

## Code key for shank tools and Coromant Capto® boring bars

Coromant Capto®

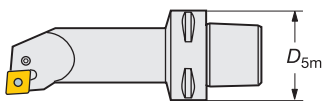
<b>C3</b>	<b>-</b>	<b>S</b>	<b>C</b>	<b>L</b>	<b>C</b>	<b>R</b>	<b>-</b>	<b>11065</b>	<b>-</b>	<b>09</b>	
1		5	6	7	8	9		13		10	11

Shank tools

<b>S</b>	<b>40</b>	<b>V</b>	<b>-</b>	<b>S</b>	<b>C</b>	<b>L</b>	<b>C</b>	<b>R</b>	<b>-</b>	<b>12</b>		<b>-</b>	<b>ID</b>
2	3	4		5	6	7	8	9		10	11		12

## 1 Coupling size

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



C3	$D_{5m}=32$
C4	$D_{5m}=40$
C5	$D_{5m}=50$
C6	$D_{5m}=63$
C8	$D_{5m}=80$

Coromant Capto®

## 2 Type of bar

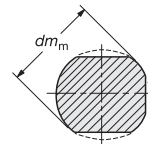
A = Steel bar with internal coolant supply

E = Carbide shank bar

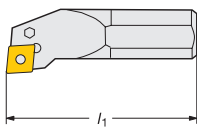
F = Carbide shank damped bar

S = Solid steel bar

## 3 Bar diameter

4 Tool length,  $l_1$  mm

Shank tool

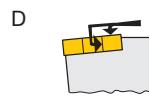


F = 80	S = 250
H = 100	T = 300
K = 125	U = 350
M = 150	V = 400
P = 170	W = 450
Q = 180	Y = 500
R = 200	X = Special

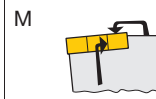
## 5 Clamping system



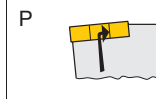
Top clamping



Top and hole clamping (RC)











Top and hole clamping







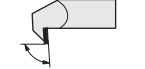





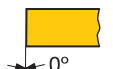

Hole clamping

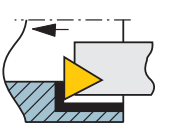
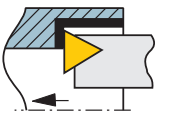








Screw clamping

6 Insert shape	
C 	D 
K 	R 
S 	T 
V 	W 

7 Bar style	
F  90°	L  95°
J  93°	Q  107° 30'
K  75°	U  93°
U-X  93°	

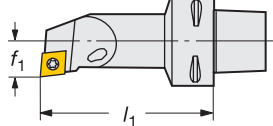
8 Clearance angle on major cutting edge	
B  5°	C  7°
E  20°	N  0°
P  11°	O Specific description

9 Hand of tool	
R 	
L 	

10 Cutting edge length, mm		
		
		

11 Manufacturer's option	
When required a supplementary symbol of max. 3 letters may be added to the ISO code, separated by a dash, e.g.	
D	= Extended $f_1$ -dimension, +1.0 mm
E	= Extended $f_1$ -dimension, +2.0 mm
R	= Round shank
W	= Wedge design
X	= Back boring

12 Clamping system Ceramics	
ID	= Clamp with pressure plate

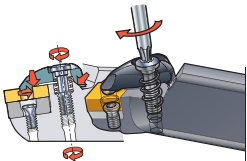
13 Coromant Capto cutting unit size	
$f_1 \times l_1$	

# CoroTurn® RC rigid clamping

## Internal tools for T-Max® P inserts

First choice for stability and security in productive turning

CoroTurn® RC system is available as Coromant Capto® cutting units and conventional steel shank design for all insert shapes and in different entering angles



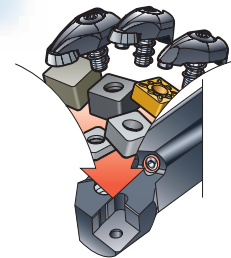
### The 1st choice system for internal turning of large hole diameters, giving:

- Unique stability
- Excellent function even in dirty environments e.g. cast iron machining
- User-friendly handling; one key for insert and shim change
- Easy access even if holder is in up side down position



### Modular internal solution

Negative basic-shape turning inserts and the CoroTurn® RC clamping system can also be used in the modular CoroTurn® SL (570) system using exchangeable cutting heads and different types of boring bars, see page A199



### A flexible system

By changing clamp set and/or shim, the tip seat on all CoroTurn® RC holders has been designed for total interchangeability between:

- Cemented carbide inserts
- Ceramic inserts with holes
- Ceramic inserts without holes
- Different insert thicknesses

For further information see page A281.

### Internal coolant supply

All Coromant Capto® and most of the conventional steel shank bars have internal coolant supply.

### EasyFix™ sleeves

For all round conventional boring bars the EasyFix sleeve is the best clamping method giving the correct centre height.

# Coromant Capto® boring bars

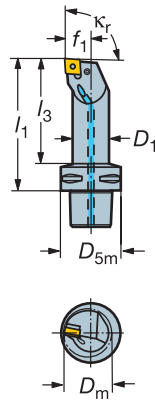
## T-Max P lever clamp design

### PCLNR/L

Entering angle:  $\kappa_r 95^\circ$



- CNMM, CNGP
- CNMG
- CNMA, CNGA



Right hand style shown

$\kappa_r$	Main application	Ordering code	Dimensions, mm									Gauge inserts
			$D_m$ min	$D_1$	$D_{5m}$	$f_1$	$l_1$	$l_3$	$\gamma^1$	$\lambda_s^2$		
95°		09 C4-PCLNR/L-13080-09	25	20	40	13.0	80	58.0	-6°	-11°	CNMG 09 03 08	
		C5-PCLNR/L-13080-09	25	20	50	13.0	80	56.0	-6°	-11°	CNMG 09 03 08	
		12 C3-PCLNR/L-17090-12	32	25	32	17.0	90	75.0	-6°	-11°	CNMG 12 04 08	
		C3-PCLNR/L-22064-12	40	32	32	22.0	64	50.0	-6°	-11°	CNMG 12 04 08	
		C3-PCLNR/L-22096-12	40	32	32	22.0	96	82.0	-6°	-11°	CNMG 12 04 08	
		C4-PCLNR/L-17090-12	32	25	40	17.0	90	69.0	-6°	-11°	CNMG 12 04 08	
		C4-PCLNR/L-22110-12	40	32	40	22.0	110	89.0	-6°	-11°	CNMG 12 04 08	
		C4-PCLNR/L-27080-12	50	40	40	27.0	80	60.0	-6°	-10°	CNMG 12 04 08	
		C4-PCLNR/L-27120-12	50	40	40	27.0	120	100.0	-6°	-11°	CNMG 12 04 08	
		C5-PCLNR/L-17090-12	32	25	50	17.0	90	67.0	-6°	-11°	CNMG 12 04 08	
		C5-PCLNR/L-22110-12	40	32	50	22.0	110	88.0	-6°	-11°	CNMG 12 04 08	
		C5-PCLNR/L-27140-12	50	40	50	27.0	140	119.0	-6°	-10°	CNMG 12 04 08	
		C5-PCLNR/L-35100-12	63	50	50	35.0	100	81.0	-6°	-7°	CNMG 12 04 08	
		C6-PCLNR/L-17100-12	32	25	63	17.0	100	74.0	-6°	-11°	CNMG 12 04 08	
		C6-PCLNR/L-22110-12	40	32	63	22.0	110	84.0	-6°	-11°	CNMG 12 04 08	
		16 C5-PCLNR/L-35150-16	63	50	50	35.0	150	131.0	-6°	-11°	CNMG 16 06 12	
		C6-PCLNR/L-27140-16	50	40	63	27.0	140	115.0	-6°	-11°	CNMG 16 06 12	
		C6-PCLNR/L-35175-16	63	50	63	35.0	175	152.0	-6°	-11°	CNMG 16 06 12	

<sup>1)</sup>  $\gamma$  = Rake angle (valid with flat insert).

<sup>2)</sup>  $\lambda_s$  = Angle of inclination.

Ordering example: 2 pieces C4-PCLNR-13080-09

C4-PCLNL-13080-09

R = Right hand, L = Left hand

### Main spare parts

Insert size	Bar dia.	Lever	Screw	Key (mm)	Shim
09	20-25	174.3-845-1	174.3-829	170.3-864 (1.98)	-
12	25	438.3-841-1	438.3-832M	174.1-863 (2.5)	-
12	32-50	174.3-841M	174.3-821	174.1-864 (3.0)	171.31-850M
16	40-50	438.3-840	438.3-831	174.1-864 (3.0)	171.31-852



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G6



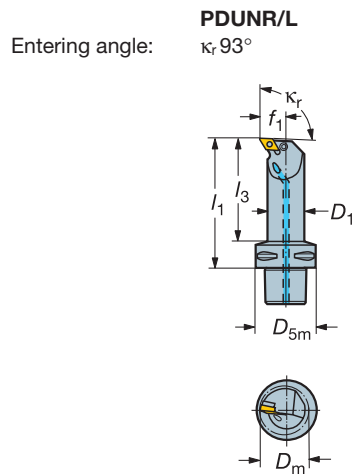
A2

# Coromant Capto® boring bars

## T-Max P lever clamp design



- DNMM, DNGP, DNMX
- DNMG
- DNMA, DNMA



Right hand style shown

$\kappa_r$	Main application	Ordering code	Dimensions, mm								Gauge inserts
			$D_m$ min	$D_1$	$D_{5m}$	$f_1$	$l_1$	$l_3$	$\gamma^1$	$\lambda_s^2$	
93°		11 C3-PDUNR/L-17090-11	32	25	32	17.0	90	75.0	-6°	-11°	DNMG 11 04 08
		C4-PDUNR/L-17090-11	32	25	40	17.0	90	69.0	-6°	-11°	DNMG 11 04 08
		C4-PDUNR/L-22110-11	40	32	40	22.0	110	89.0	-6°	-10°	DNMG 11 04 08
		C5-PDUNR/L-17090-11	32	25	50	17.0	90	67.0	-6°	-11°	DNMG 11 04 08
		C5-PDUNR/L-22110-11	40	32	50	22.0	110	88.0	-6°	-10°	DNMG 11 04 08
		C6-PDUNR/L-17100-11	32	25	63	17.0	100	74.0	-6°	-11°	DNMG 11 04 08
		15 C4-PDUNR/L-27080-15	50	40	40	27.0	80	60.0	-6°	-11°	DNMG 15 06 08
		C4-PDUNR/L-27120-15	50	40	40	27.0	120	100.0	-6°	-11°	DNMG 15 06 08
		C5-PDUNR/L-27140-15	50	40	50	27.0	140	119.0	-6°	-11°	DNMG 15 06 08
		C5-PDUNR/L-35100-15	63	50	50	35.0	100	81.0	-6°	-10°	DNMG 15 06 08
C5-PDUNR/L-35150-15	63	50	50	35.0	150	131.0	-6°	-10°	DNMG 15 06 08		
C6-PDUNR/L-22110-15	40	32	63	22.0	110	84.0	-6°	-12°	DNMG 15 06 08		
C6-PDUNR/L-27140-15	50	40	63	27.0	140	115.0	-6°	-11°	DNMG 15 06 08		
C6-PDUNR/L-35175-15	63	50	63	35.0	175	152.0	-6°	-10°	DNMG 15 06 08		

<sup>1)</sup>  $\gamma$  = Rake angle (valid with flat insert).  
<sup>2)</sup>  $\lambda_s$  = Angle of inclination.

Ordering example: 2 pieces C3-PDUNR-17090-11  
 C3-PDUNL-17090-11  
 R = Right hand, L = Left hand

### Main spare parts

Insert size					
	Bar dia.	Lever	Screw	Key (mm)	Shim
11	25	5432 015-021	438.3-830	174.1-870 (1.98)	-
11	32	5432 001-01	174.3-820M	174.1-863 (2.5)	5322 255-01
15	32-50	174.3-847M	174.3-830	174.1-864 (3.0)	171.35-851M



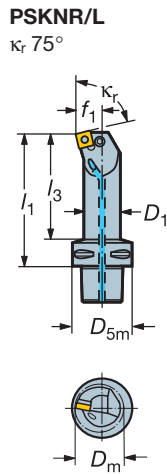
## Coromant Capto® boring bars

## T-Max P lever clamp design



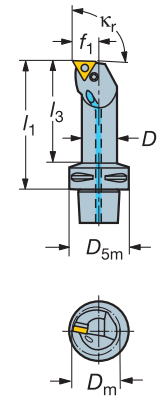
- SNMM
- SNMG
- SNMA, SNGA

Entering angle:  $\kappa_r$  75°



- TNMM, TNMX
- TNMG
- TNMA, TNGA

Entering angle:  $\kappa_r$  91°



Right hand style shown

$\kappa_r$	Main application	□	Ordering code	Dimensions, mm							Gauge inserts	
				$D_m$ min	$D_1$	$D_{5m}$	$f_1$	$l_1$	$l_3$	$\gamma^1$		$\lambda_s^2$
75°		12	C4-PSKNR-17090-12	40	32	40	22.0	110	89.0	-6°	-10°	SNMG 12 04 08
			C4-PSKNL-22110-12	32	25	40	17.0	90	69.0	-6°	-11°	SNMG 12 04 08
			C5-PSKNR-17090-12	32	25	50	17.0	90	67.0	-6°	-11°	SNMG 12 04 08
			C5-PSKNR-22110-12	40	32	50	22.0	110	88.0	-6°	-10°	SNMG 12 04 08
			C5-PSKNR-27140-12	50	40	50	27.0	140	119.0	-6°	-10°	SNMG 12 04 08
			C6-PSKNR-22110-12	40	32	63	22.0	110	84.0	-6°	-10°	SNMG 12 04 08

<sup>1)</sup>  $\gamma$  = Rake angle (valid with flat insert).

<sup>2)</sup>  $\lambda_s$  = Angle of inclination.

Ordering example: 2 pieces C4-PSKNL-22110-12  
R = Right hand, L = Left hand

$\kappa_r$	Main application	△	Ordering code	Dimensions, mm							Gauge inserts	
				$D_m$ min	$D_1$	$D_{5m}$	$f_1$	$l_1$	$l_3$	$\gamma^1$		$\lambda_s^2$
91°		11	C3-PTFNR/L-13075-11	25	20	32	13.0	75	59.0	-6°	-12°	TNMG 11 03 04
			C4-PTFNR/L-13080-11	25	20	40	13.0	80	58.0	-6°	-12°	TNMG 11 03 04
			C5-PTFNR/L-13080-11	25	20	50	13.0	80	56.0	-6°	-12°	TNMG 11 03 04

<sup>1)</sup>  $\gamma$  = Rake angle (valid with flat insert).

<sup>2)</sup>  $\lambda_s$  = Angle of inclination.

Ordering example: 2 pieces C3-PTFNR-13075-11  
C3-PTFNL-13075-11  
R = Right hand, L = Left hand

## Main spare parts

Insert size					
□	Bar dia.	Lever	Screw	Key (mm)	Shim
12	25	438.3-841-1	438.3-832M	174.1-863 (2.5)	-
12	32-40	174.3-841M	174.3-821	174.1-864 (3.0)	174.3-851M
15	40-50	438.3-840	438.3-831	174.1-864 (3.0)	174.3-857
Insert size					
△	Bar dia.	Lever	Screw	Key (mm)	Shim
11	20	174.3-846-1	174.3-829	170.3-864 (1.98)	-



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A2

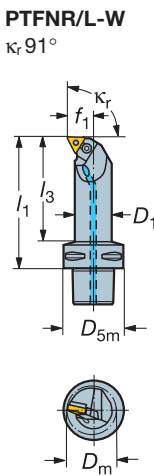
## Coromant Capto® boring bars

T-Max P wedge design



- TNMM, TNMX
- TNMG
- TNMA, TNGA

Entering angle:  $\kappa_r 91^\circ$



Right hand style shown

$\kappa_r$	Main application	$\triangle$	Ordering code	Dimensions, mm							Gauge inserts		
				$D_m$ min	$D_1$	$D_{5m}$	$f_1$	$l_1$	$l_3$	$\gamma^1)$		$\lambda_s^2)$	
91°		16	C3-PTFNR-17090-16W	32	25	32	17.0	90	75.0	-6°	-13°	TNMG 16 04 08	
			C4-PTFNR/L-17090-16W	32	25	40	17.0	90	69.0	-6°	-13°	TNMG 16 04 08	
			C4-PTFNR/L-22110-16W	40	32	40	22.0	110	89.0	-6°	-12°	TNMG 16 04 08	
			C4-PTFNR/L-27120-16W	50	40	40	27.0	120	100.0	-6°	-11°	TNMG 16 04 08	
			C5-PTFNR/L-17090-16W	32	25	50	17.0	90	67.0	-6°	-13°	TNMG 16 04 08	
			C5-PTFNR/L-22110-16W	40	32	50	22.0	110	88.0	-6°	-12°	TNMG 16 04 08	
			C5-PTFNR/L-27140-16W	50	40	50	27.0	140	119.0	-6°	-11°	TNMG 16 04 08	
			C6-PTFNR/L-22110-16W	40	32	63	22.0	110	84.0	-6°	-12°	TNMG 16 04 08	
			C6-PTFNR/L-27140-16W	50	40	63	27.0	140	115.0	-6°	-11°	TNMG 16 04 08	
			22	C4-PTFNR-27120-22W	50	40	40	27.0	120	100.0	-6°	-11°	TNMG 22 04 08
				C5-PTFNL-35150-22W	63	50	50	35.0	150	131.0	-6°	-10°	TNMG 22 04 08
				C5-PTFNR/L-27140-22W	50	40	50	27.0	140	119.0	-6°	-11°	TNMG 22 04 08
C6-PTFNR/L-27140-22W	50	40		63	27.0	140	115.0	-6°	-11°	TNMG 22 04 08			
	C6-PTFNR/L-35175-22W	63	50	63	35.0	175	152.0	-6°	-10°	TNMG 22 04 08			

<sup>1)</sup>  $\gamma$  = Rake angle (valid with flat insert).  
<sup>2)</sup>  $\lambda_s$  = Angle of inclination.

Ordering example: 2 pieces C3-PTFNR-17090-16W  
 C3-PTFNL-17090-16W  
 R = Right hand, L = Left hand

## Main spare parts

Insert size							
$\triangle$	Bar dia.	Wedge set	Key (mm)	Shim	Pin	Screw	Key (mm/Torx Plus)
16	25	170.38-823-2	174.1-864 (3.0)	-	5313 021-01	5512 031-01	5680 051-03 (9IP)
16	32-40	170.38-823-1	174.1-864 (3.0)	170.3-852	5313 021-02	5512 031-01	5680 051-03 (9IP)
22	40	170.38-824-1	3021 010-040 (4.0)	170.3-855	5313 021-03	5512 031-02	5680 049-02 (15IP)
22	50	170.38-823-1	3021 010-040 (4.0)	170.3-852	5313 021-02	5512 031-01	5680 051-03 (9IP)



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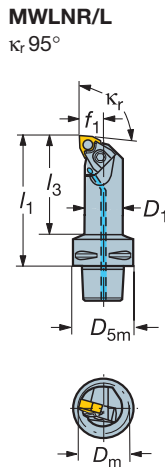
# Coromant Capto® boring bars

T-Max P wedge clamp design

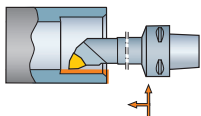


-  WNMM,
-  WNMG
-  WNGA, WNMA

Entering angle:  $\kappa_r 95^\circ$



Right hand style shown

$\kappa_r$	Main application	Ordering code	Dimensions, mm							Gauge inserts	
			$D_m$ min	$D_1$	$D_{5m}$	$f_1$	$l_1$	$l_3$	$\gamma^1$		$\lambda_s^2$
95°		06 C3-MWLNR/L-13075-06	25	20	32	13.0	75	59.0	-6°	-14°	WNMG 06 04 08
		C3-MWLNR-17090-06M1	32	25	32	17.0	90	75.0	-6°	-12°	WNMG 06 04 08
		C4-MWLNR/L-13075-06	25	20	40	13.0	75	53.0	-6°	-14°	WNMG 06 04 08
		C4-MWLNR/L-17090-06M1	32	25	40	17.0	90	69.0	-6°	-12°	WNMG 06 04 08
		08 C4-MWLNR/L-17090-08	32	25	40	17.0	90	69.0	-6°	-14°	WNMG 08 04 08
		C4-MWLNR/L-22110-08	40	32	40	22.0	110	89.0	-6°	-14°	WNMG 08 04 08
		C4-MWLNR/L-27120-08	50	40	40	27.0	120	100.0	-6°	-12°	WNMG 08 04 08
		C5-MWLNR/L-17090-08	32	25	50	17.0	90	67.0	-6°	-14°	WNMG 08 04 08
		C5-MWLNR/L-22110-08	40	32	50	22.0	110	88.0	-6°	-14°	WNMG 08 04 08
		C5-MWLNR/L-27140-08	50	40	50	27.0	140	119.0	-6°	-12°	WNMG 08 04 08

<sup>1)</sup>  $\gamma$  = Rake angle (valid with flat insert).

<sup>2)</sup>  $\lambda_s$  = Angle of inclination.

Ordering example: 2 pieces C3-MWLNR-13075-06

C3-MWLNL-13075-06

R = Right hand, L = Left hand

## Main spare parts

Insert size							
$\kappa_r$	Bar dia.	Wedge clamp set	Key (mm)	Shim	Pin	Screw	Key (mm/Torx Plus)
06	20-25	5431 125-011	170.3-860 (2.5)	-	5313 022-02	-	170.3-864 (1.98)
08	25	5431 125-021	174.1-864 (3.0)	5322 331-09	5313 022-03	-	-
08	32-40	5431 125-021	174.1-864 (3.0)	5322 331-07	5313 021-03	5512 030-04	174.1-863 (2.5)



A9



A174



A308



G6



A2



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