

CoroCut® 1-2 system

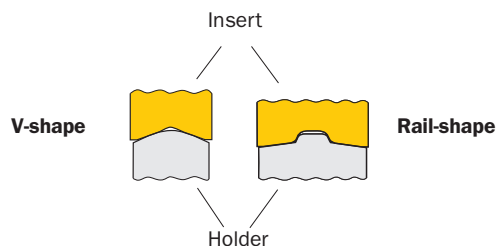
System with 1 or 2 cutting edges

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



Toolholder assortment

There are a wide range of different toolholders for CoroCut® 1-2 edge inserts.

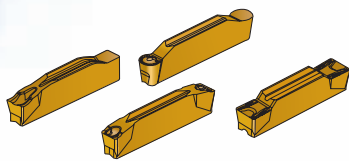


Insert clamping

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

Insert geometries

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



Insert versions

CoroCut® 1-2 inserts are available in widths from 1.5mm up to 8mm.

- CoroCut® 2-edge for the most economical machining.
- CoroCut® 1-edge version for cutting depths deeper than 20mm.



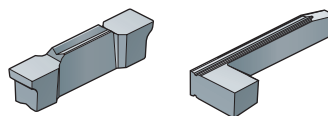
CoroCut® SL - Flexible tool solution

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

Insert grades

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

- Cemented carbide
- Polycrystalline diamond
- Cubic boron nitride



Design your own solution

Blanks for grinding your profile

ISO application areas:




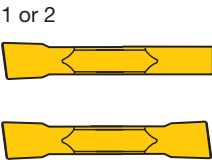


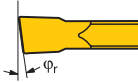
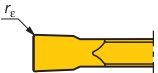


Tailor Made

Even more options are available thanks to tailored design. For more information on our Tailor Made program see page I2

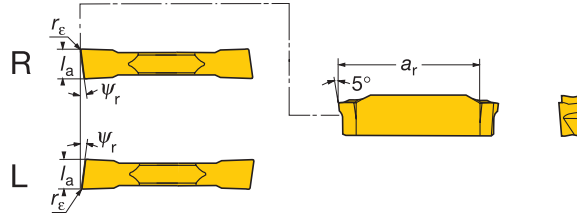
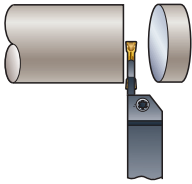
Code key for CoroCut® inserts

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

<p>1 Hand of tool</p> <p>R </p> <p>N </p> <p>L </p>	<p>2 Main code</p> <p style="font-size: 24px; text-align: center;">123</p>	<p>3 Insert seat size</p> <p>CoroCut® 1-2 D G K E H L F J</p> <p>CoroCut® 3 T = Right hand cutting U = Left hand cutting</p> <p>To correspond with seat size on holder.</p>			
<p>4 Number of edges</p> <p>1 or 2 </p> <p>3 </p>	<p>5 Insert width</p> <p>E.g.: 0400 = 4.0 mm</p> 	<p>6 Front angle</p> <p>E.g.: 00 = 0° 05 = 5°</p> 			
<p>7 Corner radius</p> <p>E.g.: 04 = 0.4 mm 08 = 0.8 mm</p> 	<p>8 Geometry designation</p> <table style="width: 100%; border: none;"> <tr> <td style="width: 50%; border: none; vertical-align: top;"> <p>First digit: Type of operation</p> <p>A = Aluminium/profiling C = Cut off T = Turning G = Grooving R = Profiling</p> </td> <td style="width: 50%; border: none; vertical-align: top;"> <p>Second digit:</p> <p>E = ER treated cutting edge F = Low feed M = Medium feed R = High feed O = Optimized for special areas S = Sharp cutting edge</p> </td> </tr> </table>			<p>First digit: Type of operation</p> <p>A = Aluminium/profiling C = Cut off T = Turning G = Grooving R = Profiling</p>	<p>Second digit:</p> <p>E = ER treated cutting edge F = Low feed M = Medium feed R = High feed O = Optimized for special areas S = Sharp cutting edge</p>
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CoroCut® 1- and 2-edge

Parting



For ISO application areas, see bottom of the page.

	Selection criteria, mm				Seat size ¹⁾	Ordering code	P				M			K			S			
	l _a	ψ _r	r _ε	a _r			GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
Low feed						CoroCut 2-edge														
					D	R/L123D2-0150-1001-CS														
						R/L123D2-0150-1501-CS														
					E	R/L123E2-0200-1001-CS														
						R/L123E2-0200-1501-CS														
					F	R/L123F2-0250-1001-CS														
						R/L123F2-0250-1501-CS														
					G	R/L123G2-0300-1001-CS														
					R/L123G2-0300-1501-CS															
						P35	P45	P15	P20	P30	M30	M40	M25	K15	K25	K30	S30	S40	S25	

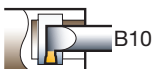
¹⁾ To correspond with seat size on holder.

Ordering example: 10 pieces R123D2-0150-1001-CS 4125
 L123D2-0150-1001-CS 4125
 R = Right hand, L = Left hand

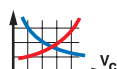
For tolerances, see page B106.



B9



B10



B118



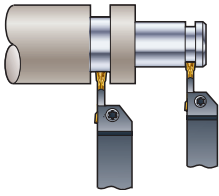
B122



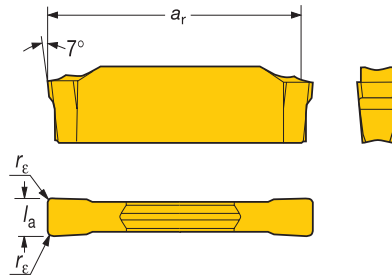
B2

CoroCut® 1- and 2-edge

Grooving



Tailor Made



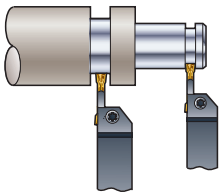
For ISO application areas, see bottom of the page.

	Selection criteria, mm						Seat size 1)	Ordering code	P				M				K				N				S											
	la	Inch	re	ar					GC	GC	GC	GC	GC	GC	GC	-	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC								
									2135	3115	4025	4125	1005	2135	4125	H13A	3115	4025	4125	H13A	H13A	-	H13A	-	1005	2135	4125	H13A								
Medium feed								CoroCut 2-edge																												
	2.00		0.2	18.8			E	N123E2-0200-0002-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆				
	2.39	.094	0.2	18.4				N123E2-0239-0002-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆				
	3.00		0.3	18.2			G	N123G2-0300-0003-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆				
	3.18	.125	0.3	18				N123G2-0318-0003-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆				
	4.00		0.3	23			H	N123H2-0400-0003-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆				
	4.75	.187	0.3	22.6			J	N123J2-0475-0003-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆				
	5.00		0.4	22.9				N123J2-0500-0004-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆				
	6.00		0.4	22.7			K	N123K2-0600-0004-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆				
	6.35	.250	0.3	22.6				N123K2-0635-0003-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆				
7.92	.312	0.3	28.76			L	N123L2-0792-0003-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆					
8.00		0.5	28.4				N123L2-0800-0005-GM	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆	☆	☆	★	☆					

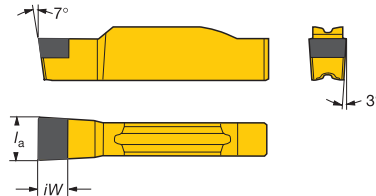
1) To correspond with seat size on holder.

Ordering example: 10 pieces N123E2-0200-0002-GM 4025
N = Neutral

Cubic Boron Nitride



Tailor Made



For ISO application areas, see bottom of the page.

	Selection criteria, mm						Seat size 1)	Ordering code	H		
	la	Inch	re	iW	ar					CB	
										CB20	
Low feed								For grooving of hardened materials			
								CoroCut 1-edge			
	3.00		0.2	3.2	∞		G	N123G1-0300-0002-GE	★		
	3.18	.125	0.2	3.2	∞			N123G1-0318-0002-GE	★		
	4.00		0.2	3.2	∞		H	N123H1-0400-0002-GE	★		
	4.70	.185	0.2	3.2	∞			N123H1-0470-0002-GE	★		
	5.00		0.2	3.2	∞			N123H1-0500-0002-GE	★		
	6.00		0.2	3.2	∞		J	N123J1-0600-0002-GE	★		
	6.35	.250	0.2	3.2	∞		K	N123K1-0635-0002-GE	★		
7.93	.312	0.2	3.2	∞		L	N123L1-0793-0002-GE	★			
8.00		0.2	3.2	∞			N123L1-0800-0002-GE	★			

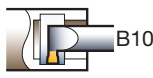
1) To correspond with seat size on holder.

Ordering example: 2 pieces N123G1-0300-0002-GE CB20
N = Neutral
★ = First choice

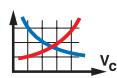
For tolerances, see page B106.



B9



B10



B118



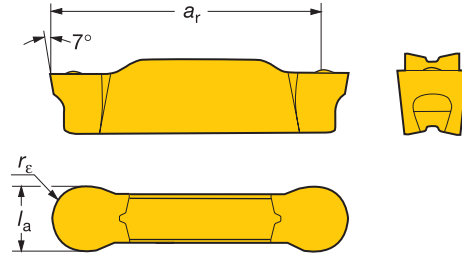
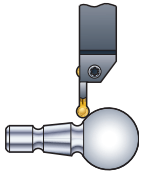
GC



B122

CoroCut® 1- and 2-edge

Profiling



Tailor Made

For ISO application areas, see bottom of the page.

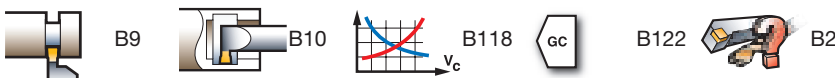
	Selection criteria, mm					Seat size 1)	Ordering code	P				M				K				S			
	la	Inch	re	ar	Seat size 1)			GC	GC	GC	GC	GC	GC	GC	-	GC	GC	GC	-	GC	GC	GC	-
								2135	3115	4025	4125	1005	2135	4125	H13A	3115	4025	4125	H13A	1005	4125	H13A	S05F
	CoroCut 1-edge																						
	4.00		2	∞	G	N123G1-0400-RM	☆	☆	★	☆			☆	☆	☆	★	☆	☆					
	6.00		3	∞	J	N123J1-0600-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
	8.00		4	∞	L	N123L1-0800-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
	CoroCut 2-edge																						
	3.00		1.5	18.6	F	N123F2-0300-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
	3.18	.125	1.59	18.6		N123F2-0318-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
	4.00		2	18.1	G	N123G2-0400-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
	4.00		2	23.2	H	N123H2-0400-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
	4.75	.187	2.38	22.9		N123H2-0475-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
	5.00		2.5	22.7		N123H2-0500-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
	6.00		3	22.2	J	N123J2-0600-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
	6.35	.250	3.18	22		N123J2-0635-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆				
8.00		4	27	L	N123L2-0800-RM	☆	☆	★	☆			☆	★	☆	☆	★	☆	☆					
	CoroCut 2-edge																						
	2.00		1	19.3	E	N123E2-0200-RO	☆			★	☆	☆	☆			★	☆	☆	☆	☆	★	★	
	2.39	.094	1.2	19.1		N123E2-0239-RO				★	☆	☆	☆			★	☆	☆	☆	☆	★	★	
	3.00		1.5	18.7	F	N123F2-0300-RO	☆			★	☆	☆	☆			★	☆	☆	☆	☆	★	★	
	3.18	.125	1.59	18.6		N123F2-0318-RO				★	☆	☆	☆			★	☆	☆	☆	☆	★	★	
	3.96	.156	1.98	23.4	H	N123H2-0396-RO				★	☆		★	☆		★	☆	☆	☆	☆	★	★	
	4.00		2	23.4		N123H2-0400-RO	☆			★	☆	☆	☆			★	☆	☆	☆	☆	★	★	
	4.50		2.25	23.1		N123H2-0450-RO				★			★	☆		★	☆	☆	☆	☆	★	★	
	4.75	.187	2.38	22.9		N123H2-0475-RO				★	☆		★	☆		★	☆	☆	☆	☆	★	★	
	5.00		2.5	22.8		N123H2-0500-RO	☆			★	☆	☆	☆			★	☆	☆	☆	☆	★	★	
	6.35	.250	3.18	22.1		N123J2-0635-RO				★	☆	★	☆			★	☆	☆	☆	☆	★	★	
6.00		3	22.3	J	N123J2-0600-RO	☆			★	☆	☆	☆			★	☆	☆	☆	☆	★	★		
7.14	.281	3.57	21.6	K	N123K2-0714-RO				★	☆	★	☆			★	☆	☆	☆	☆	★	★		
8.00		4	27.4	L	N123L2-0800-RO	☆			★	☆	★	☆			★	☆	☆	☆	☆	★	★		

1) To correspond with seat size on holder.

Ordering example: 10 pieces N123G1-0400-RM 4025

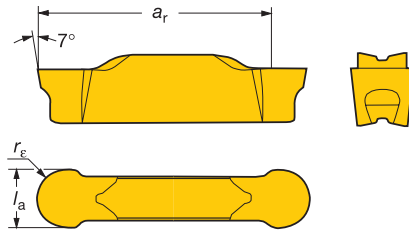
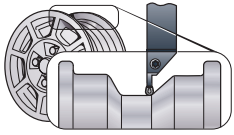
N = Neutral
★ = First choice

For tolerances, see page B106.



CoroCut® 1- and 2-edge

Aluminium profiling



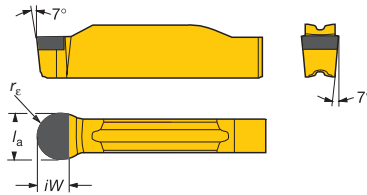
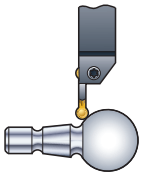
For ISO application areas, see bottom of the page.

		Selection criteria, mm						N	
Medium feed		la	re	ar	Seat size 1)	Ordering code			
		6.00	3	22.2	J	CoroCut 2-edge	H10		
		8.00	4	27.3	L	N123J2-0600-AM	★		
						N123L2-0800-AM	★		
							N10		

1) To correspond with seat size on holder.

Ordering example: 2 pieces N123J2-0600-AM H10
N = Neutral

Profiling



For ISO application areas, see bottom of the page.

		Selection criteria, mm						N H		
Low feed		la	Inch	re	iW	ar	Seat size 1)	Ordering code	CD10	CB20
		For profiling in non-ferrous materials								
								CoroCut 1-edge		
		3.00		1.5	2.5	∞	F	N123F1-0300-RS	★	
		4.00		2	3	∞	H	N123H1-0400-RS	★	
		5.00		2.5	3.5	∞		N123H1-0500-RS	★	
		6.00		3	4	∞	J	N123J1-0600-RS	★	
		8.00		4	5	∞	L	N123L1-0800-RS	★	
For profiling of hardened materials										
								CoroCut 1-edge		
		3.00		1.5	2.5	∞	F	N123F1-0300-RE	★	
		3.18		1.59	2.5	∞		N123F1-0318-RE	★	
		4.00		2	3	∞	H	N123H1-0400-RE	★	
		5.00		2.5	3.5	∞		N123H1-0500-RE	★	
		6.00		3	4	∞	J	N123J1-0600-RE	★	
		6.35	.250	3.17	4	∞		N123J1-0635-RE	★	
		7.93	.312	3.96	5	∞	L	N123L1-0793-RE	★	
		8.00		4	5	∞		N123L1-0800-RE	★	
									N01	H01

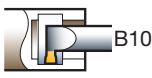
1) To correspond with seat size on holder.

Ordering example: 2 pieces N123F1-0300-RS CD10
N = Neutral
★ = First choice

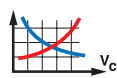
For tolerances, see page B106.



B9



B10



B118



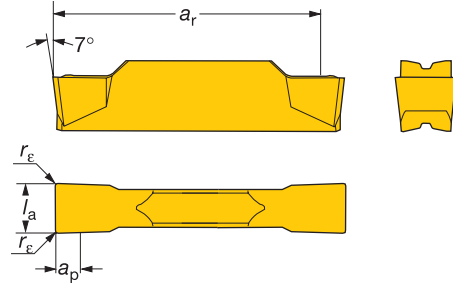
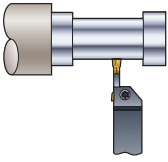
B122



B2

CoroCut® 1- and 2-edge

Turning



For ISO application areas, see bottom of the page.

		Selection criteria, mm					Seat size 1)	Ordering code	P				M				K				N				S			
		la	re	ar	Max ap				GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC
Low feed		3.00	0.3	∞	2.6	G	CoroCut 1-edge	2135	2145	3115	4025	4125	1005	2135	2145	4125	H13A	3115	4025	4125	H13A	H13A	1005	2135	2145	4125	H13A	
		4.00	0.4	∞	3.5	H	N123G1-0300-0003-TF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		6.00	0.4	∞	4.4	K	N123H1-0400-0004-TF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		CoroCut 2-edge							☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		3.00	0.3	18.5	2.6	G	N123G2-0300-0003-TF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		4.00	0.4	23.3	5.0	H	N123H2-0400-0004-TF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		5.00	0.4	23.3	5.0	J	N123J2-0500-0004-TF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
		6.00	0.4	23.3	3.8	K	N123K2-0600-0004-TF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
	8.00	0.8	28.0	7.0	L	N123L2-0800-0008-TF	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
	Medium feed		CoroCut 2-edge							☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	
			3.00	0.4	18.4	3.5	G	N123G2-0300-0004-TM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
			4.00	0.4	23.4	4.6	H	N123H2-0400-0004-TM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
4.00			0.8	23.4	4.6		N123H2-0400-0008-TM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
5.00			0.4	23.4	4.6	J	N123J2-0500-0004-TM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
5.00			0.8	23	4.6		N123J2-0500-0008-TM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
6.00			0.4	23.4	4.5	K	N123K2-0600-0004-TM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
6.00			0.8	23	4.5		N123K2-0600-0008-TM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆
8.00	0.8	28.0	7.0	L	N123L2-0800-0008-TM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		
8.00	1.2	27.6	7.0		N123L2-0800-0012-TM	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆		

1) To correspond with seat size on holder.

Ordering example: 10 pieces N123G1-0300-0003-TF 4125

N = Neutral

☆ = First choice

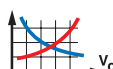
For tolerances, see page B106.



B9



B10



B118



B122

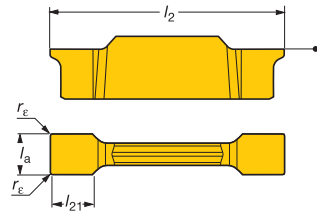


B2

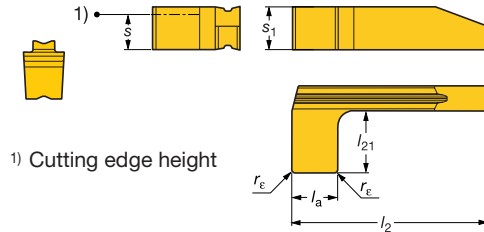
CoroCut® 1- and 2-edge

Blanks

0° blanks



90° blanks



1) Cutting edge height

Right hand

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

For grinding instructions see Metalcutting Technical guide

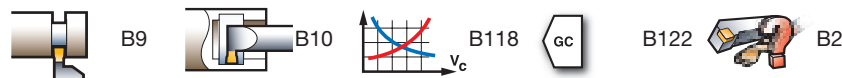
	Selection criteria, mm					Seat size 2)	Ordering code	Dimensions, mm				Material					
	l_a	r_e	Width range min	Width range max				l_2	l_{21} min	s	s_1	M	K	N		S	
	0°						CoroCut 2-edge										
	3.8	0.2	2.3	3.4	F	N123F2-0380-0002-BG	21.6	4									
	4.2	0.2	2.6	3.8	G	N123G2-0420-0002-BG	21.6	4.7									
	5.2	0.2	3.2	4.8	H	N123H2-0520-0002-BG	26.2	6									
	6.2	0.2	4.5	6.8	J	N123J2-0620-0002-BG	26.2	6									
	7.2	0.2	5.5	6.8	K	N123K2-0720-0002-BG	26.2	6									
	8.4	0.2	6.5	8	L	N123L2-0840-0002-BG	31.5	7									
	90°						CoroCut® 1-edge										
	6.0	0.2		5.9	H	R/LG123H1-0600-BG	25.65	4.5	4.5	5.6							
	6.0	0.2		5.9	L	R/LG123L1-0600-BG	25.65	4.5	6.4	7.7							
											M15	K20	N10	N20	S15	S15	

2) To correspond with seat size on holder.

Ordering example: 10 pieces N123D2-0230-0002-BG H13A
 RG123H1-0600-BG H13A
 LG123H1-0600-BG H13A

For tolerances, see page B106.

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



Code key for CoroCut® holders

Coromant Capto®

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

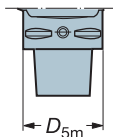
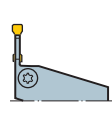
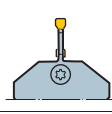
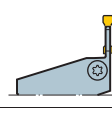
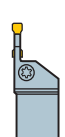


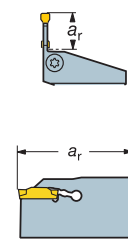
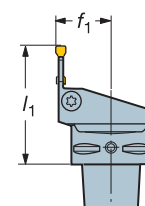
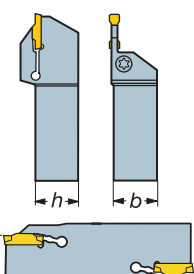

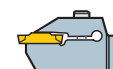

Shank holder

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

R	F	123	E	08	-	1616	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

<p>1 Coupling size</p> <p>C = Coromant Capto® D_{5m} = Coupling size</p>  <table> <tr><td>C3</td><td>$D_{5m} = 32$</td></tr> <tr><td>C4</td><td>$D_{5m} = 40$</td></tr> <tr><td>C5</td><td>$D_{5m} = 50$</td></tr> <tr><td>C6</td><td>$D_{5m} = 63$</td></tr> </table>	C3	$D_{5m} = 32$	C4	$D_{5m} = 40$	C5	$D_{5m} = 50$	C6	$D_{5m} = 63$	<p>2 Hand of tool</p> <p>R </p> <p>N </p> <p>L </p>	<p>3 Holder style</p> <p>F  0°</p> <p>G  90°</p> <p>X  1-70°</p>	
C3	$D_{5m} = 32$										
C4	$D_{5m} = 40$										
C5	$D_{5m} = 50$										
C6	$D_{5m} = 63$										
<p>4 Main code</p> <p>123</p>	<p>5 Insert seat size</p> <p>CoroCut® 1-2 D G K E H L F J</p> <p>CoroCut® 3 T = Right hand cutting U = Left hand cutting</p> <p>To correspond with seat size on insert.</p>	<p>6 Machining limitations</p>  <p>Max cutting depth a_r, in mm</p>	<p>7 Shank/cutting unit dimension</p> <p>Coromant Capto®  Shank tool </p> <p>For example: f_1 27 l_1 055</p> <p>Integers to be preceded by 0, e.g. b = 8 indicated by 08</p>								
<p>8 Clamping system</p> <p>A Spring clamp </p> <p>B Screw clamp </p> <p>C Shallow grooving </p>			<p>9 Number of insert seats</p> <p>1 One insert seat 2 Two insert seats</p>	<p>10 Holder angle</p> <p>007 = 7° 045 = 45° 070 = 70°</p> <p>Valid for holder style = X</p>	<p>11 Special application</p> <p>S = Holder for Swiss type machines</p>						
<p>12 Min. diameter for first cut, for face grooving</p> <p>Min. diameter for first cut</p>		<p>13 Type of curve, for face grooving</p> <p>B = B-curved A = A-curved</p>									

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