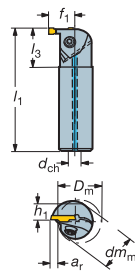


## CoroCut® 1- and 2-edge

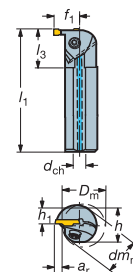
Boring bars

Screw clamp

## Cylindrical

 $dm_m = 16-25$  mm

## With flats

 $dm_m = 32-50$  mm

Right hand style shown

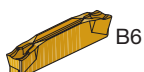
Main application	$D_m$		Seat size <sup>1)</sup>	Ordering code	Dimensions, mm							Gauge inserts	Nm <sup>3)</sup>
	min	$a_r$ max			$dm_m$	$h$	$h_1$	$l_1$	$f_1$	$l_3$	$d_{ch}$		
	25	4.5	D	R/LAG123D04-16B	16			150	12.5	25	6 (G1/8")	N123D2-0150- CM	3
	32	5		R/LAG123D05-20B	20			180	15.25	30	6 (G1/8")	N123D2-0150- CM	3
	32	5	E	R/LAG123E05-20B <sup>2)</sup>	20			180	15.25	30	6 (G1/8")	N123E2-0200- GM	3.5
	32	7		R/LAG123E07-25B	25			200	19.75	35	9 (G1/8")	N123E2-0200- GM	3.5
	40	9.5		R/LAG123E09-32B	32	30	15	250	25.5	45	6 (G1/8")	N123E2-0200- GM	4
	32	6	G	R/LAG123G06-20B <sup>2)</sup>	20			180	15.25	30	6 (G1/8")	N123G2-0300- GM	4
	32	7		R/LAG123G07-25B	25			200	19.75	35	9 (G1/8")	N123G2-0300- GM	4
	40	9		R/LAG123G09-32B	32	30	15	250	25.25	45	9 (G1/8")	N123G2-0300- GM	4.5
	50	11		R/LAG123G11-40B	40	37	18.5	300	31	55	12 (G1/4")	N123G2-0300- GM	4.5
	32	7	H	R/LAG123H07-25B	25			200	19.25	35	9 (G1/8")	N123H2-0400- GM	4.5
40	10		R/LAG123H10-32B	32	30	15	250	26.5	45	9 (G1/8")	N123H2-0400- GM	4.5	
50	11		R/LAG123H11-40B	40	37	18.5	300	31	55	12 (G1/4")	N123H2-0400- GM	5	
60	13		R/LAG123H13-50B	50	47	23.5	350	38.25	65	12 (G1/4")	N123H2-0400- GM	5	
32	8	J	R/LAG123J08-25B	25			200	19.75	35	9 (G1/8")	N123J2-0500- GM	5	
40	11		R/LAG123J11-32B	32	30	15	250	27	45	9 (G1/8")	N123J2-0500- GM	5	
50	11		R/LAG123J11-40B	40	37	18.5	300	31	55	12 (G1/4")	N123J2-0500- GM	5.5	
60	13		R/LAG123J13-50B	50	47	23.5	350	38.25	65	12 (G1/4")	N123J2-0500- GM	5.5	
50	11	K	R/LAG123K11-40B	40	37	18.5	300	31	55	12 (G1/4")	N123K2-0600- GM	5.5	
60	13		R/LAG123K13-50B	50	47	23.5	350	38.25	65	12 (G1/4")	N123K2-0600- GM	5.5	

<sup>1)</sup> To correspond with seat size on insert.<sup>2)</sup> When using an insert with -GF geometry, min. hole diameter ( $D_m$ ) is 25 mm.<sup>3)</sup> Insert tightening torque NmOrdering example: 2 pieces RAG123D04-16B  
LAG123D04-16B

R = Right hand, L = Left hand

## Main spare parts

Seat size	Screw clamp		
	Bar dia, $dm_m$ mm	Screw	Key (Torx Plus)
D, E, G	16-20	5512 031-03	5680 043-13 (15IP)
E	25-32	3212 012-259	5680 043-14 (20IP)
G	25-40	3212 012-309	5680 043-14 (20IP)
H, J	25	3212 012-309	5680 043-14 (20IP)
H, J	32	3212 012-359	5680 143-17 (30IP)
H, J, K	40-50	3212 012-360	5680 043-17 (30IP)



B6



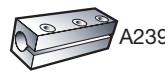
B95



G6



B2



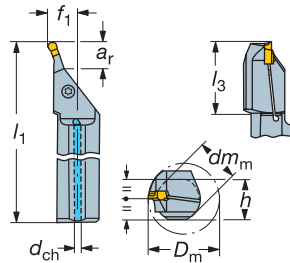
A239

# CoroCut® 1- and 2-edge

Boring bars for profiling

Screw clamp

R/LAX123



Right hand style shown

Main application	Dimensions, mm		Seat size 1)	Ordering code	Dimensions, mm								Gauge inserts	Nm 2)
	$D_m$ min	$a_r$			$h$	$h_1$	$l_1$	$d_{m,m}$	$f_1$	$l_3$	$d_{ch}$	dch		
	63.5	25	J	R/LAX123J25-40B-020	37	18.5	254	40	26	65.6	12 (G¼")	N123J2-0600- AM	3	
	63.5	25	L	R/LAX123L25-40B-020	37	18.5	254	40	26	65.6	12 (G¼")	N123L2-0800- AM	3	

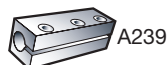
1) To correspond with seat size on insert.

2) Insert tightening torque Nm

Ordering example: 2 pieces RAX123J25-40B-020  
LAX123J25-40B-020  
R = Right hand, L = Left hand

## Main spare parts

Seat size	Bar dia, $d_{m,m}$ mm	Screw	Key (Torx Plus)
J, L	40	3212 012-360	5680 043-17 (30IP)



# CoroCut® 3

## System with 3 cutting edges

The productive choice for shallow parting

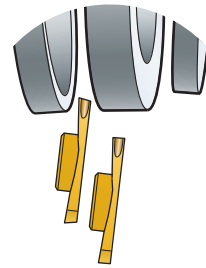


### CoroCut® 3 system

Intended for economical shallow parting in mass production featuring:

- Extremely small parting widths, down to 1 mm
- Cutting depths up to 6.4 mm
- 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.



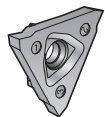
### Insert geometries

- CM, chip breaking geometry for normal cutting conditions
- CS, with extra sharp cutting edges to be used at very low cutting data and in low carbon materials.



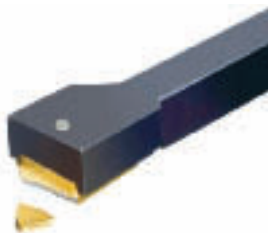
### Unique clamping system

The insert can be indexed directly on the machine by unscrewing two turns. If insert breakage should occur the clamping mechanism will not be affected - just index the insert and re-start the machine



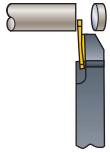
### Design your own solution

Insert blanks for grinding your profile



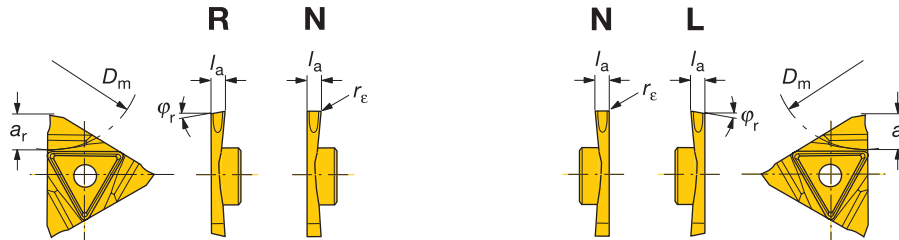
# CoroCut® 3

## Shallow parting



N123T3/R123T3

N123U3/L123U



		Selection criteria, mm										
		la	ψ	re	ar	Seat size 1)	Ordering code	P GC	M GC	K GC	S GC	
Medium feed								<b>CoroCut 3-edge</b>				
		1.00	0°	0	4.3	T	N123T3-0100-0000-CS	☆	☆	☆	☆	
		1.50	0°	0	6.4		N123T3-0150-0000-CS	☆	☆	☆	☆	
		2.00	0°	0	6.4		N123T3-0200-0000-CS	☆	☆	☆	☆	
		1.00	5°	0	4.2		R123T3-0100-0500-CS	☆	☆	☆	☆	
		1.00	10°	0	4.2		R123T3-0100-1000-CS	☆	☆	☆	☆	
		1.50	5°	0	6.3		R123T3-0150-0500-CS	☆	☆	☆	☆	
		1.50	10°	0	6.3		R123T3-0150-1000-CS	☆	☆	☆	☆	
		2.00	5°	0	6.3		R123T3-0200-0500-CS	☆	☆	☆	☆	
		2.00	10°	0	6.3		R123T3-0200-1000-CS	☆	☆	☆	☆	
		1.00	5°	0	4.2	U	L123U3-0100-0500-CS	☆	☆	☆	☆	
		1.00	10°	0	4.2		L123U3-0100-1000-CS	☆	☆	☆	☆	
	1.50	5°	0	6.3		L123U3-0150-0500-CS	☆	☆	☆	☆		
	1.50	10°	0	6.3		L123U3-0150-1000-CS	☆	☆	☆	☆		
	2.00	5°	0	6.3		L123U3-0200-0500-CS	☆	☆	☆	☆		
	2.00	10°	0	6.3		L123U3-0200-1000-CS	☆	☆	☆	☆		
	1.00	0°	0	4.3		N123U3-0100-0000-CS	☆	☆	☆	☆		
	1.50	0°	0	6.4		N123U3-0150-0000-CS	☆	☆	☆	☆		
	2.00	0°	0	6.4		N123U3-0200-0000-CS	☆	☆	☆	☆		
									<b>CoroCut 3-edge</b>			
1.00	0°		0.1	4.3	T	N123T3-0100-0001-CM	☆	☆	☆	☆		
1.50	0°		0.1	6.4		N123T3-0150-0001-CM	☆	☆	☆	☆		
2.00	0°		0.1	6.4		N123T3-0200-0001-CM	☆	☆	☆	☆		
1.00	0°		0.1	4.3	U	N123U3-0100-0001-CM	☆	☆	☆	☆		
1.50	0°		0.1	6.4		N123U3-0150-0001-CM	☆	☆	☆	☆		
2.00	0°	0.1	6.4		N123U3-0200-0001-CM	☆	☆	☆	☆			
								P30	M25	K30	S25	

1) To correspond with seat size on holder.

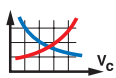
Ordering example: 10 pieces N123T3-0100-0000-CS  
R123T3-0100-0500-CS  
L123U3-0100-0500-CS

T = Right hand cutting insert, U = Left hand cutting insert.  
For tolerances, see page B110.

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



B9



B118



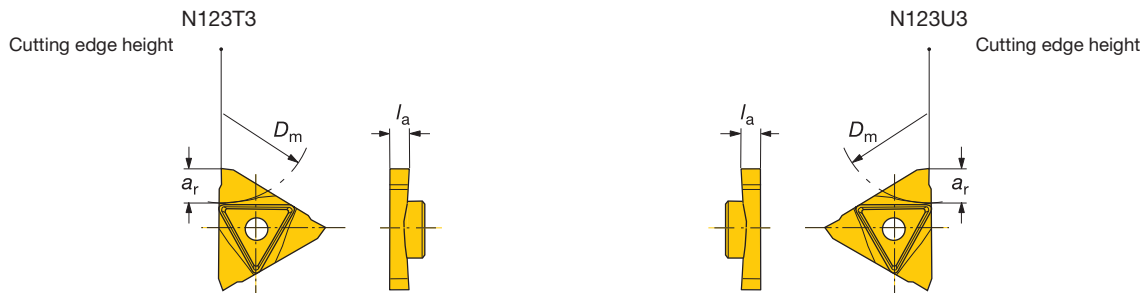
B122



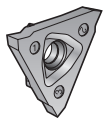
B2

# CoroCut® 3

## Blanks



For grinding instructions, see Metalcutting Technical guide.

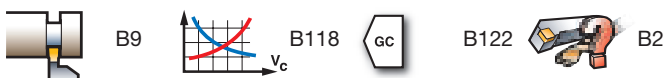


	Selection criteria, mm				Ordering code	Dimensions, mm			H10F
	$l_a$	Width range min	Width range max	Seat size <sup>1)</sup>		$a_r$	$D_{mmax}$	$\alpha_f$	
	3.4	0.5	3	T	N123T3-0340-BG	6.4	100	3°	☆
	3.4	0.5	3	U	N123U3-0340-BG	6.4	100	3°	☆

<sup>1)</sup> To correspond with seat size on holder.

Ordering example: 10 pieces N123T3-0340-BG H10F  
N = Neutral

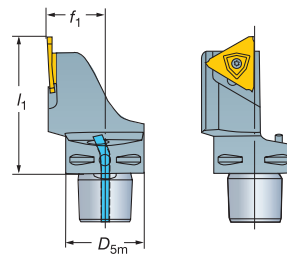
T = Right hand cutting insert, U = Left hand cutting insert.  
For tolerances, see page B110.



# CoroCut® 3

Coromant Capto® cutting units for shallow parting  
Screw clamp design

Cx-R/LF123



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

Main application	a <sub>r</sub> max	Seat size <sup>1)</sup>	Ordering code	Dimensions, mm			Gauge inserts	Nm <sup>2)</sup>
				l <sub>1</sub>	D <sub>5m</sub>	f <sub>1</sub>		
	6.4	T	C3-RF123T06-22045B	45	32	22	N123T3-0150- CM	3
	6.4		C4-RF123T06-27060B	60	40	27	N123T3-0150- CM	3
	6.4	U	C3-LF123U06-22045B	45	32	22	N123U3-0150- CM	3
	6.4		C4-LF123U06-27060B	60	40	27	N123U3-0150- CM	3

<sup>1)</sup> To correspond with seat size on insert.

<sup>2)</sup> Insert tightening torque Nm

Ordering example: 2 pieces C3-RF123T06-22045B  
C3-LF123U06-22045B

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

R = Right hand, L = Left hand

**Note!**

When using CoroCut3 inserts, the a<sub>r</sub> of the insert gives the maximum depth of cut.

**Main spare parts**

Cutting unit size	Screw	Key (Torx Plus)
C3-C4	5513 020-32	5680 049-02 (15IP)

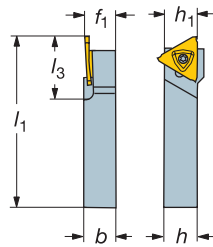


## CoroCut® 3

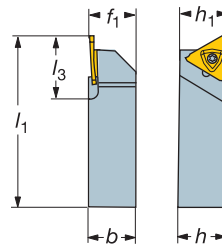
Shank tools for shallow parting

Screw clamp design

**R/LF123**  
Shank size 1010 – 1616 mm



**R/LF123**  
Shank size 2020 – 3232 mm



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

Main application	$a_r$ max	Seat size <sup>1)</sup>	Ordering code	Dimensions, mm						Gauge inserts	Nm <sup>2)</sup>
				$b$	$h$	$h_1$	$l_1$	$f_1$	$l_3$		
	6.4	T	RF123T06-1010B	10	10	10	125	10	23	N123T3-0150- CM	3
	6.4		RF123T06-1212B	12	12	12	125	12	23	N123T3-0150- CM	3
	6.4		RF123T06-1616B	16	16	16	125	16	23	N123T3-0150- CM	3
	6.4		RF123T06-2020B	20	20	20	125	20	23	N123T3-0150- CM	3
	6.4		RF123T06-2525B	25	25	25	150	25	23	N123T3-0150- CM	3
	6.4		RF123T06-3232B	32	32	32	170	32	23	N123T3-0150- CM	3
	6.4	U	LF123U06-1010B	10	10	10	125	10	23	N123U3-0150- CM	3
	6.4		LF123U06-1212B	12	12	12	125	12	23	N123U3-0150- CM	3
	6.4		LF123U06-1616B	16	16	16	125	16	23	N123U3-0150- CM	3
	6.4		LF123U06-2020B	20	20	20	125	20	23	N123U3-0150- CM	3
6.4		LF123U06-2525B	25	25	25	150	25	23	N123U3-0150- CM	3	
6.4		LF123U06-3232B	32	32	32	170	32	23	N123U3-0150- CM	3	

<sup>1)</sup> To correspond with seat size on insert.

<sup>2)</sup> Insert tightening torque Nm

Ordering example: 2 pieces RF123T06-1010B  
LF123U06-1010B

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.

### Main spare parts

Shank size	Screw	Key (Torx Plus)
1010	5513 020-09	5680 049-02 (15IP)
1212 - 3232	5513 020-32	5680 049-02 (15IP)



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