

CoroTurn® 107

Rhombic 80°

		□	Ordering code	P								M				K		S							
				GC	GC	GC	GC	GC	GC	CT	CT	GC	GC	GC	GC	GC	-	GC	GC	GC	GC				
				1525	4005	4015	4025	4035	4225	5005	5015	1025	2015	2025	2035	3215	H13A	1005	1025	1105	H10A	H13A			
Finishing		06	CCMT 06 02 02-PF																						
			CCMT 06 02 04-PF			★					☆	☆													
			09	CCMT 09 T3 02-PF																					
				CCMT 09 T3 04-PF			★						☆	☆											
			CCMT 09 T3 08-PF			★							☆												
			12	CCMT 12 04 04-PF			★						☆												
		06	CCMT 06 02 02-MF									★									★				
			CCMT 06 02 04-MF									☆	★								★				
			09	CCMT 09 T3 02-MF										★							☆	☆	★		
				CCMT 09 T3 04-MF										★	☆						☆	☆	★		
			CCMT 09 T3 08-MF										☆	★	☆						☆	☆	★		
			12	CCMT 12 04 04-MF									☆	★	☆						★				
Medium		06	CCMT 06 02 08-WM			★					☆									★					
			09	CCMT 09 T3 04-WM	☆	☆	★					☆	★								★				
				CCMT 09 T3 08-WM	☆	☆	★						☆	★								★			
			12	CCMT 12 04 04-WM	☆	☆	★						☆	★							★				
	CCMT 12 04 08-WM	☆	☆	★							☆	★							★						
		06	CCMT 06 02 04-PM	☆	☆	★						☆													
			CCMT 06 02 08-PM	☆	☆	★							☆												
			09	CCMT 09 T3 04-PM	☆	☆	☆						☆	☆											
				CCMT 09 T3 08-PM	☆	☆	☆						☆	☆											
		12	CCMT 12 04 04-PM	☆	☆	☆						☆	☆												
			CCMT 12 04 08-PM	☆	☆	☆						☆	☆												
			CCMT 12 04 12-PM	☆	☆	☆						☆	☆												
Medium				06	CCMT 06 02 04-MM								☆	★							☆	☆	★		
	CCMT 06 02 08-MM											☆	★							☆	☆	★			
	09	CCMT 09 T3 04-MM											☆	☆	★	☆					☆	☆	★		
		CCMT 09 T3 08-MM											☆	☆	★	☆					☆	☆	★		
	12	CCMT 12 04 04-MM									☆	☆	★	☆					☆	☆	★				
		CCMT 12 04 08-MM									☆	☆	★	☆					☆	☆	★				
		CCMT 12 04 12-MM									☆	☆	★	☆					☆	☆	★				
		Roughing		06	CCGT 06 02 01-UM								☆	☆							☆	★		☆	
	CCGT 06 02 02-UM												☆	☆							☆	★		☆	
	CCGT 06 02 04-UM													☆	☆						☆	★		☆	
	09				CCGT 09 T3 01-UM									☆	☆							☆	☆	★	☆
				CCGT 09 T3 02-UM									☆	☆							☆	☆	★	☆	
CCGT 09 T3 04-UM												☆	☆							☆	☆	★	☆		
CCGT 09 T3 08-UM												☆	☆							☆	☆	★	☆		
12	CCGT 12 04 04-UM																						★		
	CCGT 12 04 08-UM																						★		
	06			CCMT 06 02 08-PR			★			☆															
				09	CCMT 09 T3 08-PR			☆			★														
CCMT 09 T3 12-PR							☆			★															
12		CCMT 12 04 08-PR			☆			★																	
CCMT 12 04 12-PR			☆			★																			

Ordering example: 10 pieces CCMT 06 02 02-PF 4225
★ = First choice

= New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.



CoroTurn® 107
Rhombic 55°

				P					M				K		S									
				GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC				
				1525	4005	4015	4035	4225	5005	5015	1025	2015	2025	2035	3210	3215	H13A	S05F	1005	1025	1105	H13A		
Finishing		07	DCMT 07 02 02-PF					★																
			DCMT 07 02 04-PF			★		★																
	11	DCMT 11 T3 02-PF							★															
		DCMT 11 T3 04-PF			★		★		★															
		DCMT 11 T3 08-PF			★		★		★															
		DCMT 11 T3 08-PF			★		★		★															
Finishing		07	DCMT 07 02 02-MF								★										★			
			DCMT 07 02 04-MF									★	★	★								★		
		11	DCMT 11 T3 02-MF									★	★	★								★		
			DCMT 11 T3 04-MF									★	★	★								★		
Threading		11	DCMX 11 T3 04-WM	★	★	★		★			★	★								★				
			DCMX 11 T3 08-WM	★	★	★		★				★	★			★	★				★			
Medium		07	DCMT 07 02 04-PM			★	★	★																
			DCMT 07 02 08-PM			★	★	★																
	11	DCMT 11 T3 04-PM			★	★	★		★															
		DCMT 11 T3 08-PM			★	★	★		★															
		DCMT 11 T3 12-PM			★	★	★		★															
		DCMT 11 T3 12-PM			★	★	★		★															
Medium		07	DCMT 07 02 04-MM								★	★	★	★						★	★	★		
			DCMT 07 02 08-MM									★	★	★	★						★	★	★	
		11	DCMT 11 T3 04-MM									★	★	★	★						★	★	★	
			DCMT 11 T3 08-MM									★	★	★	★						★	★	★	
Roughing		07	DCGT 07 02 01-UM								★	★								★	★	★		
			DCGT 07 02 02-UM									★	★								★	★	★	
			DCGT 07 02 04-UM									★	★								★	★	★	
			DCGT 07 02 08-UM									★	★								★	★	★	
		11	DCGT 11 T3 01-UM									★	★									★	★	★
			DCGT 11 T3 02-UM									★	★									★	★	★
			DCGT 11 T3 04-UM									★	★									★	★	★
			DCGT 11 T3 08-UM									★	★									★	★	★
Roughing		11	DCMT 11 T3 08-PR		★	★	★	★																
			DCMT 11 T3 12-PR		★	★	★	★																

Ordering example: 10 pieces DCMT 07 02 02-PF 4025
★ = First choice

= New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.



CoroTurn® 107

Round

	Image	IO	Ordering code	K		S	
				H13A	S05F	GC	GC
Medium		06	RCMT 06 03 00-SM	☆	★		
		09	RCMT 09 T3 00-SM	☆	★		
		12	RCMT 12 04 00-SM	☆	★		
		08	RCMT 08 03 M0-SM	★	☆	★	☆
		10	RCMT 10 T3 M0-SM	★	☆	★	☆
		12	RCMT 12 04 M0-SM	★	☆	★	☆
		16	RCMT 16 06 M0-SM	★	☆	★	☆
				K20	S05	S15	S15

Ordering example: 10 pieces RCMT 06 03 00-SM S05F
★= First choice

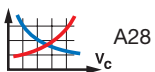
Square

	Image	IO	Ordering code	P						M			S			
				GC	GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC
Finishing		09	SCMT 09 T3 04-PF SCMT 09 T3 08-PF	1525	4005	4015	4035	4225	5015	1025	2015	2025	2035	1005	1025	1105
					★	☆	★	☆								
Medium		09	SCMT 09 T3 04-PM SCMT 09 T3 08-PM	☆	☆	☆	★	☆	☆							
		12	SCMT 12 04 04-PM SCMT 12 04 08-PM SCMT 12 04 12-PM	☆	☆	☆	★	☆								
		09	SCMT 09 T3 04-MM SCMT 09 T3 08-MM						☆	☆	★	☆	☆	☆	☆	★
	12	SCMT 12 04 04-MM SCMT 12 04 08-MM SCMT 12 04 12-MM						☆	☆	★	☆	☆	★			
	09	SCMT 09 T3 08-PR SCMT 09 T3 12-PR		☆	☆	☆	★									
Roughing		12	SCMT 12 04 08-PR SCMT 12 04 12-PR		☆	☆	★	★								
				P15	P05	P15	P35	P25	P10	M15	M15	M25	M35	S15	S15	S15

Ordering example: 10 pieces SCMT 09 T3 04-PF 4015
★= First choice

= New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.



CoroTurn® 107

Triangular

	Ordering code	P						M				K		S								
		1525	4005	4015	4035	4225	5005	5015	1025	2015	2025	2035	235	3210	3215	H13A	1005	1025	1105	H10A	H13A	
Finishing	06	TCMT 06 T1 02-PF																				
		TCMT 06 T1 04-PF			★																	
		TCMT 06 T1 08-PF			★																	
	09	TCMT 09 02 02-PF					★															
		TCMT 09 02 04-PF					★															
		TCMT 09 02 08-PF					★															

Finishing	11	TCMT 11 03 02-PF				★															
		TCMT 11 03 04-PF				★															
		TCMT 11 03 08-PF					★														
Medium	16	TCMT 16 T3 04-PF				★															
	11	TCMX 11 03 04-WM			★			★											★		
		TCMX 11 03 08-WM			★									★							
Medium	16	TCMX 16 T3 08-WM	☆	☆	★								★	☆							

Medium	09	TCMT 09 02 04-PM	☆	☆	☆	★		☆													
		TCMT 09 02 08-PM	☆	☆	☆	★		☆													
	11	TCMT 11 03 04-PM	☆	☆	☆	★		☆													
		TCMT 11 03 08-PM	☆	☆	☆	★		☆													
		TCMT 11 03 12-PM	☆	☆	☆	★		☆													
	16	TCMT 16 T3 04-PM	☆	☆	☆	★		☆													

Medium	09	TCMT 09 02 04-MM						☆	☆	★	☆								★		
		TCMT 09 02 08-MM						☆	☆	★	☆								★		
	11	TCMT 11 03 04-MM						☆	☆	★	☆							☆	☆	★	
		TCMT 11 03 08-MM						☆	☆	★	☆							☆	☆	★	
		TCMT 16 T3 04-MM						☆	☆	★	☆							☆	☆	★	
		TCMT 16 T3 08-MM						☆	☆	★	☆							☆	☆	★	

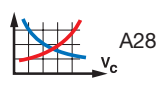
Medium	09	TCGT 09 02 04-UM						☆													
	11	TCGT 11 02 01-UM						☆	☆			☆			☆				★		☆
		TCGT 11 02 02-UM						☆	☆			☆			☆				★		☆
		TCGT 11 02 04-UM						☆	☆			☆			☆				★		☆
		TCGT 11 02 08-UM						☆	☆			☆			☆				★		☆
		TCGT 11 03 01-UM						☆	☆			☆			☆				★		☆

Roughing	11	TCMT 11 03 08-PR		☆	☆	★															
		TCMT 11 03 12-PR				★															
	16	TCMT 16 T3 08-PR		☆	☆	★															
		TCMT 16 T3 12-PR		☆	☆	★															
	22	TCMT 22 04 08-PR				★															
		TCMT 22 04 12-PR				★															

Roughing	11	TCMT 11 03 08-MR								★	☆										
	16	TCMT 16 T3 08-MR							☆	★	☆					☆			★		
		TCMT 16 T3 12-MR							☆	★	☆										
	22	TCMT 22 04 08-MR									★										

Ordering example: 10 pieces TCMT 06 T1 02-PF 4225
 ★ = First choice

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.



CoroTurn® 107

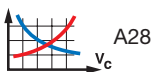
Rhombic 35°

		Ordering code	P					M					K	S						
			GC	GC	GC	GC	CT	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC		
			1525	4005	4015	4035	4225	5015	1020	1025	2015	2025	2035	H13A	S05F	1005	1025	1105	H13A	
Finishing		11	VBMT 11 03 02-PF	☆	☆															
			VBMT 11 03 04-PF	☆		★														
			VBMT 11 03 08-PF			★														
			VBMT 11 03 12-PF			★														
		16	VBMT 16 04 02-PF																	
	VBMT 16 04 04-PF			★																
	VBMT 16 04 08-PF			★																
	VBMT 16 04 12-PF			★																
		11	VCEX 11 03 00R/L-F								★	★						★		
			VCEX 11 03 01R/L-F								★	★							★	
Medium		16	VBMT 16 04 04-PM	☆	☆	☆	☆	★	☆											
			VBMT 16 04 08-PM	☆	☆	☆	☆	★	☆											
			VBMT 16 04 12-PM	☆		☆	☆	★	☆											
		16	VBMT 16 04 04-MM								☆	☆	★	☆			☆	☆	★	
			VBMT 16 04 08-MM								☆	☆	★	☆			☆	☆	★	
			VBMT 16 04 12-MM									☆	☆	★	☆			☆	☆	★
		16	VBGT 16 04 01-UM								☆				☆			★		☆
		VBGT 16 04 02-UM								☆				☆			★		☆	
		VBGT 16 04 04-UM								☆			☆	☆			☆	★	☆	
		VBGT 16 04 08-UM								☆			☆	☆			☆	★	☆	
Roughing		16	VBMT 16 04 08-PR		☆	☆	☆	★												
			VBMT 16 04 12-PR		☆	☆	☆	★												
		16	VBMT 16 04 08-MR									☆	★	☆		☆		★		
			VBMT 16 04 12-MR									☆	★	☆		☆		★		

Ordering example: 10 pieces VBMT 11 03 02-PF 4225
 ☆ = New item
 ★ = First choice

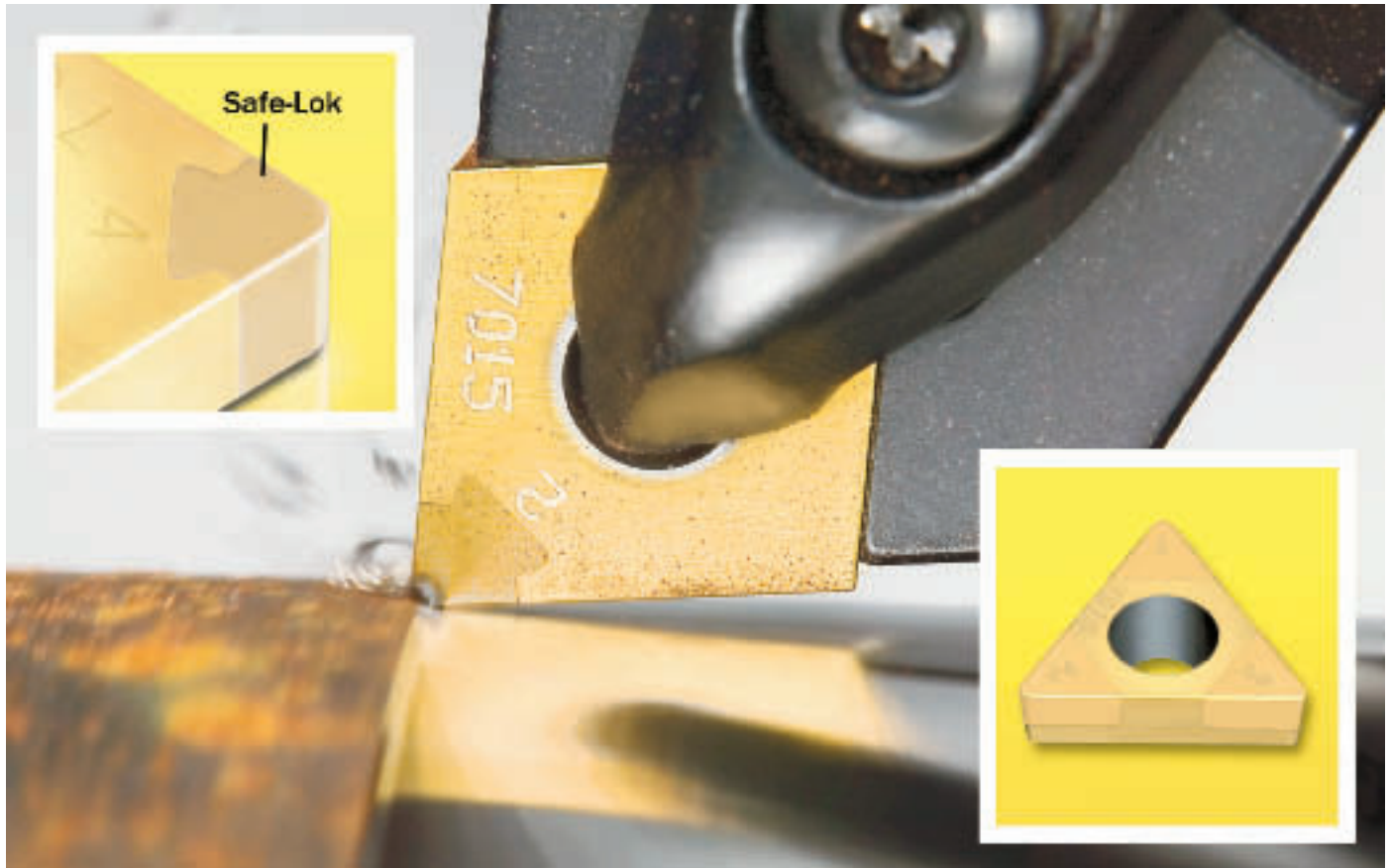
☆ = New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.



Cubic Boron Nitride CB7015 grade with Safe-Lok technology

Hard part turning is getting easier



Now a full range of negative inserts

With the recent success that CB7015 and Safe-Lok technology has brought to the field of hard part turning, HPT, we can now offer you a full assortment of T-Max P negative inserts as well as a range of positive inserts in CoroTurn 107. Together these introductions will further advance highly productive finish turning of quality surfaces in case hardened steels.

All insert styles have been designed to give you predictable performance and increased speed capability in continuous to light interrupted cuts, which in turn contributes to shorter cycle times.

CB7015

The key to the improved performance in these applications lies in the fine grain size of the low content cubic boron nitride, CBN, grade and its unique ceramic binder, which allows wear to develop more slowly and in a controlled way even at higher temperatures. This means that the cutting edge strength is preserved and that wear has minimal effect on the surface finish generated throughout the life of the insert.

Multi-corner technology

T-MAX P negative basic shape inserts

All negative inserts are equipped with our Safe-Lok multi-corner technology, a mechanically interlocked CBN brazed corner which gives strength and security superior to conventional tip design. In addition, Safe-Lok offers generously sized cutting edges with added benefits when machining up to shoulders, undercuts and in other profiling operations.

CoroTurn 107 positive basic shape inserts

CoroTurn 107 will now enable you to carry out external machining of long slender components and internal machining of holes from a minimum hole diameter of 32 mm. Our new range of positive inserts is also of multi-corner design.

Wiper technology




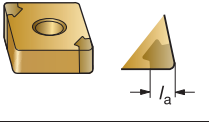
Process reliability thanks to our patented radius configuration that is less sensitive to misalignment than conventional wipers. Inserts with Wiper are marked with "WH".

Detection

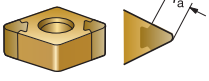

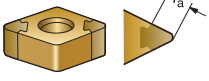
To simplify detection of used and unused edges, the inserts have a thin, yellow TiN coating and each cutting edge is laser marked with an identity number.

Negative basic-shape inserts – T-Max P

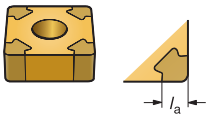

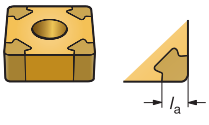
Rhombic 80°

	l_a		Ordering code	H
				7015
	2.3	09	CNGA090304T01030AWH	★
	2.2		CNGA090308T01030AWH	★
	2.8	12	CNGA120404T01030AWH	★
	2.7		CNGA120408T01030AWH	★
	2.7		CNGA120412T01030AWH	★
	2.3	09	CNGA090304S01030A	★
	2.2		CNGA090308S01030A	★
	2.8	12	CNGA120404S01030A	★
	2.7		CNGA120408S01030A	★
	2.7		CNGA120412S01030A	★
				H15

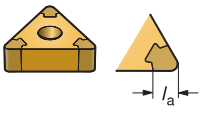

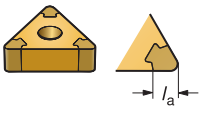
Rhombic 55°

	l_a		Ordering code	H
				7015
	3.0	11	DNGA110404S01030A	★
	2.6		DNGA110408S01030A	★
	3.8	15	DNGA150404S01030A	★
	3.4		DNGA150408S01030A	★
	3.0		DNGA150412S01030A	★
				H15


Square

	l_a		Ordering code	H
				7015
	2.7	12	SNGA120408S01030A	★
	2.7		SNGA120412S01030A	★
				H15

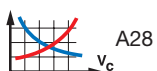
Triangular

	l_a		Ordering code	H
				7015
	1.6	11	TNGA110304S01030A	★
	1.3		TNGA110308S01030A	★
	2.9	16	TNGA160404S01030A	★
	2.6		TNGA160408S01030A	★
	2.3		TNGA160412S01030A	★
				H15

Ordering example: 10 pieces CNGA090304T01030AWH 7015



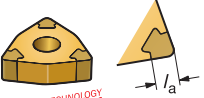
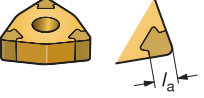
 = New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.





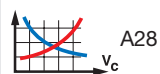
Negative basic-shape inserts – T-Max P


Trigon 80°

	l_a		Ordering code	H
				CB
 	2.3	06	WNGA060404T01030AWH	7015
	2.2		WNGA060408T01030AWH	★
	2.8	08	WNGA080404T01030AWH	★
	2.7		WNGA080408T01030AWH	★
	2.7		WNGA080412T01030AWH	★
	2.3	06	WNGA060404S01030A	★
	2.2		WNGA060408S01030A	★
	2.8	08	WNGA080404S01030A	★
	2.7		WNGA080408S01030A	★
	2.7		WNGA080412S01030A	★
				H15

Rhombic 35°

	l_a		Ordering code	H
				CB
	4.2	16	VNGA160404S01030A	7015
	3.3		VNGA160408S01030A	★
				H15


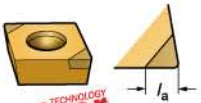
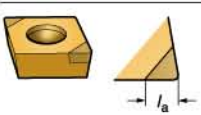


 = New item

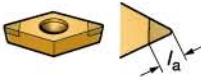
For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.

Positive basic-shape inserts CoroTurn® 107

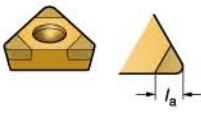
Rhombic 80°

	l_a	K	Ordering code	H
				CB
	2.5	09	CCGW09T308T01020FWH	7015
	2.5	09	CCGW09T308S01020F	7015


Rhombic 55°

	l_a	F	Ordering code	H
				CB
	3.2	11	DCGW11T304S01020F	7015
	2.8		DCGW11T308S01020F	7015


Triangular

	l_a	D	Ordering code	H
				CB
	2.7	11	TCGW110208S01020F	7015
	2.7		TCGW110308S01020F	7015

Rhombic 35°

	l_a	M	Ordering code	H
				CB
	4.2	16	VBGW160404S01020F	7015
	3.3		VBGW160408S01020F	7015

Ordering example: 10 pieces CCGW09T308T01020FWH 7015

 = New item

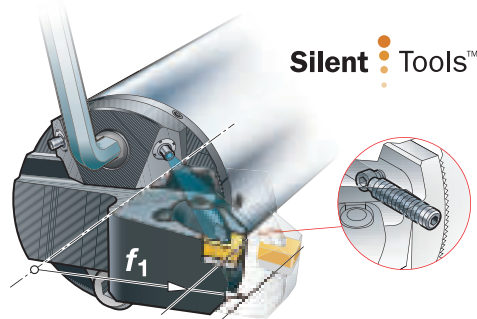
For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.



Cutting heads with CoroTurn® SL quick change

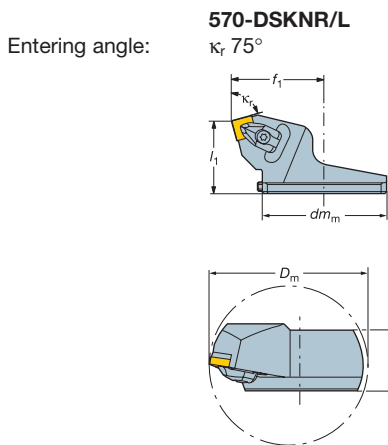
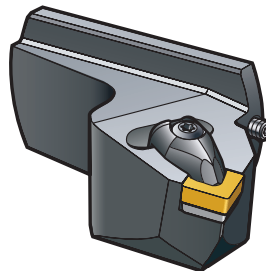
CoroTurn SL quick change cutting head - CoroTurn RC

CoroTurn SL with quick change function is a system for vibration free machining of large diameter bores using different cutting heads and adaptors. Bars are available in diameter 80 and 100 mm for overhangs up to 10 x bar diameter. The assortment has now been extended with a CoroTurn RC cutting head with 75° entering angle for square style inserts for roughing applications.



Benefits

- Up to 8 cutting edges
- Reduced entry angle reduces notch wear tendency in HRSA materials.



For f_1 range and D_m dimensions, see page A233 in Main Catalogue 2006



- SNMM
- SNMG
- SNMA, SNGA

κ_r Main application	□	Ordering code	Dimensions, mm					Gauge inserts	Nm ¹⁾
			dm_m	h	l_1	γ	λ_s		
75°	12	570-DSKNR/L-80-12	77	37.5	45	-6°	-8°	SNMG 12 04 08	3.9

¹⁾ Insert tightening torque Nm

Ordering example: 2 pieces 570-DSKNR-80-12
570-DSKNL-80-12
R = Right hand, L = Left hand

Main spare parts

Insert size	Shim screw	Shim	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	Adjustment screw	Key (mm)
12	5513 020-02	5322 425-01	5680 049-01 (15IP)	5412 028-021	5680 049-01 (15IP)	3214 020-311	174.1-863 (2.5)

= New item

For a complete product assortment and further technical information, see Main Catalogue 2006 and Metalcutting Technical guide.

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