

Cutting heads with CoroTurn® SL quick change

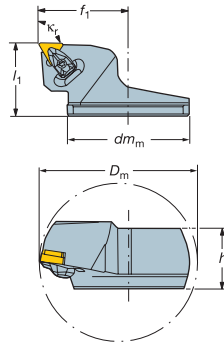
CoroTurn® RC rigid clamp design



- TNMM, TNMX
- TNMG
- TNMA, TNGA

Entering angle:

570-DTFNR/L
κ_r 91°



κ _r	Main application	△	Ordering code	Dimensions, mm					Gauge inserts	Nm ³⁾
				dm _m	h	l ₁	γ ¹⁾	λ _s ²⁾		
91°		16	570-DTFNR/L-80-16	77	37.5	45	-8°	-6°	TNMG 16 04 08	1.7
			570-DTFNR/L-80-22	77	37.5	45	-8°	-6°	TNMG 22 04 08	1.7

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces 570-DTFNR-80-16
570-DTFNL-80-16
R = Right hand, L = Left hand

Main spare parts

Insert size				Complete clamp set			Adjustment screw	Key (mm)
△	Shim screw	Shim	Key (Torx Plus)	Key (Torx Plus)	Key (Torx Plus)	Key (Torx Plus)	Key (mm)	
16	5513 020-04	5322 315-02	5680 051-03 (9IP)	5412 028-011	5680 051-03 (9IP)	3214 020-311	174.1-863 (2.5)	
22	5513 020-02	5322 315-04	5680 049-01 (15IP)	5412 028-021	5680 049-01 (15IP)	3214 020-311	174.1-863 (2.5)	



A10



A2



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Cutting heads with CoroTurn® SL quick change

CoroTurn® 107 screw clamp design



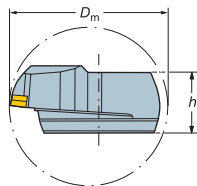
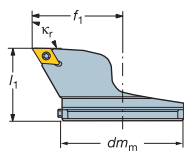
DCMT, DCMX
DCGT, DCGX

DCMW

Entering angle:

570-SDUCR

$\kappa_r 93^\circ$



κ_r	Main application		Ordering code	Dimensions, mm					Gauge inserts	Nm ³⁾
				dm_m	h	l_1	$\gamma^1)$	$\lambda_s^2)$		
93°		11	570-SDUCR/L-80-11	77	37.5	45.7	0°	-4°	DCMT 11 T3 08	0.9

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces 570-SDUCR-80-11

570-SDUCL-80-11

R = Right hand, L = Left hand

Main spare parts

Insert size	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)	Adjustment screw	Key (mm)
11	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 263-01	5512 090-01	5680 049-01 (3.5)	3214 020-311	174.1-863 (2.5)



A10



A2

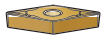


A233

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Cutting heads with CoroTurn® SL quick change

CoroTurn® 107 screw clamp design

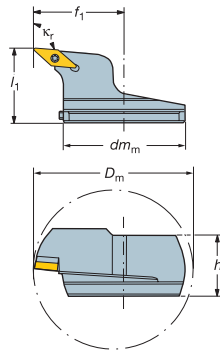


- VBMT, VBGT
- VCGX, VCEX, VCGT
- VBMW, VCMW

Entering angle:

570-SVLBR

$\kappa_r 95^\circ$



κ_r	Main application		Ordering code	Dimensions, mm					Gauge inserts	Nm ³⁾
				dm_m	h	l_1	$\gamma^1)$	$\lambda_s^2)$		
95°		16	570-SVLBR/L-80-16	77	37.5	45.7	0°	-4°	VBMT 16 04 08	3.9

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm

Ordering example: 2 pieces 570-SVLBR-80-16

570-SVLBL-80-16

R = Right hand, L = Left hand

Main spare parts

Insert size	Insert screw (thread)	Key (Torx Plus)	Shim	Shim screw	Key (mm)	Adjustment screw	Key (mm)
16	5513 020-01 (M3.5)	5680 049-01 (15IP)	5322 270-01	5512 090-01	5680 049-01 (3.5)	3214 020-311	174.1-863 (2.5)



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A2



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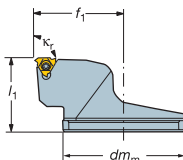
Cutting heads with CoroTurn® SL quick change

T-Max U-Lock® screw design for threading



166.0L,
154.0G¹⁾

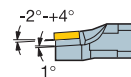
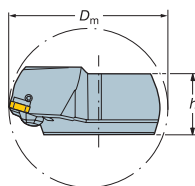
x and z, see infeed tables on pages C58.



27mm



Angle of inclination from 0° to +3° with different shims, see page C52



Main application	Pitch range		Dimensions, mm				
		mm (t.p.i.)	Ordering code	dm_m	l_1	h	Nm ²⁾
	27	8 (3)	R566.0KFC-804557-27	77	45	37.5	

Ordering example: 2 pieces R566.0KFC-804557-27

R = Right hand

1) For optional shims, see page C58.

2) Insert tightening torque Nm

Main spare parts

Insert size	Insert screw	Key (Torx Plus)	Shim ³⁾ Inclination angle +1°	Shim screw	Key (mm)	Adjustment screw	Key (mm)
	5513 020-14	5680 043-15 (25IP)	5322 383-11	5512 090-08	3021 010-060 (6.0)	3214 020-311	174.1-863 (2.5)

3) For optional shims, see page C58.



A10

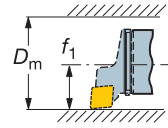
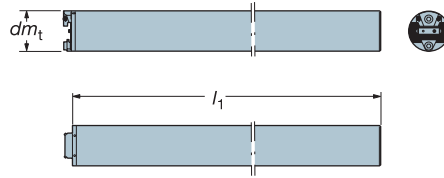
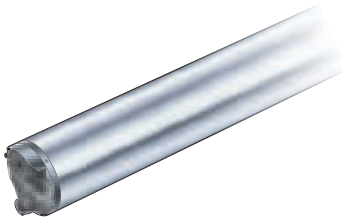


A2



A233

Damped boring bars with CoroTurn® SL quick change



Short design. Max overhang $7 \times dm_m$ All with internal coolant supply
 Long design. Max overhang $10 \times dm_m$

Both bar sizes use cutting heads in 80 mm size.

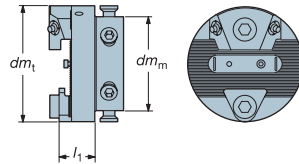
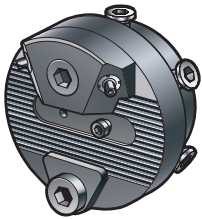
Silent Tools™

Bar dia.	Ordering code	Dimensions, mm		
		dm_t	D_m min	l_1 f_1 min.-max.
80	570-3C 80 880	80	100	880 55 - 74
100	570-3C 100 1100	100	120	1100 67 - 88
80	570-3C 80 1200	80	100	1200 55 - 74
100	570-3C 100 1500	100	120	1500 67 - 88

Ordering example: 2 pieces 570-3C 80 880

580 Boring bar adaptor

Conversion from 580-coupling to CoroTurn® SL quick change



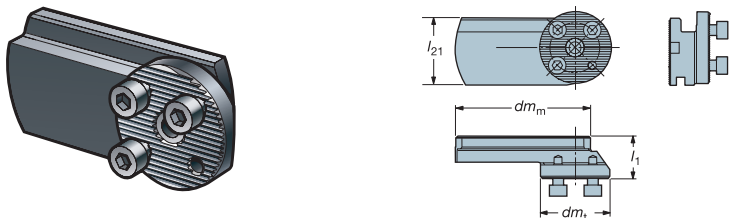
Internal coolant supply

580 coupling size, mm dm_m	Ordering code	Dimensions, mm	
		dm_t	l_1
65	570-80 17-580-80	80	17

Ordering example: 2 pieces 570-80 17-580-80



CoroTurn® SL quick change adaptor for cutting heads



Right hand style shown.

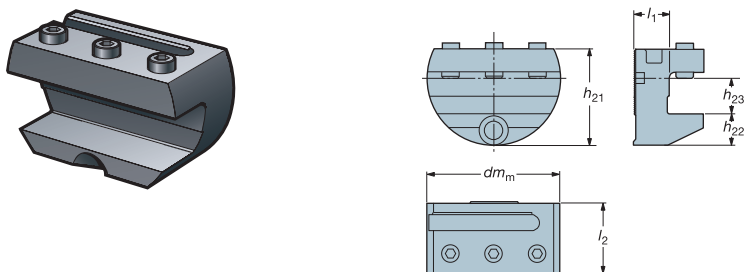
Coupling size, mm dm_t	Ordering code	Dimensions, mm		
		dm_m	l_1	l_{21}
40	570-80 23-40R/L	77	23	37.5

Ordering example: 2 pieces 570-80 23-40R

570-80 23-40L

R = Right hand, L = Left hand

CoroTurn® SL quick change adaptor for square shank tools



For shank size ($b \times h$)	Ordering code	Dimensions, mm					
		dm_m	l_1	l_2	h_{21}	h_{22}	h_{23}
2020	570-80 20 2020R	77	20	40	54.5	18	20

Ordering example: 2 pieces 570-80 20 2020R

R = Right hand



Damped boring bars and adaptors with 580 coupling

Silent Tool boring bars from 120mm diameter for overhangs up to 14 x Diameter.

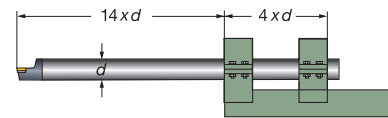
Increase your productivity when machining large bores with the 580 system, which consists of boring bars from diameter 120 to 300mm in diameter. The program consists of damped steel shank bodies for overhangs up to 10 x the diameter or carbide shank bodies up to 14 x diameter overhang. The 580 system is designed primarily for flat bed machines, and is not recommended to be used in turret type lathes due to the design of the dampening system. The adapter program enables the use of CoroTurn® SL quick change cutting heads as well as Coromant Capto® and square shank tools.

The delivery time for the 580 boring bars is between 2 to 5 weeks and up to 10 weeks for the carbide reinforced boring bars (CR).

For price and further information, please contact your local Sandvik Coromant representative.



Silent Tools™



Damped boring bars

Max recommended overhang 10 x dm_m



Ordering code	Weight kg	Ordering code	Weight kg	Ordering code	Weight kg
580-3 120 1320	104	580-3 150 2100	235	580-3 200 3200	635
580-3 120 1680	130	580-3 150 2400	265	580-3 220 2420	550
580-3 120 1920	150	580-3 160 1760	225	580-3 220 3080	680
580-3 130 1430	135	580-3 160 2240	275	580-3 220 3520	760
580-3 130 1820	170	580-3 160 2560	310	580-3 250 2750	870
580-3 130 2080	195	580-3 180 1980	325	580-3 250 3500	1080
580-3 140 1540	155	580-3 180 2520	405	580-3 250 4000	1225
580-3 140 1960	193	580-3 180 2880	455	580-3 300 3300	1470
580-3 140 2240	220	580-3 200 2200	450	580-3 300 4200	1850
580-3 150 1650	190	580-3 200 2800	560	580-3 300 4800	2075

Damped carbide reinforced boring bars

Max recommended overhang 14 x dm_m



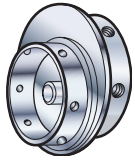
Ordering code	Weight kg	Ordering code	Weight kg	Ordering code	Weight kg
580-3 120-2220-CR	200	580-3 160-2846-CR	465	580-3 250-4556-CR	1595
580-3 130-2368-CR	245	580-3 180-3186-CR	630	580-3 300-5432-CR	2820
580-3 140-2521-CR	315	580-3 200-3691-CR	855		
580-3 150-2861-CR	375	580-3 220-4001-CR	995		

Code key

580	-	3	120	2220	CR
Front coupling		Bar diameter	Bar length	Carbide reinforced	

Damped boring bars and adaptors with 580 coupling

Reduction adaptors

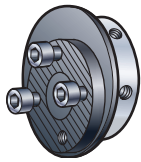


Ordering code	Weight kg	Ordering code	Weight kg	Ordering code	Weight kg
580-R/L-80-27//580-100	1.2	580-R/L-80-27//580-150	2.5	580-R/L-80-27//580-220	4.0
580-R/L-80-27//580-120	1.8	580-R/L-80-27//580-160	2.8	580-R/L-80-27//580-250	5.0
580-R/L-80-27//580-130	2.1	580-R/L-80-27//580-180	2.9	580-R/L-80-27//580-300	11.3
580-R/L-80-27//580-140	2.3	580-R/L-80-27//580-200	3.5		

Code key

580 Front coupling	-	R/L Right or left hand	-	80 Front coupling diameter	-	27 Programming length	//	580 Boring bar coupling	-	100 Boring bar diameter
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Adaptors for SL (570) style cutting heads

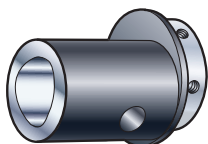


Ordering code	Max cutting force		Weight kg
	N	lbf	
570-R/L-32-15//580-080	5300	1190	0.62
570-R/L-40-15//580-080	8100	1820	0.70
570-R/L-50-15//580-080	11900	2675	0.77
570-R/L-60-15//580-080	15800	3550	0.82

Code key

570 Front coupling	-	R/L Right or left hand	-	32 Front coupling diameter	-	15 Programming length	//	580 Boring bar coupling	-	080 Boring bar diameter
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Adaptors for Coromant Capto® cutting units



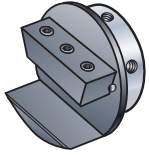
Ordering code	Max cutting force		Weight kg
	N	lbf	
C5-R/L-50-76//580-080	5500	1235	1.4
C6-R/L-63-86//580-080	5500	1235	2.1

Code key

C5 Coromant Capto® size	-	R/L Right or left hand	-	50 Front coupling diameter	-	76 Programming length	//	580 Boring bar coupling	-	080 Boring bar diameter
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Damped boring bars and adaptors with 580 coupling

Adaptors for square shank tools

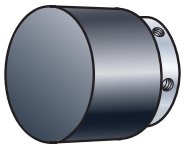


Ordering code	Weight kg	Ordering code	Weight kg	Ordering code	Weight kg
2020-R/L-25//580-080	0.9	3232-R/L-37//580-160	3.6	3232-R/L-37//580-220	7.2
2525-R/L-30//580-080	0.9	3232-R/L-37//580-180	4.4	3232-R/L-37//580-250	8.9
3232-R/L-37//580-150	3.2	3232-R/L-37//580-200	5.3	3232-R/L-37//580-300	15.2

Code key

2020	-	R/L	-	25	//	580	-	080
Square shank tool size		Right or left hand		Programming length		Boring bar coupling		Boring bar diameter

Blank adaptors



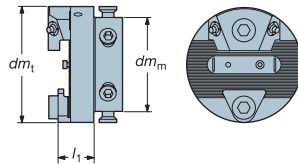
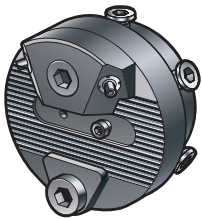
Ordering code	Ordering code	Ordering code
580-080 080 50 B	580-140 100 75 B	580-200 125 125 B
580-100 100 60 B	580-150 100 80 B	580-220 150 135 B
580-120 100 65 B	580-160 125 90 B	580-250 150 150 B
580-130 100 70 B	580-180 125 100 B	580-300 150 175 B

Code key

580	-	080		080		50		B
Boring bar style		Boring bar diameter		Programming length		Boring bar coupling		Blank

580 Boring bar adaptor

Conversion from 580-coupling to CoroTurn® SL quick change



Internal coolant supply

580 coupling size, mm dm_m	Ordering code	Dimensions, mm	
		dm_t	l_1
65	570-80 17-580-80	80	17

Ordering example: 2 pieces 570-80 17-580-80

EasyFix™

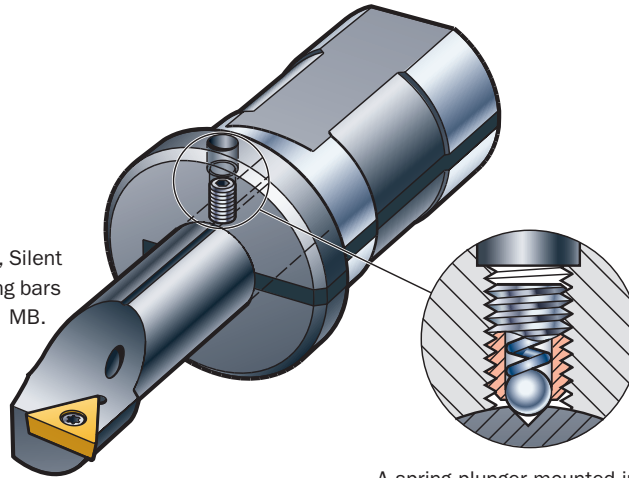
Sleeves for cylindrical bars

For correct mounting of cylindrical bars

EasyFix™ gives a fast and simple way of achieving correct indexing of centre height when mounting cylindrical bars into the machine, due to a spring loaded plunger design.

The slot in the cylindrical sleeve is filled with a silicon sealer which allows the existing coolant supply system to be used.

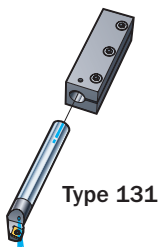
The EasyFix™ sleeves fit a wide range of products; CoroTurn® 107, CoroTurn® 111, Silent Tools damped boring bars, CoroCut® boring bars and also our brand new system CoroCut® MB.



A spring plunger mounted in the sleeve clicks into a groove in the bar to guarantee correct centre height and fast and simple handling when mounting the cylindrical bar into the machine.

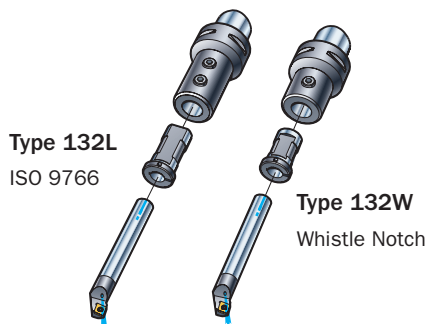
Correct clamping with Easy Fix™

Conventional lathe



Type 131

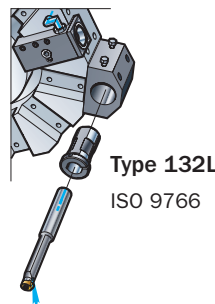
Coromant Capto®



Type 132L
ISO 9766

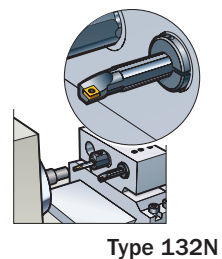
Type 132W
Whistle Notch

Turret type lathe



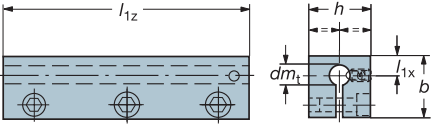
Type 132L
ISO 9766

Sliding head machine



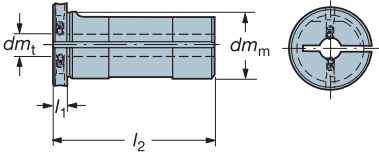
Type 132N

EasyFix™ sleeves for cylindrical bars

Square sleeves	Clamping diameter	Ordering code	Dimensions, mm				Spare parts	
			l_{1z}	h	b	l_{1x}	Screw	Key
131-	dm_m							
	5	131 -2005-B	80	20	20	5.5	3212 010-258	174.1-864
	6	131 -2006-B	80	20	20	6	3212 010-258	174.1-864
	8	131 -2008-B	80	20	20	7	3212 010-258	174.1-864
	10	131 -2010-B	80	20	20	7.5	3212 010-258	174.1-864
	12	131 -2512-B	80	25	25	9	3212 010-259	174.1-864
	16	131 -2516-B	80	25	25	10	3212 010-259	174.1-864
	20	131 -3220-B	100	32	40	12	3212 010-310	5680 010-05

Sleeves for boring bars, type 131- and 132-, can be used for all Sandvik Coromant boring bars in diameter range 5-25 mm

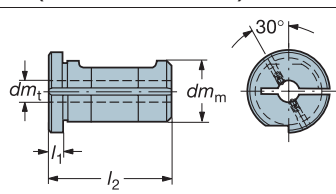
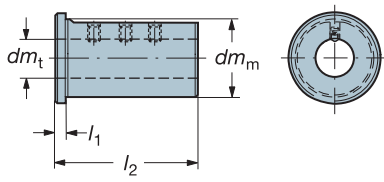
Ordering example: 2 pieces 131-2005-B

Cylindrical sleeves	Clamping diameter	Ordering code	Dimensions, mm		
			l_1	l_2	dm_m
132L-	dm_t	132L-ISO 9766			
	6	132 -2506-B	5	61	25
	8	132 -2508-B	5	61	25
	10	132 -2510-B	5	61	25
	12	132 -2512-B	5	61	25
	16	132 -2516-B	5	61	25
	20	132 -4020-B	5	75	40
	25	132 -4025-B	5	75	40
	dm_t	132L-	l_1	l_2	dm_m
	5	132 -1205050-B	5	50	19.05
	5	132 -2205050-B	5	50	22
	5	132 -1605050-B	5	50	25.4
	6	132 -1206050-B	5	50	19.05
	6	132 -2206050-B	5	50	22
	6	132 -1606050-B	5	50	25.4
	8	132 -1208050-B	5	50	19.05
	8	132 -2208050-B	5	50	22
	8	132 -1608050-B	5	50	25.4
	10	132 -1210050-B	5	50	19.05
	10	132 -2210050-B	5	50	22
	10	132 -1610050-B	5	50	25.4
	12	132 -2212050-B	5	50	22
	12	132 -1612050-B	5	50	25.4
	16	132 -1616050-B	5	50	25.4
	5	132 -2505085-B	5	85	25
	5	132 -3205085-B	5	85	32
	6	132 -3206085-B	5	85	32
	8	132 -3208085-B	5	85	32
	10	132 -3210085-B	5	85	32
	12	132 -3212085-B	5	85	32
	16	132 -3216085-B	5	85	32
	20	132 -3220085-B	5	85	32
	6	132 -4006105-B	5	105	40
	8	132 -4008105-B	5	105	40
	10	132 -4010105-B	5	105	40
	12	132 -4012105-B	5	105	40
	16	132 -4016105-B	5	105	40
	20	132 -4020105-B	5	105	40
	25	132 -4025105-B	5	105	40
	12	132 -5012125-B	5	125	50
	16	132 -5016125-B	5	125	50
	20	132 -5020125-B	5	125	50
	25	132 -5025125-B	5	125	50

Sleeves for boring bars, type 131- and 132-, can be used for all cylindrical Sandvik Coromant boring bars in diameter range 5-32 mm

Ordering example: 2 pieces 132L-2506-B

EasyFix™ sleeves for cylindrical bars

Cylindrical sleeves	Clamping diameter	Ordering code	Dimensions, mm			Spare parts	
			l_1	l_2	dm_m	Screw	Key
132W- (Whistle Notch)	dm_t		l_1	l_2	dm_m		
	5	132W-2505-B	5	50	25		
	6	132W-2506-B	5	50	25		
	8	132W-2508-B	5	50	25		
	10	132W-2510-B	5	50	25		
	12	132W-2512-B	5	50	25		
	16	132W-2516-B	5	50	25		
	20	132W-4020-B	5	75	40		
25	132W-4025-B	5	75	40			
132N-	dm_t		l_1	l_2	dm_m		
	6	132N-2506	5	61	25	3214 010-356	174.1-864 (3.0)
	8	132N-2508	5	61	25	3214 010-406	174-815 (4.0)
	10	132N-2510	5	61	25	3214 010-405	174-815 (4.0)
	12	132N-2512	5	61	25	3214 010-405	174-815 (4.0)
	16	132N-2516	5	61	25	–	–
	20	132N-2520	5	61	25	–	–
	20	132N-4020	5	75	40	3214 010-457	3021 010-050
	25	132N-4025	5	75	40	3214 010-456	3021 010-050
	32	132N-4032	5	75	40	–	–

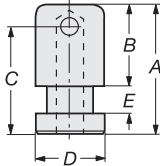
Sleeves for boring bars, type 131- and 132-, can be used for all cylindrical Sandvik Coromant boring bars in diameter range 5-32 mm

Ordering example: 2 pieces 132W-2505-B

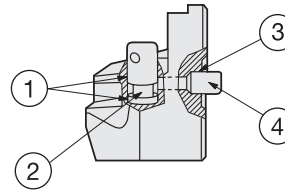
EasyFix™ sleeves for cylindrical bars

Coolant nozzle

For cutting heads with internal coolant supply	Cutting head diameter dm_m	Ordering code	Dimensions, mm				
			A	B	C	D	E
Diameters 32-60 mm	32-40	5691 032-01	10.8	5.3	7.8	8	4
		5691 032-02	12.9	7.4	9.9	8	4
		5691 032-03	15	9.5	12	8	4
	50-60	5691 032-04	16	7.5	12	12	5
		5691 032-05	19.5	11	15.5	12	5
		5691 032-06	23	14.5	19	12	5



Mounting instructions for coolant nozzles



1. Glue with Loctite 648.
2. Coolant nozzle
3. Glue with Loctite 648.
4. Location tube

Ordering example: 2 pieces 5691 032-01

Coolant connectors

	Bar dia. dm_t	Ordering code	Dimensions, mm		
			D_{21}	D_{22}	l_2
	6	CS-060-054	5.4	6.0	25.0
	8	CS-080-066	6.6	8.0	28.5
	10	CS-100-086	8.6	10.0	28.5
	12	CS-120-086	8.6	12.0	38.0
	16	CS-160-137	13.7	16.0	40.0
	20	CS-200-137	13.7	20.0	40.0
	25	CS-250-137	13.7	25.0	44.0

Ordering example: 2 pieces CS-060-054

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