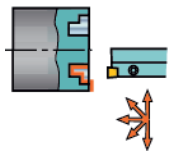
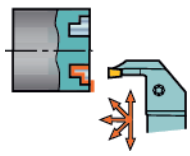


Shank style 90°
R/LG 151.37



Right hand style shown

Inch version

Main application	First cut diameter, inch min	max	a_r max mm[1]	a_{r2}	Shank style	Seat size[2]	Ordering code	Dimensions, inch b	f_1	f_{21}	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[3]
	.945	1.378	.343	.590	0°[4]	25	R/LF151.37-16-024B25	1.000	1.039	.189	1.000	1.000	6.000	1.484	N151.3-300-25- 7G	
	1.142	1.575	.343	.590	0°[4]		R/LF151.37-16-029B25	1.000	1.039	.189	1.000	1.000	6.000	1.484	N151.3-300-25- 7G	
	1.339	1.969	.343	590	0°[4]		R/LF151.37-16-034B25	1.000	1.039	.189	1.000	1.000	6.000	1.484	N151.3-300-25- 7G	
	1.732	2.756	.591		0°		R/LF151.37-16-044B25	1.000	1.039		1.000	1.000	6.000	1.484	N151.3-300-25- 7G	2.4
	2.520	3.937	.591		0°		R/LF151.37-16-064B25	1.000	1.039		1.000	1.000	6.000	1.484	N151.3-300-25- 7G	
	3.701	5.197	.591		0°		R/LF151.37-16-094B25	1.000	1.039		1.000	1.000	6.000	1.484	N151.3-300-25- 7G	
	5.197	7.874	.591		0°		R/LF151.37-16-132B25	1.000	1.039		1.000	1.000	6.000	1.484	N151.3-300-25- 7G	
	1.083	1.772	.343	.790	0°[4]	30	R/LF151.37-16-027B30	1.000	1.039	.228	1.000	1.000	6.000	1.760	N151.3-400-30- 7G	
	1.260	1.969	.343	.790	0°[4]		RF151.37-16-032B30	1.000	1.039	.228	1.000	1.000	6.000	1.760	N151.3-400-30- 7G	
	1.654	2.758	.787		0°		R/LF151.37-16-042B30	1.000	1.039		1.000	1.000	6.000	1.760	N151.3-400-30- 7G	
	2.441	4.724	.787		0°		R/LF151.37-16-062B30	1.000	1.039		1.000	1.000	6.000	1.760	N151.3-400-30- 7G	
	4.409	7.874	.787		0°		R/LF151.37-16-112B30	1.000	1.039		1.000	1.000	6.000	1.760	N151.3-400-30- 7G	
	.984	1.772	.422	.790	0°[4]	40	R/LF151.37-16-025B40	1.000	1.039	.267	1.000	1.000	6.000	1.800	N151.3-500-40- 7G	
	1.181	2.165	.422	.790	0°[4]		R/LF151.37-16-030B40	1.000	1.039	.267	1.000	1.000	6.000	1.800	N151.3-500-40- 7G	
	1.772	3.15	.787		0°		R/LF151.37-16-045B40	1.000	1.039		1.000	1.000	6.000	1.800	N151.3-500-40- 7G	
	2.758	4.724	.787		0°		R/LF151.37-16-070B40	1.000	1.039		1.000	1.000	6.000	1.800	N151.3-500-40- 7G	
	3.543	7.874	.787		0°		R/LF151.37-16-090B40	1.000	1.039		1.000	1.000	6.000	1.800	N151.3-500-40- 7G	
	.906	1.772	.420	.790	0°[4]	50	R/LF151.37-16-023B50	1.000	1.039	.307	1.000	1.000	6.000	1.840	N151.3-600-50- 7G	2.8
	1.496	2.756	.787		0°		R/LF151.37-16-038B50	1.000	1.039		1.000	1.000	6.000	1.840	N151.3-600-50- 7G	
	2.283	4.331	.787		0°		R/LF151.37-16-058B50	1.000	1.039		1.000	1.000	6.000	1.840	N151.3-600-50- 7G	
	3.150	7.874	.787		0°		R/LF151.37-16-088B50	1.000	1.039		1.000	1.000	6.000	1.840	N151.3-600-50- 7G	
	1.063	1.772	.340	.790	90°[4]	30	R/LG151.37-16-027B30	1.000	1.850	.009	1.000	1.000	6.000	1.024	N151.3-400-30- 7G	2.2
	1.260	1.968	.790		90°		R/LG151.37-16-032B30	1.000	1.850		1.000	1.000	6.000	1.024	N151.3-400-30- 7G	2.2
	1.654	2.755	.790		90°		R/LG151.37-16-042B30	1.000	1.850		1.000	1.000	6.000	1.024	N151.3-400-30- 7G	2.2
	.906	1.771	.420	.790	90°[4]	50	R/LG151.37-16-023B50	1.000	1.850	.009	1.000	1.000	6.000	1.189	N151.3-600-50- 7G	2.2
	1.496	2.755	.790		90°		R/LG151.37-16-038B50	1.000	1.850		1.000	1.000	6.000	1.189	N151.3-600-50- 7G	2.6

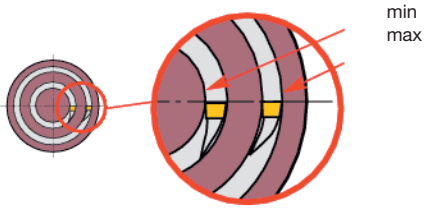
1) For max stability choose a holder with shortest possible a_r.
2) To correspond with seat size on insert.
3) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.
4) Reinforced blade.

R = Right hand, L = Left hand

Main spare parts

Seat size	Screw	Key (Torx Plus)
25-50	3212 012-360	5680 043-17 (30IP)

First cut diameters



B6 B118 G6 B2 J3 J2

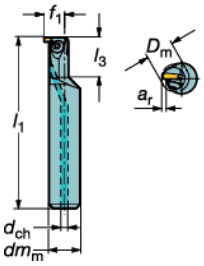
T-Max Q-Cut® (Type 151.3)

Boring bars for grooving, turning and profiling

Screw clamp

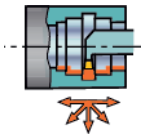
R/LAG151.32
Cylindrical, eccentric
With groove for EasyFix sleeve

The AG 151.32 tools can only accept the 151.3 inserts.

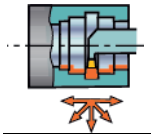


Right hand style shown

Metric version

Main application	D_m min	a_r max	Seat size[1]	Ordering code	Dimensions dm_m	f_1	l_1	l_3	d_{ch}	Gauge inserts	Nm[2]
	12	2	20	**R/LAG151.32-16M12-20**	16	10	150	20	6	N151.3-200-20- 4G	2.5
	15	4	25	**R/LAG151.32-16M15-25**	16	12	150	20	6	N151.3-265-25- 4G	2.5
	16	4.5	30	**R/LAG151.32-20Q16-30**	20	14.25	180	21.5	6	N151.3-300-30- 4G	2.5
	18	5	40	**R/LAG151.32-20Q18-40**	20	14.75	180	23	6	N151.3-400-40- 4G	3.5

Inch version

Main application	D_m min	a_r max	Seat size[1]	Ordering code	Dimensions, inch dm_m	f_1	l_1	l_3	d_{ch}	Gauge inserts	ft-lbs[3]
	.472	.079	20	**R/LAG151.32-D10M47-20**	.625	.394	5.906	.787	.236	N151.3-200-20- 4G	1.8
	.591	.157	25	**R/LAG151.32-D10M59-25**	.625	.472	5.906	.787	.236	N151.3-265-25- 4G	1.8
	.591	.157		**R/LAG151.32-D12-M59-25**	.750	.453	6.000	1.400	.236	N151.3-265-25- 4G	1.6
	.630	.187	30	**R/LAG151.32-D12Q63-30**	.750	.551	7.087	.846	.236	N151.3-300-30- 4G	1.8
	.709	.207	40	**R/LAG151.32-D12Q71-40**	.750	.571	7.087	.906	.236	N151.3-400-40- 4G	2.2

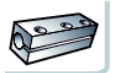
1) To correspond with seat size on insert.
2) Insert tightening torque, Nm. Use torque wrench, see page B110.
3) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

For coolant connector, see page A308.

Main spare parts

	Seat size	Screw	Key (Torx Plus)
R/LAG151.32	20	5512 031-07	5680 043-10 (8IP)
R/LAG151.32	25-30	5512 031-04	5680 043-10 (8IP)
R/LAG151.32	40	5512 031-03	5680 043-10 (8IP)

 B6
 B120
 G6
 B2
 A304
 J2

SANDVIK Coromant

T-Max Q-Cut® (Type 151.3)

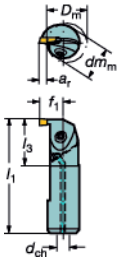
Boring bars for grooving, turning and profiling

Screw clamp

The AG 151.32 tools can only accept the 151.3 inserts.

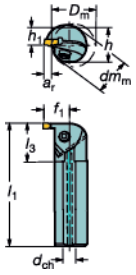
R/LAG151.32
Cylindrical with groove for EasyFix sleeve

dm_m = 16–25 mm



R/LAG151.32
Cylindrical with flats

dm_m = 32–50 mm / .625-1.500 inch



Right hand style shown

Metric version

D_m min	a_r max	Seat size[1]	Ordering code	Dimensions dm_m	f_1	h	h_1	l_1	l_3	d_{ch}	Gauge inserts	Nm[2]
20	3.5	20	**R/LAG151.32-16M-20**	16	11.5			150	24	6	N151.3-200-20- 4G	2.5
25	4.5		**R/LAG151.32-20Q-20**	20	14.5			180	30	6	N151.3-200-20- 4G	2.5
20	3.5	25	**R/LAG151.32-16M-25**	16	11.6			150	24.2	6	N151.3-265-25- 4G	3.0
25	4.6		**R/LAG151.32-20Q-25**	20	14.6			180	30	6	N151.3-265-25- 4G	3.0
32	6.1		**R/LAG151.32-25R-25**	25	18.6			200	32.2	8.5	N151.3-265-25- 4G	3.0
40	7.1		**R/LAG151.32-32S-25**	32	23.1	30	15	250	36.3	8.5	N151.3-265-25- 4G	3.0
25	4.5	30	**R/LAG151.32-20Q-30**	20	14.5			180	30	6	N151.3-300-30- 4G	3.5
32	6		**R/LAG151.32-25R-30**	25	18.5			200	32.2	8.5	N151.3-300-30- 4G	3.5
40	7		**R/LAG151.32-32S-30**	32	23	30	15	250	36.2	8.5	N151.3-300-30- 4G	3.5
32	6.1	40	**R/LAG151.32-25R-40**	25	18.5			200	32.2	8.5	N151.3-400-40- 4G	4.5
40	7.1		**R/LAG151.32-32S-40**	32	23.1	30	15	250	36.3	8.5	N151.3-400-40- 4G	4.5
50	8.1		**R/LAG151.32-40T-40**	40	28.1	37	18.5	300	42.3	11.5	N151.3-400-40- 4G	4.5
40	7	50	**R/LAG151.32-32S-50**	32	23	30	15	250	36.2	8.5	N151.3-500-50- 4G	5.0
50	8		**R/LAG151.32-40T-50**	40	28	37	18.5	300	42.3	11.5	N151.3-500-50- 4G	5.0
50	8	60	**R/LAG151.32-40T-60**	40	28	37	18.5	300	43.3	11.5	N151.3-800-60- 4G	5.0

Inch version

D_m min	a_r max	Seat size[1]	Ordering code	Dimensions, inch dm_m	f_1	h	h_1	l_1	l_3	d_{ch}	Gauge inserts	ft-lbs[3]
.790	.138	20	**R/LAG151.32-D10-20**	.625	.453	.560	.280	6.000	.950	.240	N151.3-200-20- 4G	1.4
.980	.177		**R/LAG151.32-D12-20**	.750	.571	.710	.350	7.000	1.180	.240	N151.3-200-20- 4G	1.4
.790	.138	25	**R/LAG151.32-D10-25**	.625	.457	.560	.280	6.000	.950	.240	N151.3-265-25- 4G	1.6
.980	.181		**R/LAG151.32-D12-25**	.750	.575	.710	.350	7.000	1.180	.240	N151.3-265-25- 4G	1.6
1.260	.240		**R/LAG151.32-D16-25**	1.000	.732	.910	.450	8.000	1.270	.350	N151.3-265-25- 4G	1.6
1.580	.280		**R/LAG151.32-D20-25**	1.250	.909	1.180	.590	10.000	1.430	.350	N151.3-265-25- 4G	1.6
.980	.177	30	**R/LAG151.32-D12-30**	.750	.571	.710	.350	7.000	1.180	.240	N151.3-300-30- 4G	1.9
1.260	.236		**R/LAG151.32-D16-30**	1.000	.728	.910	.450	8.000	1.270	.350	N151.3-300-30- 4G	1.9
1.580	.276		**R/LAG151.32-D20-30**	1.250	.906	1.180	.590	10.000	1.430	.350	N151.3-300-30- 4G	1.9
1.580	.281	40	**R/LAG151.32-D20-40**	1.250	.911	1.180	.590	10.000	1.430	.350	N151.3-400-40- 4G	2.4
1.970	.319		**R/LAG151.32-D24-40**	1.500	1.106	1.460	.730	12.000	1.530	.470	N151.3-400-40- 4G	2.4
1.260	.240		**RAG151.32-D16-40**	1.000	.734	.910	.450	8.000	1.270	.350	N151.3-400-40- 4G	2.4
1.970	.315	50	**R/LAG151.32-D24-50**	1.500	1.102	1.460	.730	12.000	1.530	.470	N151.3-500-50- 4G	2.7
1.580	.276		**RAG151.32-D20-50**	1.250	.906	1.180	.590	10.000	1.430	.350	N151.3-500-50- 4G	2.7
1.970	.315	60	**R/LAG151.32-D24-60**	1.500	1.102	1.460	.730	12.000	1.550	.470	N151.3-800-60- 4G	2.7

[1] To correspond with seat size on insert.

R = Right hand, L = Left hand

[2] Insert tightening torque, Nm. Use torque wrench, see page B110.

[3] Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

For coolant connector, see page A308.

Main spare parts

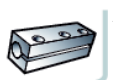
Metric	Inch	Seat size	Screw	Key (Torx Plus)
R/LAG 151.32	R/LAG 151.32	20-30	5512 031-03	5680 043-13 (8IP)
R/LAG 151.32-25R	R/LAG 151.32-D16-40	40	5512 031-03	5680 043-13 (8IP)
R/LAG 151.32	R/LAG 151.32	40-60	3212 012-360	5680 043-17 (30IP)

 B6

 B120

 G6

 B2

 A304

 J2

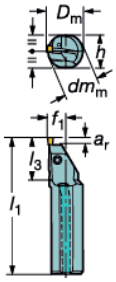
T-Max Q-Cut® (Type 151.3)

Boring bars for facegrooving

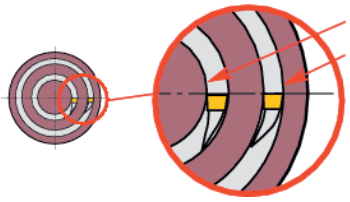
Screw clamp

The 151.37 bar can only accept the 151.3 inserts

Cylindrical with flats
Shank, 0° style

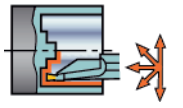


First cut diameters



Right hand style shown

Metric version

Main application	First cut diameter, inch min	max	D_m min	a_r max	Seat size[1]	Ordering code	Dimensions dm_m	f_1	h	l_1	l_3	Gauge inserts	Nm[2]
	18	101	26	5.3	25	**R/LAF151.37-25-024A25**	25	12.75	23	200	31.4	N151.3-300-25- 7G	3.0
	16	101	26	5.3	30	**R/LAF151.37-25-024A30**	25	12.75	23	200	31.4	N151.3-400-30- 7G	3.0
	16	55	26	12		**R/LAF151.37-25-025A30**	25	12.75	23	200	31.4	N151.3-400-30- 7G	3.5
	23	400	42	6.3	50	**R/LAF151.37-40-035A50**[3]	40	20.8	37	300	50	N151.3-600-50-7G	5.0
	23	80	42	15		**R/LAF151.37-40-036A50**[3]	40	20.8	37	300	50	N151.3-600-50-7G	5.0

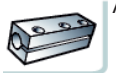
R = Right hand, L = Left hand

1) To correspond with seat size on insert.
2) Insert tightening torque, Nm. Use torque wrench, see page B110.
3) When using insert N151.3-500-40-7G, first cut diameter, D_m min and f_1 dimensions will be changed.

For coolant connector, see page A308.

Main spare parts

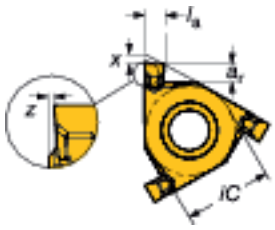
Seat size	Screw	Key (Torx Plus)
25-30	3212 012-257	5680 043-14 (20IP)
50	3212 012-359	5680 043-17 (30IP)

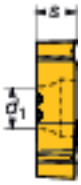
 B6
 B120
 G6
 B2
 A304
 J2

CoroThread® 254 for circlip grooving

For circlip grooving and machining in shallow grooves

CoroThread® for circlip grooving





△	iC	d_1 mm	d_1 in.	s mm	s in.
16	3/8	4.39	.173	3.96	.156
22	1/2	5.51	.217	5.56	.219

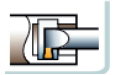
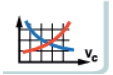
Tolerances, inch (mm):
l_a= + 0.13 / + 0.05
(+ .005 / + .002)
s = ± 0.13
(±.005)

Note!
The right hand insert can be used for right hand external and left hand internal holders. The left hand insert can be used for left hand external and right hand internal holders.

Right hand style shown.

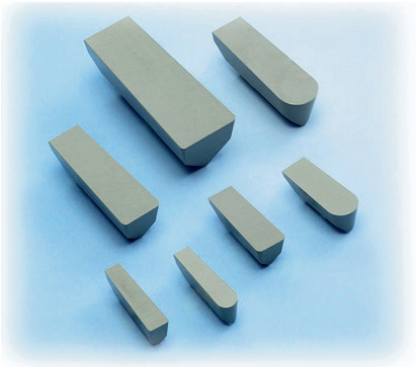
	Selection criteria, millimeter, inch (mm, in.)									Dimensions, millimeter, inch (mm, in.)				P	M	K	N	S
														GC	GC	GC	GC	GC
	l_a mm	l_a in.	r_ε mm	r_ε in.	a_r max mm	a_r max in.	△	iC	Ordering code	x mm	x in.	z mm	z in.	1135	1135	1135	1135	1135
	1.10	.043	.080	.003	1.30	.051	16	3/8	254LG-16CC01-110	1.35	.053	0.05	.050	★	★	★	★	★
	1.30	.051	.080	.003	1.60	.063			254LG-16CC01-130	1.35	.053	0.05	.050	★	★	★	★	★
	1.60	.063	.080	.003	1.85	.073			254LG-16CC01-160	1.35	.053	0.05	.050	★	★	★	★	★
	1.85	.073	.080	.003	1.85	.073			254LG-16CC01-185	1.35	.053	0.05	.050	★	★	★	★	★
	2.15	.085	.080	.003	1.85	.073			254LG-16CC01-215	1.35	.053	0.05	.050	★	★	★	★	★
	1.10	.043	.080	.003	1.30	.051			254RG-16CC01-110	1.35	.053	0.05	.050	★	★	★	★	★
	1.30	.051	.080	.003	1.60	.063			254RG-16CC01-130	1.35	.053	0.05	.050	★	★	★	★	★
	1.60	.063	.080	.003	1.85	.073			254RG-16CC01-160	1.35	.053	0.05	.050	★	★	★	★	★
	1.85	.073	.080	.003	1.85	.073			254RG-16CC01-185	1.35	.053	0.05	.050	★	★	★	★	★
	2.15	.092	.080	.003	1.85	.073			254RG-16CC01-215	1.35	.053	0.05	.050	★	★	★	★	★
	2.65	.104	.150	.006	2.20	.087	22	1/2	254LG-22CC01-265	1.70	.067	0.05	.050	★	★	★	★	★
	3.15	.124	.150	.006	2.20	.087			254LG-22CC01-315	1.70	.067	0.05	.050	★	★	★	★	★
	4.15	.163	.150	.006	2.60	.102			254LG-22CC01-415	1.30	.051	0.05	.050	★	★	★	★	★
	2.65	.104	.150	.006	2.20	.087			254RG-22CC01-265	1.70	.067	0.05	.050	★	★	★	★	★
	3.15	.124	.150	.006	2.20	.087			254RG-22CC01-315	1.70	.067	0.05	.050	★	★	★	★	★
	4.15	.163	.150	.006	2.60	.102			254RG-22CC01-415	1.30	.051	0.05	.050	★	★	★	★	★
														P25	M25	K20	N25	S25

R = Right hand, L = Left hand

 C8
 B124
 B146
 B2

T-Max® ceramic

For grooving and profiling of Heat Resistant Super Alloys and hardened materials



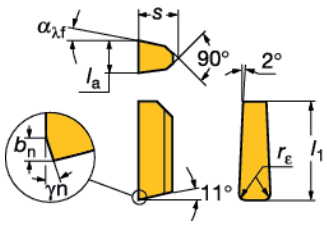
- Sharp cutting edges giving high quality grooves
- For both external and internal machining
- Grooving widths from .125 to .375 inch (3.17 mm to 9.52 mm)
- Bores down to 2.500 inch (63.5 mm)

Ceramic grade CC670
- A silicon carbide “whisker” reinforced grade

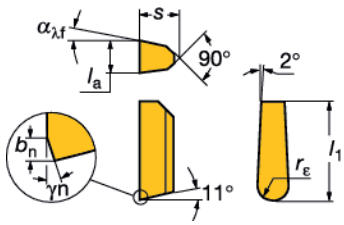
Ceramic grooving and profiling inserts

Tolerances, mm (inch):
s = +0/0.13 (+0/.005)
r_ε = ±0.10 (±.004)
l_1 = ±0.03 (±.001)
l_a = ±0.03 (±.001)

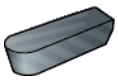
Grooving



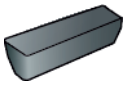
Profiling



Profiling

	Selection criteria, millimeter, inch (mm, in.)							Dimensions, millimeter, inch (mm, in.)								S	H	
	l_a mm	l_a in.	r_ε mm	r_ε in.	□	iC	ISO	l_1 mm	l_1 in.	s mm	s in.	b_n mm	b_n in.	γ_n	α_f	CC 670	CC 670	ANSI
	3.17	.125	1.59	.063	1	1	150.23 0317 16E	12.70	.500	4.74	.187				6°	☆	☆	CSG-4125-A
	3.17	.125	1.59	.063			150.23 0317 16T01020	12.70	.500	4.74	.187	0.10	.004	20°		☆	☆	CSG-4125-T0320
	4.75	.187	2.38	.094	2	2	150.23 0476 24E	12.70	.500	4.74	.187				11°	☆	☆	CSG-4187-A
	4.75	.187	2.38	.094			150.23 0476 24T01020	12.70	.500	4.74	.187	0.10	.004	20°		☆	☆	CSG-4187-T0320
	6.35	.250	3.17	.125	3	3	150.23 0635 32E	19.05	.750	6.35	.250				11°	☆	☆	CSG-6250-A
	6.35	.250	3.17	.125			150.23 0635 32T01020	19.05	.750	6.35	.250	0.10	.004	20°		☆	☆	CSG-6250-T0320
																S10	H10	

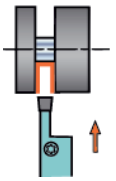
Grooving

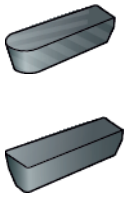
	Selection criteria, millimeter, inch (mm, in.)							Dimensions, millimeter, inch (mm, in.)								S	H	
	l_a mm	l_a in.	r_ε mm	r_ε in.	□	iC	ISO	l_1 mm	l_1 in.	s mm	s in.	b_n mm	b_n in.	γ_n	α_f	CC 670	CC 670	ANSI
	3.17	.125	0.38	.015	1	1	150.23 0317 04E	12.70	.500	4.74	.187				6°	☆	☆	CSG-4125-1A
	3.17	.125	0.38	.015			150.23 0317 04T01020	12.70	.500	4.74	.187	0.10	.004	20°		☆	☆	CSG-4125-1T0320
	4.75	.187	0.79	.031	2	2	150.23 0476 08E	12.70	.500	4.74	.187				11°	☆	☆	CSG-4187-2A
	4.75	.187	0.79	.031			150.23 0476 08T01020	12.70	.500	4.74	.187	0.10	.004	20°		☆	☆	CSG-4187-2T0320
	6.35	.250	0.79	.031	3	3	150.23 0635 08E	19.05	.750	6.35	.250				11°	☆	☆	CSG-6250-2A
	6.35	.250	0.79	.031			150.23 0635 08T01020	19.05	.750	6.35	.250	0.10	.004	20°		☆	☆	CSG-6250-2T0320
	7.93	.312	0.79	.031	4	4	150.23 0794 08E	25.40	1.000	8.56	.337				11°	☆	☆	CSG-8312-2A
	7.93	.312	0.79	.031			150.23 0794 08T01020	25.40	1.000	8.56	.337	0.10	.004	20°		☆	☆	CSG-8312-2T0320
	9.52	.375	0.79	.031			150.23 0952 08E	25.40	1.000	8.56	.337					☆	☆	CSG-8375-2A
	9.52	.375	0.79	.031			150.23 0952 08T01020	25.40	1.000	8.56	.337	0.10	.004	20°		☆	☆	CSG-8375-2A
																S10	H10	

B87 B87 B124 B146 B2

Shank tools for ceramic grooving and profiling inserts

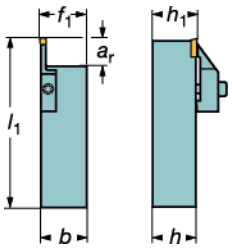
Screw clamp





150.23

R/LF150.23



Right hand style

a_r max	Seat size[1]	Ordering code	Dimensions, mm, inch b	f_1	h	h_1	l_1	Gauge inserts	Nm[2]
19	1	R/LF150.23-3244M-0317C	44	44.2	32	32	150	150.23-0317	3.5
			1.732	*1.740*	*1.260*	*1.260*	*5.906*		
19	2	R/LF150.23-3244M-0476C	44	44.4	32	32	150	150.23-0476	4.5
			1.732	*1.748*	*1.260*	*1.260*	*5.906*		
29	3	R/LF150.23-3244M-0635C	44	44.6	32	32	150	150.23-0635	5.0
			1.732	*1.756*	*1.260*	*1.260*	*5.906*		
38	4	R/LF150.23-3244M-0952C	44	45	32	32	150	150.23-0952	5.0
			1.732	*1.772*	*1.260*	*1.260*	*5.906*		

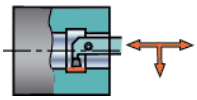
[1] To correspond with seat size on insert.

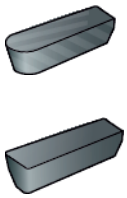
R = Right hand, L = Left hand

[2] Insert tightening torque, Nm. Use torque wrench, see page B110.

Boring bars for ceramic grooving and profiling inserts

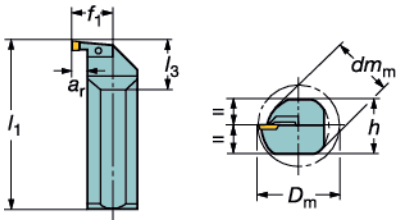
Screw clamp





150.23

R/LAG150.23
Cylindrical with flats



Right hand style

Metric version

D_m min	a_r max	Seat size[1]	Ordering code	Dimensions, mm, inch dm_m	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[2]
63.5	10	2	R/LAG150.23-50V-0476C	50	35	47	23.5	400	55	150.23-0476	4.5
		2		*1.968*	*1.378*	*1.850*	*.925*	*15.748*	*2.165*		

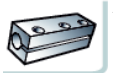
[1] To correspond with seat size on insert.

R = Right hand, L = Left hand

[2] Insert tightening torque, Nm. Use torque wrench, see page B110.

Main spare parts

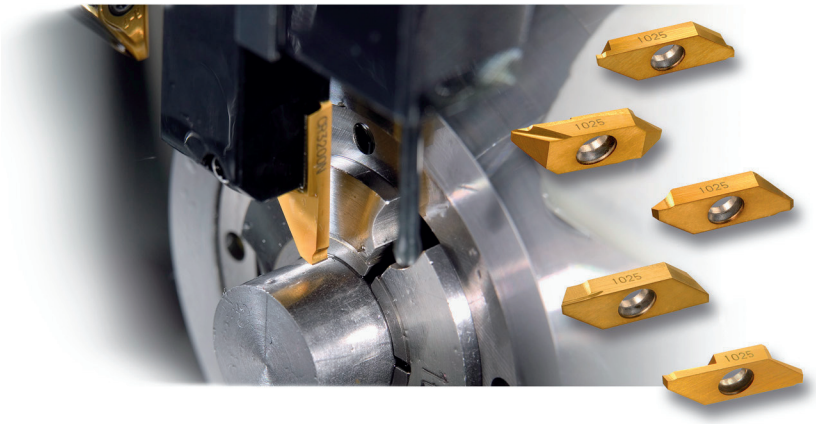
Shank tool	Screw	Key (Torx Plus)
R/LF 150.23	3212 036-506	5680 043-17 (30IP)
R/LAG 150.23	3212 106-504	5680 043-16 (27IP)

 B86
 B123
 G6
 B2
 A304

CoroCut® XS

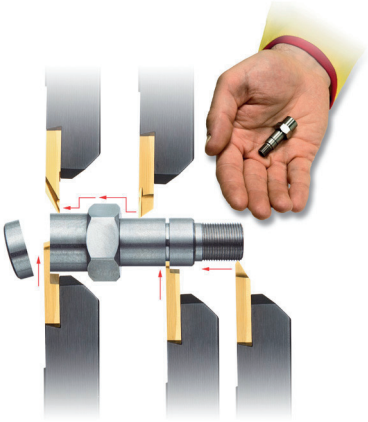
For external Small Part Machining

For external parting off, grooving, threading and turning of small diameters

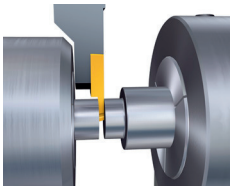


Toolholders

All inserts fit into the same toolholder
Also available as SL-cutting head, see page I51

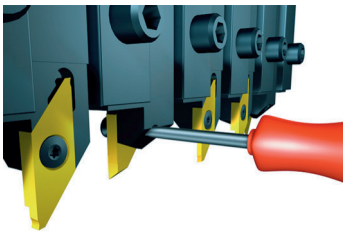


High precision square shank holders, including dedicated holders for parting off close to the sub-spindle, are available.



CoroCut® XS

- Designed for sliding head machines, workpiece 1 mm (.039 inch) in diameter
- High quality ground insert and holders
- Easy indexing
- Good accessibility when changing the insert. Insert screw can be reached from both sides, reducing downtime and increasing productivity.



Save material

With parting off insert widths down to .028 inch, a considerable amount of workpiece material can be saved when parting off.

ISO application areas:

P M N S

Code key for CoroCut® XS

Insert for parting

M	A	C	R	3	070	–	N
1	2	3	4	5	6		7

Insert for turning/grooving

M	A	G	R	3	125
1	2	3	4	5	6

Insert for threading

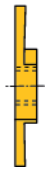
M	A	T	R	3	60	–	A
1	2	3	4	5	8		9

Shank holder

S	M	AL	R	1010	K	3	–	X
10	1	11	4	12	13	5		14

1 Family description

M =



2 Insert clearance angle

A = 50°

3 Type of operation

C = Cut off/parting
G = Grooving
T = Threading
F = Turning
B = Back turning
X = Semi-finishing blanks

4 Hand of insert/holder

R = Right hand
L = Left hand

5 Insert seat size

3

6 Insert thickness/corner radius, mm

For parting insert width (l_a) 070 = 0.70 mm (.028 inch)

For back turning insert corner radius (r_ε) 005 = 0.05 mm (.002 inch)

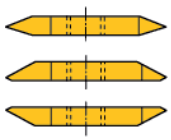
7 For cut off inserts (C in third position)

N = Neutral with geometry
T = Neutral without geometry
L = Left handed with geometry
R = Right handed with geometry

8 For threading inserts (T in third position)

60 = V-profile 60°

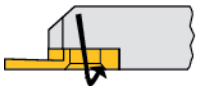
9 For threading inserts Hand of thread point



N = Neutral
A = Right hand
C = Left hand

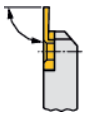
10 Clamping system

S = Screw clamping



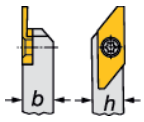
11 Holder style

AL = 90°



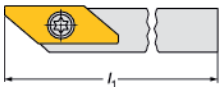
12 Shank dimensions

ex. 1010 = 10 x 10 (Metric version)
ex. 08 = 1/2" x 1/2" (Inch version)



13 Shank tool length, inch/mm

C : l_1 = 5"
K : l_1 = 125 mm



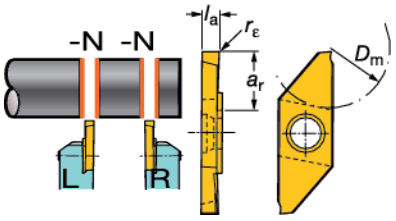
14 Additional information

X = Special design for working with sub-spindle

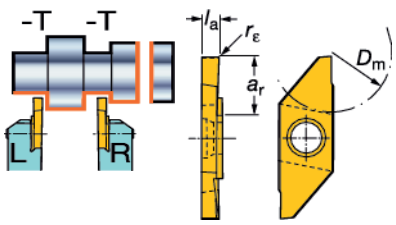
CoroCut® XS inserts

Parting off

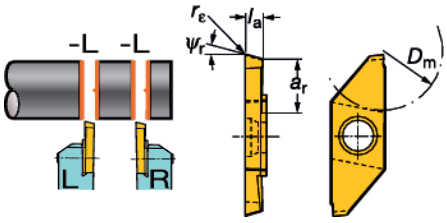
MACR/L -N



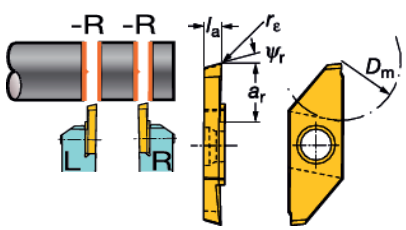
MACR/L -T



MACR/L -L



MACR/L -R



Right hand style shown

For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a: ±0.02 (±.0008)
r_ε: ±0.03 (±.001)
Repeatability: ±0.03 (±.001)
Center height: ±0.03 (±.001)

	Selection criteria, millimeter, inch (mm, in.)											P		M		N			S		
												GC	GC	GC	GC	GC	GC	-	GC	GC	-
	l_a mm	l_a in.	r_ε mm	r_ε in.	D_m max mm	D_m max in.	a_r max mm	a_r max in.	ψ_r	Insert seat size[1]	Ordering code	1025	1105	1025	1105	1025	1105	H13A	1025	1105	H13A
MAC-N	0.70	.028	0.05	.002	8	.315	4.3	.169	0°	3	MACR/L 3 070-N	★		★		★			★		
	1.00	.039	0.05	.002	12	.472	6.3	.248	0°		MACR/L 3 100-N	★	☆	★	☆	★	☆		★	☆	
	1.50	.059	0.05	.002	12	.472	6.3	.248	0°		MACR/L 3 150-N	★	☆	★	☆	★	☆		★	☆	
	2.00	.079	0.05	.002	16	.630	8.5	.335	0°		MACR/L 3 200-N	★	☆	★	☆	★	☆		★	☆	
MAC-R	0.70	.028	0.05	.002	8	.315	4.3	.169	15°	3	MACR/L 3 070-R	★		★		★			★		
	1.00	.039	0.05	.002	12	.472	6.3	.248	15°		MACR/L 3 100-R	★		★		★		☆	★		☆
	1.50	.059	0.05	.002	12	.472	6.3	.248	15°		MACR/L 3 150-R	★		★		★		☆	★		☆
	1.50	.059	0.05	.002	12	.472	6.3	.248	20°		MACR/L 3 150-R20	★		★		★			★		
	2.00	.079	0.05	.002	16	.630	8.5	.335	15°		MACR/L 3 200-R	★		★		★		☆	★		☆
	2.00	.079	0.05	.002	16	.630	8.5	.335	20°		MACR/L 3 200-R20	★		★		★			★		
MAC-L	0.70	.028	0.05	.002	8	.315	4.3	.169	15°	3	MACR/L 3 070-L	★		★		★			★		
	1.00	.039	0.05	.002	12	.472	6.3	.248	15°		MACR/L 3 100-L	★		★		★			★		
	1.50	.059	0.05	.002	12	.472	6.3	.248	15°		MACR/L 3 150-L	★		★		★			★		
	2.00	.079	0.05	.002	16	.630	8.5	.335	15°		MACR/L 3 200-L	★		★		★			★		
MAC-T	1.00	.039	0.05	.002	12	.472	6.3	.248	0°	3	MACR/L 3 100-T	★		★		★			★		
	1.50	.059	0.05	.002	12	.472	6.3	.248	0°		MACR/L 3 150-T	★		★		★			★		
	2.00	.079	0.05	.002	16	.630	8.2	.323	0°		MACR/L 3 200-T	★		★		★			★		
	2.50	.098	0.05	.002	16	.630	8.2	.323	0°		MACR 3 250-T	★		★		★			★		
												P25	P15	M25	M15	N25	N15	N20	S25	S15	S15

[1] To correspond with seat size on holder.

R = Right hand, L = Left hand

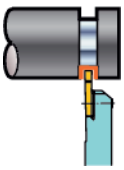
★= First choice

B94 B136 B146 B2

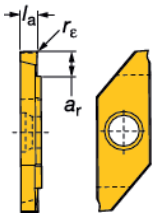
SANDVIK Coromant

CoroCut® XS inserts

Grooving



MAGR/L



For ISO application areas, see bottom of the table.

Tolerances, mm (inch):

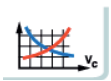
l_a=	±0.025 (±.0008)
r_ε =	±0.02 (±.001)
Repeatability	±0.025 (±.001)
Center height:	±0.025 (±.001)

Right hand style shown

	Selection criteria, millimeter, inch (mm, in.)								P	M	N		S	
									GC	GC	GC	-	GC	-
	l_a mm	l_a in.	r_ε mm	r_ε in.	a_r max mm	a_r max in.	Insert seat size[1]	Ordering code	1025	1025	1025	H13A	1025	H13A
 MAG	0.50	0.02	0.05	0.002	1.30	.051	3	MAGR/L 3 050	★	★	★	☆	★	☆
	0.75	0.03	0.05	0.002	2.50	.098		MAGR/L 3 075	★	★	★	☆	★	☆
	1.00	0.039	0.05	0.002	2.70	.106		MAGR/L 3 100	★	★	★	☆	★	☆
	1.25	0.049	0.05	0.002	2.70	.106		MAGR/L 3 125	★	★	★	☆	★	☆
	1.50	0.059	0.05	0.002	3.70	.146		MAGR/L 3 150	★	★	★	☆	★	☆
	1.75	0.069	0.05	0.002	3.70	.146		MAGR/L 3 175	★	★	★	☆	★	☆
	2.00	0.079	0.05	0.002	3.70	.146		MAGR/L 3 200	★	★	★	☆	★	☆
	2.50	0.098	0.05	0.002	3.70	.146		MAGR/L 3 250	★	★	★	☆	★	☆
									P25	M25	N25	N20	S25	S15

[1] To correspond with seat size on holder.

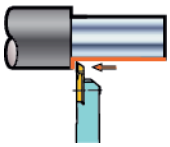
R = Right hand, L = Left hand

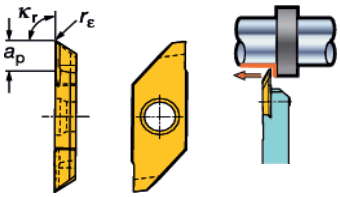
 B94
 B136
 B146
 B2

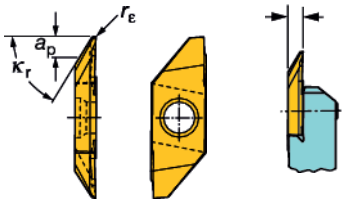
CoroCut® XS inserts

Turning, back turning

	Turning	Back turning
	MAFR/L	**MABR/L**
Entering angle	κ_r 90°	κ_r 59°
Lead angle	0°	31°







3.18 mm
(.125 inch)

Tolerances, mm (inch):

r_ε:	+0-0.05 (+0-.002)
Repeatability	±.025 (±.001)
Center height:	±.025 (±.001)

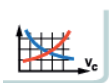
Right hand style shown

	Selection criteria, millimeter, inch (mm, in.)						P		M		N			S		
							GC	GC	GC	GC	GC	GC	-	GC	GC	-
	r_ε mm	r_ε in.	Max a_p mm	ap max in.	Insert seat size[1]	**Ordering code**	1025	1105	1025	1105	1025	1105	H13A	1025	1105	H13A
 **MAF**	0.03	.001	4	.157	3	**MAFL 3 003**	☆		☆		☆		☆	☆		☆
	0.03	.001	4	.157		**MAFR 3 003**	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	0.05	.002	4	.157		**MAFL 3 005**	☆		☆		☆		☆	☆		☆
	0.05	.002	4	.157		**MAFR 3 005**	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	0.10	.004	4	.157		**MAFL 3 010**	☆		☆		☆		☆	☆		☆
	0.10	.004	4	.157		**MAFR 3 010**	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	0.20	.008	4	.157		**MAFL 3 020**	☆		☆		☆		☆	☆		☆
	0.20	.008	4	.157		**MAFR 3 020**	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
 **MAB**	0.03	.001	4	.157	3	**MABL 3 003**	☆		☆		☆		☆	☆		☆
	0.03	.001	4	.157		**MABR 3 003**	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	0.05	.002	4	.157		**MABL 3 005**	☆		☆		☆		☆	☆		☆
	0.05	.002	4	.157		**MABR 3 005**	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	0.10	.004	4	.157		**MABL 3 010**	☆		☆		☆		☆	☆		☆
	0.10	.004	4	.157		**MABR 3 010**	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	0.20	.008	4	.157		**MABL 3 020**	☆		☆		☆		☆	☆		☆
	0.20	.008	4	.157		**MABR 3 020**	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
							P25	P15	M25	M15	N25	N15	N20	S25	S15	S15

[1] To correspond with seat size on holder.

R = Right hand, L = Left hand

★= First choice

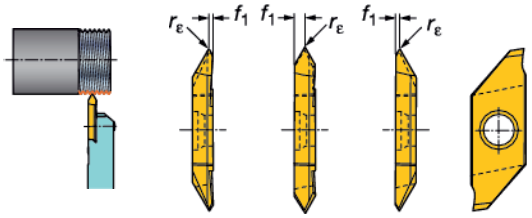
 B94
 B136
 B146
 B2

CoroCut® XS inserts

Threading

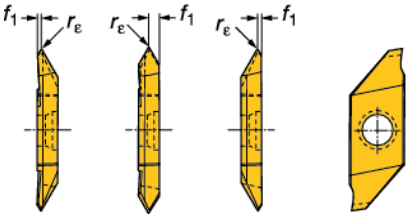
V-profile 60°

MATR Right hand cutting insert



-C -N -A

MATL Left hand cutting insert



-C -N -A

Tolerances, mm (inch):

r_ε	±0.02 (±.0008)
Repeatability	±0.025 (±.001)
Center height:	±0.025 (±.001)

	Selection criteria, millimeter, inch (mm, in.)		Pitch range, mm				Dimensions, millimeter, inch (mm, in.)		P	M		N			S	
									GC	GC	GC	GC	-		GC	GC
	r_ε mm	r_ε in.	min	max	Insert seat size[1]	Ordering code	f_1 mm	f_1 inch	1025	1025	1105	1025	H13A		1025	1105
 MAT	0.05	.002	0.2	1	3	MATR/L 3 60-A	0.6	.024	☆	☆		☆	☆		☆	
	0.05	.002	0.2	1		MATR/L 3 60-C	0.6	.024	☆	☆		☆	☆		☆	
	0.05	.002	0.2	2		MATR/L 3 60-N	1.59	.063	☆	☆	☆	☆	☆		☆	☆
									P25	M25	M15	N25	N20		S25	S15

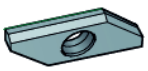
[1] To correspond with seat size on holder.

R = Right hand, L = Left hand

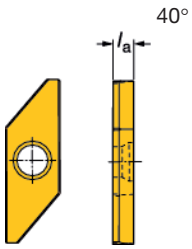
CoroCut® XS

Blanks

MAXR/L



MAX



Tolerances, mm (inch):

l_a	±0.02 (±.0008)
r_ε	±0.03 (±.001)
Repeatability	±0.03 (±.001)
Center height:	±0.03 (±.001)

For grinding instructions, see Metalcutting Technical guide.

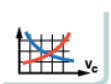
Right hand style shown

Insert seat size[1]	Ordering code	Dimensions, millimeter, inch (mm, in.) l_a mm	l_a in.	- H10F
3	MAXR/L 3 300	3.18	.125	★

[1] To correspond with seat size on holder.

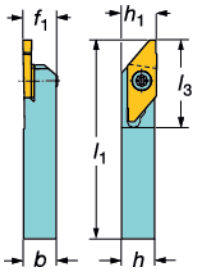
R = Right hand, L = Left hand

Note: Precaution should be taken when grinding cemented carbide products. See page J7 for safety information.

 B94
 B136
 B146
 B2

CoroCut® XS shank holders

SMALR/L



Right hand tools use right hand inserts. Insert screw accessible from both sides.

Right hand style shown

Metric version

Seat size[1]	Ordering code	Dimensions b	f_1	h	h_1	l_1	l_3	Gauge inserts	Nm[2]
3	SMALR/L 1010K 3	10	10	10	10	125	27	MAxL 3..	1.2
	SMALR/L 1212K 3	12	12	12	12	125	27	MAxL 3..	1.2
	SMALR/L 1616K 3	16	16	16	16	125	27	MAxL 3..	1.2

Inch version

Seat size[1]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[3]
3	SMALR/L 08C3	.500	.500	.500	.500	5.000	1.063	MAxL 3..	0.9
	SMALR/L 10C3	.625	.625	.625	.625	5.000	1.063	MAxL 3..	0.9

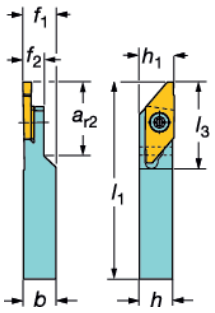
1) To correspond with seat size on holder.
2) Insert tightening torque, Nm. Use torque wrench, see page B110.
3) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

CoroCut® XS shank holders

Cut off holder for sub-spindle

SMALR-X



Shank holders for QS-holding system, see page A230.

Right hand style shown

Metric version

Seat size[1]	Ordering code	Dimensions a_{r2} max	b	f_1	f_2	h	h_1	l_1	l_3	Gauge inserts	Nm[2]
	SMALR 1010K 3-X	20	10	10	7.5	10	10	125	27	MAxR 3..	1.2
	SMALR 1212K 3-X	20	12	12	7.5	12	12	125	27	MAxR 3..	1.2

Inch version

Seat size[1]	Ordering code	Dimensions, inch a_{r2} max	b	f_1	h	h_1	l_1	l_3	Gauge inserts	ft-lbs[3]
	SMALR 08C 3-X	.031	.500	.500	.500	.500	5.000	1.063	MAxR 3..	0.9

1) To correspond with seat size on holder.
2) Insert tightening torque, Nm. Use torque wrench, see page B110.
3) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

R = Right hand, L = Left hand

Main spare parts

Holder type	Screw	Key (Torx Plus)
SMALR C3/K3	5513 027-01	5680 046-01 (8IP)
SMALR C3-X/K3-X	5513 027-02	5680 046-01 (8IP)

 B90

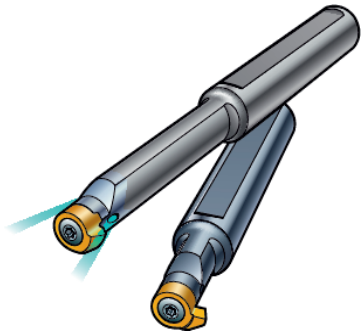
 G6

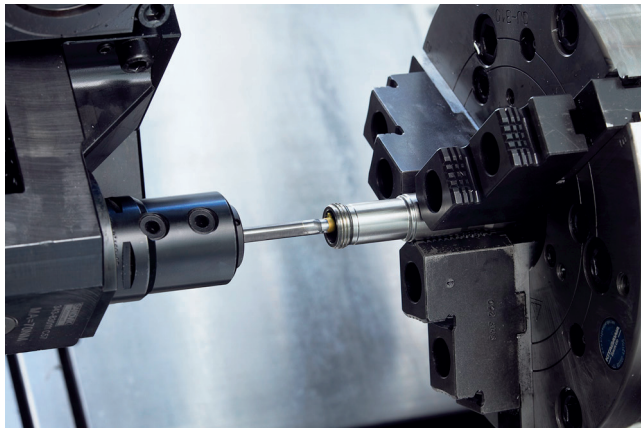
 J2

CoroCut® MB

A system for machining of high precision components

Grooving, threading and turning from 10 mm (.394 inch)
Face grooving from 12 mm (.472 inch)





CoroCut® MB boring bars

To increase stability and accessibility, the bars are designed with an eccentric head with oval cross section.

Bars are available in two designs:
- Steel shank bars for overhang up to 1 x bar diameter
- Carbide shank bars for overhang up to 5.5 x bar diameter

CoroCut MB external tool holders

- Face grooving down to 12 mm (.472 inch) curve diameter
- Radial grooving
- Circlip grooving

Clamping of bars

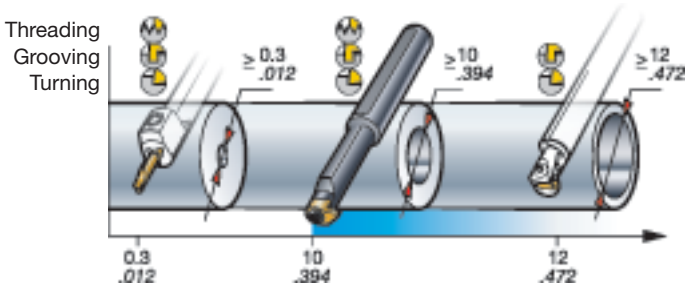
- EasyFix clamping for best stability and accuracy
- Conventional bars with flats

For accurate machining with less vibrations and precise center height of the insert, use cylindrical bars with EasyFix sleeves.

CoroCut® MB

A system for internal machining of high precision components

CoroTurn® XS boring bars | **CoroCut® MB boring bars** | **T-Max Q-Cut® and CoroCut® boring bars**



Min hole diameter, mm , inch

CoroCut® MB inserts

Application	Size 07	Size 09
	Min hole 10 mm (.394 inch)	Min hole 14 mm (.551 inch)
Grooving		
Turning		—
Threading		—
Face grooving	—	

Insert for turning/back boring

MB	–	07	T	093	–	02	–	10	R
1		2	3	4		5		9	12

Insert for grooving/pre-parting

MB	–	07	G	070	–	00	–	10	R
1		2	3	6		5		9	12

Insert for threading

MB	–	07	TH	050	VM	–	10	R
1		2	3	7	8		9	12

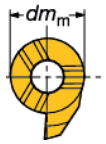
Boring bars

MB	–	A	16	–	16	–	07	R
1		13	14		10		2	15

1 Main code

MB = CoroCut® MB

2 Insert size, mm (inch)



07 = 7 mm (.276 inch)
09 = 9 mm (.354 inch)

3 Type of operation

B = Back boring
G = Grooving
GX = Pre-parting
R = Profiling full radius
T = Turning
TE = Turning, copying, extended l_1 dimension
TH = Threading
FA = Face grooving A-sweep
FB = Face grooving B-sweep

4 Entering angle (Turning)

E.g.: 093 = 93°

5 Nose radius, r_ε (Turning)

E.g.: 00 = Sharp
02 = 0.2 mm (.008 inch)

6 Insert width, l_a inch (Grooving)

E.g.: 100 = 1.00 mm (.039 inch)

7 Pitch (Threading)

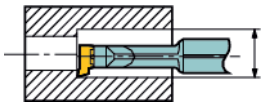
mm: pitch x 100

inch: No. of threads per inch x 10 (TPI)

8 Thread profile (Threading)

V = V profile 60°
M = Metric 60°
W = Whitworth 55°
U = UN 60°
NT = NPT 60°
AC = ACME 29°
SA = STUB-ACME

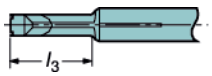
9 Min bore diameter, D_m min. (Insert)



min. hole

E.g.: 10 = 10 mm (.394 inch)

10 Penetration depth, l_3 (boring bar)



Inch, e.g.: e.g.: 06 = .630 inch
08 = .787 inch
12 = 1.260 inch

Metric, e.g.: 16 = 16 mm

12 Hand of insert

R = Right hand style

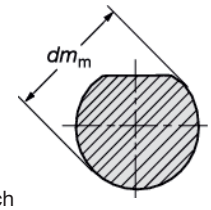
L = Left hand style

13 Type of bar

A = Steel bar with internal coolant supply

E = Carbide shank bar

14 Bar dia, dm_m inch



Inch
0625 = .625 inch
Metric
16 = 16 mm

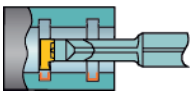
15 Shank type

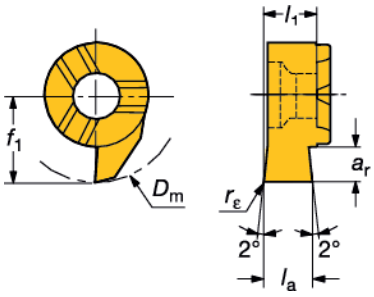
R = Cylindrical

No symbol = With flats

CoroCut® MB inserts

Grooving





Right hand style shown

For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a: +0.05 (+.002/- 0)
r_ε ±0.02 (±.0008)
l_1: ±0.02 (± 0008)
Center height:
+0.05 (+.002/-0)

Tolerances, mm (inch):
For circlip grooves
l_a: + 0.03 (.0012 / - 0)
l_1: ± 0.02 (.0008)
Center height:
+ 0.05 (.002)
- 0

	Selection criteria, millimeter, inch (mm, in.)				Insert size[1]		Dimensions, millimeter, inch (mm, in.)								P	M	N	S	H
															GC	GC	GC	GC	GC
	l_a mm	l_a in.	a_r max mm	a_r max in.	dm_m	Ordering code	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	r_ε mm	r_ε in.	1025	1025	1025	1025	1025
 MB-..G	1.00	.039	1.8	.071	07	MB-07G100-00-10R/L	10	.394	5.8	.228	3.9	.154	0	0	★	★	★	★	
	1.50	.059	1.8	.071		MB-07G150-00-10R/L	10	.394	5.8	.228	3.9	.154	0	0	★	★	★	★	
	2.00	.079	1.8	.071		MB-07G200-00-10R/L	10	.394	5.8	.228	3.9	.154	0	0	★	★	★	★	
	2.50	.098	1.8	.071		MB-07G250-00-10R/L	10	.394	5.8	.228	3.9	.154	0	0	★	★	★	★	
	3.00	.118	1.8	.071		MB-07G300-00-10R/L	10	.394	5.8	.228	3.9	.154	0	0	★	★	★	★	
	3.18	.125	1.8	.071		MB-07G318-00-10R/L	10	.394	5.8	.228	3.9	.154	0	0	★	★	★	★	
	1.00	.039	2.8	.110	07	MB-07G100-00-11R/L	11	.433	6.8	.268	3.9	.154	0	0	★	★	★	★	
	1.50	.059	2.8	.110		MB-07G150-00-11R/L	11	.433	6.8	.268	3.9	.154	0	0	★	★	★	★	
	2.00	.079	2.8	.110		MB-07G200-00-11R/L	11	.433	6.8	.268	3.9	.154	0	0	★	★	★	★	
	2.50	.098	2.8	.110		MB-07G250-00-11R/L	11	.433	6.8	.268	3.9	.154	0	0	★	★	★	★	
	3.00	.118	2.8	.110		MB-07G300-00-11R/L	11	.433	6.8	.268	3.9	.154	0	0	★	★	★	★	
	3.18	.125	2.8	.110		MB-07G318-00-11R/L	11	.433	6.8	.268	3.9	.154	0	0	★	★	★	★	
	1.00	.039	3.4	.134	07	MB-07G100-00-12R/L	12	.472	7.4	.291	3.9	.154	0	0	★	★	★	★	
	1.50	.059	3.4	.134		MB-07G150-00-12R/L	12	.472	7.4	.291	3.9	.154	0	0	★	★	★	★	
	2.00	.079	3.4	.134		MB-07G200-00-12R/L	12	.472	7.4	.291	3.9	.154	0	0	★	★	★	★	
	1.50	.059	4	.157	09	MB-09G150-00-14R/L	14	.551	9	.354	5.3	.209	0	0	★	★	★	★	
	2.00	.079	4	.157		MB-09G200-00-14R/L	14	.551	9	.354	5.3	.209	0	0	★	★	★	★	
	2.00	.079	4	.157		MB-09G200-02-14R/L	14	.551	9	.354	5.3	.209	0.2	.008	★	★	★	★	
	2.50	.098	4	.157		MB-09G250-00-14R/L	14	.551	9	.354	5.3	.209	0	0	★	★	★	★	
	3.00	.118	4	.157		MB-09G300-00-14R/L	14	.551	9	.354	5.3	.209	0	0	★	★	★	★	
	1.50	.059	5.5	.216	09	MB-09G150-00-16R/L	16	.630	10.5	.413	5.2	.205	0	0	★	★	★	★	
	2.00	.079	5.5	.216		MB-09G200-00-16R/L	16	.630	10.5	.413	5.2	.205	0	0	★	★	★	★	
	2.00	.079	5.5	.216		MB-09G200-02-16R/L	16	.630	10.5	.413	5.2	.205	0.2	.008	★	★	★	★	
	2.50	.098	5.5	.216		MB-09G250-00-16R/L	16	.630	10.5	.413	5.2	.205	0	0	★	★	★	★	
	2.50	.098	5.5	.216		MB-09G250-02-16R/L	16	.630	10.5	.413	5.2	.205	0.2	.008	★	★	★	★	
	3.00	.118	5.5	.216		MB-09G300-00-16R/L	16	.630	10.5	.413	5.2	.205	0	0	★	★	★	★	
	3.00	.118	5.5	.216		MB-09G300-02-16R/L	16	.630	10.5	.413	5.2	.205	0.2	.008	★	★	★	★	
	1.50	.059	6.5	.256	09	MB-09G150-00-17R/L	17	.669	11.5	.453	5.2	.205	0	0	★	★	★	★	
	2.00	.079	6.5	.256		MB-09G200-00-17R/L	17	.669	11.5	.453	5.2	.205	0	0	★	★	★	★	
	2.50	.098	6.5	.256		MB-09G250-00-17R/L	17	.669	11.5	.453	5.2	.205	0	0	★	★	★	★	
	3.00	.118	6.5	.256		MB-09G300-00-17R/L	17	.669	11.5	.453	5.2	.205	0	0	★	★	★	★	
	For circlip grooves																		
	0.73	.029	1.2	.047	07	MB-07G070-00-10R/L	10	.394	5.8	.228	3.8	.150	0	0	★	★	★	★	
	0.83	.033	1.3	.051		MB-07G080-00-10R/L	10	.394	5.8	.228	3.8	.150	0	0	★	★	★	★	
	0.93	.037	1.5	.059		MB-07G090-00-10R/L	10	.394	5.8	.228	3.8	.150	0	0	★	★	★	★	
	1.20	.047	1.8	.071		MB-07G120-00-10R/L	10	.394	5.8	.228	3.9	.154	0	0	★	★	★	★	
	1.40	.055	1.8	.071		MB-07G140-00-10R/L	10	.394	5.8	.228	3.9	.154	0	0	★	★	★	★	
	1.70	.067	1.8	.071		MB-07G170-00-10R/L	10	.394	5.8	.228	3.9	.154	0	0	★	★	★	★	
	0.73	.029	1.2	.047	09	MB-09G070-00-14R/L	14	.551	9	.354	5.2	.205	0	0	★	★	★	★	
	0.83	.033	1.3	.051		MB-09G080-00-14R/L	14	.551	9	.354	5.2	.205	0	0	★	★	★	★	
	0.93	.037	1.5	.059		MB-09G090-00-14R/L	14	.551	9	.354	5.2	.205	0	0	★	★	★	★	
	1.20	.047	4	.157		MB-09G120-00-14R/L	14	.551	9	.354	5.3	.209	0	0	★	★	★	★	
	1.40	.055	4	.157		MB-09G140-00-14R/L	14	.551	9	.354	5.3	.209	0	0	★	★	★	★	
	1.70	.067	4	.157		MB-09G170-00-14R/L	14	.551	9	.354	5.3	.209	0	0	★	★	★	★	
															P25	M25	N25	S25	

[1] To correspond to insert size on holder

R = Right hand, L = Left hand

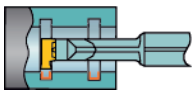
★= First choice

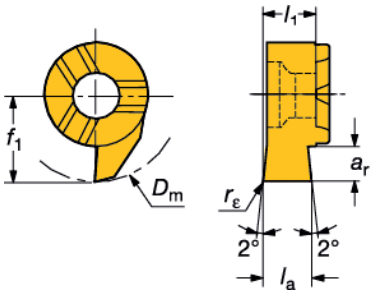
B107 B137 B146 B2

CoroCut® MB inserts

Grooving

For hardened materials





Right hand style shown

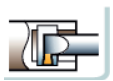
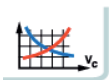
For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_a: +0.05/-0 (+.002/-0)
l_1: ±0.02 (±.0008)
Center height:
+0.05/-0 (+.002/-0)
-0

	Selection criteria, millimeter, inch (mm, in.)				Insert size[1]		Dimensions, millimeter, inch (mm, in.)								H CB 7015
	l_a mm	l_a in.	a_r max mm	a_r max in.	dm_m	Ordering code	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	r_ε mm	r_ε in.	
 MB-..G	1.00	.039	2.8	.110	07	MB-07G100-00-11R	11	.433	6.8	.268	3.9	.154	0	0	★
	1.50	.059	2.8	.110		MB-07G150-00-11R	11	.433	6.8	.268	3.9	.154	0	0	★
															H15

[1] To correspond to insert size on holder

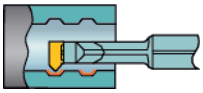
R = Right hand, L = Left hand
★= First choice

 B107
 B137
 B146
 B2

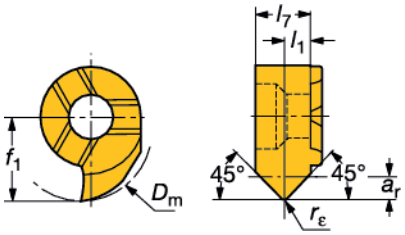
CoroCut® MB inserts

Turning and turning/copying

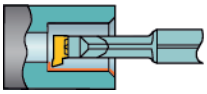
Entering angle 45°
Lead angle 45°



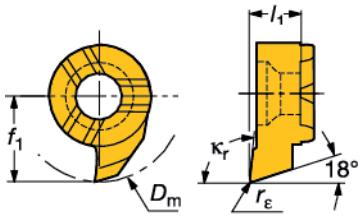
MB-07T 045 Turning/profiling



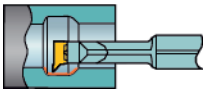
Entering angle 93°
Lead angle -3°



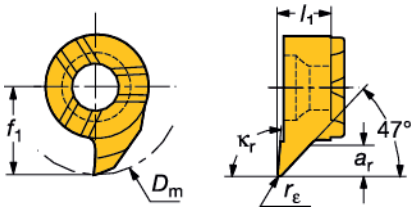
MB-07T 93 Turning



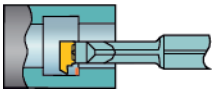
Entering angle 93°
Lead angle -3°



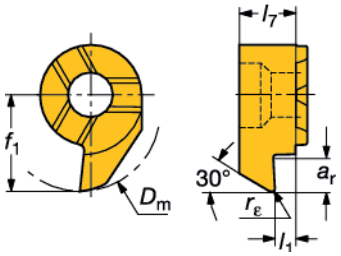
MB-07TE 93 Copying



Entering angle 90°
Lead angle 0°



MB-07B Back boring



Tolerances, mm (inch):
l_a: +0.05 (+.002)
r_ε: ±0.02 (±.0008)
l_1: ±0.02 (±.0008)
Center height:
+0.05/-0 (+.002/-0)

Entering angle

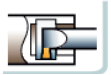
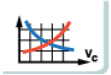
For ISO application areas, see bottom of the table.

Right hand style shown

	Selection criteria, millimeter, inch (mm, in.)				Insert size[2]		Dimensions, millimeter, inch (mm, in.)								P	M	N	S
															GC	GC	GC	GC
	r_ε mm	r_ε in.	a_r max mm	a_r max in.	dm_m	Ordering code	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	l_7 mm	l_7 in.	1025	1025	1025	1025
 MB-..T045	0.20	.008	1.50	.059	07	MB-07T045-02-10R/L	10	.394	5.80	.228	2.00	.079	4.00	.157	☆	☆	☆	☆
 MB-..T093	0.20	.008	1.80	.071	07	MB-07T093-02-10L	10	.394	5.60	.220	3.90	.154			☆	☆	☆	☆
	0.20	.008	1.80	.071		MB-07T093-02-10R	10	.394	5.60	.220	3.90	.154			☆	☆	☆	☆
 MB-..TE93	0.20	.008	1.80	.071	07	MB-07TE93-02-10R/L[2]	10	.394	5.80	.220	3.90	.154			☆	☆	☆	☆
 MB-..B	0.20	.008	2.60	.102	07	MB-07B030-02-11R/L	11	.433	6.80	.268	1.30	.051	4.00	.157	☆	☆	☆	☆
															P25	M25	N25	S25

[1] To correspond to insert size on holder
[2] Insert with extended f_1 dimension

R = Right hand, L = Left hand
★= First choice

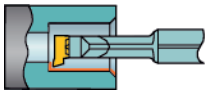
 B107
 B137
 B146
 B2

CoroCut® MB inserts

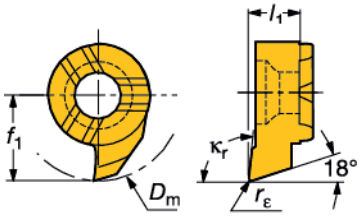
Turning

For hardened materials

Entering angle κ_r 93°
Lead angle -3°



MB-07T 93 Turning



For ISO application areas, see bottom of the table.

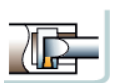
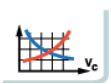
Tolerances, mm (inch):
r_ε= ±0.02 (±.0008)
l_1= ±0.02 (±.0008)
Center height:
+0.05/-0 (+.002 /-0)

Right hand style shown

	Selection criteria, millimeter, inch (mm, in.)				Insert size[1]		Dimensions, millimeter, inch (mm, in.)						H CB 7015
	r_ε mm	r_ε in.	a_r max mm	a_r max in.	dm_m	Ordering code	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	
 MB-..T093	0.20	.008	1.80	.071	07	MB-07T093-02-10R	10.00	.394	5.60	.220	3.90	.154	☆
													H15

[1] To correspond with insert size on holder.

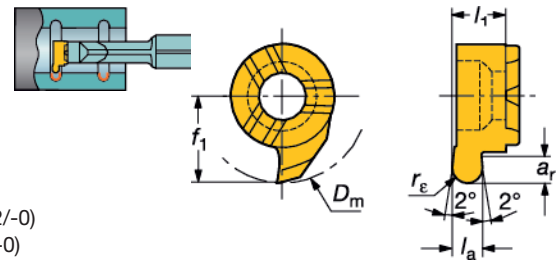
R = Right hand, L = Left hand
★= First choice

 B107
 B137
 B146
 B2

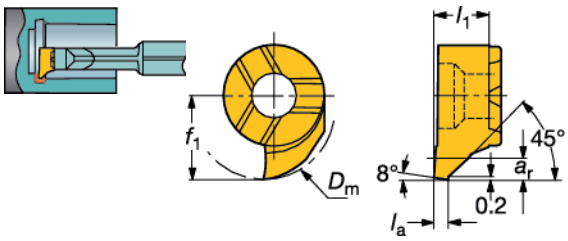
CoroCut® MB inserts

Profiling and pre-parting

MB-07R Profiling



MB-07GX Pre-parting



Tolerances, mm
l_a +0.05/-0 (+.002/-0)
r_ε ±0.02 (±.0008/-0)
l_1 ±0.02 (±.0008)
Center height:
+0.05/-0 (+.002/-0)

For ISO application areas, see bottom of the table.
Right hand style shown

	Selection criteria, millimeter, inch (mm, in.)						Insert size[1]		Dimensions, millimeter, inch (mm, in.)						P	M	N	S
															GC	GC	GC	GC
	l_a mm	l_a in.	r_ε mm	r_ε in.	a_r max mm	a_r max in.	dm_m	Ordering code	D_m min, mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	1025	1025	1025	1025
 MB-..R	0.80	.032	0.40	.016	1.80	.071	07	MB-07R080-04-10R/L	10	.394	5.80	.228	3.90	.154	★	★	★	★
	1.20	.047	0.60	.024	1.80	.071		MB-07R120-06-10R/L	10	.394	5.80	.228	3.90	.154	★	★	★	★
	1.80	.071	0.90	.035	1.80	.071		MB-07R180-09-10R/L	10	.394	5.80	.228	3.90	.154	★	★	★	★
	2.00	.079	1.00	.039	1.80	.071		MB-07R200-10-10R/L	10	.394	5.80	.228	3.90	.154	★	★	★	★
	0.80	.032	0.40	.016	4.00	.157	09	MB-09R080-04-14R/L	14	.551	9.00	.354	5.20	.205	★	★	★	★
	1.20	.047	0.60	.024	4.00	.157		MB-09R120-06-14R/L	14	.551	9.00	.354	5.30	.209	★	★	★	★
	1.80	.071	0.90	.035	4.00	.157		MB-09R180-09-14R/L	14	.551	9.00	.354	5.30	.209	★	★	★	★
	2.00	.079	1.00	.039	4.00	.157		MB-09R200-10-14R/L	14	.551	9.00	.354	5.30	.209	★	★	★	★
	2.20	.087	1.10	.043	4.00	.157		MB-09R220-11-14R/L	14	.551	9.00	.354	5.30	.209	★	★	★	★
	3.00	.118	1.50	.059	4.00	.157		MB-09R300-15-14R/L	14	.551	9.00	.354	5.30	.209	★	★	★	★
 MB-..GX	1.00	.039			1.50	.059	07	MB-07GX100-00-10R/L	10	.394	5.80	.228	3.90	.154	★	★	★	★
															P25	M25	N25	S25

[1] To correspond to insert size on holder

R = Right hand, L = Left hand
★= First choice

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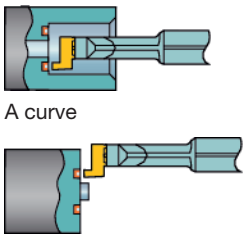
CoroCut® MB inserts

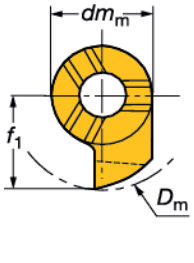
Face grooving

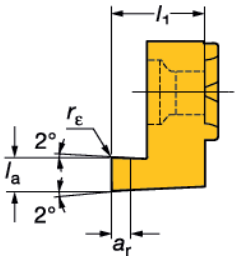
MB-09FA A-curve



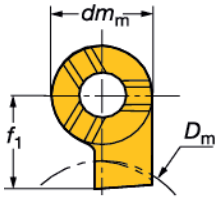
A curve

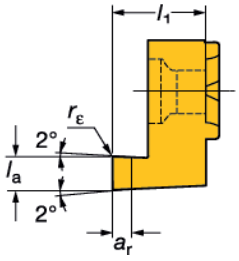
B curve





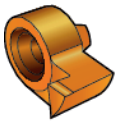
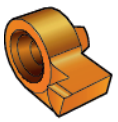
MB-09FB B-curve





Tolerances, mm (inch):
l_a = +0.05/-0 (+.002/-0)
r_ε = ±0.02 (±.0008)
l_1 = ±0.02 (±.0008)
Center height:
+0.05/-0 (+.002/- 0)

For ISO application areas, see bottom of the table.
Right hand style shown

	Selection criteria, millimeter, inch (mm, in.)								Insert size[1]		Dimensions, millimeter, inch (mm, in.)				P	M	N	S
	l_a mm	l_a in.	r_ε mm	r_ε in.	D_m min mm	D_m min in.	a_r max mm	a_r max in.	dm_m	Ordering code	f_1 mm	f_1 in.	l_1 mm	l_1 in.	GC 1025	GC 1025	GC 1025	GC 1025
 MB-FA	1.000	.039	0	.000	14	.551	1.5	.059	09	MB-09FA100-00-14R/L	9	.354	8.3	.327	★	★	★	★
	1.500	.059	0.2	.008	14	.551	2.5	.098		MB-09FA150-02-14R/L	9	.354	8.3	.327	★	★	★	★
	2.000	.079	0.2	.008	14	.551	5	.197		MB-09FA200-02-14R/L	9	.354	10.3	.406	★	★	★	★
	2.500	.098	0.2	.008	14	.551	5	.197		MB-09FA250-02-14R/L	9	.354	10.3	.406	★	★	★	★
	3.000	.118	0.2	.008	14	.551	5	.197		MB-09FA300-02-14R/L	9	.354	10.3	.406	★	★	★	★
 MB-FB	1.000	.039	0	.000	12	.472	1.5	.059	09	MB-09FB100-00-14R/L	7	.276	8.3	.327	★	★	★	★
	1.500	.059	0.2	.008	12	.472	2.5	.098		MB-09FB150-02-14R/L	7.5	.295	8.3	.327	★	★	★	★
	2.000	.079	0.2	.008	12	.472	5	.197		MB-09FB200-02-14R/L	8	.315	10.3	.406	★	★	★	★
	2.500	.098	0.2	.008	12	.472	5	.197		MB-09FB250-02-14R/L	8.5	.335	10.3	.406	★	★	★	★
	3.000	.118	0.2	.008	12	.472	5	.197		MB-09FB300-02-14R/L	9	.354	10.3	.406	★	★	★	★
															P25	M25	N25	S25

[1] To correspond to insert size on holder

N = Neutral, R = Right hand, L = Left hand
★= First choice

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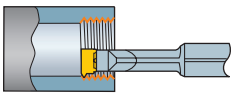
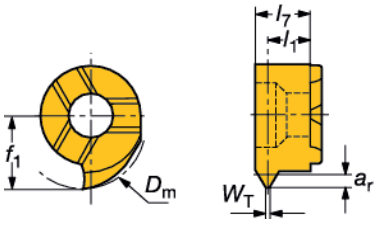
CoroCut® MB inserts

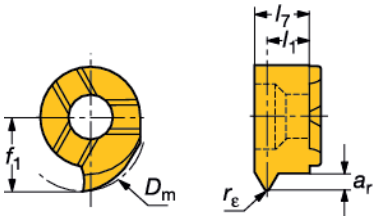
Threading



Metric 60°
UN 60°
V-profile 60°
NPT 60°

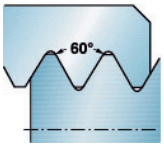
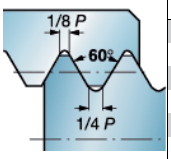
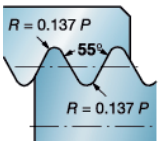
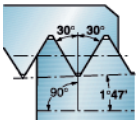


Whitworth 55°



Tolerances, mm (inch):
l_a +0.05/-0 (+.002/-0)
r_ε ±0.02 (±.0008)
l_1 ±0.02 (±.0008)
Center height:
+0.05/-0 (+.002/-0)

For ISO application areas, see bottom of the table.
Right hand style shown

	Insert size[1]	Pitch, mm			Pitch, TPI				Dimensions, millimeter, inch (mm, in.)												P		M		N		S	
																					GC	GC	GC	GC	GC	GC	GC	GC
	dm_m	mm	min	max	TPI	min	max	Ordering code	a_r max mm	a_r max in.	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	l_7 mm	l_7 in.	W_T mm	W_T in.	1025		1025		1025		1025	
								V profile 60°																				
	07		0.5	0.75	32			MB-07TH050VM-10R/L	0.41	.016	10	.394	5.8	.228	3.4	.134	3.8	.150	0.06	.002	☆	☆	☆	☆	☆	☆	☆	☆
			1	1.25		24	28	MB-07TH100VM-10R/L	0.55	.022	10	.394	5.8	.228	3.2	.126	3.8	.150	0.12	.005	☆	☆	☆	☆	☆	☆	☆	☆
			1.5	1.75		16	20	MB-07TH150VM-10R/L	0.81	.032	10	.394	5.8	.228	3	.118	3.8	.150	0.18	.007	☆	☆	☆	☆	☆	☆	☆	☆
			2	2.25		12	14	MB-07TH200VM-10R/L	1.08	.042	10	.394	5.8	.228	2.7	.108	3.8	.150	0.25	.010	☆	☆	☆	☆	☆	☆	☆	☆
		2.5				10	11	MB-07TH250VM-10R/L	1.35	.053	10	.394	5.8	.228	2.5	.100	3.8	.150	0.31	.012	☆	☆	☆	☆	☆	☆	☆	☆
								Metric 60°																				
	07	0.5						MB-07TH050MM-10R/L	0.27	.011	10	.394	5.8	.228	3.4	.134	3.8	.150	0.06	.002	☆	☆	☆	☆	☆	☆	☆	☆
		1.0						MB-07TH100MM-10L	0.54	.021	10	.394	5.8	.228	3.2	.126	3.8	.150	0.12	.005	☆	☆	☆	☆	☆	☆	☆	☆
		1.0						MB-07TH100MM-10R	0.54	.021	10	.394	5.8	.228	3.2	.126	3.8	.150	0.12	.005	☆	☆	☆	☆	☆	☆	☆	☆
		1.5						MB-07TH150MM-10L	0.81	.032	10	.394	5.8	.228	3	.118	3.8	.150	0.18	.007	☆	☆	☆	☆	☆	☆	☆	☆
		1.5						MB-07TH150MM-10R	0.81	.032	10	.394	5.8	.228	3	.118	3.8	.150	0.18	.007	☆	☆	☆	☆	☆	☆	☆	☆
		1.8						MB-07TH175MM-10R/L	0.95	.037	10	.394	5.8	.228	2.9	.114	3.8	.150	0.21	.008	☆	☆	☆	☆	☆	☆	☆	☆
		2.0						MB-07TH200MM-10R/L	1.08	.042	10	.394	5.8	.228	2.7	.108	3.8	.150	0.25	.010	☆	☆	☆	☆	☆	☆	☆	☆
		2.5						MB-07TH250MM-10R/L	1.35	.053	10	.394	5.8	.228	2.5	.100	3.8	.150	0.31	.012	☆	☆	☆	☆	☆	☆	☆	☆
								UN 60°																				
	07				14			MB-07TH140UN-10R/L	0.98	.039	10	.394	5.8	.228	3.2	.126	3.9	.154	0.22	.009	☆	☆	☆	☆	☆	☆	☆	☆
					16			MB-07TH160UN-10R/L	0.86	.034	10	.394	5.8	.228	3.1	.122	3.9	.154	0.19	.008	☆	☆	☆	☆	☆	☆	☆	☆
					18			MB-07TH180UN-10R/L	0.76	.030	10	.394	5.8	.228	3.2	.126	3.9	.154	0.17	.007	☆	☆	☆	☆	☆	☆	☆	☆
					20			MB-07TH200UN-10R/L	0.68	.027	10	.394	5.8	.228	3.2	.126	3.9	.154	0.15	.006	☆	☆	☆	☆	☆	☆	☆	☆
					24			MB-07TH240UN-10R/L	0.57	.022	10	.394	5.8	.228	3.3	.130	3.9	.154	0.13	.005	☆	☆	☆	☆	☆	☆	☆	☆
					28			MB-07TH280UN-10R/L	0.49	.019	10	.394	5.8	.228	3.4	.134	3.9	.154	0.11	.004	☆	☆	☆	☆	☆	☆	☆	☆
					32			MB-07TH320UN-10R/L	0.42	.016	10	.394	5.8	.228	3.4	.134	3.9	.154	0.1	.004	☆	☆	☆	☆	☆	☆	☆	☆
								Whitworth 55°											r_ε mm	r_ε in.								
	07				11			MB-07TH110WH-10R/L	1.48	.058	10	.394	5.8	.228	2.3	.091	3.8	.150	0.31	.012	☆	☆	☆	☆	☆	☆	☆	☆
					14			MB-07TH140WH-10R/L	1.16	.046	10	.394	5.8	.228	2.6	.102	3.8	.150	0.24	.009	☆	☆	☆	☆	☆	☆	☆	☆
					19			MB-07TH190WH-10R/L	0.85	.034	10	.394	5.8	.228	2.8	.110	3.8	.150	0.18	.007	☆	☆	☆	☆	☆	☆	☆	☆
								NPT 60°											W_T mm	W_T in.								
	07				14			MB-07TH140NT-10R/L	1.48	.058	10	.394	5.8	.228	2.7	.106	3.8	.150	0.07	.003	☆	☆	☆	☆	☆	☆	☆	☆
					18			MB-07TH180NT-10R/L	1.19	.047	10	.394	5.8	.228	2.9	.114	3.8	.150	0.05	.002	☆	☆	☆	☆	☆	☆	☆	☆
																					P25		M25		N25		S25	

[1] To correspond to insert size on holder

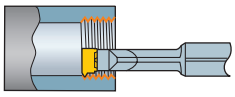
R = Right hand, L = Left hand
★= First choice

B107 B137 B146 B2

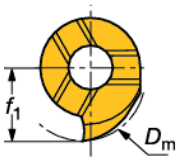
CoroCut® MB inserts

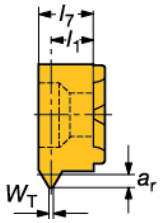
Threading

For hardened materials



Metric 60°

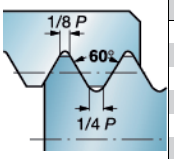




For ISO application areas, see bottom of the table.

Tolerances, mm (inch):
l_1 ±0.02 (±.0008)
Center height:
+0.05/-0 (+ .002/-0)

Right hand style shown

	Insert size[1] dm_m	Pitch mm	Ordering code	Dimensions, millimeter, inch (mm, in.) a_r max mm	a_r max in.	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	l_7 mm	l_7 in.	W_T mm	W_T in.	H CB 7015
			**Metric 60°**													
	07	1.0	**MB-07TH100MM-10R**	0.54	.021	10	.394	5.8	.228	3.2	.126	3.8	.150	0.12	.005	☆
		1.5	**MB-07TH150MM-10R**	0.81	.032	10	.394	5.8	.228	3	.118	3.8	.150	0.18	.007	☆
																H15

[1] To correspond with insert size on holder.

R = Right hand, L = Left hand

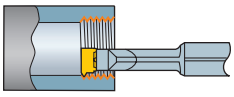
★= First choice

B107 B137 B146 B2

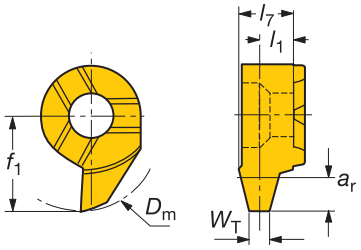
SANDVIK Coromant

CoroCut® MB inserts

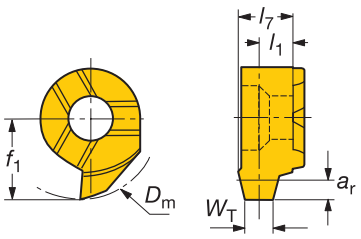
Threading



ACME 29°
Non-topping

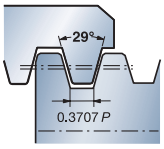
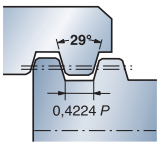


STUB-ACME 29°
Non-topping



Tolerances, mm (inch):
l_1 = ±0.02 (± .008)
Center height:
+0.05/-0 (+.002/-0)

For ISO application areas, see bottom of the table.
Right hand style shown

	Insert size[1]	Pitch, TPI		Dimensions, millimeter, inch (mm, in.)												P	M	N	S
																GC	GC	GC	GC
	dm_m	TPI	Ordering code	a_r max mm	a_r max in.	D_m min mm	D_m min in.	f_1 mm	f_1 in.	l_1 mm	l_1 in.	l_7 mm	l_7 in.	W_T mm	W_T in.	1025	1025	1025	1025
			**Acme 29°**																
	07	8	**MB-07TH080AC-11R**	1.87	.074	11	.433	6.8	.268	2.8	.110	3.9	.154	1.03	.041	☆	☆	☆	☆
		10	**MB-07TH100AC-11R**	1.54	.061	11	.433	6.8	.268	3	.118	3.9	.154	0.8	.032	☆	☆	☆	☆
		12	**MB-07TH120AC-11R**	1.2	.047	11	.433	6.8	.268	3.1	.122	3.9	.154	0.71	.028	☆	☆	☆	☆
		14	**MB-07TH140AC-11R**	1.05	.041	11	.433	6.8	.268	3.2	.126	3.9	.154	0.6	.024	☆	☆	☆	☆
		16	**MB-07TH160AC-11R**	0.93	.037	11	.433	6.8	.268	3.3	.130	3.9	.154	0.52	.020	☆	☆	☆	☆
			**STUB-Acme 29°**																
	07	8	**MB-07TH080SA-10R**	1.24	.049	10	.394	5.8	.228	2.45	.096	3.72	.146	1.19	.047	☆	☆	☆	☆
		10	**MB-07TH100SA-10R**	1.04	.041	10	.394	5.8	.228	3.05	.120	3.9	.154	0.93	.037	☆	☆	☆	☆
		12	**MB-07TH120SA-10R**	0.78	.031	10	.394	5.8	.228	3.2	.126	3.9	.154	0.82	.032	☆	☆	☆	☆
		14	**MB-07TH140SA-10R**	0.69	.027	10	.394	5.8	.228	3.25	.128	3.9	.154	0.69	.027	☆	☆	☆	☆
		16	**MB-07TH160SA-10R**	0.63	.025	10	.394	5.8	.228	3.35	.132	3.9	.154	0.59	.023	☆	☆	☆	☆
																P25	M25	N25	S25

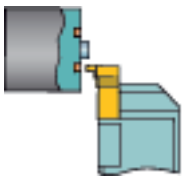
[1] To correspond to insert size on holder

R = Right hand, L = Left hand
★= First choice

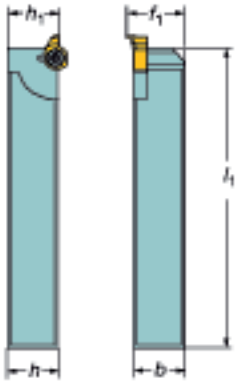
B107 B137 B146 B2

CoroCut® MB

Shank holders for external machining



MB-G



Metric version

Insert size[1]	Ordering code	Dimensions b	f_1	h	h_1	l_1	Gauge inserts	Nm[2]
09	**MBG-1212-09R/L**	12	15.1	12	12	100	MB-09FB150-xx-xxx	3.0
	MBG-1616-09R/L	16	19.1	16	16	120	MB-09FB150-xx-xxx	3.0
	MBG-2020-09R/L	20	23.1	20	20	120	MB-09FB150-xx-xxx	3.0
	MBG-2525-09R/L	25	28.1	25	25	150	MB-09FB150-xx-xxx	3.0

Inch version

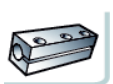
Insert size[1]	Ordering code	Dimensions, inch b	f_1	h	h_1	l_1	Gauge inserts	ft-lbs[3]
09	**MBG-08A-09R/L**	.500	.622	.500	.500	3.937	MB-09FB150-xx-xxx	2.2
	MBG-10C-09R/L	.625	.747	.625	.625	4.724	MB-09FB150-xx-xxx	2.2
	MBG-12C-09R/L	.750	.872	.750	.750	4.724	MB-09FB150-xx-xxx	2.2
	MBG-16D-09R/L	1.000	1.122	1.000	1.000	5.906	MB-09FB150-xx-xxx	2.2

1) To correspond to insert size on holder
2) Insert tightening torque, Nm. Use torque wrench, see page B110.
3) Insert tightening torque, ft-lbs. Use torque wrench, see page B110.

General minimum hole depends on insert; see respective insert ordering page.

Main spare parts

Insert size	Insert screw	Key (Torx Plus)
09	5513 039-02	5680 049-01 (15IP)

 B97
 G6
 A304
 J2

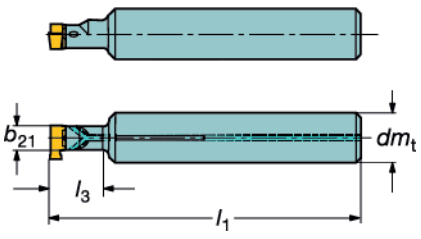
CoroCut® MB

Boring bars

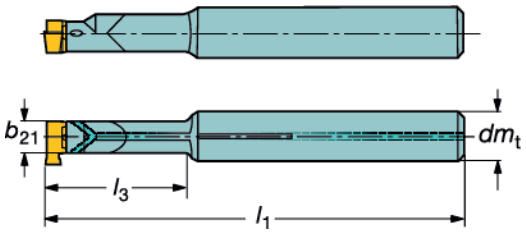
Cylindrical

With groove for EasyFix sleeve

MB-A
Steel shank



MB-E
Carbide shank



All with internal coolant supply

Metric version

Bar dia. dm_t	Insert size[1]	Ordering code	Dimensions b_{21}	l_1	l_3	Gauge inserts	Nm[2]
12	07	MB-E12-24-07R	7.4	92	24	MB-07..	1.4
12		MB-E12-32-07R	7.4	100	32	MB-07..	1.4
12		MB-E12-48-07R	7.4	115	48	MB-07..	1.4
16		MB-A16-16-07R	7.4	97	16	MB-07..	1.4
12	09	MB-E12-34-09R	9.5	100	34	MB-09..	3
12		MB-E12-45-09R	9.5	110	45	MB-09..	3
12		MB-E12-64-09R	9.5	130	64	MB-09..	3
16		MB-A16-20-09R	9.5	100	20	MB-09..	3
16		MB-E16-34-09R	9.5	100	34	MB-09..	3
16		MB-E16-45-09R	9.5	110	45	MB-09..	3
16		MB-E16-64-09R	9.5	130	64	MB-09..	3

Inch version

Bar dia. dm_t	Insert size[1]	Ordering code	Dimensions, inch b_{21}	l_1	l_3	Gauge inserts	ft-lbs[2]
.500	07	MB-E0500-12-07R	.291	3.937	1.260	MB-07..	1.0
.500		MB-E0500-19-07R	.291	4.528	1.890	MB-07..	1.0
.625		MB-A0625-06-07R	.291	3.937	.630	MB-07..	1.0
.500	09	MB-E0500-13-09R	.374	3.937	1.339	MB-09..	2.2
.500		MB-E0500-17-09R	.374	4.331	1.772	MB-09..	2.2
.500		MB-E0500-25-09R	.374	5.118	2.520	MB-09..	2.2
.625		MB-A0625-08-09R	.374	3.937	.787	MB-09..	2.2
.625		MB-E0625-13-09R	.374	3.937	1.339	MB-09..	2.2
.625		MB-E0625-17-09R	.374	4.331	1.772	MB-09..	2.2
.625		MB-E0625-25-09R	.374	5.118	2.520	MB-09..	2.2

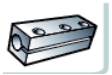
[1] To correspond to insert size on holder

[2] Insert tightening torque, Nm. Use torque wrench, see page B110.

General minimum hole depends on insert; see respective insert ordering page.

Main spare parts

Insert size	Insert screw	Key (Torx Plus)
07	5513 039-01	5680 051-03 (9IP)
09	5513 039-02	5680 049-01 (15IP)

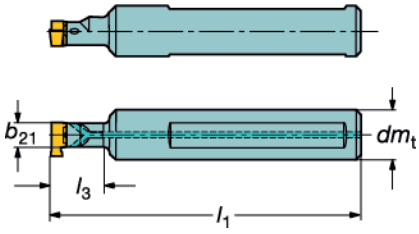
 B97
 G6
 A304
 J2

CoroCut® MB

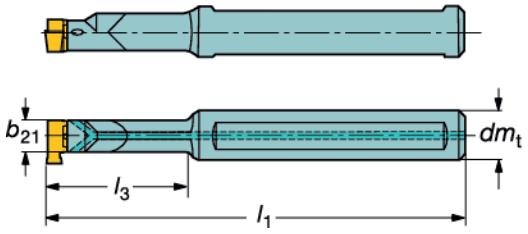
Carbide shank boring bars

Cylindrical with flat

MB-A
Steel shank



MB-E
Carbide shank



All with internal coolant supply

Metric version

Bar dia. dm_t	Insert size[1]	Ordering code	Dimensions b_{21}	l_1	l_3	Gauge inserts	Nm[2]
12	07	**MB-E12-24-07**	7.4	92	24	MB-07..	1.4
12		**MB-E12-32-07**	7.4	100	32	MB-07..	1.4
12		**MB-E12-48-07**	7.4	115	48	MB-07..	1.4
16		**MB-A16-16-07**	7.4	97	16	MB-07..	1.4
12	09	**MB-E12-34-09**	9.5	100	34	MB-09..	3
12		**MB-E12-45-09**	9.5	110	45	MB-09..	3
12		**MB-E12-64-09**	9.5	130	64	MB-09..	3
16		**MB-A16-20-09**	9.5	100	20	MB-09..	3
16		**MB-E16-34-09**	9.5	100	34	MB-09..	3
16		**MB-E16-45-09**	9.5	110	45	MB-09..	3
16		**MB-E16-64-09**	9.5	130	64	MB-09..	3

Inch version

Bar dia. dm_t	Insert size[1]	Ordering code	Dimensions, inch b_{21}	l_1	l_3	Gauge inserts	ft-lbs[2]
.500	07	**MB-E0500-12-07**	.291	3.937	1.260	MB-07..	1.0
.500		**MB-E0500-19-07**	.291	4.528	1.890	MB-07..	1.0
.625		**MB-A0625-06-07**	.291	3.937	.630	MB-07..	1.0
.500	09	**MB-E0500-17-09**	.374	4.331	1.772	MB-09..	2.2
.500		**MB-E0500-25-09**	.374	5.118	2.520	MB-09..	2.2
.625		**MB-A0625-08-09**	.374	3.937	.787	MB-09..	2.2
.625		**MB-E0625-25-09**	.374	5.118	2.520	MB-09..	2.2

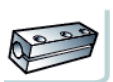
1) To correspond to insert size on holder

2) Insert tightening torque, Nm. Use torque wrench, see page B110.

General minimum hole depends on insert; see respective insert ordering page.

Main spare parts

Insert size	Insert screw	Key (Torx Plus)
07	5513 039-01	5680 051-03 (9IP)
09	5513 039-02	5680 049-01 (15IP)

 B97  G6  A304  J2

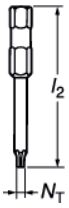
Torque wrenches for correct insert clamping

Information

To get the best performance out of our tools, especially in parting and grooving, it is of great importance to have the correct insert tightening torque.
In the Sandvik Coromant assortment, four metric and four inch torque wrenches, using bits for different Torx Plus sizes, are available.

Sizes -01, -02, -03, -04

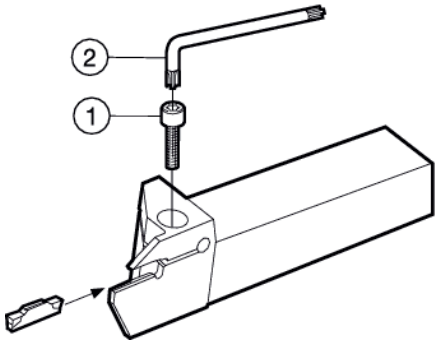
Sizes -05, -06, -07, -08

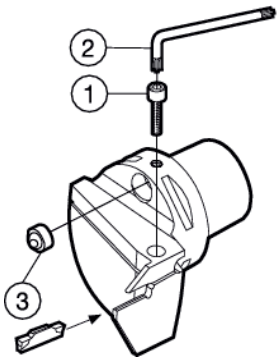


Torque wrench	Torque range Nm	In-lbs	Handle
5680 105-01	0.3 - 1.2		Straight
5680 105-02	1.2 - 3.0		Straight
5680 105-05	3.0 - 6.0		Angled
5680 105-06	4.0 - 8.8		Angled
5680 105-03		2.5 - 11.5	Straight
5680 105-04		11.0 - 26.0	Straight
5680 105-07		26.0 - 55.0	Angled
5680 105-08		35.4 - 78.0	Angled

Bit	l_2 mm	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

CoroCut® external screw clamp tools



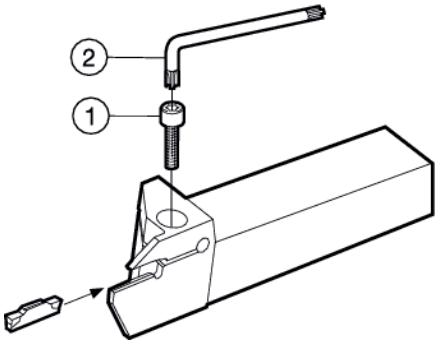


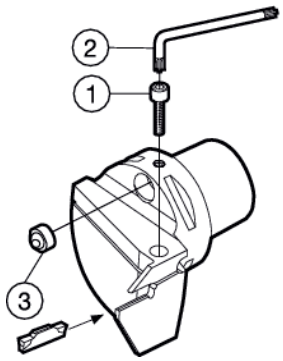
Nozzle for Coromant Capto® cutting units	
NF 123 Cutting unit size	3 Nozzle
C3–C4	5691 029-01
C5–C6	5691 029-02
R/L 123	
C3-C4	5691 029-06
C5-C6	5691 029-02

Shank holders		Coromant Capto®	1	2
Metric	Inch		Clamping screw	Key (Torx Plus)
		C3-NF123 G20-00060B C4-NF123 G20-00070B C5-NF123 G20-00070B C6-NF123 G20-00075B	3212 012-310	5680 043-15 (25IP)
NF123J25-2525BM NF123J25-3225BM			5512 044-01[1]	5680 043-17 (30IP)
		C4-NF123 J25-00077B C5-NF123 J25-00077B C6-NF123 J25-00082B	3212 012-360	5680 043-17 (30IP)
R/LF123D08-1212B	R/LF123D032-08B		3212 012-257	5680 043-14 (20IP)
R/LF123D08-1616B R/LF123D08-2020B R/LF123D08-2525B	R/LF123D032-10B R/LF123D032-12B R/LF123D032-16B		3212 012-259	5680 043-14 (20IP)
R/LF123D10-1010B-S	R/LF123D039-06B-S		5513 021-07	5680 043-13 (15IP)
R/LF123D11-1212B-S	R/LF123D043-08B-S		5513 021-07	5680 043-13 (15IP)
R/LF123D15-1616B R/LF123D15-2020B R/LF123D15-2525B	R/LF123D059-10B R/LF123D059-12B R/LF123D059-16B	C3-R/LF123 D15-22050B C4-R/LF123 D15-27055B C5-R/LF123 D15-35055B	3212 012-259	5680 043-14 (20IP)
R/LF123E08-1212B	R/LF123E032-08B		3212 012-257	5680 043-14 (20IP)
R/LF123E08-1616B R/LF123E08-2020B R/LF123E08-2525B	R/LF123E032-10B R/LF123E032-12B R/LF123E032-16B		3212 012-259	5680 043-14 (20IP)
R/LF123E10-1010B-S	R/LF123E039-06B-S		5513 021-07	5680 043-13 (15IP)
R/LF123E11-1212B-S	R/LF123E043-08B-S		5513 021-07	5680 043-13 (15IP)
R/LF123E12-1212B			3212 012-257	5680 043-14 (20IP)
	R/LF123E059-08B		3212 012-257	5680 043-14 (20IP)
R/LF123E15-1616B R/LF123E15-2020B R/LF123E15-2525B	R/LF123E059-10B R/LF123E059-12B R/LF123E059-16B	C3-R/LF123 E15-22055B C4-R/LF123 E15-27055B C5-R/LF123 E15-35060B	3212 012-259	5680 043-14 (20IP)
R/LF123E17-1616B-S	R/LF123E067-10B-S		5513 021-04	5680 043-13 (15IP)
R/LF123E17-2020D	R/LF123E067-12D		3212 012-257	5680 043-14 (20IP)
R/LF123F10-1212B			3212 012-257	5680 043-14 (20IP)
R/LF123F10-1616B R/LF123F10-2020B R/LF123F10-2525B			3212 012-259	5680 043-14 (20IP)
R/LF123F17-1616B-S	R/LF123F067-10B		5513 021-04	5680 043-13 (15IP)
R/LF123F17-2020D R/LF123F17-2525D	R/LF123F067-12D R/LF123F067-16D		3212 012-257	5680 043-14 (20IP)
R/LF123F20-1616B R/LF123F20-2020B R/LF123F20-2525B R/LF123F20-3225B	R/LF123F040-10B R/LF123F040-12B R/LF123F040-16B R/LF123F040-20B	C3-R/LF123 F20-22055B C4-R/LF123 F20-27060B C5-R/LF123 F20-35060B	3212 012-259	5680 043-14 (20IP)
	R/LF123F079-10B R/LF123F079-12B R/LF123F079-16B R/LF123F079-20B		3212 012-259	5680 043-14 (20IP)
R/LF123G07-2525C	R/LF123G028-16C		3212 012-310	5680 043-15 (25IP)
R/LF123G10-1616B			3212 012-309	5680 043-15 (25IP)
R/LF123G10-2020B R/LF123G10-2525B R/LF123G10-3225B	R/LF123G040-12B R/LF123G040-16B R/LF123G040-20B R/LF123G040-24B		3212 012-310	5680 043-15 (25IP)
R/LF123G12-1212B			3212 012-257	5680 043-14 (20IP)
R/LF123G12-2525B-034B R/LF123G12-2525B-038B	R/LF123G047-016B-034B R/LF123G047-016B-038B		3212 012-310	5680 043-15 (25IP)

[1] For holder without M in the ordering code, use screw 3212 012-360

CoroCut® external screw clamp tools



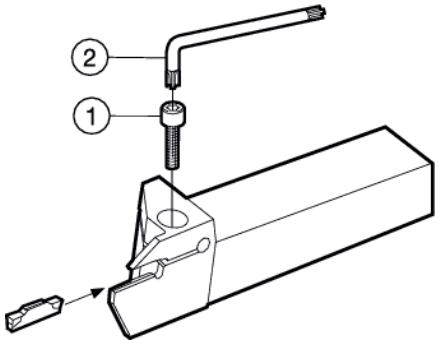


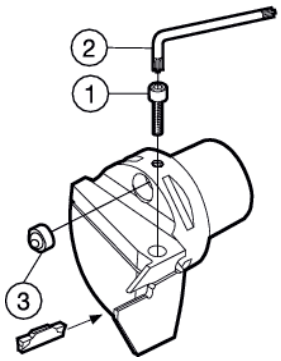
Nozzle for Coromant Capto® cutting units	
	3
Cutting unit size	Nozzle
C3–C4	5691 029-06
C5–C6	5691 029-02

Shank holders		Coromant Capto®	1	2
Metric	Inch		Clamping screw	Key (Torx Plus)
R/LF123G12-2020B-034B	R/LF123047-12B-034B		3212 012-310	5680 043-15 (25IP)
R/LF123G12-2020B-038B	R/LF123047-12B-038B			
R/LF123G13-2020B-042B	R/LF123050-12B-042B			
R/LF123G13-2020B-054B	R/LF123050-12B-054B			
R/LF123G13-2020B-067B	R/LF123050-12B-067B			
R/LF123G13-2020B-090B	R/LF123050-12B-090B			
R/LF123G13-2020B-130B	R/LF123050-12B-130B			
R/LF123G17-1616B-S	R/LF123G067-010B-S		5513 021-04	5680 043-13 (15IP)
R/LF123G19-2525B-042B	R/LF123G075-16B-042B		3212 012-310	5680 043-15 (25IP)
R/LF123G19-2525B-054B	R/LF123G075-16B-054B			
	R/LF123G075-16B-067B			
R/LF123G20-1616B			3212 012-309	5680 043-15 (25IP)
R/LF123G20-2020B	R/LF123G079-12B	C3-R/LF123 G20-22055B	3212 012-310	5680 043-15 (25IP)
R/LF123G20-2525B	R/LF123G079-16B	C4-R/LF123 G20-27060B		
R/LF123G20-3225B	R/LF123G079-20B	C5-R/LF123 G20-35060B		
R/LF123G20-3232B	R/LF123G079-24B	C6-R/LF123 G20-45065B		
R/LF123G22-2020D	R/LF123G087--12D		32312 012-310	5680 043-15 (25IP)
R/LF123G22-2525D	R/LF123G087--16D			
R/LF123G22-2525B-067B				
R/LF123G22-2525B-090B	R/LF123G087-16B-090B			
R/LF123G22-2525B-130B	R/LF123G087-16B-130B			
R/LF123H13-1616B			3212 012-309	5680 043-17 (30IP)
R/LF123H13-2020BM	R/LF123H051-12BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123H13-2525BM	R/LF123H051-16BM			
R/LF123H13-3225BM	R/LF123H051-20BM			
R/LF123H13-3232BM	R/LF123H051-24BM			
R/LF123H13-2020B-040BM	R/LF123H050-16B-040BM		5512 044-01	5680 043-17 (30IP)
R/LF123H13-2020B-052BM	R/LF123H050-16B-052BM			
R/LF123H13-2020B-064BM	R/LF123H050-16B-064BM			
R/LF123H13-2020B-092BM	R/LF123H050-16B-092BM			
R/LF123H13-2020B-132BM	R/LF123H050-16B-132BM			
R/LF123H13-2020B-220BM	R/LF123H050-16B-220BM			
	R/LF123H050-16B-300BM			
R/LF123H20-2525B-040BM	R/LF123H079-16B-040BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123H20--2525B-052BM	R/LF123H079-16B-052BM			
R/LF123H22-2020D	R/LF123H087-12D		5512 044-01	5680 043-15 (25IP)
R/LF123H22-2525D	R/LF123H087-12D		5512 044-01	5680 043-17 (30IP)
R/LF123H25-1616B		C3-R/LF123 H20-22060B	3212 012-360	5680 043-17 (30IP)
		C4-R/LF123 H25-27067B		
		C5-R/LF123 H25-35060B		
		C6-R/LF123 H25-45065B		
R/LF123H25-2020BM	R/LF123H098-12BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123H25-2525BM	R/LF123H098-16BM			
R/LF123H25-3225BM	R/LF123H098-20BM			
R/LF123H25-3232BM	R/LF123H098-24BM			
R/LF123H25-2525B-064BM	R/LF123H100-16B-064BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123H25-2525B-092BM	R/LF123H100-16B-092BM			
R/LF123H25-2525B-132BM	R/LF123H100-16B-132BM			
R/LF123H25-2525B-220BM	R/LF123H100-16B-220BM			
R/LF123H25-2525B-300BM	R/LF123H100-16B-300BM			
R/LF123J13-2020BM			5512 044-01[1)]	5680 043-17 (30IP)
R/LF123J13-2525BM	R/LF123J051-16BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123J13-3225BM	R/LF123J051-20BM			
R/LF123J13-3232BM	R/LF123J051-24BM			
R/LF123J13-2525-040BM	R/LF123J050-16B-040BM		5512 044-01	5680 043-17 (30IP)
R/LF123J13-2525-060BM	R/LF123J050-16B-060BM			
R/LF123J13-2525-085BM	R/LF123J050-16B-085BM			
R/LF123J13-2525-120BM	R/LF123J050-16B-120BM			
R/LF123J13-2525-175BM	R/LF123J050-16B-175BM			

1) For holder without M in the ordering code, use screw 3212 012-360

CoroCut® external screw clamp tools



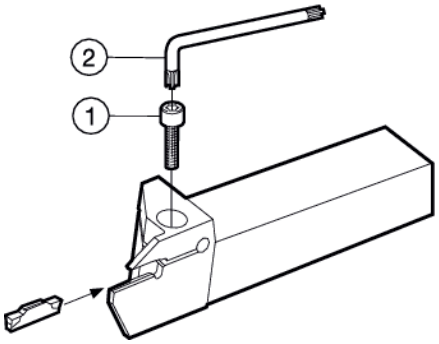


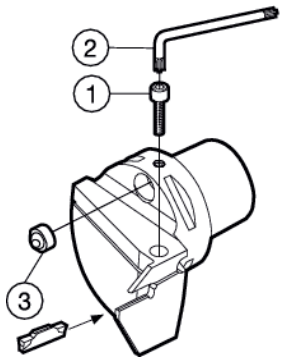
Nozzle for Coromant Capto® cutting units	
	3
Cutting unit size	Nozzle
C3–C4	5691 029-06
C5–C6	5691 029-02

Shank holders		Coromant Capto®	1	2
Metric	Inch		Clamping screw	Key (Torx Plus)
R/LF123J20-2525B-040BM R/LF123J20-2525B-180BM	R/LF123J079-16B-040BM R/LF123J079-16B-180BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123J25-2525B-060BM R/LF123J25-2525B-085BM R/LF123J25-2525B-120BM R/LF123J25-2525B-175BM	R/LF123J100-16B-060BM R/LF123J100-16B-085BM R/LF123J100-16B-120BM R/LF123J100-16B-175BM		5512 044-01[1)]	5680 043-17 (30IP)
		C4-R/LF123 J25-27067B C5-R/LF123 J25-35067B C6-R/LF123 J25-45067B	3212 012-360	5680 043-17 (30IP)
R/LF123J32-2525BBM R/LF123J32-3225BBM R/LF123J32-3232BBM	R/LF123J126-16BM R/LF123J126-20BM R/LF123J126-24BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123K08-2525BCM	R/LF123K032-16CM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123K13-2525B-040BM R/LF123K13-2525B-058BM R/LF123K13-2525B-088BM R/LF123K13-2525B-168BM	R/LF123K050-16B-040BM R/LF123K050-16B-058BM R/LF123K050-16B-088BM R/LF123K050-16B-168BM R/LF123K050-16B-220BM		5512 044-01	5680 043-17 (30IP)
R/LF123K16-2525BM R/LF123K16-3225BM R/LF123K16-3232BM	R/LF123K063-16BM R/LF123K063-20BM R/LF123K063-24BM R/LF123K063-32BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123K20-2525B-040BM R/LF123K25-2525B-058BM R/LF123K25-2525B-088BM R/LF123K25-2525B-168BM R/LF123K25-2525B-220BM	R/LF123K079-16B-040BM R/LF123K100-16B-058BM R/LF123K100-16B-088BM R/LF123K100-16B-168BM R/LF123K100-16B-220BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123K25-3225B-088BM R/LF123K25-3225B-168BM R/LF123K25-3225B-220BM	R/LF123K079-16B-040BM R/LF123K100-16B-058BM R/LF123K100-16B-088BM R/LF123K100-16B-168BM R/LF123K100-16B-220BM		5512 044-01	5680 043-17 (30IP)
		C4-R/LF123 K25-27070B C5-R/LF123 K25-35070B C5-R/LF123 K25-45075B	3212 012-360	5680 043-17 (30IP)
R/LF123K32-2525BM R/LF123K32-3225BM R/LF123K32-3232BM	R/LF123K126-16BM R/LF123K126-20BM R/LF123K126-24BM R/LF123K126-32BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123L15-2525B-075BM R/LF123L15-2525B-140BM	R/LF123L110-20B-075BM R/LF123L110-20B-140BM		5512 044-01	5680 043-17 (30IP)
R/LF123L16-2525BM R/LF123L25-2525BM R/LF123L25-3225BM R/LF123L25-2525B-050BM R/LF123L28-2525B-075BM R/LF123L28-2525B-140BM	R/LF123L063-16BM R/LG123L100-16BM R/LF123L100-20BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123L28-3225B-075BM R/LF123L28-3225B-140BM			5512 044-01	5680 043-17 (30IP)
		C5-R/LF123 L25-35070B C6-R/LF123 L25-45075B	3212 012-360	5680 043-17 (30IP)
R/LF123L32-3225BM R/LF123L32-3232BM	R/LF123L138-20BM R/LF123L138-24BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LF123G07-2525C	R/LG123G028-16C		3212 012-310	5680 043-17 (30IP)
R/LF123M32-3232B NF123M32-4040B R/LF123M32-4040B	R/LF123M125-20B NF123M125-24B R/LF123M125-24B		5512 044-01	5680 048-07 (30IP)

[1)] For holder without M in the ordering code, use screw 3212 012-360

CoroCut® external screw clamp tools





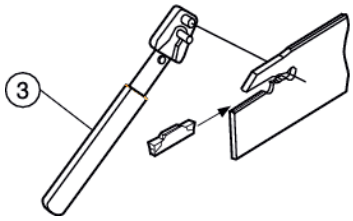
Nozzle for Coromant Capto® cutting units	
	3
Cutting unit size	Nozzle
C3–C4	5691 029-06
C5–C6	5691 029-02

Shank holders		Coromant Capto®	1	2
Metric	Inch		Clamping screw	Key (Torx Plus)
R/LF123M50-4040B	R/LF123M200-24B		5512 046-01	5680 048-15 (25IP)
R/LF123R32-3232B NF123R32-4040B R/LF123R32-4040B	R/LF123R125-20B NF123R125-24B R/LF123R125-24B		5512 044-01	5680 048-07 (30IP)
R/LF123R50-4040B	R/LF123R200-24B		3212 012-311	5680 048-15 (25IP)
R/LG123H13-2525B-040BM R/LG123H13-2525B-052BM R/LG123H13-2525B-064BM R/LG123H13-2525B-092BM R/LG123H13-2525B-132BM R/LG123H13-2525B-220BM R/LG123H13-2525B-300BM	R/LF123H050-2525B-040BM R/LF123H050-2525B-052BM R/LF123H050-2525B-064BM R/LF123H050-2525B-092BM R/LF123H050-2525B-132BM R/LF123H050-2525B-220BM R/LF123H050-2525B-300BM		5512 044-01	5680 043-17(30IP)
R/LG123H20-2525B-064BM R/LG123H20-2525B-092BM R/LG123H20-2525B-132BM	R/LG123H079-16B-064BM R/LG123H079-16B-092BM R/LG123H079-16B-132BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LG123K08-2525CM	R/LG123K032-16CM		5512 044-01[1)]	5680 043-17 (30IP)
R/LG123K20-2525B-058BM R/LG123K20-2525B-088BM R/LG123K20-2525B-168BM	R/LG123K079-16B-058BM R/LG123K079-16B-088BM R/LG123K079-16B-168BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LG123L20-2525B-050BM R/LG123L20-2525B-075BM R/LG123L20-2525B-140BM	R/LG123L079-16B-050BM R/LG123L079-16B-075BM R/LG123L079-16B-140BM		5512 044-01[1)]	5680 043-17 (30IP)
R/LX123J16-2525B-070 R/LX123J16-3232B-070	R/LX123J062-16B-070 R/LX123J062-20B-070		3212 012-360	5680 043-17 (30IP)
R/LX123L25-2525B-007 R/LX123L25-3232B-007	R/LX123L095-16B-007 R/LX123L095-20B-007		3212 012-360	5680 043-17 (30IP)
R/LX123G04-2020B-045 R/LX123G04-2525B-045	R/LX123G016-12B-045 R/LX123G016-16B-045		3212 012-309	5680 043-15 (25IP)
R/LX123J05-2020B-045 R/LX123J05-2525B-045 R/LX123J05-3225B-045	R/LX123J020-12B-045 R/LX123J020-16B-045 R/LX123J020-20B-045		3212 012-360	5680 043-17 (30IP)

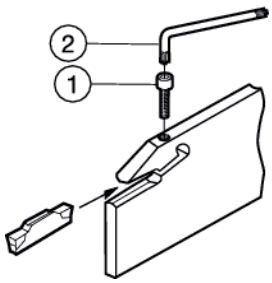
1) For holder without M in the ordering code, use screw 3212 012-360

CoroCut® parting blade

Spring clamp



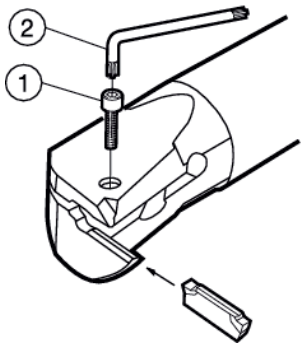
Screw clamp



	1	2	3[1]
Parting blade	Clamping screw	Key (Torx Plus)	Insert key
N123D15-21A2	–	–	5680 058-01
N123D15-25A2	–	–	
N123E15-21A2	–	–	5680 058-01
N123E20-25A2	–	–	
N123F30-21A2	–	–	5680 058-01
N123F55-25A2	–	–	
N123G30-21A2	–	–	5680 058-01
N123G55-25A2	–	–	
N123H55-25A2	–	–	5680 058-01
N123J55-25A2	–	–	5680 058-01
N123K55-25A2	–	–	5680 058-01
R/LF123E25-25B1	3212 012-259	5680 043-14 (20IP)	–
R/LF123F25-25B1	3212 012-259	5680 043-14 (20IP)	–
R/LF123G25-25B1	3212 012-259	5680 043-14 (20IP)	–
R/LF123H32-25B1	3212 012-259	5680 043-14 (20IP)	–

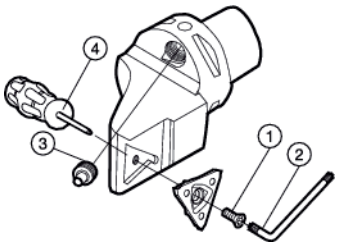
1) Optional part delivered to separate order.

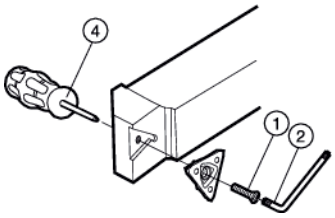
CoroCut® internal screw clamp tools



Shank holders		1	2
Metric	Inch	Clamping screw	Key (Torx Plus)
R/LAG123D 04-16B	R/LAG123D 016-10B	5512 031-03	5680 043-13 (15IP)
R/LAG123D 05-20B	R/LAG123D 020-12B	5512 031-03	5680 043-13 (15IP)
R/LAG123E 05-20B	R/LAG123E 020-12B	5512 031-03	5680 043-13 (15IP)
R/LAG123E 07-25B	R/LAG123E 028-16B	3212 012-259	5680 043-14 (20IP)
R/LAG123E 09-32B	R/LAG123E 035-20B	3212 012-259	5680 043-14 (20IP)
R/LAG123G 06-20B	R/LAG123G 024-12B	5512 031-03	5680 043-13 (15IP)
R/LAG123G 07-25B	R/LAG123G 030-16B	3212 012-309	5680 043-15 (25IP)
R/LAG123G 09-32B	R/LAG123G 037-20B	3212 012-309	5680 043-15 (25IP)
R/LAG123G 11-40B	R/LAG123G 043-24B	3212 012-309	5680 043-15 (25IP)
R/LAG123H 07-25B	R/LAG123H 030-16B	3212 012-309	5680 043-15 (25IP)
R/LAG123H 10-32B	R/LAG123H 039-20B	3212 012-359	5680 043-17 (30IP)
R/LAG123H 11-40B	R/LAG123H 043-24B	3212 012-360	5680 043-17 (30IP)
R/LAG123H 13-50B	R/LAG123H 051-32B	3212 012-360	5680 043-17 (30IP)
R/LAG123J 08-25B	R/LAG123J 031-16B	3212 012-309	5680 043-15 (25IP)
R/LAG123J 11-32B	R/LAG123J 045-20B	3212 012-359	5680 043-17 (30IP)
R/LAG123J 11-40B	R/LAG123J 045-24B	3212 012-360	5680 043-17 (30IP)
R/LAG123J 13-50B	R/LAG123J 051-32B	3212 012-360	5680 043-17 (30IP)
R/LAG123K 11-40B	R/LAG123K 043-24B	3212 012-360	5680 043-17 (30IP)
R/LAG123K 13-50B	R/LAG123K 053-32B	3212 012-360	5680 043-17 (30IP)
R/LAX123J 25-40B-020	R/LAX123J094-24B-020	5512-044-01	5680 043-17 (30IP)
R/LAX123L 25-40B-020	R/LAX123L094-24B-020	5512-044-01	5680 043-17 (30IP)

CoroCut® 3 external tools



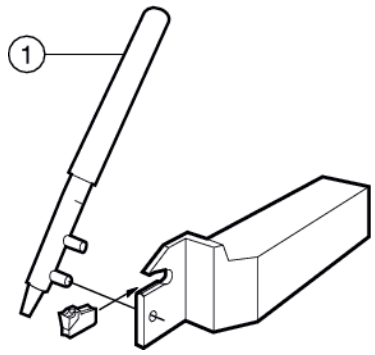


Shank holders		Coromant Capto®	1	2	4[1]
Metric	Inch		Clamping screw	Key (Torx Plus)	Screwdriver
RF123T06-1010BM	RF123T023-06BM	–	5513 020-63[2]	5680 049-02 (15IP)	5680 046-01 (8IP)
RF123T06-1212BM RF123T06-1616BM	RF123T023-08BM RF123T023-10BM	–	5513 020-62[3]	5680 049-02 (15IP)	5680 046-01 (8IP)
		C3-RF123T06-22045BM C4-RF123T06-27060BM	5513 020-62[3]	5680 049-02 (15IP)	5680 046-01 (8IP)
RF123T06-2020BM RF123T06-2525BM RF123T06-3232BM	RF123T023-12BM RF123T023-16BM RF123T023-20BM	–	5513 020-62[3]	5680 049-02 (15IP)	5680 046-01 (8IP)
LF123U06-1010BM	LF123U023-06BM	–	5513 020-63[2]	5680 049-02 (15IP)	5680 046-01 (8IP)
LF123U06-1212BM LF123U06-1616BM	LF123U023-08BM LF123U023-10BM	–	5513 020-62[3]	5680 049-02 (15IP)	5680 046-01 (8IP)
		C3-LF123U06-22045BM C4-LF123U06-27060BM	5513 020-62[3]	5680 049-02 (15IP)	5680 046-01 (8IP)
LF123U06-2020BM LF123U06-2525BM LF123U06-3232BM	LF123U023-12BM LF123U023-16BM LF123U023-20BM	–	5513 020-62[3]	5680 049-02 (15IP)	5680 046-01 (8IP)

1) Optional part to be ordered separately
2) For holders without M in the ordering code use screw 5513 020-09
3) For holders without M in the ordering code use screw 5513 020-32

Nozzle for Coromant Capto® cutting units	
	3
Cutting unit size	Nozzle
C3–C4	5691 029-08
C5–C6	5691 029-02

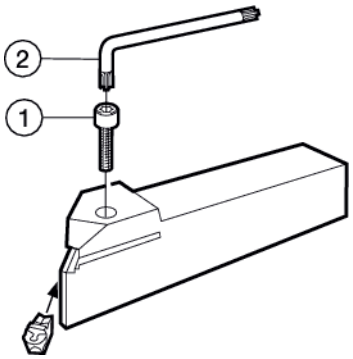
Insert changing and clamping for T-Max Q-Cut® external spring clamp tools

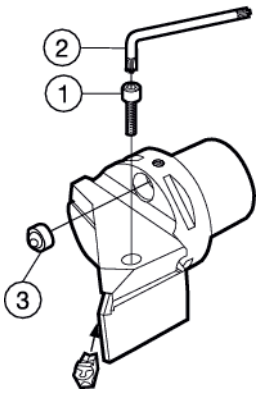


Shank holders			Shank holders		
Metric	Inch	Insert key	Metric	Inch	Insert key
R/L151.20-0808-20	R151.20-06-20	5680 057-021	R/L151.21-1616-20	R/L151.21-10-20	5680 057-021
R/L151.20-1010-20	R/L151.20-08-20		R/L151.21-1616-25	R/L151.21-10-25	
R/L151.20-1212-20	R/L151.20-10-20		R/L151.21-2020-25	R/L151.21-12-25	
R/L151.20-1612-20			R/L151.21-2020-30	R/L151.21-12-30	
R/L151.20-1616-20			R/L151.21-2525-30	R/L151.21-16-30	
R/L151.20-1212-25	R/L151.20-08-25		R/L151.21-3225-30		
R/L151.20-1612-25	R/L151.20-10-25			151.2-12-20-5	
R/L151.20-1616-25	R/L151.20-12-25			151.2-12-25-5	
R/L151.20-2012-25				151.2-17-25-5	
R/L151.20-2016-25				151.2-17-30-5	
R/L151.20-2020-25				151.2-22-30-5	
R/L151.20-2525-25				151.2-28-30-5	
R/L151.20-1612-30	R/L151.20-10-30		R/L151.20-2020-40	R/L151.20-12-40	5680 057-011
R/L151.20-1616-30	R/L151.20-12-30		R/L151.20-2525-40		
R/L151.20-2012-30	R/L151.20-12-30A		R/L151.21-2020-40	R/L151.21-12-40	
R/L151.20-2016-30			R/L151.21-2525-40	R/L151.21-16-40	
R/L151.20-2020-30			R/L151.21-3225-40	R/L151.21-16-40A	
R/L151.20-2020-30A			R/L151.21-2525-40A	R/L151.21-20-40	
R/L151.20-2525-30A			R/L151.21-3225-40A		
			R/L151.21-3232-40		
			R/L151.21-2525-50	R/L151.21-16-50	
			R/L151.21-3232-50	R/L151.21-20-50	
			R/L151.21-2525-60	R/L151.21-16-60	
			R/L151.21-3232-60	R/L151.21-20-60	
				151.2-28-40-5	
				151.2-28-60-5	

Blades	Insert key	Blades	Insert key
151.2-27-20-8	5680 057-021	151.2-27-40-8	5680 057-011
151.2-27-25-8		151.2-27-50-8	
151.2-27-30-8		151.2-40-40-8	
151.2-36-30-8		151.2-40-50-8	
151.2-40-20-8		151.2-56-50-8	
151.2-40-25-8		151.2-56-60-8	
151.2-40-30-8		151.2-21-40	
R/L151.2-16-30-8		151.2-25-40	
151.2-21-20		151.2-25-50	
151.2-21-25		151.2-25-60	
151.2-25-25			
151.2-21-30			
151.2-25-30			

T-Max Q-Cut® external screw clamp tools

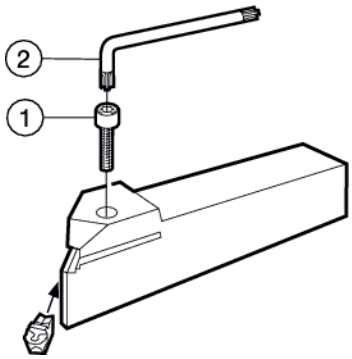




Nozzle for Coromant Capto® cutting units	
	3
Cutting unit size	Nozzle
C3–C4	5691 029-01
C5–C6	5691 029-02

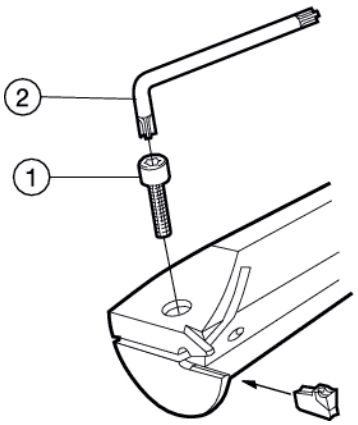
Shank holders		Coromant Capto®	1	2
Metric	Inch		Clamping screw	Key (Torx Plus)
	R/LB151.22-24-20 R/LB151.22-24-25 R/LB151.22-24-30		3212 012-259	5680 043-14 (20IP)
	R/LB151.22-24-40 R/LB151.22-24-50 R/LB151.22-24-60 R/LB151.22-24-80		3212 012-360	5680 043-17 (30IP)
R/LF151.22-1616-20 R/LF151.22-2020-20 R/LF151.22-2525-20	R/LF151.22-10-20 R/LF151.22-12-20 R/LF151.22-16-20	C3-R/LF151.22-22045-20 C4-R/LF151.22-27050-20 C5-R/LF151.22-35060-20	3212 012-259	5680 043-14 (20IP)
R/LF151.22-1616-25 R/LF151.22-2020-25 R/LF151.22-2525-25	R/LF151.22-10-25 R/LF151.22-12-25 R/LF151.22-16-25	C3-R/LF151.22-22050-25 C4-R/LF151.22-27050-25 C5-R/LF151.22-35060-25	3212 012-259	5680 043-14 (20IP)
R/LF151.22-1616-30 R/LF151.22-2020-30 R/LF151.22-2525-30 R/LF151.22-3225-30	R/LF151.22-12-30 R/LF151.22-16-30 R/LF151.22-20-30	C3-R/LF151.22-22050-30 C4-R/LF151.22-27055-30 C5-R/LF151.22-35060-30 C6-R/LF151.22-45065-30	3212 012-259	5680 043-14 (20IP)
R/LF151.22-2020-40 R/LF151.22-2525-40 R/LF151.22-3225-40	R/LF151.22-12-40 R/LF151.22-16-40 R/LF151.22-20-40	C4-R/LF151.22-27055-40 C5-R/LF151.22-35060-40 C6-R/LF151.22-45065-40	3212 012-360	5680 043-17 (30IP)
R/LF151.22-2525-50 R/LF151.22-3225-50	R/LF151.22-16-50 R/LF151.22-20-50	C4-R/LF151.22-27055-50 C5-R/LF151.22-35060-50 C6-R/LF151.22-45065-50 C8-R/LF151.22-42080-50	3212 012-360	5680 043-17 (30IP)
R/LF151.22-2525-60 R/LF151.22-3225-60	R/LF151.22-16-60 R/LF151.22-20-60	C5-R/LF151.22-35060-60 C6-R/LF151.22-45065-60 C8-R/LF151.22-42080-60	3212 012-360	5680 043-17 (30IP)
		C8-R/LF151.22-42080-80	3212 012-360	5680 043-17 (30IP)
R/LS151.22-2525-20	R/LS151.22-12-20	C3-R/LS151.22-22045-20 C4-R/LS151.22-27050-20	3212 012-259	5680 043-14 (20IP)
R/LS151.22-2525-25	R/LS151.22-12-25 R/LS151.22-16-25	C3-R/LS151.22-22050-25 C4-R/LS151.22-27050-25 C4-R/LS151.22-35060-25	3212 012-259	5680 043-14 (20IP)
R/LS151.22-2020-30 R/LS151.22-2525-30	R/LS151.22-12-30 R/LS151.22-16-30 R/LS151.22-20-30	C3-R/LS151.22-22050-30 C4-R/LS151.22-27055-30 C5-R/LS151.22-35060-30	3212 012-259	5680 043-14 (20IP)
R/LS151.22-2020-40 R/LS151.22-2525-40	R/LS151.22-16-40 R/LS151.22-20-40	C4-R/LS151.22-27055-40 C5-R/LS151.22-35060-40	3212 012-360	5680 043-17 (30IP)
R/LS151.22-2525-50 R/LS151.22-3225-50	R/LS151.22-20-50	C4-R/LS151.22-27055-50 C5-R/LS151.22-35060-50	3212 012-360	5680 043-17 (30IP
R/LS151.22-2525-60 R/LS151.22-3225-60	R/LS151.22-20-60	C5-R/LS151.22-35060-60 C6-R/LS151.22-45065-60	3212 012-360	5680 043-17 (30IP)
	R/LB151.23-24-20 R/LB151.23-24-25 R/LB151.23-24-30		3212 012-059	5680 043-14 (20IP)
	R/LB151.23-24-40 R/LB151.23-24-50 R/LB151.23-24-60 R/LB151.23-24-80		3212 012-360	5680 043-17 (30IP)
R/LF151.23-1616-20M1 R/LF151.23-2020-20M1 R/LF151.23-2525-20M1	R/LF151.23-08-20 R/LF151.23-10-20	C3-R/LF151.23-22050-20 C4-R/LF151.23-27055-20 C5-R/LF151.23-35060-20	3212 012-309	5680 043-14 (20IP)
R/LF151.23-1616-25M1 R/LF151.23-2020-25M1 R/LF151.23-2525-25M1	R/LF151.23-08-25 R/LF151.23-10-25 R/LF151.23-12-25	C3-R/LF151.23-22055-25 C4-R/LF151.23-27060-25 C5-R/LF151.23-35060-25	3212 012-259	5680 043-14 (20IP)
R/LF151.23-1616-30M1 R/LF151.23-2020-30M1 R/LF151.23-2525-30M1 R/LF151.23-3225-30M1	R/LF151.23-12-30 R/LF151.23-16-30 R/LF151.23-20-30	C3-R/LF151.23-22055-30 C4-R/LF151.23-27060-30 C5-R/LF151.23-35060-30 C6-R/LF151.23-45065-30	3212 012-310	5680 043-15 (25IP)
R/LF151.23-2020-40M1 R/LF151.23-2525-40M1 R/LF151.23-3225-40M1	R/LF151.23-12-40 R/LF151.23-16-40 R/LF151.23-20-40	C4-R/LF151.23-27067-40 C5-R/LF151.23-35067-40 C6-R/LF151.23-45067-40	3212 012-360	5680 043-17 (30IP)
R/LF151.23-2525-50M1 R/LF151.23-3225-50M1	R/LF151.23-16-50 R/LF151.23-20-50	C5-R/LF151.23-35075-50 C6-R/LF151.23-45075-50	3212 012-360	5680 043-17 (30IP)
R/LF151.23-2525-60M1 R/LF151.23-3225-60M1	R/LF151.23-16-60 R/LF151.23-20-60	C5-R/LF151.23-35075-60 C6-R/LF151.23-45080-60	3212 012-360	5680 043-17 (30IP)

T-Max Q-Cut® external screw clamp tools



Shank holders		1	2
Metric	Inch	Clamping screw	Key (Torx Plus)
R/LF151.37-2525-024B25 R/LF151.37-2525-029B25 R/LF151.37-2525-034B25 R/LF151.37-2525-044B25 R/LF151.37-2525-064B25	R/LF151.37-16-024B25 R/LF151.37-16-029B25 R/LF151.37-16-034B25 R/LF151.37-16-044B25 R/LF151.37-16-064B25 R/LF151.37-16-094B25 R/LF151.37-16-132B25	3212 012-360	5680 043-17 (30IP)
R/LF151.37-2525-027B30 R/LF151.37-2525-032B30 R/LF151.37-2525-042B30 R/LF151.37-2525-062B30 R/LF151.37-2525-112B30	R/LF151.37-16-027B30 R/LF151.37-16-032B30 R/LF151.37-16-042B30 R/LF151.37-16-062B25 R/LF151.37-16-112B30	3212 012-360	5680 043-17 (30IP)
R/LF151.37-2525-025B40 R/LF151.37-2525-030B40 R/LF151.37-2525-045B40 R/LF151.37-2525-070B40 R/LF151.37-2525-090B40	R/LF151.37-16-025B40 R/LF151.37-16-030B40 R/LF151.37-16-045B40 R/LF151.37-16-070B40 R/LF151.37-16-090B40	3212 012-360	5680 043-17 (30IP)
R/LF151.37-2525-023B50 R/LF151.37-2525-038B50 R/LF151.37-2525-058B50 R/LF151.37-2525-088B50	R/LF151.37-16-023B50 R/LF151.37-16-038B50 R/LF151.37-16-058B50 R/LF151.37-16-088B50	3212 012-360	5680 043-17 (30IP)
R/LG151.37-2525-027B30 R/LG151.37-2525-032B30 R/LG151.37-2525-042B30	R/LF151.37-16-027B30 R/LF151.37-16-032B30 R/LF151.37-16-042B30	3212 012-360	5680 043-17 (30IP)
R/LG151.37-2525-023B50 R/LG151.37-2525-038B50	R/LF151.37-16-023B50 R/LF151.37-16-038B50	3212 012-360	5680 043-17 (30IP)
NF151.42-2525-40 NF151.42-3225-40		3212 012-360	5680 043-17 (30IP)
NF151.42-2525-60 NF151.42-3225-60		3212 012-360	5680 043-17 (30IP)
R/LF151.42-2525-40 R/LF151.42-3225-40		3212 012-360	5680 043-17 (30IP)
R/LF151.42-2525-60 R/LF151.42-3225-60		3212 012-360	5680 043-17 (30IP)

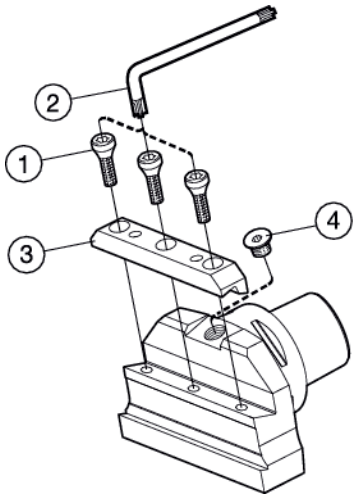
T-Max Q-Cut® internal screw clamp tools



Shank holders		1	2
Metric	Inch	Clamping screw	Key (Torx Plus)
R/LAF151.37-25-024A25		3212 012-257	5680 043-14 (20IP)
R/LAF151.37-25-024A30 R/LAF151.37-25-025A30		3212 012-257	5680 043-14 (20IP)
R/LAF151.37-40-035A50 R/LAF151.37-40-036A50		3212 012-359	5680 043-17 (30IP)
R/LAG151.22-25R-20 R/LAG151.22-32S-20	R/LAG151.22-D16-20 R/LAG151.22-D20-20	3212 012-257	5680 043-14 (20IP)
R/LAG151.22-25R-25 R/LAG151.22-32S-25 R/LAG151.22-40T-25	R/LAG151.22-D15-25 R/LAG151.22-D20-25 R/LAG151.22-D24-25	3212 012-257	5680 043-14 (20IP)
R/LAG151.22-25R-30 R/LAG151.22-32S-30 R/LAG151.22-40T-30	R/LAG151.22-D16-30 R/LAG151.22-D20-30 R/LAG151.22-D24-30	3212 012-257	5680 043-14 (20IP)
R/LAG151.22-32S-40 R/LAG151.22-40T-40 R/LAG151.22-50U-40	R/LAG151.22-D20-40 R/LAG151.22-D24-40 R/LAG151.22-D32-40	3212 012-359	5680 043-17 (30IP)
R/LAG151.22-32S-50 R/LAG151.22-40T-50 R/LAG151.22-50U-50	R/LAG151.22-D20-50 R/LAG151.22-D24-50 R/LAG151.22-D32-50	3212 012-359	5680 043-17 (30IP)
R/LAG151.22-40T-60 R/LAG151.22-50U-60	R/LAG151.22-D20-60 R/LAG151.22-D24-60 R/LAG151.22-D32-60	3212 012-359	5680 043-17 (30IP)
	R/LAG151.32-D12M59-25	5512 031-04	5680 043-10 (8IP)
R/LAG151.32-16M-20 R/LAG151.32-20Q-20	R/LAG151.32-D10-20 R/LAG151.32-D12-20	5512 031-03	5680 043-13 (15IP)
R/LAG151.32-16M-25 R/LAG151.32-20Q-25 R/LAG151.32-25R-25 R/LAG151.32-32S-25	R/LAG151.32-D10-25 R/LAG151.32-D12-25 R/LAG151.32-D16-25 R/LAG151.32-D20-25	5512 031-03	5680 043-13 (15IP)
R/LAG151.32-20Q-30 R/LAG151.32-25R-30 R/LAG151.32-32S-30	R/LAG151.32-D12-30 R/LAG151.32-D16-30 R/LAG151.32-D20-30	5512 031-03	5680 043-13 (15IP)
R/LAG151.32-25R-40	R/LAG151.32-D16-40	5512 031-03	5680 043-13 (15IP)
R/LAG151.32-32S-40	R/LAG151.32-D20-40	3212 012-359	5680 043-17 (30IP)
R/LAG151.32-40T-40	R/LAG151.32-D24-40	3212 012-359	5680 043-17 (30IP)
R/LAG151.32-32S-50 R/LAG151.32-40T-50	R/LAG151.32-D20-50 R/LAG151.32-D24-50	3212 012-359	5680 043-17 (30IP)
R/LAG151.32-40T-60	R/LAG151.32-D24-60	3212 012-359	5680 043-17 (30IP)
R/LAG151.32-16M12-20	R/LAG151.32-D10M47-20	5512 031-07	5680 043-10 (8IP)
R/LAG151.32-16M15-25 R/LAG151.32-20Q16-30	R/LAG151.32-D10M59-25 R/LAG151.32-D12M63-30	5512 031-04	5680 043-10 (8IP)
R/LAG151.32-20Q18-40	R/LAG151.32-D12Q71-40	5512 031-03	5680 043-10 (8IP)

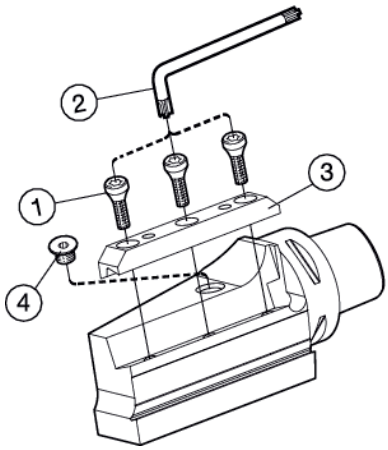
Adapters for CoroCut® and Q-Cut® parting blades

Radial mounting



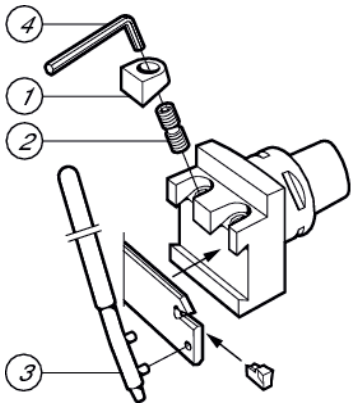
	1	2	3	4	
Adapter	Screw	Key (mm)	Clamp	Plug	Optional coolant adapter
C5-APBA-40058-21	3212 010-410	3021 010-060 (6.0)	5412 120-01	5519 055-01	5691 050-011
C6-APBA-60060-25	3212 010-411	3021 010-060 (6.0)	5412 120-02	5519 055-01	5691 050-011
C8-APBA-60068-25	3212 010-411	3021 010-060 (6.0)	5412 120-02	5412 120-01	5691 050-011

Axial mounting



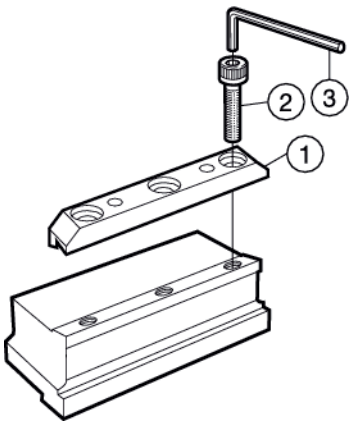
	1	2	3	4	
Adapter	Screw	Key (mm)	Clamp	Plug	Optional coolant adapter
C5-APBR/L-31095-21	3212 010-410	3021 010-060 (6.0)	5412 120-01	5519 055-01	5691 050-011
C6-APBR/L-37147-25	3212 010-411	3021 010-060 (6.0)	5412 120-02	5519 055-01	5691 050-011
C8-APBR/L-46155-25	3212 010-411	3021 010-060 (6.0)	5412 120-02	5519 055-01	5691 050-011

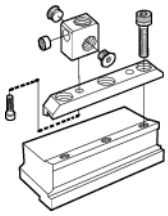
Adapter for CoroCut® and T-Max Q-Cut® parting blades



	1	2	3	4
Adapter	Clamp	Clamp screw	Insert key	Key (Size, mm)
C4-151.2-25040-21	150.2-820	269-833	5680 057-021	3021 010-040 (4.0)
C5-151.2-33040-21	150.2-820	269-833	5680 057-011	3021 010-040 (4.0)
C6-151.2-43045-21				
C5-151.2-33040-25				
C6-151.2-43045-25				

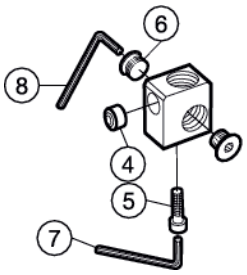
Tool block for CoroCut® 1- and 2-edge T-Max Q-Cut®





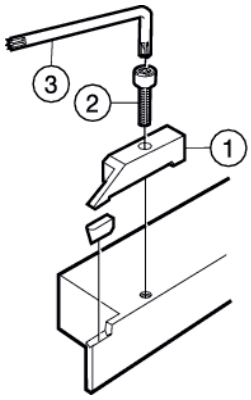
Tool block		1	2	3
Metric	Inch	Clamp	Clamp screw	Key (mm)
151.2-2020-21M 151.2-2520-21	151.2-12-21M	5412 120-01	3212 010-410	3021 010-060 (6.0)
151.2-2020-25 151.2-2520-25 151.2-3232-25	151.2-16-25M 151.2-20-25M 151.2-24-25M	5412 120-02	3212 010-411	3021 010-060 (6.0)
151.2-3232-45 151.2-4040-45	151.2-20-45 151.2-24-45	5412 120-03	3212 010-412	3021 010-060 (6.0)
	HDG-50-93	HDG-50-93-Clamp	3212 010-464	3021 010-080 (8.0)

Coolant adapter



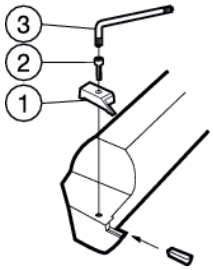
4	5	6	7	8
Nozzle	Mounting screw	Plug	Key (mm)	Key (mm)
5691 029-02	3212 010-358	5519 055-01	3021 010-050 (5.0)	3021 010-060 (6.0)

T-Max® external and internal tools



	1		2	3
Ceramic shank holders	Clamp Right hand	Clamp Left hand	Clamp screw	Key (Torx Plus)
R/LF150.23-3244M-0317C	5412 117-01	5412 117-02	3212 036-506	5680 043-17 (30IP)
R/LF150.23-3244M-0476C	5412 117-05	5412 117-06	3212 036-506	5680 043-17 (30IP)
R/LF150.23-3244M-0635C	5412 117-09	5412 117-10	3212 036-506	5680 043-17 (30IP)
R/LF150.23-3244M-0952C	5412 117-17	5412 117-18	3212 036-506	5680 043-17 (30IP)

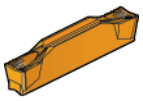
T-Max® ceramic boring bars



	1		2	3
Boring bar	Clamp Right hand	Clamp Left hand	Clamp screw	Key (Torx Plus)
R/LAG150.23-50V-0317C	5412 115-01	5412 115-02	3212 106-504	5680 043-16 (27IP)
R/LAG150.23-50V-0476C	5412 115-05	5412 115-06	3212 106-504	5680 043-16 (27IP)
R/LAG150.23-50V-0635C	5412 115-03	5412 115-04	3212 106-504	5680 043-16 (27IP)
R/LAG150.23-50V-0952C	5412 115-11	5412 115-12	3212 106-504	5680 043-16 (27IP)

CoroCut® 1- and 2-edge inserts

Parting

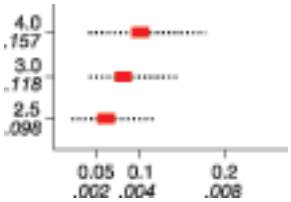


123-CF

Wiper TECHNOLOGY

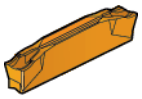
Low feed choice

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

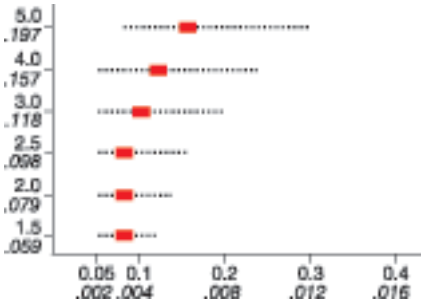
Stainless steels and sticky materials
Very good chip control at low feeds.
The positive geometry eliminates the risk of built-up edge.
Gives soft cutting action.
Generates good surface finish due to wiper design on the side.
Available as CoroCut 2-edge inserts.



123-CM

Medium feed choice

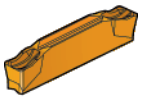
Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Parting off stainless steels
Also recommended for thin walled tubes and small diameter components in all materials.
The positive geometry eliminates the risk of built-up edge.
Low cutting forces resulting in reduced vibration.

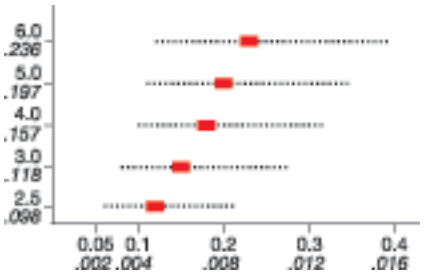
Available as CoroCut 1 and 2-edged inserts.



123-CR

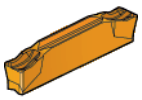
High feed choice

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

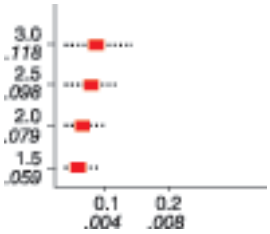
Rough machining
Strong cutting edges reduce risk of edge fractures.
Suitable for parting off bars and interrupted cuts.
For steel and cast iron, but also suitable for stainless steels when there is a need for strong edges.
Available as CoroCut 1 and 2-edged inserts.



123-CS

Low feed

Radial feed
Insert width (l_a), inch



Feed (f_n), mm/r, inch/r

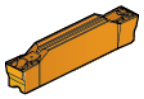
Pip and burr free machining.
Ideal solution for minimizing pips and burrs on components thanks to the sharp cutting edge and front angles of 10° and 15°.
Recommended for small components.
Suitable for free cutting steel.
Available as CoroCut 2-edge inserts.

■ = Recommended starting value.

For cutting speed recommendations, see page B138.

CoroCut® 1- and 2-edge inserts

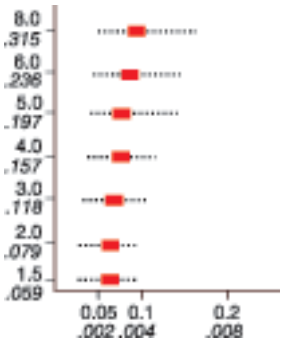
Grooving



123-GF

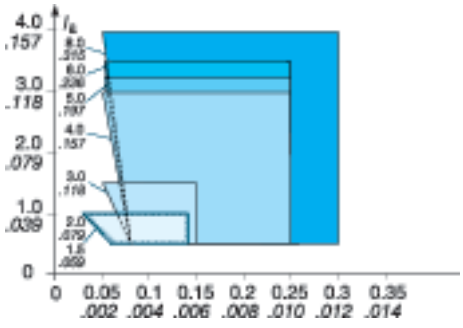
Low feed choice

Radial feed
Insert width (l_a), mm, inch



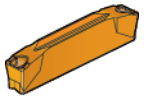
Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch

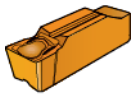


Feed (f_n), mm/r, inch/r

For precision grooves
Good accuracy and repeatability due to tight tolerances on inserts.
Low cutting forces and good surface finishing due to sharp cutting edge.
Large number of different widths
Designed for side turning.
Available as CoroCut 2-edge inserts.
Can be ordered as Tailor Made with different insert width and corner radii.



123-GM

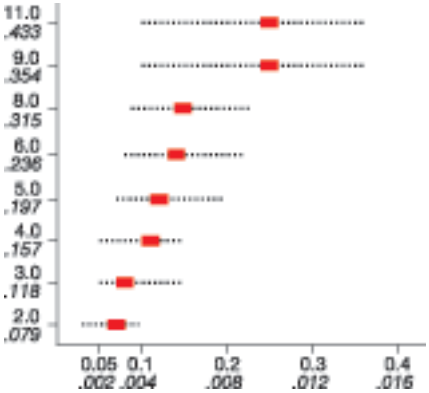


123-GM

Medium feed choice

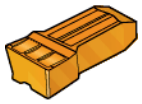
M Seat size
l_a, mm (inch)
9-11 (.354-.433)

Radial feed
Insert width (l_a), mm, inch



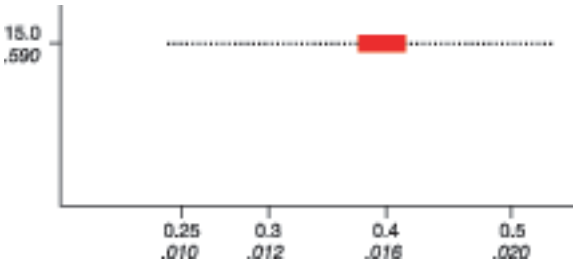
Feed (f_n), mm/r, inch/r

Grooving in all materials
Outstanding chip control.
Reduces chip width giving good surfaces.



123-GR

Radial feed
Insert width (l_a), mm, inch



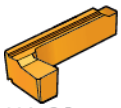
Feed (f_n), mm/r, inch/r

■ = Recommended starting value.

For cutting speed recommendations, see page B138.

CoroCut® 1- and 2-edge inserts

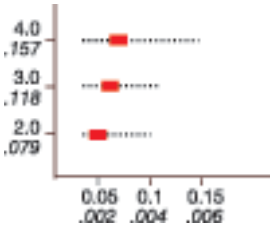
Grooving



123-GS

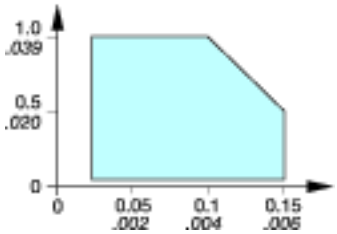
Low feed choice

Radial feed
Insert width (l_a), mm, inch

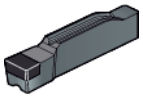


Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



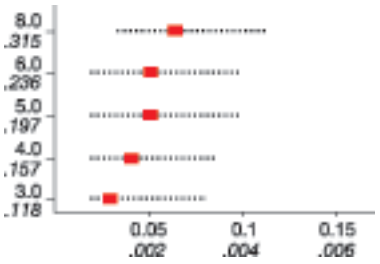
Feed (f_n), mm/r, inch/r



123-GE

Cubic boron nitride tipped

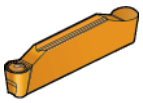
Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Alternative for finish grooving of hardened materials
Maintains close tolerances and gives excellent finish on components.
Available as CoroCut 1-edged inserts.

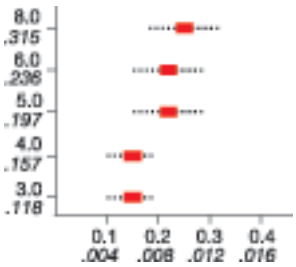
Profiling



123-RM

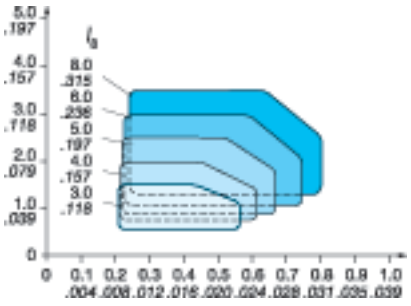
Medium feed choice

Radial feed
Insert width (l_a), mm, inch



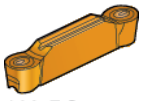
Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



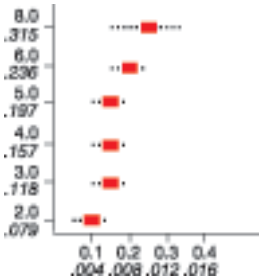
Feed (f_n), mm/r, inch/r

Excellent for profiling in all materials
Outstanding chip control even at low feeds and small depths of cut.
Good surface finish.
Available as CoroCut 1 and 2-edged inserts.



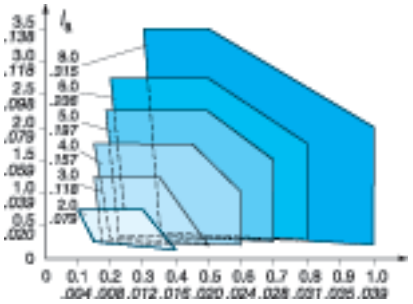
123-RO

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

Excellent for profiling in stainless steel
HRSA and other sticky materials.
Outstanding chip control at low feeds and small depths of cut.

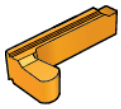
Good surface finish. Sharp cutting edge.
Available as CoroCut 2-edge inserts.

■ = Recommended starting value.

For cutting speed recommendations, see page B138.

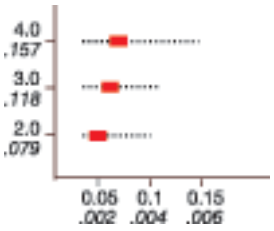
CoroCut® 1- and 2-edge inserts

Profiling



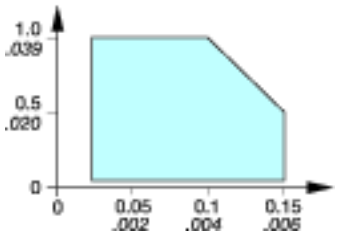
123-RS

Radial feed
Insert width (l_a), mm, inch

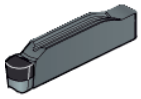


Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



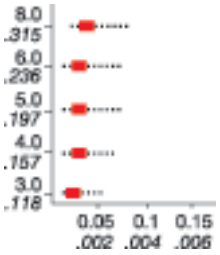
Feed (f_n), mm/r, inch/r



123-RE

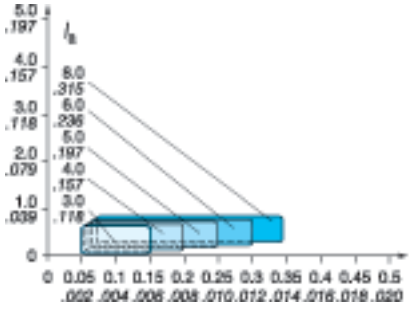
Cubic boron nitride tipped

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



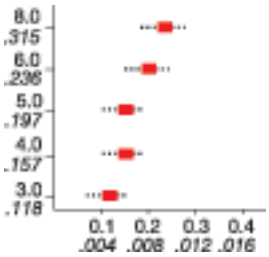
Feed (f_n), mm/r, inch/r

Alternative for finish profiling of hardened materials.
Gives outstanding productivity and exceptional surface finish.
Available as CoroCut 1-edged inserts.

123-RS

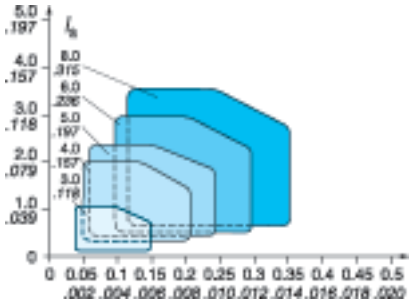
Diamond tipped

Radial feed
Insert width (l_a), inch



Feed (f_n), inch/r

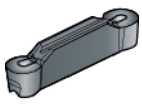
Axial feed
Cutting depth (a_p), inch



Feed (f_n), inch/r

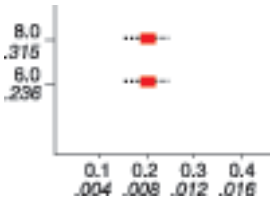
Alternative for finish profiling of non-ferrous materials.
Gives outstanding productivity and exceptional surface finish.
For use under stable conditions.
Available as CoroCut 1-edged inserts.

Aluminum profiling



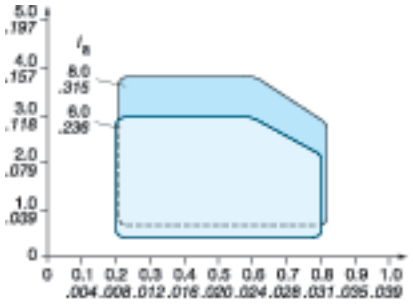
123-AM

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

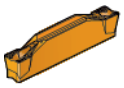
First choice for profiling in non-ferrous materials.
Good chip flow giving good surface finish.
Sharp cutting edge.
Available as CoroCut 2-edge inserts.

■ = Recommended starting value.

For cutting speed recommendations, see page B138.

CoroCut® 1- and 2-edge inserts

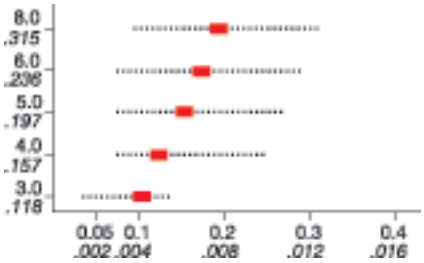
Turning and plunge turning



123-TF

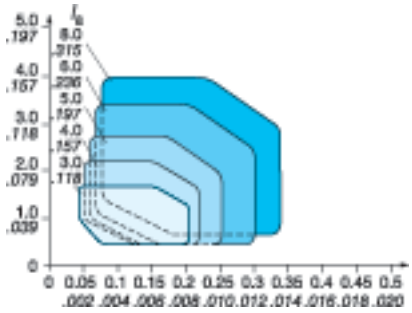
Low feed choice

Radial feed
Insert width (l_a), mm, inch



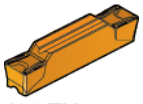
Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

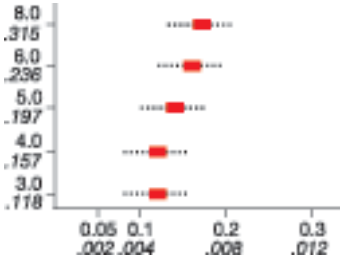
The first choice for plunge turning and face grooving
Suitable for all turning operations in stainless steels.
The positive geometry eliminates the risk of built-up edge.
Good chip control and surface finish.
Wiper design on the side.
Available as CoroCut 1 and 2-edged inserts.
First choice for facegrooving.



123-TM

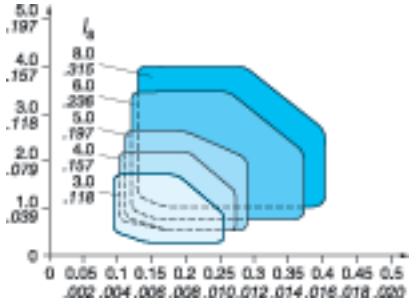
Medium feed choice

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

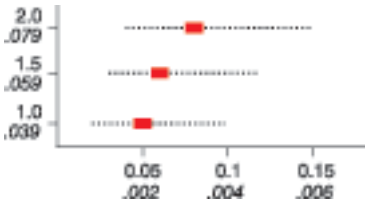
General turning operations
The positive geometry eliminates the risk of built-up edge.
Available as CoroCut 2-edge inserts.

CoroCut® 3-edge inserts

Shallow parting

123-CM

Radial feed
Insert width (l_a), mm, inch

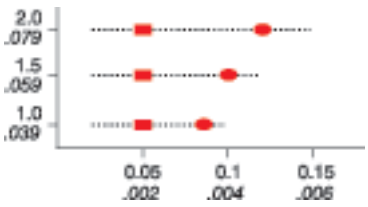


Feed (f_n), mm/r, inch/r

First choice for shallow parting
First choice in most materials
Sharp edge line, chip breaking geometry
To be used at normal cutting speeds 100 – 250 m/min (330 – 820 ft/min)

123-CS

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

First choice for shallow parting at low speeds.
For sticky materials and ball bearing materials
Extremely sharp edge line with an open chip former
To be used for non-ferrous materials at normal cutting speeds 100 – 250 m/min (330 – 820 ft/min)

■ = Recommended starting value at normal speeds
● = Recommended starting value at low speeds

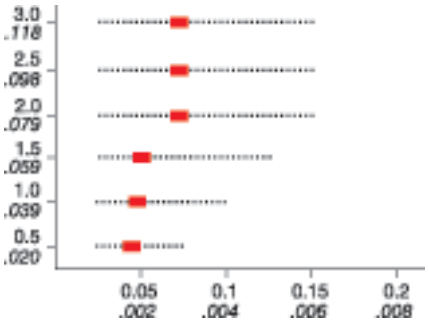
For cutting speed recommendations, see page B138.

CoroCut® 3-edge inserts

Grooving

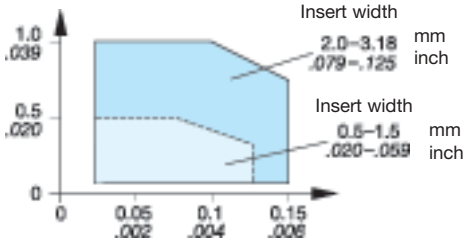
123-GS

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch

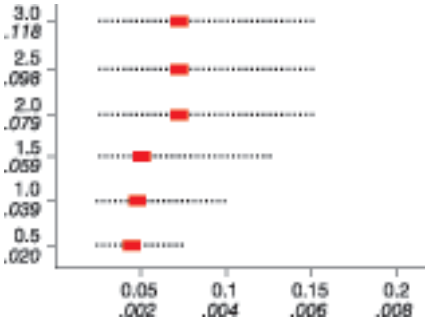


Feed (f_n), mm/r, inch/r

Profiling

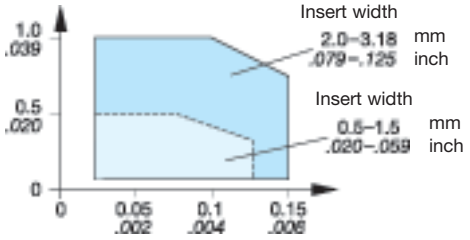
123-RS

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



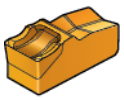
Feed (f_n), mm/r, inch/r

■ = Recommended starting value at normal speeds
● = Recommended starting value at low speeds

For cutting speed recommendations, see page B138.

T-Max Q-Cut® 151.2 inserts

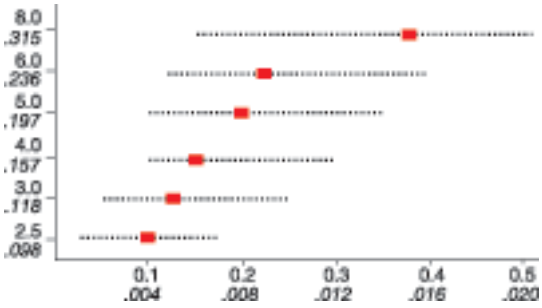
Parting



151.2-4E

High feed choice

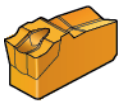
Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

First choice for parting off bars

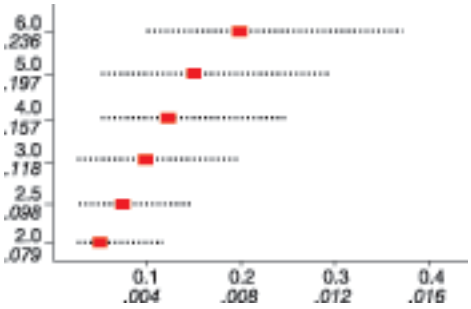
Strong geometry ideal for interrupted cuts.
For parting off steel and cast iron.
Good chip control at high feeds.



151.2-5E

High feed choice

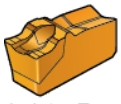
Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

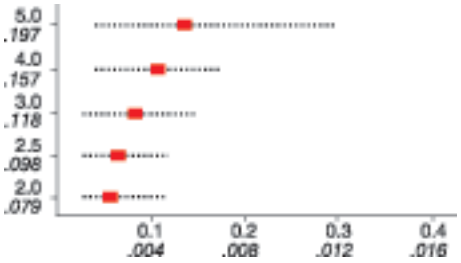
First choice for parting off tubes

Particularly recommended for thin-walled tubes and small diameter components in all materials.
For parting off stainless steel.



151.2-5F

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

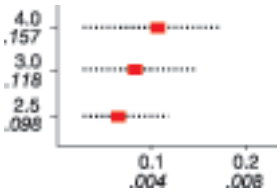
Optimizer to minimize pips and burrs on components due to sharp cutting edge, with a wide choice of front angles

Recommended for stainless steels, ductile and work hardening materials.

151.2-7E

Low feed choice

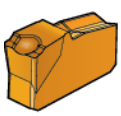
Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

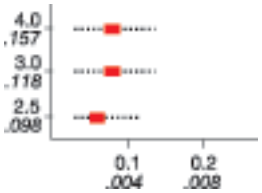
Alternative for good chip control at low feeds

Soft cutting action.
Low cutting forces.
Generates good surface finish due to Wiper design.
Very good chip control.



151.2-9E

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Optimizer for ball bearing operations and long chipping materials.

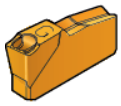
Good chip control giving high productive and problem-free machining.

■ = Recommended starting value.

For cutting speed recommendations, see page B138.

T-Max Q-Cut® 151.2 inserts

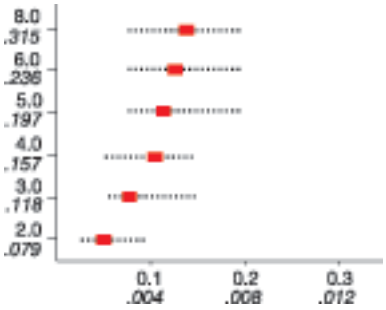
Grooving



151.2-5G

Medium feed choice

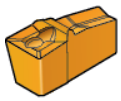
Radial feed
Insert width (l_3), mm, inch



Feed (f_n), mm/r, inch/r

First choice for general purpose grooving.

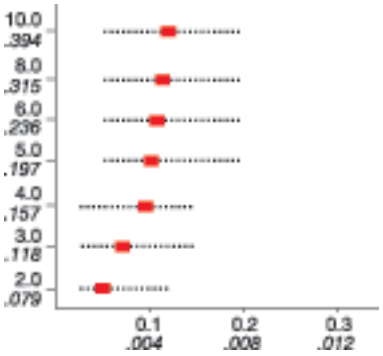
Outstanding chip control.
Reduces chip width giving good surfaces.
For grooving in all materials



151.2-4G

Low feed choice

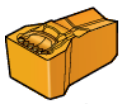
Radial feed
Insert width (l_3), mm, inch



Feed (f_n), mm/r, inch/r

Alternative choice for precision grooving.

Good accuracy and repeatability due to tight tolerances on inserts.
Low cutting forces and good chip control in a wide range of materials.
Sharp cutting edge.
Can be ordered as Tailor Made with different insert width and corner radii.

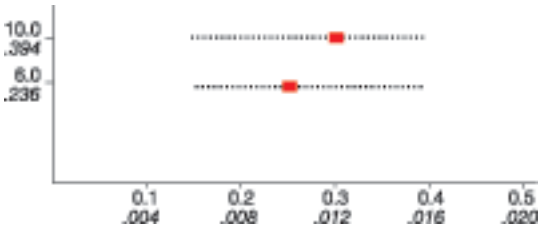


151.2-6G

Wiper TECHNOLOGY

High feed choice

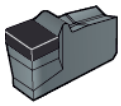
Radial feed
Insert width (l_3), mm, inch



Feed (f_n), mm/r, inch/r

Alternative choice when chip control is of prime importance at high production rates.

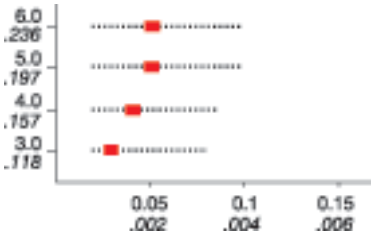
Particularly recommended for mass production operations, e.g. cam shaft production.



151.2-EG

Cubic boron nitride tipped

Radial feed
Insert width (l_3), inch



Feed (f_n), mm/r, inch/r

Alternative for finish grooving of hardened materials

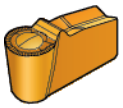
Maintains close tolerances and gives excellent finish on components.

■ = Recommended starting value.

For cutting speed recommendations, see page B138.

T-Max Q-Cut® 151.2 inserts

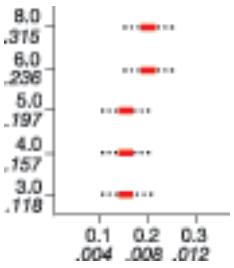
Profiling



151.2-5P

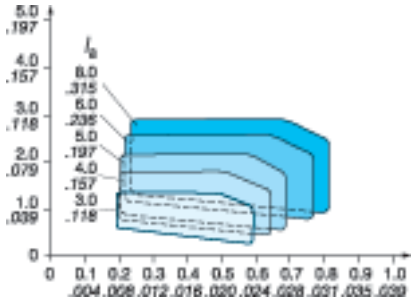
Medium feed choice

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

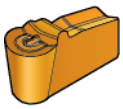
Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

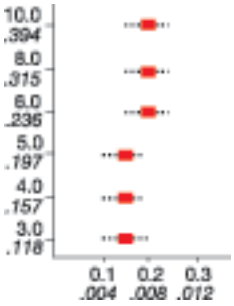
First choice for profiling in all materials.

Outstanding chip control even at low feeds and small depths of cut. Generates good surface finish.
For profiling in all materials.



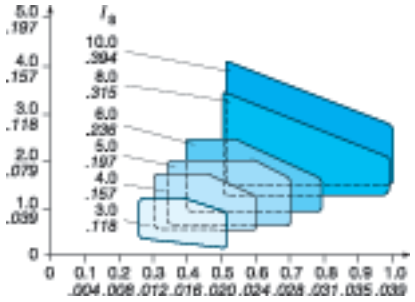
151.2-4P

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

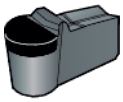
Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

Optimizer for profiling and turning in stainless steels and heat resistant materials where there is a risk of built-up edges forming.

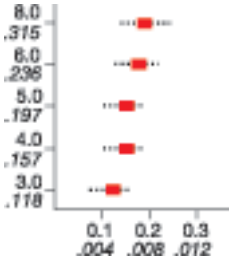
Generates excellent surface finish. Recommended for stainless steels and heat resistant materials. Diamond coated (grade CD1810) is a good alternative for finish profiling of non-ferrous materials.



151.2-F-P

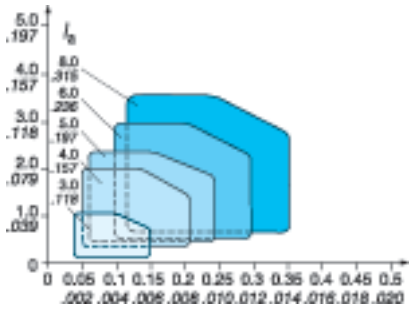
Diamond tipped

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

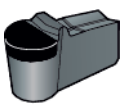
Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

Alternative for finish profiling of non-ferrous materials.

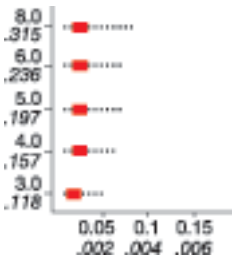
Gives outstanding productivity and exceptional surface finish.
For use under stable conditions.



151.2-E-P

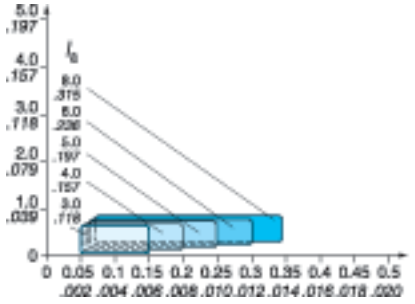
Cubic boron nitride tipped

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

Alternative for finish profiling of hardened materials.

Gives outstanding productivity and exceptional surface finish.

■ = Recommended starting value.

For cutting speed recommendations, see page B138.

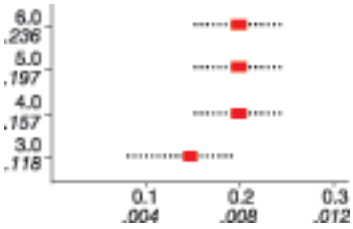
T-Max Q-Cut® 151.2 inserts

Turning

151.2-5T

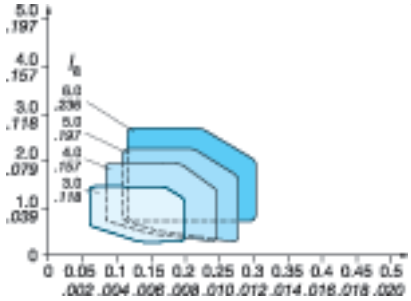
Medium feed choice

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

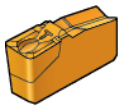
Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

First choice for turning with Q-Cut® .

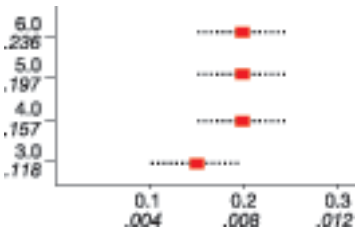
Good chip control.
Versatile - one insert can replace two conventional (one left and one right hand).



151.2-4T

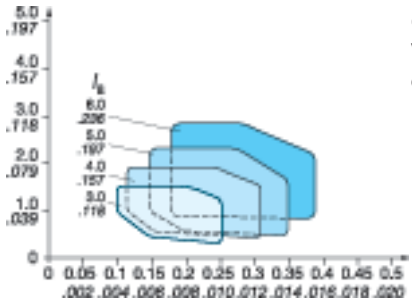
High feed choice

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

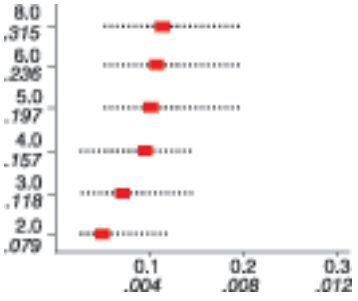
Alternative, especially for turning with high feeds.

Good chip control.
Versatile-one insert can replace two conventional (one right and one left hand insert).

Undercutting

151.2-4U

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

For the turning of reliefs and undercuts.

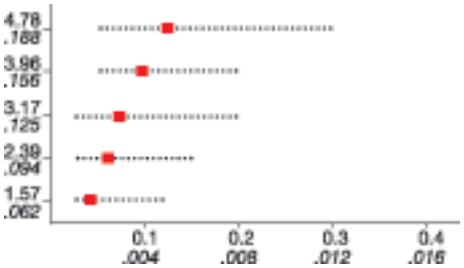
Large clearance angle permits undercutting of smaller diameters down 23 mm (.906 inch).

Parting

First choice for Multi-Spindle machines

151.2-3F

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

First choice for parting off in low speed applications.

Parting and breakdown where cutting oil is applied
Parallel wiper design for excellent flatness and surface finish.
Insert widths of 1.57, 2.39, 3.17, 3.96 mm (.062, .094, .125, .156 inch)
Neutral 5°, 10° and 15° right hand front angle

■ = Recommended starting value.

For cutting speed recommendations, see page B138.

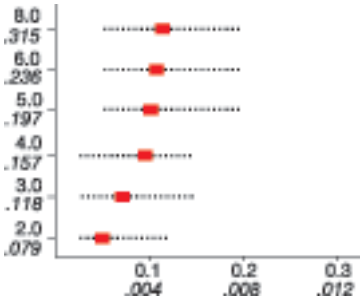
T-Max Q-Cut® 151.3 inserts

Internal grooving

151.3-4G

Low feed choice

Radial feed
Insert width (l_a), mm, inch



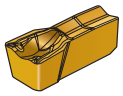
Feed (f_n), mm/r, inch/r

Note:
Inserts type 151.3 (-4G, -7G and -7P) can only be used with holders type F151.37 or bars type AG151.32

Alternative choice for internal grooving of smallest bores.

Good accuracy and repeatability due to tight tolerances on inserts.
Low cutting forces and good chip control in a wide range of materials.
Sharp cutting edge.

Face grooving

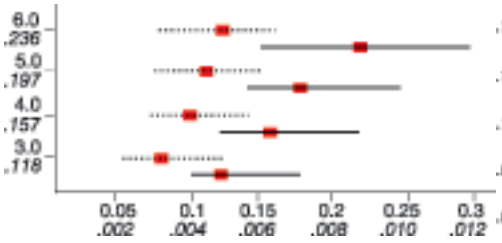


151.3-7G

Wiper TECHNOLOGY

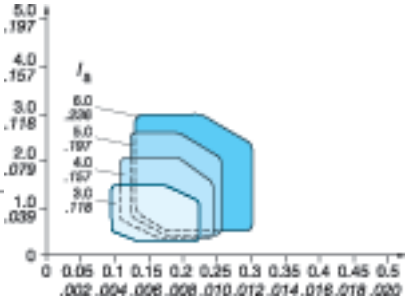
Medium feed choice

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

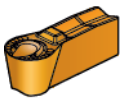
..... = Axial feed, approx. range, inch/r, first cut
——— = Axial feed, approx. range, inch/r, opening cut

First choice for facegrooving.

Good chip control both when cutting first groove and opening up. Smaller diameter grooves can be cut. Excellent stability.
For facegrooving in all materials.

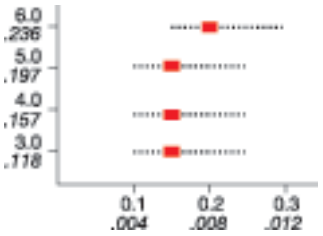
First choice for internal turning/grooving

Good chip control.
Generates good surface finish due to Wiper design.



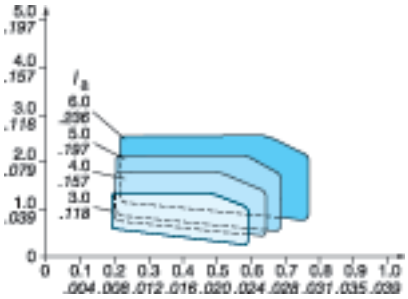
151.3-7P

Radial feed
Insert width (l_a), mm, inch



Feed (f_n), mm/r, inch/r

Axial feed
Cutting depth (a_p), mm, inch



Feed (f_n), mm/r, inch/r

For profiling in face grooving operations.

Good chip control in both axial and radial direction.
Also well suited for internal profiling operations.

■ = Recommended starting value.

For cutting speed recommendations, see page B138.

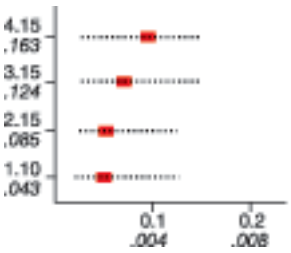
SANDVIK Coromant

CoroThread®

Circlip grooving

254R/LG

Radial feed
Insert width (f_a), mm, inch



Feed (f_n), mm/r, inch/r

Alternative for good economy when grooving circlips.

High productivity and reliability through low cutting forces and little vibration.
Three cutting edges give good economy.
Recommended for use in all materials.

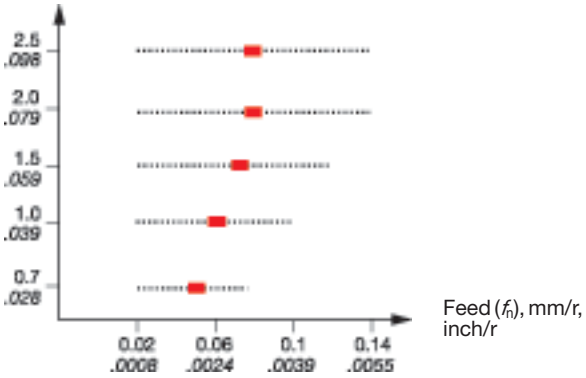
■ = Recommended starting value.

For cutting speed recommendations, see page B138.

Cutting data recommendations for CoroCut® XS

Parting off

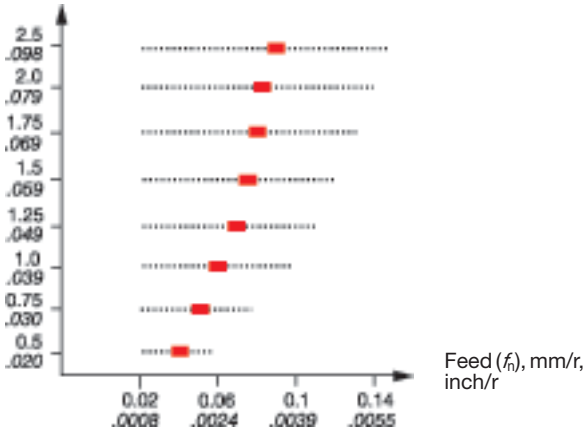
Insert width (l_a), mm, inch



■ = Recommended starting value.

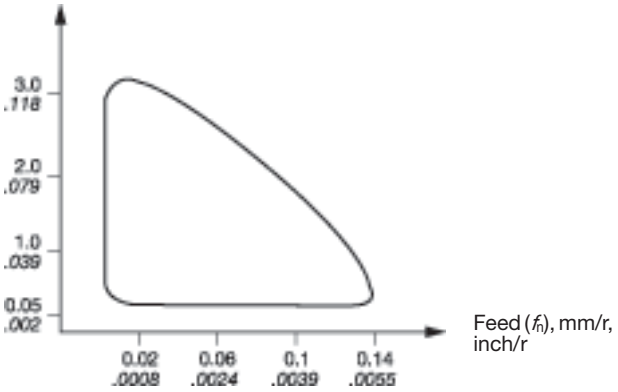
Grooving

Insert width (l_a), mm, inch



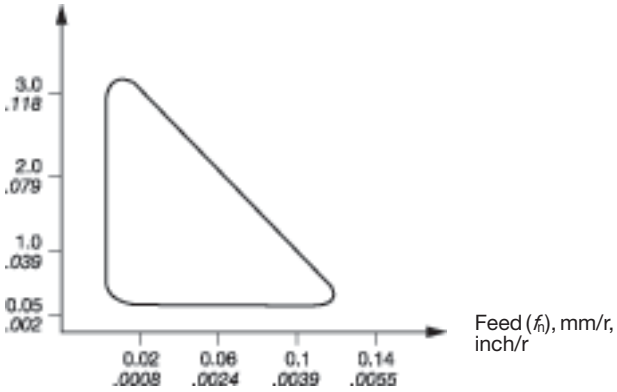
Turning

Cutting depth (a_p), mm, inch



Back turning

Cutting depth (a_p), mm, inch



Threading (Infeed recommendations)

Metric 60°

Pitch, mm	a_p mm	a_p inch	*nap*
0.20	0.12	.005	4
0.25	0.15	.006	4
0.30	0.18	.007	4
0.35	0.20	.008	4
0.40	0.25	.010	4
0.45	0.28	.011	4
0.50	0.28	.011	4
0.75	0.46	.018	4
1.00	0.61	.024	5
1.25	0.74	.029	6
1.50	0.89	.035	6
1.75	1.07	.042	8
2.00	1.22	.048	8

Can be used for thread types:
– ISO metric 60°
– UN 60°
– NPT

a_p = total depth of thread
nap = number of passes

UN 60°

Pitch, TPI	a_p mm	a_p inch	*nap*
72	0.22	.0086	4
64	0.25	.0098	4
56	0.28	.0110	4
48	0.33	.0129	4
44	0.36	.0142	4
40	0.40	.0157	4
36	0.43	.0169	4
32	0.49	.0193	5
28	0.56	.0220	5
24	0.65	.0256	5
20	0.80	.0315	6
18	0.86	.0339	6
16	0.97	.0382	7
14	1.12	.0441	8
13	1.19	.0469	8
12	1.30	.0512	9

Cutting speed recommendations

Cutting speed (v_c), m/min (ft/min)

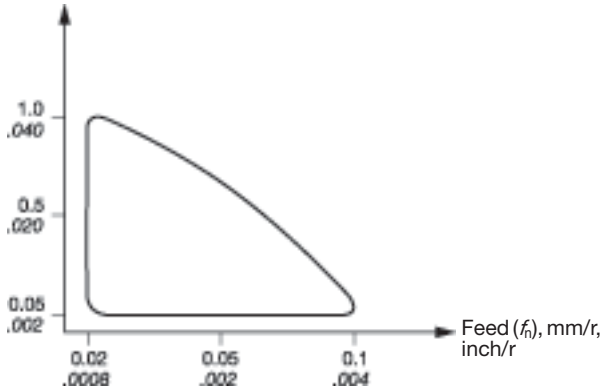
Grade 1025/1105	P	M	N	S
	60-200 (195-1020)	60-180 (300-920)	90-400 (450-2030)	20-50 (100-250)

Cutting data recommendations for CoroCut® MB

Turning

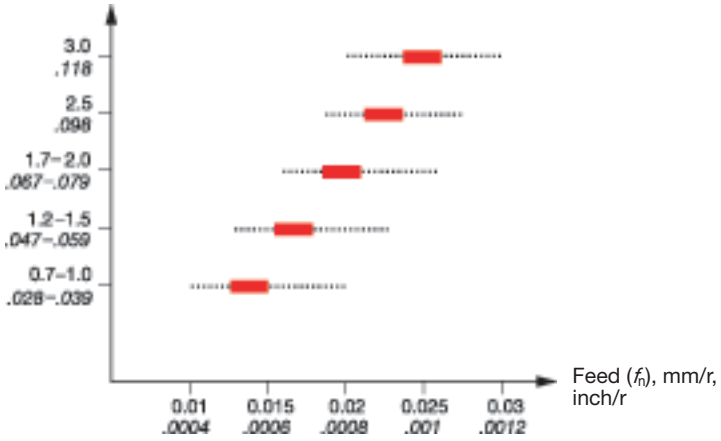
Insert size 07

Cutting depth (a_p), mm, inch



Grooving and face grooving

Insert width (l_a), mm, inch



■ = Recommended starting value.

Threading (Infeed recommendations)

Thread	Insert	a_p mm	a_p inch	*nap*
V-profile 60°	MB-07TH050VM-10R/L	0.33	.013	4
	MB-07TH100VM-10R/L	0.64	.025	5
	MB-07TH150VM-10R/L	0.89	.035	6
	MB-07TH200VM-10R/L	1.19	.047	8
	MB-07TH250VM-10R/L	1.50	.059	10
Metric 60°	MB-07TH050MM-10R/L	0.33	.013	4
	MB-07TH100MM-10R/L	0.64	.025	5
	MB-07TH150MM-10R/L	0.89	.035	6
	MB-07TH175MM-10R/L	1.07	.042	8
	MB-07TH200MM-10R/L	1.19	.047	8
	MB-07TH250MM-10R/L	1.50	.059	10
UN 60°	MB-07TH320UN-10R/L	0.48	.019	4
	MB-07TH280UN-10R/L	0.58	.023	5
	MB-07TH240UN-10R/L	0.66	.026	5
	MB-07TH200UN-10R/L	0.79	.031	6
	MB-07TH180UN-10R/L	0.86	.034	6
	MB-07TH160UN-10R/L	0.94	.037	7
	MB-07TH140UN-10R/L	1.09	.043	8
Whitworth 55°	MB-07TH190WH-10R/L	0.91	.036	6
	MB-07TH140WH-10R/L	1.21	.048	8
	MB-07TH110WH-10R/L	1.54	.061	9
NPT 60°	MB-07TH180NT-10R/L	1.11	.044	8
	MB-07TH140NT-10R/L	1.42	.056	10

Thread	Insert	a_p mm	a_p inch	*nap*
ACME 29°	MB-07TH160AC-11R	0.96	.038	6
	MB-07TH140AC-11R	1.09	.043	7
	MB-07TH120AC-11R	1.24	.049	8
	MB-07TH100AC-11R	1.60	.063	10
	MB-07TH080AC-11R	1.90	.075	12
STUB-ACME 29°	MB-07TH160SA-10R	0.66	.026	5
	MB-07TH140SA-10R	0.74	.029	5
	MB-07TH120SA-10R	0.81	.032	6
	MB-07TH100SA-10R	1.09	.043	7
	MB-07TH080SA-10R	1.27	.050	8

a_p = total depth of thread
nap = number of passes

Cutting speed recommendations

Cutting speed (v_c), m/min (ft/min)

	P	M	N	S
Grade 1025	60-200 (185-655)	60-180 (195-590)	90-400 (295-1310)	20-50 (65-165)

	H
Grade CB7015	60-200 (200-600)

Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO P		Steel	Specific cutting force k_c 0.4	Hardness Brinell	<<<< WEAR RESISTANCE		
					CT525	GC3115	GC3020
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.05-0.5	0.05-0.5	0.05-0.5
MC No.	No.	Material	N/mm²	HB	Cutting speed (V_c), m/min		
		Unalloyed					
P1.1.Z.AN	01.1	C = 0.1–0.25%	2000	125	235-170	355-185	355-185
P1.2.Z.AN	01.2	C = 0.25–0.55%	2100	150	220-155	330-140	330-140
P1.3.Z.AN	01.3	C = 0.55–0.80%	2200	170	210-145	300-125	300-125
		Low-alloy ≤5%					
P2.1.Z.AN	02.1	Non-hardened	2150	180	205-145	290-135	290-135
P2.5.Z.HT	02.2	Hardened and tempered	2550	275	185-120	270-105	270-105
P2.5.Z.HT	02.2	Hardened and tempered	2850	350	150-100	220-85	220-85
		High-alloy >5%					
P3.0.Z.AN	03.11	Annealed	2500	200	130-100	260-115	260-115
P3.0.Z.HT	03.21	Hardened tool steel	3900	325	80-55	205-75	205-75
		Castings					
P1.5.C.UT	06.1	Unalloyed	2000	180	150-100	175-75	175-75
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	2100	200	135-85	200-90	200-90
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	2650	225	115-70	160-75	160-75
P3.2.C.AQ	06.33	Manganese steel, 12–14% Mn	3600	250	75-50	90-50	90-50

ISO M		Stainless steel	Specific cutting force k_c 0.4	Hardness Brinell	<<<< WEAR RESISTANCE		
					CT525	GC1105	GC1005
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.05-0.5	0.05-0.5	0.05-0.5
MC No.	No.	Material	N/mm²	HB	Cutting speed (V_c), m/min		
		Ferritic/martensitic					
		Bars/forged					
P5.0.Z.AN	05.11	Non-hardened	2300	200	195-135	400-175	400-175
P5.0.Z.PH	05.12	PH-hardened	3550	330	135-95	215-95	215-95
P5.0.Z.HT	05.13	Hardened	2850	330	150-100	255-110	255-110
		Austenitic					
		Bars/forged					
M1.0.Z.AQ	05.21	Austenitic	2300	180	190-130	435-190	435-190
M1.0.Z.PH	05.22	PH-hardened	3550	330	115-80	235-100	235-100
M2.0.Z.AQ	05.23	Super austenitic	2950	200	130-90	260-115	260-115
		Austenitic-ferritic (Duplex)					
		Bars/forged					
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	2550	230	115-90	335-145	335-145
M3.2.Z.AQ	05.52	Weldable < 0.05%C	3050	260	90-70	300-130	300-130
		Ferritic/martensitic					
		Cast					
P5.0.C.UT	15.11	Non-hardened	2100	200	165-115	-	-
P5.0.C.HT	15.13	Hardened	2650	330	110-75	-	-
		Austenitic					
		Cast					
M1.0.C.UT	15.21	Austenitic	2200	180	160-110	-	-
	15.22	PH-hardened	3150	330	95-65	-	-
		Austenitic-ferritic (Duplex)					
		Cast					
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	2250	230	100-80	-	-
M3.2.C.AQ	15.52	Weldable < 0.05%C	2750	260	80-60	-	-

ISO K		Cast iron	Specific cutting force k_c 0.4	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC3115	GC3020	GC4225
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.05-0.5	0.05-0.5	0.05-0.5
MC No.	No.	Material	N/mm²	HB	Cutting speed (V_c), m/min		
		Malleable					
	07.1	Ferritic (short chipping)	940	130	340-170	325-160	320-170
K1.1.C.NS	07.2	Pearlitic (long chipping)	1100	230	250-115	240-110	235-110
		Gray					
K2.1.C.UT	08.1	Low tensile strength	1100	180	290-140	275-135	275-130
K2.2.C.UT	08.2	High tensile strength	1150	220	250-120	235-115	240-115
		Nodular SG iron					
K3.1.C.UT	09.1	Ferritic	1050	160	260-115	245-110	250-105
K3.3.C.UT	09.2	Pearlitic	1750	250	205-100	195-90	195-90
K3.4.C.UT	09.3	Martensitic	2700	380	145-70	140-65	140-70

TOUGHNESS >>>>

GC4225	GC1115	GC1125	GC1025	GC2135	GC1145	GC235	
0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	
340-180 315-140 290-120	360-180 325-145 290-130	295-145 265-115 235-105	235-115 210-90 185-85	205-100 180-75 175-70	200-100 185-75 175-70	165-130 150-120 140-105	
280-130 265-100 215-80	290-135 250-115 200-95	235-110 205-95 165-75	185-85 165-75 135-60	175-80 155-70 125-55	180-85 165-70 130-55	140-110 120-85 95-70	
255-105 195-75	255-115 185-75	205-95 150-65	170-75 120-50	155-70 105-45	160-75 105-45	70-60 45-33	
165-70 190-85 130-95 85-45	- - - -	135-65 160-85 120-50 70-40	110-55 130-65 80-45 55-30	105-50 120-60 90-40 50-29	110-50 125-65 85-38 -	100-70 90-55 80-45 100-80	

TOUGHNESS >>>>

GC1115	GC1125	GC1025	GC2135	GC1145	GC235	H13A	
0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	
235-110 185-85 200-90	190-85 150-65 160-70	160-70 120-55 130-55	145-65 110-45 120-50	150-60 110-45 125-50	130-100 90-70 100-75	90-70 60-40 70-50	
265-125 185-90 200-95	215-100 150-70 160-75	175-80 120-55 130-60	165-70 105-50 115-55	165-65 110-50 105-50	125-95 75-55 85-65	100-65 50-33 65-45	
225-105 185-90	180-85 150-70	145-70 120-55	135-60 110-50	145-60 115-50	125-95 95-70	- -	
215-100 -	175-80 145-65	140-65 120-50	130-60 110-45	140-55 115-45	110-85 70-55	75-60 50-38	
230-110 150-80	185-90 120-65	150-70 95-50	135-60 90-45	145-60 90-45	105-80 65-50	70-45 45-29	
195-95 155-80	155-75 125-65	125-60 105-50	115-55 95-45	120-55 95-45	110-85 85-60	- -	

TOUGHNESS >>>>

GC1125	GC1025	H13A					
0.05-0.5	0.05-0.5	0.05-0.5					
255-125 170-95	205-100 140-75	100-85 70-55					
210-110 175-90	170-85 140-70	80-65 80-60					
185-95 150-75 100-55	150-80 120-60 85-45	70-55 60-45 40-30					

Cutting speed recommendations, metric values

The recommendations are valid for use with cutting fluid.

ISO N		Non-ferrous material	Specific cutting force k_c 0.4	Hardness Brinell	<<<< WEAR RESISTANCE		
					CD10	GC1005	H10
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.05-0.5	0.06-0.31	0.05-0.8
MC No.	No.	Material	N/mm²	HB	Cutting speed (V_c), m/min		
		Aluminum alloys					
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	500	60	2100 (2650 - 265)	1900 (2400 - 240)	1800 (2250-225)
N1.2.Z.AG	30.12		800	100	2100 (2650 - 265)	1900 (2400 - 240)	1800 (2250-225)
		Aluminum alloys					
N1.3.C.UT	30.21	Cast, non-aging	750	75	2100 (2650 - 265)	1900 (2400 - 240)	1800 (2250-225)
N1.3.C.AG	30.22	Cast or cast and aged	900	90	2100 (2650 - 265)	1900 (2400 - 240)	1800 (2250-225)
		Aluminum alloys					
	30.41	Cast, 13–15% Si	950	130	1600 (2000 - 200)	500 (630 - 65)	450 (560-55)
N1.4.C.NS	30.42	Cast, 16–22% Si	950	130	800 (1000 - 100)	350 (440 - 45)	300 (375-38)
		Copper and copper alloys					
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	700	110	600 (750 - 75)	500 (630 - 65)	500 (630-65)
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	700	90	600 (750 - 75)	500 (630 - 65)	500 (630-65)
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	1750	100	300 (375 - 38)	300 (375 - 38)	300 (375-38)

ISO S		Heat resistant super alloys	Specific cutting force k_c 0.4	Hardness Brinell	<<<< WEAR RESISTANCE		
					S05F	GC1105	GC1005
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.05-0.3	0.05-0.3	0.05-0.3
MC No.	No.	Material	N/mm²	HB	Cutting speed (V_c), m/min		
		Iron base					
S1.0.U.AN	20.11	Annealed or solution treated	3000	200	200-135	180-120	70-38
S1.0.U.AG	20.12	Aged or solution treated and aged	3050	280	165-110	150-100	150-100
		Nickel base					
S2.0.Z.AN	20.21	Annealed or solution treated	3300	250	100-60	90-55	90-55
S2.0.Z.AG	20.22	Aged or solution treated and aged	3600	350	90-60	80-50	80-50
S2.0.C.NS	20.24	Cast or cast and aged	3700	320	80-50	70-45	70-45
		Cobalt base					
S3.0.Z.AN	20.31	Annealed or solution treated	3300	200	100-65	90-60	90-60
S3.0.Z.AG	20.32	Solution treated and aged	3700	300	90-55	80-50	80-50
S3.0.C.NS	20.33	Cast or cast and aged	3800	320	80-50	70-45	70-45
		Titanium alloys1)		**Rm2)**			
S4.1.Z.UT	23.1	Commercial pure (99.5% Ti)	1550	400	-	-	-
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	1700	950	-	-	-
S4.3.Z.AG	23.22	α + β alloys in aged conditions, β alloys, annealed or aged	1700	1050	-	-	-

ISO H		Material	Specific cutting force k_c 0.4	Hardness Brinell	<<<< WEAR RESISTANCE		
					CB20	CC670	CB7015
					h_{ex}, mm ≈ feed f_n, mm/r		
	CMC				0.05-0.1	0.05-0.1	0.05-0.1
MC No.	No.	Hardened material	N/mm²	HB	Cutting speed (V_c), m/min		
		Extra hard steel					
H1.3.Z.HA	04.1	Hardened and tempered	5550	60 HRC	125-120	110-100	145-135
		Chilled					
H2.0.C.UT	10.1	Cast or cast and aged	2800	400	200-195	110-100	-

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

2) Rm = ultimate tensile strength measured in MPa.

TOUGHNESS >>>>							
GC1125	**GC1025**	**H13A**					
0.05-0.8	0.05-0.8	0.05-0.8					
1500 (1900 - 190) 1500 (1900 - 190)	1500 (1900 - 190) 1500 (1900 - 190)	1500 (1900 - 190) 1500 (1900 - 190)					
1500 (1900 - 190) 1500 (1900 - 190) 400 (500 - 50) 250 (315 - 31)	1500 (1900 - 190) 1500 (1900 - 190) 400 (500 - 50) 250 (315 - 31)	1500 (1900 - 190) 1500 (1900 - 190) 400 (500 - 50) 250 (315 - 31)					
350 (440 - 45) 400 (500 - 50) 250 (315 - 31)	350 (440 - 45) 400 (500 - 50) 250 (315 - 31)	350 (440 - 45) 400 (500 - 50) 250 (315 - 31)					

TOUGHNESS >>>>									
H10	**GC1115**	**GC1125**	**GC1025**	**H13A**	**GC2135**	**GC1145**	**GC235**	**CC670**	**CB7015**
0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3	0.05-0.3
- -	100-55 70-40	80-45 55-33	60-35 45-28	50-37 40-26	50-29 40-26	45-34 45-30	50-37 40-26	- -	- -
- - -	65-40 60-32 45-23	50-32 45-26 35-18	45-28 40-22 30-16	30-23 20-13 20-13	40-26 35-21 25-10	29-23 19-13 20-13	30-23 20-13 20-13	600-320 500-250 250-120	400-300 350-250 200-125
- - -	70-50 60-32 45-23	55-38 45-26 35-18	50-33 40-22 30-16	35-27 23-15 20-13	45-28 35-17 25-14	34-23 23-12 19-13	35-27 23-15 20-13	410-220 350-210 320-150	250-150 250-150 200-125
190-150	310-140	220-100	190-95	175-145	170-80	-	-	-	-
80-60 70-55	100-55 95-45	80-45 75-37	65-37 60-32	70-60 65-55	- -	- -	- -	- -	- -

TOUGHNESS >>>>								

Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO P		Steel	Specific cutting force k_c .016	Hardness Brinell	<<<< WEAR RESISTANCE		
					CT525	GC3115	GC3020
					Feed f_n, inch/rev		
	CMC				.002-.020	.002-.020	.002-.020
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Unalloyed					
P1.1.Z.AN	01.1	C = 0.1–0.25%	288,500	125	770-550	1150-610	1150-610
P1.2.Z.AN	01.2	C = 0.25–0.55%	306,000	150	720-510	1050-460	1050-460
P1.3.Z.AN	01.3	C = 0.55–0.80%	317,000	170	690-475	980-405	980-405
		Low-alloy ≤5%					
P2.1.Z.AN	02.1	Non-hardened	308,000	180	670-475	950-440	950-440
P2.5.Z.HT	02.2	Hardened and tempered	371,500	275	600-400	880-335	880-335
P2.5.Z.HT	02.2	Hardened and tempered	413,500	350	485-320	710-270	710-270
		High-alloy >5%					
P3.5.Z.AN	03.11	Annealed	361,500	200	425-320	840-375	840-375
P3.5.Z.HT	03.21	Hardened tool steel	563,500	325	260-180	670-245	670-245
		Castings					
P1.5.C.UT	06.1	Unalloyed	289,000	180	490-330	570-235	570-235
P2.6.C.UT	06.2	Low-alloy (alloying elements ≤5%)	302,500	200	440-280	650-290	650-290
P3.0.C.UT	06.3	High-alloy (alloying elements >5%)	385,000	225	375-230	520-245	520-245
P3.2.C.AQ	06.33	Manganese steel, 12–14% Mn	521,500	250	245-165	290-155	290-155

ISO M		Stainless steel	Specific cutting force k_c .016	Hardness Brinell	<<<< WEAR RESISTANCE		
					CT525	GC1105	GC1005
					Feed f_n, inch/rev		
	CMC				.002-.020	.002-.020	.002-.020
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Ferritic/martensitic					
		Bars/forged					
P5.0.Z.AN	05.11	Non-hardened	334,500	200	640-440	1300-570	1300-570
P5.0.Z.PH	05.12	PH-hardened	514,500	330	450-310	710-305	710-305
P5.0.Z.HT	05.13	Hardened	414,000	330	485-330	840-365	840-365
		Austenitic					
		Bars/forged					
M1.0.Z.AQ	05.21	Austenitic	337,000	180	620-430	1450-610	1450-610
M1.0.Z.PH	05.22	PH-hardened	517,500	330	370-255	770-330	770-330
M2.0.Z.AQ	05.23	Super austenitic	428,000	200	420-290	860-370	860-370
		Austenitic-ferritic (Duplex)					
		Bars/forged					
M3.1.Z.AQ	05.51	Non-weldable ≥ 0.05%C	372,500	230	375-295	1100-475	1100-475
M3.2.Z.AQ	05.52	Weldable < 0.05%C	445,500	260	295-225	980-420	980-420
		Ferritic/martensitic					
		Cast					
P5.0.C.UT	15.11	Non-hardened	304,500	200	540-375	-	-
P5.0.C.HT	15.13	Hardened	385,000	330	355-245	-	-
		Austenitic					
		Cast					
M1.0.C.UT	15.21	Austenitic	316,500	180	520-360	-	-
	15.22	PH-hardened	456,000	330	320-220	-	-
		Austenitic-ferritic (Duplex)					
		Cast					
M3.1.C.AQ	15.51	Non-weldable ≥ 0.05%C	329,500	230	335-260	-	-
M3.2.C.AQ	15.52	Weldable < 0.05%C	401,000	260	260-200	-	-

ISO K		Cast iron	Specific cutting force k_c .016	Hardness Brinell	<<<< WEAR RESISTANCE		
					GC3115	GC3020	GC4225
					Feed f_n, inch/rev		
	CMC				.002-.020	.002-.020	.002-.020
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Malleable					
	07.1	Ferritic (short chipping)	136,500	130	1100-560	1050-520	1050-550
K1.1.C.NS	07.2	Pearlitic (long chipping)	160,000	230	810-370	780-355	760-350
		Gray					
K2.1.C.UT	08.1	Low tensile strength	158,500	180	950-450	900-435	900-430
K2.2.C.UT	08.2	High tensile strength	164,500	220	810-395	770-370	780-370
		Nodular SG iron					
K3.1.C.UT	09.1	Ferritic	152,000	160	850-375	810-355	810-350
K3.3.C.UT	09.2	Pearlitic	252,000	250	670-325	640-290	640-300
K3.4.C.UT	09.3	Martensitic	390,500	380	470-230	455-220	450-220

TOUGHNESS >>>>

GC4225	GC1115	GC1125	GC1025	GC2135	GC1145	GC235	
.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	
1100-590 1050-460 950-395	1200-580 1050-470 950-415	960-475 860-380 770-340	770-370 680-295 610-270	670-330 590-250 570-235	650-330 600-245 570-225	530-430 490-385 460-345	
920-415 860-320 700-255	940-450 820-375 660-305	770-365 660-305 530-245	600-280 540-245 435-195	570-260 500-220 400-180	580-275 530-230 425-185	460-355 390-275 315-220	
830-345 640-235	830-380 600-250	670-305 490-205	550-250 395-160	500-225 335-140	520-235 350-140	230-205 145-110	
540-230 620-280 425-315 275-145	- - - -	440-210 520-275 395-170 225-130	365-175 425-220 265-155 180-95	335-160 390-200 295-130 160-95	360-170 410-205 280-120 -	325-220 295-185 260-155 325-260	

TOUGHNESS >>>>

GC1115	GC1125	GC1025	GC2135	GC1145	GC235	H13A	
.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	.002-.020	
770-355 600-275 650-295	620-285 480-220 520-235	520-230 385-170 420-185	470-210 350-150 385-165	485-195 365-150 410-170	425-320 300-225 320-245	295-225 195-130 220-170	
870-415 600-290 650-315	700-335 485-230 520-250	570-270 385-180 415-200	530-230 340-160 370-180	530-215 355-165 335-160	415-315 245-185 280-210	320-215 160-110 215-145	
730-350 610-295	580-280 490-235	475-225 390-185	440-190 360-165	470-195 375-165	410-310 310-230	- -	
700-325 -	560-260 470-215	455-205 390-170	425-190 360-150	450-175 375-150	360-275 235-180	250-190 165-125	
750-365 495-260	600-290 395-205	485-230 310-160	445-190 295-145	470-195 300-140	350-265 210-160	230-155 140-95	
640-305 510-265	510-245 405-210	410-190 335-165	375-170 300-145	- -	365-275 270-205	- -	

TOUGHNESS >>

GC1125	GC1025	H13A					
.002-.020	.002-.020	.002-.020					
830-415 560-310	670-325 455-255	325-275 230-175					
680-365 570-295	560-280 460-235	265-210 260-200					
600-320 485-250 330-180	490-225 390-200 270-140	230-175 195-145 135-100					

Cutting speed recommendations, inch values

The recommendations are valid for use with cutting fluid.

ISO N		Non-ferrous material	Specific cutting force k_c .016	Hardness Brinell	<<<< WEAR RESISTANCE		
					CD10	GC1005	H10
					Feed f_n, inch/rev		
	CMC				.002-.020	.006-.031	.002-.020
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Aluminum alloys					
N1.2.Z.UT	30.11	Wrought or wrought and coldworked, non-aging	72,500	60	6900 (8650-860)	6250 (7800-780)	5900 (7400-740)
N1.2.Z.AG	30.12		116,000	100	6900 (8650-860)	6250 (7800-780)	5900 (7400-740)
		Aluminum alloys					
N1.3.C.UT	30.21	Cast, non-aging	109,000	75	6900 (8650-860)	6250 (7800-780)	5900 (7400-740)
N1.3.C.AG	30.22	Cast or cast and aged	130,500	90	6900 (8650-860)	6250 (7800-780)	5900 (7400-740)
	30.41	Cast, 13–15% Si	138,000	130	5250 (6550-660)	1650 (2050-205)	1500 (1900-190)
N1.4.C.NS	30.42	Cast, 16–22% Si	138,000	130	2600 (3250-325)	1150 (1450-145)	980 (1250-125)
		Copper and copper alloys					
N3.3.U.UT	33.1	Free cutting alloys, ≥1% Pb	101,500	110	1950 (2450-245)	1650 (2050-205)	1650 (2050-205)
N3.2.C.UT	33.2	Brass, leaded bronzes, ≤1% Pb	101,500	90	1950 (2450-245)	1650 (2050-205)	1650 (2050-205)
N3.1.U.UT	33.3	Bronze and non-leaded copper incl. electrolytic copper	254,000	100	980 (1250-125)	980 (1250-125)	980 (1250-125)

ISO S		Heat resistant super alloys	Specific cutting force k_c .016	Hardness Brinell	<<<< WEAR RESISTANCE		
					S05F	GC1105	GC1005
					Feed f_n, inch/rev		
	CMC				.002-.012	.002-.012	.002-.012
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Iron base					
S1.0.U.AN	20.11	Annealed or solution treated	435,000	200	660-435	590-385	590-385
S1.0.U.AG	20.12	Aged or solution treated and aged	445,500	280	550-360	490-320	490-320
		Nickel base					
S2.0.Z.AN	20.21	Annealed or solution treated	479,500	250	330-200	295-185	295-185
S2.0.ZAG	20.22	Aged or solution treated and aged	522,000	350	295-200	265-165	265-165
S2.0.C.NS	20.24	Cast or cast and aged	538,500	320	255-160	235-150	235-150
		Cobalt base					
S3.0.Z.AN	20.31	Annealed or solution treated	478,500	200	330-215	295-185	295-185
S3.0.Z.AG	20.32	Solution treated and aged	540,000	300	295-180	265-165	265-165
S3.0.C.NS	20.33	Cast or cast and aged	552,000	320	255-160	235-150	235-150
Titanium		**Commercial pure**		**Rm[2]**			
S4.1.Z.UT	23.1	(99.5% Ti)	221,500	**400**	-	-	-
		Titanium alloys1)					
S4.2.Z.AN	23.21	α, near α and α + β alloys, annealed	243,000	**950**	-	-	-
S4.3.Z.AG	23.22		245,000	**1050**	-	-	-

ISO H		Hardened material	Specific cutting force k_c .016	Hardness Brinell	<<<< WEAR RESISTANCE		
					CB20	CC670	CB7015
					Feed f_n, inch/rev		
	CMC				.002-.004	.002-.004	.002-.004
MC No.	No.	Material	lbs/in²	HB	Cutting speed (V_c) ft/min		
		Extra hard steel					
H1.3.Z.HA	04.1	Hardened and tempered	804,500	60 HRC	420-400	355-320	475-450
		Chilled					
H2.0.C.UT	10.1	Cast or cast and aged	408,000	400	650-640	360-325	-

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

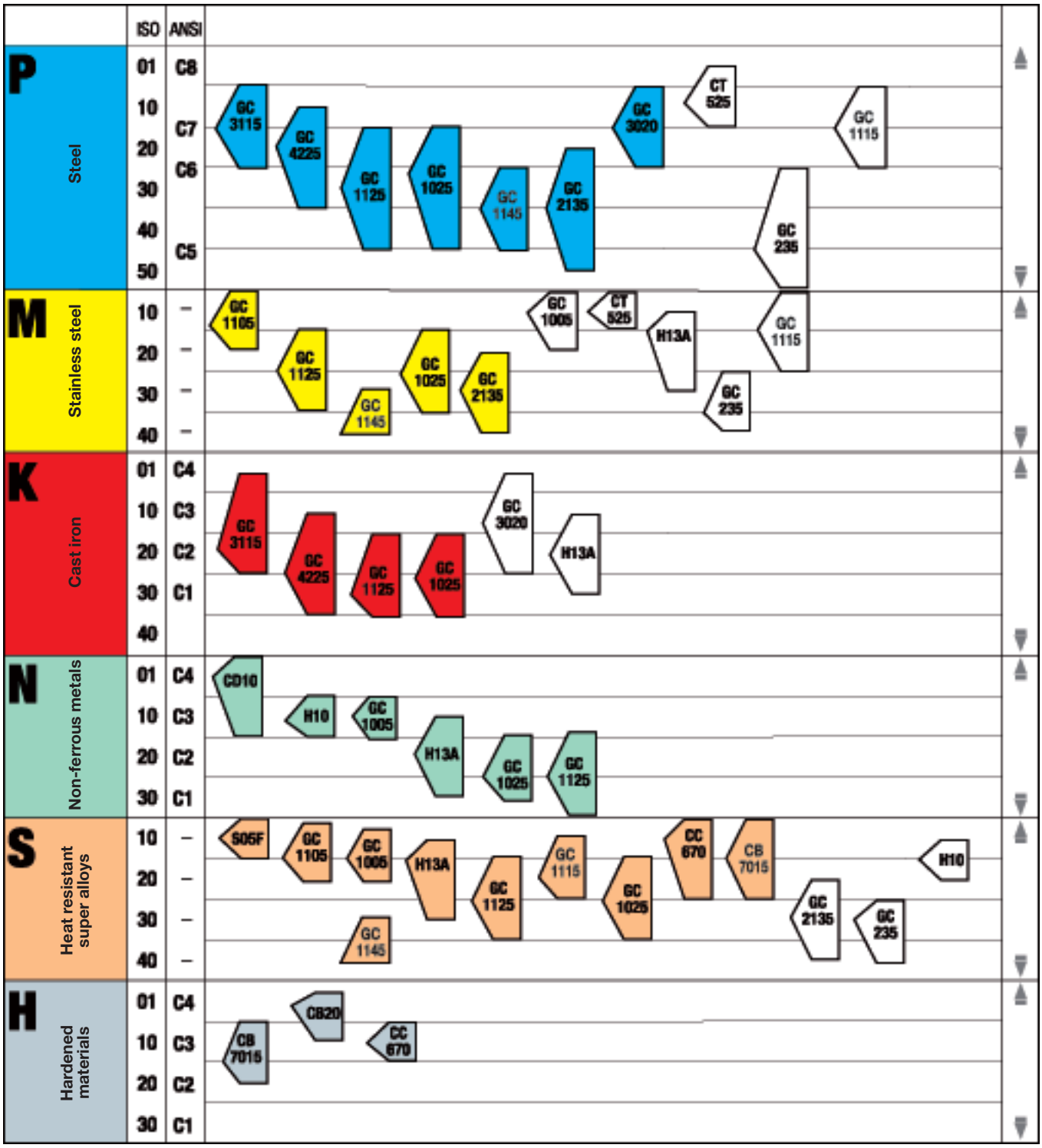
2) Rm = ultimate tensile strength measured in MPa.

TOUGHNESS >>>>						
GC1125	**GC1025**	**H13A**				
.002-.031	002-.031	.002-.031				
4900 (6150-610) 4900 (6150-610)	4900 (6150-610) 4900 (6150-610)	4900 (6150-610) 4900 (6150-610)				
4900 (6150-610) 4900 (6150-610)	4900 (6150-610) 4900 (6150-610)	4900 (6150-610) 4900 (6150-610)				
1300 (1650-165) 820 (1050-105) 1150 (1450-145) 1300 (1650-165) 820 (1050-105)	1300 (1650-165) 820 (1050-105) 1150 (1450-145) 1300 (1650-165) 820 (1050-105)	1300 (1650-165) 820 (1050-105) 1150 (1450-145) 1300 (1650-165) 820 (1050-105)				

TOUGHNESS >>>>									
H10	**GC1115**	**GC1125**	**GC1025**	**H13A**	**GC2135**	**GC1145**	**GC235**	**CC670**	**CB7015**
.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012	.002-.012
- -	330-180 235-135	260-140 185-110	195-115 145-90	165-120 130-85	165-95 130-85	150-145 115-75	165-120 130-85	- -	- -
- - -	215-130 190-105 140-75	170-105 150-85 115-60	145-90 130-75 100-50	100-75 65-45 65-45	130-85 115-70 80-31	95-75 65-40 65-40	100-75 65-45 65-45	1950-1050 1650-810 820-390	1300-980 1150-820 650-410
- - -	235-155 190-105 140-75	185-125 150-85 115-60	165-110 130-75 100-50	115-90 75-50 65-45	145-90 115-55 80-45	115-75 75-37 65-40	115-90 75-50 65-45	1350-720 1150-680 1050-490	820-490 820-490 650-410
620-485	1000-455	720-325	620-310	570-470	550-265	-	-	-	-
255-195 230-180	330-180 310-155	265-140 245-120	210-120 200-105	235-190 215-175	- -	- -	- -	- -	- -

TOUGHNESS >>>>						

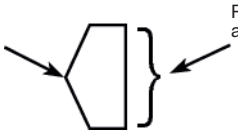
Grades for parting and grooving



The position and form of the grade symbols indicate the suitable field of application.

= Basic grades

= Complementary grades



Wear resistance

Toughness

SANDVIK Coromant

Grades for parting and grooving

P Steel, cast steel, long chipping malleable iron

Basic grades

GC3115 (HC) – P15 (P05-P25)
A very high wear resistant CVD coated grade. Especially recommended for grooving and turning in stable conditions. Due to its excellent hot hardness, also effective in hard steels. To be used at high cutting speeds under good conditions.
GC3020 (HC) – P15 (P05 – P25)
A very high wear resistant CVD coated grade. Especially recommended for grooving and turning in stable conditions. Due to its excellent hot hardness, also effective in hard steels. To be used at high cutting speeds under good conditions.
GC4225 (HC) – P20 (P10 – P35)
An all-purpose CVD-coated grade with an excellent combination of high wear resistance and good edge security; first choice for grooving and turning operations under stable conditions. Medium to high cutting speeds.
GC1025 (HC) – P25 (P15 – P45)
An excellent all-purpose grade for parting off, grooving and turning operations. This PVD coated grade works very well in low carbon steel and other smearing materials. Speeds and feeds from medium to low.
GC1125 (HC) - P30 (P15-P45)
An excellent general purpose grade. First choice for parting off tubes in steel. Also very good in grooving and turning operations. This new PVD coated grade works very well in low carbon steel and other smearing materials. Speeds and feeds from medium to low.
GC2135 (HC) – P35 (P20-P50)
A CVD coated carbide grade for toughness demanding operations such as cut-off to center and interrupted cuts. Backup alternative when grooving and turning. Very good bulk and edgeline toughness. To be used at low to medium cutting speeds.

Complementary grades

CT525 (HT) – P10 (P01-P15)
A titanium based grade with excellent resistance to oxidation and smearing. For high quality surface finishes when grooving low alloyed and alloyed steels under fairly good conditions. Moderate cutting speeds and feeds.
GC235 (HC) – P45 (P25-P50)
Parting and grooving of steel in operations requiring toughness. Suitable for low speeds and under unfavorable conditions.
GC1115 (HC) – P15 (P05-P25)
Recommended to be used as a complementary grade at low feed rate or medium cutting speed.

M Austenitic/ferritic/martensitic stainless steel, cast steel, manganese steel, alloy cast iron, malleable iron, free cutting steel.

Basic grades

GC1105 (HC) – M15 (M05 – M20)
The substrate consists of a hard fine-grained WC with 6% Co for high hot hardness and good resistance against plastic deformation. The new thin PVD TiAlN-coating with excellent adhesion, also on sharp edges, guarantees toughness, even flank wear and high performance. Suitable for finishing of stainless steels at high speeds.
GC1125 (HC) - M25 (M15-M35)
An excellent general purpose PVD coated grade with a combination of high wear resistance and good edge security for stainless steels. First choice for grooving and turning operations. Also good for parting off, especially tubes. Medium to low cutting speeds and feeds from medium to low.
GC2135 (HC) – M30 (M20-M40)
First choice CVD coated carbide grade for parting off in stainless steel and other toughness demanding operations. Very good bulk and edgeline toughness. To be used at medium to low cutting speeds.
GC1025 (HC) – M25 (M15 **–** M35)
An excellent all-purpose PVD coated grade with a combination of high wear resistance and good edge security for stainless steels. Recommended for grooving and turning operations, also good for parting off, especially tubes. Medium to low cutting speeds.
GC1145 (HC) – M40 (M40-M50)
This grade is a solution for stainless steel applications with very high demands on toughness behavior. It is suitable in parting off operations and applications demanding very good edge line toughness. The grade is coated with a PVD-oxide that works well in smearing materials. The substrate has an extremely good bulk toughness and should be used at low cutting speeds.

Complementary grades

GC1005 (HC) – M10 (M05-M20)
PVD coated carbide. The combination of a hard, fine grain substrate with good plastic deformation resistance and a coating with high wear resistance at high temperatures, makes this grade suitable for finishing of stainless steels at high speeds.
CT525 (HT) – M10 (M05-M15)
A titanium based grade with excellent resistance to oxidation and smearing. For high quality surface finishes when grooving stainless steels under good conditions. Moderate cutting speeds and feeds.
H13A (HW) – M15 (M10-M30)
Combines good abrasive wear resistance and toughness for grooving of heat resistant steels and titanium alloys.
GC235 (HC) – M35 (M25-M40)
Parting and grooving of stainless steels where toughness is required. Use at low speeds and under unfavorable conditions.
GC1115 (HC) – M15 (M05-M25)
A PVD coated fine-grained carbide. The substrate has high hot hardness and good resistance against plastic deformation combined with good edge line security. The thin PVD-oxide coating offers excellent resistance to smearing material and good adhesion on sharp edges. This guarantees toughness, even flank wear and high performance.

Grades for parting and grooving

K Cast iron, chilled cast iron, short chipping malleable iron.

Basic grades

GC3115 (HC) – K15 (K05-K25)
A very high wear resistant CVD coated grade for high cutting speeds in grooving and turning under good conditions. Due to its excellent hot hardness, also effective on hard cast iron.
GC4225 (HC) - K25 (K10-K35)
An all-purpose CVD coated grade with an excellent combination of high wear resistance and good edge security. To be used in grooving and turning operations at medium to high cutting speeds. Also good in parting off tubes.
GC1125 (HC) - K30 (K15-K35)
A new PVD coated all-purpose grade for toughness demanding operations and interrupted cuts. To be used at medium to low cutting speeds.
GC1025 (HC) - K30 (K15-K35)
A PVD coated all-purpose grade for toughness demanding operations and interrupted cuts. To be used at medium to low cutting speeds.

Complementary grades

GC3020 (HC) – K15 (K05-K25)
A very high wear resistant CVD coated grade for high cutting speeds in grooving and turning under good conditions. Due to its excellent hot hardness, also effective on hard cast iron.
H13A (HW) – K20 (K10-K30)
Good abrasive wear resistance and toughness for parting/grooving of cast iron.

N Non-ferrous metals

Basic grades

CD10 (DP) – N01 (N01-N15)
A polycrystalline diamond (PCD) grade recommended for machining of non-ferrous metals and non-metallic materials. Very good surface finish.
H10 (HW) – N10 (N05-N15)
Uncoated carbide grade with good edge sharpness. Recommended for machining of aluminum and for intermittent cuts.
GC1005 (HC) - N10 (N05-N15)
A PVD coated carbide grade.The combination of a hard fine grain substrate and a coating with high wear resistance makes this grade most suitable for roughing of aluminum.
H13A (HW) – N20 (N10-N30)
Uncoated carbide grade. Combines good abrasive wear resistance and toughness for parting and grooving of aluminum alloys.
GC1025 (HC) – N25 (N15 – N20)
A PVD coated grade for toughness demanding operations, recommended for interrupted cuts.
GC1125 (HC) - N25 (N15-N35)
A new PVD coated grade for toughness demanding operations, recommended for interrupted cuts.

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

Ceramics:

CA	Oxide ceramics containing primarily aluminum oxide (Al_2O_3).
CM	Mixed ceramics containing primarily aluminum oxide (Al_2O_3) but containing components other than oxides.
CN	Nitride ceramics containing primarily silicon nitride (Si_3N_4).
CC	Ceramics as above, but coated.

Diamond:

DP	Polycrystalline diamond[1)]

Cubic boron nitride:

BN	Polycrystalline boron nitride[1)]

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

Grades for parting and grooving

S Heat resistant super alloys

Basic grades

S05F (HC) - S10 (S05-S15)
MT-CVD coated TiCN-Al_2O_3-TiN layer with a fine grained carbide substrate. An all-purpose grade for heat resistant super alloys. For both high speed finishing and roughing operations.
GC1105 (HC) – S15 (S10 – S20)
The substrate consists of a hard fine-grained WC with 6% Co for high hot hardness and good resistance against plastic deformation. The new thin PVD TiAlN-coating with excellent adhesion, also on sharp edges, guarantees toughness, even flank wear and outstanding performance in heat resistant super alloys.
GC1005 (HC) – S15 (S10-S20)
PVD coated carbide. The combination of a hard, fine grain substrate with good plastic deformation resistance and a coating with high wear resistance at high temperatures, makes this grade most suitable for Ni, Fe or Co-based heat resistant super alloys.
H13A (HW) – S15 (S10-S30)
Uncoated carbide grade. Combines good abrasive wear resistance and toughness for parting and grooving. First choice in titanium.
GC1025 (HC) – S25 (S15 – S35)
A PVD coated grade for toughness demanding operations, recommended for interrupted cuts. To be used at low cutting speeds.
GC1125 (HC) - S25 (S15-S35)
A PVD coated grade for toughness demanding operations. First choice for interrupted cuts. To be used at low cutting speeds.
CC670 (CA) – S10 (S05-S25)
A silicon carbide whisker reinforced aluminum oxide based ceramic with excellent bulk toughness. Recommended for heat resistant alloys under favorable conditions.
CB7015 (BN) – S15 (S05-S25)
A high performance cubic boron nitride composite also suited for heat resistant super alloys. This grade allows sharp edges optimized for surface finish and low depths of cut.
GC1145 (HC) – S40 (S40-S50
A first choice when parting off in heat resistance super alloys due to a very secure grade. The tough substrate is coated with a PVD coating including an oxide layer to improve the heat protection. To be used at low cutting speeds.
GC1115 (HC) – S20 (S10-S25)
Recommended for heat resistant super alloys. A PVD coated fine-grained carbide with high hot hardness combined with superior edge line security. Good resistance against notch makes the grade suitable to use in difficult materials.

Complementary grades

H10 (HW) – S15 (S10-S20)
Uncoated carbide grade with good edge sharpness. Recommended for finishing in titanium.
GC2135 (HC) – S30 (S20 – S40)
A CVD coated grade for toughness demanding operations such as cutoff to center and interrupted cuts in heat resistant super alloys.
GC235 (HC) – S30 (S25-S40)
A CVD coated carbide grade for parting and grooving of heat resistant super alloys. Use at low cutting speeds.
GC2145 (HC) – S40 (S30-S40)
A tough PVD coated grade. First choice in parting off in heat resistant super alloys.

H Hardened materials

Basic grades

CB20 (BN) – H01 (H01-H10)
High performance Cubic Boron Nitride composite. Suitable for hardened ferrous materials. Can be used for both continuous and interrupted cuts.
CC670 (CA) – H10 (H05-H15)
A silicon carbide whisker reinforced aluminum oxide based ceramic with excellent bulk toughness. Primarily recommended for heat resistant alloys and hard part turning under unfavorable conditions.
CB7015 (BN) - H15 (H05-H20)
High performance Cubic Boron Nitride composite for hardened ferrous materials. Suitable for both continuous and interrupted cuts.