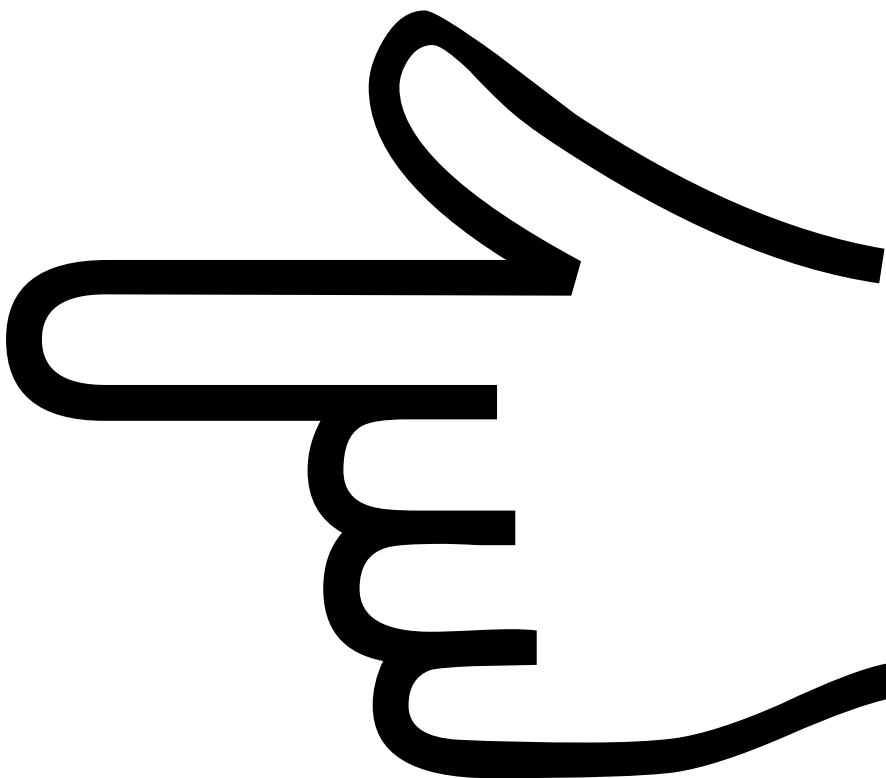


*This PDF document is divided into several files*

*Please click here to continue*



# GENERAL TURNING

## Build-in tools

**Choosing build-in tools** A 218

Code key A 219

### Cartridges for negative inserts

CoroTurn™ RC rigid clamp design A 221

T-MAX P lever design A 223

T-MAX P wedge clamp design A 226

### Cartridges for positive inserts

CoroTurn™ 107 screw clamp design A 228

### Round shank boring tools for positive inserts

CoroTurn™ 107 screw clamp design A 232

**Spare parts** A 233

**Obsolete parts** A 282

**Technical information** A 293



## Build-in tools

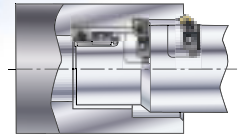
Build-in tools are primarily intended for use in multi-cutting edge tools. Compared to tools with fixed insert seats the use of build-in tools gives the following advantages:

- An expensive tool is not damaged should insert breakage occur.
- Relatively small positional tolerances can be maintained.
- If the tool has to be changed, due to a minor modification of the work-piece, the build-in units can be adjusted rather than the entire tool.



### CoroTurn cartridges to ISO

- Boring operations with multi-cutting edge tools, when several different operations are performed simultaneously.
- When necessary to distribute the total depth of cut over several cutting edges, both external and internal.
- End machining i.e. facing and chamfering of tubes and bars.



### CoroTurn™ 107 round shank boring tools

- Boring individual workpieces or production in series involving only a few machining operations.

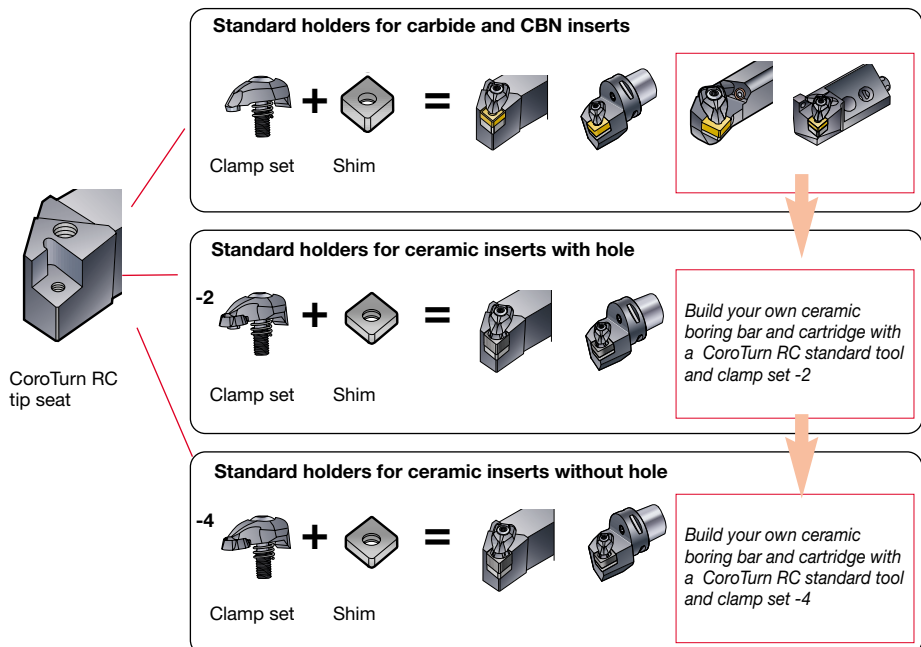
	Application		Min. hole diameter	Adjustment accuracy, mm	
	External	Internal		Radial	Axial
CoroTurn RC rigid clamp design – negative inserts	X	X	55	±0,05	±0,05
T-MAX P lever design – negative inserts	X	X	50	±0,05	±0,05
CoroTurn 107 screw clamp design – positive inserts	X	X	20	±0,05	–
CoroTurn 107 round shank boring tools – positive inserts	–	X	–	±0,05	–

### CoroTurn™ RC with the possibility of changing clamps and shims

The tip seat on all CoroTurn RC holders is designed for total interchangeability of clamps and shims to suit inserts in different cutting materials and thicknesses.

Example: You can complement your standard boring bar with -2 clamp set for thicker inserts with hole, or -4 for thicker inserts without hole. In this way you can transform your cartridge from carbide inserts into a cartridge for ceramic inserts.

For optional parts, see spare part list for each holder.

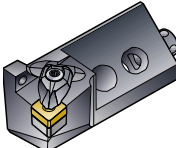
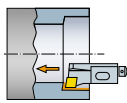
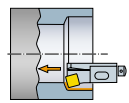
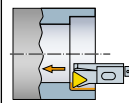
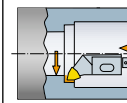
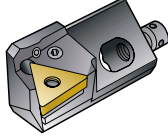
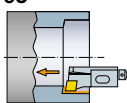
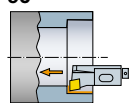
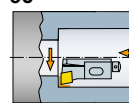
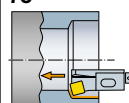
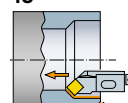
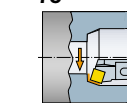
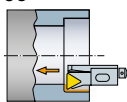
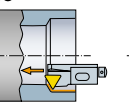
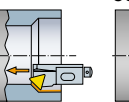
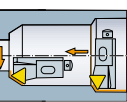
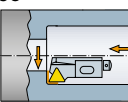
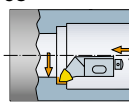


Code key for cartridges

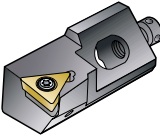
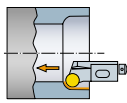
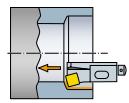
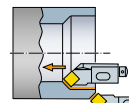
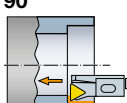
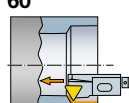
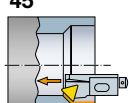
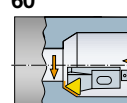
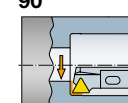
<b>P</b>	<b>C</b>	<b>L</b>	<b>N</b>	<b>R</b>	<b>16</b>	<b>C</b>	<b>A</b>	<b>-</b>	<b>12</b>
1	2	3	4	5	6	7	8	9	10

<p><b>1 Clamping system</b></p>	<p><b>2 Insert shape</b></p>	<p><b>3 Cartridge style</b></p>		
<p><b>D</b> Top and hole clamping (RC) </p>	<p><b>C</b> 80° </p> <p><b>T</b> </p>	<p><b>F</b> 90° </p>	<p><b>G</b> 90° </p>	<p><b>K</b> 75° </p>
<p><b>P</b> Hole clamping </p>	<p><b>R</b> </p> <p><b>W</b> 80° </p>	<p><b>L</b> 95° </p>	<p><b>R</b> 75° </p>	<p><b>S</b> 45° </p>
<p><b>S</b> Screw clamping </p>	<p><b>S</b> </p>	<p><b>T</b> 60° </p>	<p><b>W</b> 60° </p>	
<p><b>M</b> Top and hole clamping </p>				
<p><b>4 Clearance angle, on major cutting edge</b></p>	<p><b>5 Hand of tool</b></p>	<p><b>6 Cutting edge height, <math>h_1</math> mm</b></p>		
<p><b>C</b> </p> <p><b>N</b> </p>	<p><b>R</b> </p>			
<p><b>7 Type of tool</b></p> <p><b>C</b> = cartridge</p>	<p><b>L</b> </p>			
<p><b>8 Type of design</b></p>	<p><b>9 Tool length</b></p>	<p><b>10 Cutting edge length, / mm</b></p>		
<p><b>A</b> = letter for alternative designs according to ISO 5611.</p>	<p>The dash means tool length according to ISO 5611.</p>			

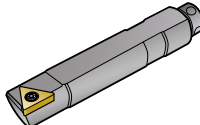
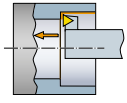
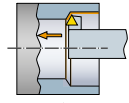
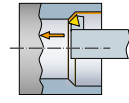
## Cartridges for negative inserts

<b>CoroTurn™ RC rigid clamp design</b> 	Entering angle $\kappa_r$ 95°      75°      90°      95°						
	 DCLNR/L	 DSKNR/L	 DTFNR/L	 DWLNR/L			
	A 221	A 221	A 222	A 222			
<b>T-MAX P lever design</b> 	Entering angle $\kappa_r$ 95°      90°      90°      75°      45°      75°						
	 PCLNR/L	 PCFNR/L	 PCGNR/L	 PSKNR/L	 PSSNR/L	 PSRNR/L	
	A 223	A 223	A 223	A 224	A 224	A 224	
	Entering angle $\kappa_r$ 90°      60°      45°      60°      90°					<b>T-MAX P wedge clamp design</b>	Entering angle $\kappa_r$ 95°
 PTFNR/L	 PTWNR/L	 PTSNR/L	 PTTNR/L	 PTGNR/L	 MWLNR/L		
A 225	A 225	A 225	A 225	A 225		A 226	

## Cartridges for positive inserts

<b>CoroTurn™ 107 screw clamp design</b> 	Entering angle $\kappa_r$ -      75°      45°				
	 SRSCR/L	 SSKCR/L	 SSSCR/L		
	A 228	A 228	A 228		
	Entering angle $\kappa_r$ 90°      60°      45°      60°      90°				
 STFCR/L	 STWCR/L	 STSCR/L	 STTCR/L	 STGCR/L	
A 229	A 229	A 229	A 229	A 229	

## Round shank boring tools for positive inserts

<b>CoroTurn™ 107 screw clamp design</b> 	Entering angle $\kappa_r$ 90°      60°      45°			
	 R/L 141.0	 R/L 140.0	 R/L 142.0	
A 232	A 232	A 232		

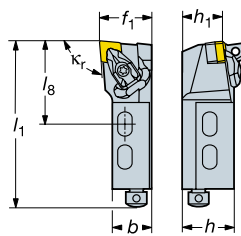
## Cartridges

### CoroTurn™ RC rigid clamp design



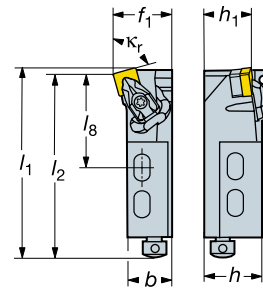
Entering angle:  $\kappa_r 95^\circ$

- CNMM, CNGP
- CNMG
- CNMA, CNGA



Entering angle:  $\kappa_r 75^\circ$

- SNMM
- SNMG
- SNGA, SNMA



Right hand style shown

	Ordering code		Dimensions, mm										Gauge inserts	 Torque Nm
			b	$D_{m1}$ min	$f_1$	h	$h_1$	$l_1$	$l_8$	$\gamma^1$	$\lambda^2$			
 $\kappa_r 95^\circ$	12	DCLNR/L 25CA-12	25	100	32	38	25	100	50	-8°	-8°	CNMG 12 04 08	3,9	
	16	DCLNR/L 25CA-16	25	100	32	38	25	100	50	-8°	-8°	CNMG 16 04 12	6,4	
	Ordering code		Dimensions, mm										Gauge inserts	 Torque Nm
			b	$D_{m1}$ min	$f_1$	h	$h_1$	$l_1$	$l_2$	$l_8$	$\gamma^1$	$\lambda^2$		
 $\kappa_r 75^\circ$	12	DSKNR/L 25CA-12	25	100	32	38	25	100	96,9	50	-6°	-6°	SNMG 12 04 08	3,9

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

Ordering example: 2 pieces DCLNR 25CA-12

Mounting dimensions, see page A 227.  
 Dimensions on master insert with  $r_e$ .  
 For other nose radii, see page A 231.

### Main spare parts

Insert size	Main spare parts					For additional spare parts and accessories, see complete spare part list. * To modify CoroTurn RC holders for other inserts, see clamp sets on pages A 236 – A 237.
	Shim	Shim screw	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	
 	5322 234-01	5513 020-02	5680 049-01 (15IP)	5412 028-021*	5680 049-02 (15IP)	
	5322 234-03	5513 020-07	5680 043-14 (20IP)	5412 028-031*	5680 043-14 (20IP)	
	5322 425-01	5513 020-02	5680 049-01 (15IP)	5412 028-021*	5680 049-01 (15IP)	

Inserts  
 A 14, A 20-26, A 34-47, A80-81, A84-85

Spare parts  
 A 274

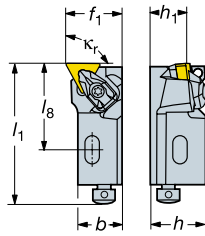
Technical information  
 A 293

# Cartridges

## CoroTurn™ RC rigid clamp design



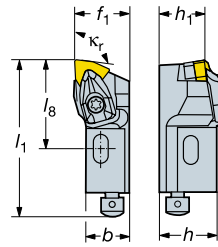
Entering angle:  $\kappa_r 90^\circ$



- TNMM, TNMX
- TNMG
- TNGA, TNMA



Entering angle:  $\kappa_r 95^\circ$



- WNMM,
- WNMG
- WNGA, WNMA

Right hand style shown

	Ordering code	Dimensions, mm									Gauge inserts	 Torque Nm
		$b$	$D_{m1 \text{ min}}$	$f_1$	$h$	$h_1$	$l_1$	$l_8$	$\gamma^1$	$\lambda^2$		
	<b>16 DTFNR/L 16CA-16</b>	20	55	25	25	16	63	39	-6°	-8°	TNMG 16 04 08	1,7
$\kappa_r 90^\circ$												
	Ordering code	Dimensions, mm								Gauge inserts	 Torque Nm	
		$b$	$D_{m1 \text{ min}}$	$D_{m2}$	$f_1$	$h$	$h_1$	$l_1$	$l_8$			
	<b>08 DWLNR/L 20CA-08</b>	20	70	90	25	25	20	70	40	WNMG 08 04 08	3,9	
$\kappa_r 95^\circ$												

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

Ordering example: 2 pieces DTFNR 16CA-16

Mounting dimensions, see page A 227.  
 Dimensions on master insert with  $r_{\epsilon}$ .  
 For other nose radii, see page A 231.

### Main spare parts

Insert size	Spare parts					For additional spare parts and accessories, see complete spare part list. * To modify CoroTurn RC holders for other inserts, see clamp sets on pages A236 – A237.
	Shim	Shim screw	Key (Torx Plus)	Complete clamp set	Key (Torx Plus)	
<b>16</b>	5322 316-01	5513 020-04	5680 051-03 (09IP)	5412 028-011	5680 049-02 (15IP)	
<b>08</b>	5322 331-12	5513 020-02	5680 049-01 (15IP)	5412 028-021*	5680 049-01 (15IP)	

Inserts  
 A 15-16, A 38-43, A 46-49, A 86-87

Spare parts  
 A 274

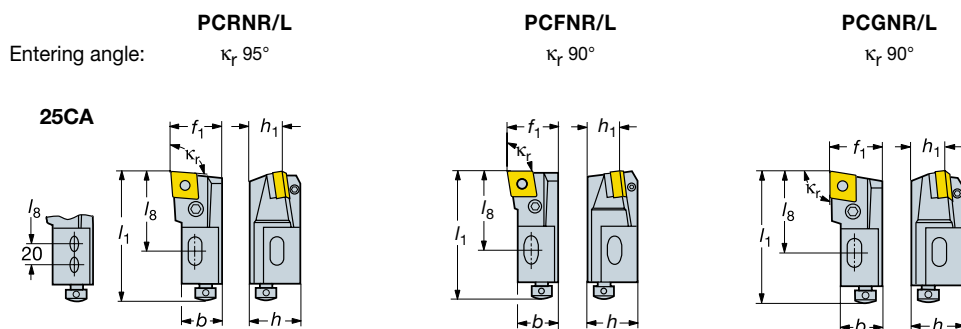
Technical information  
 A 293

# Cartridges

## T-MAX P lever design



- CNMM, CNGP
- CNMG
- CNMA, CNGA



Right hand style shown

	Ordering code	Dimensions, mm										Gauge inserts		
				$b$	$D_{m1 \min}$	$D_{m2 \min}$	$f_1$	$h$	$h_1$	$l_1$	$l_8$		$\gamma^1$	$\lambda^2$
	<b>12 PCLNR/L 16CA-12</b>			20	55	-	25	25	16	63	39	-8°	-8°	CNM.12 04 08
	<b>19 PCLNR/L 25CA-19</b>			25	100	-	32	38	25	100	50	-8°	-8°	CNM.19 06 12
$\kappa_r 95^\circ$														
	<b>12 PCFNR/L 16CA-12</b>			20	55	-	25	25	16	63	39	-6°	-8°	CNM.12 04 08
$\kappa_r 90^\circ$														
	<b>12 PCGNR/L 16CA-12</b>			20	60	75	25	25	16	63	39	-10°	-6°	CNM.12 04 08
$\kappa_r 90^\circ$														

1)  $\gamma$  = Rake angle (valid wth flat insert).2)  $\lambda$  = Angle of inclination.

Ordering example: 2 pieces PCLNR 16CA-12

Mounting dimensions, see page A 227.

Dimensions on master insert with  $r_e$ .

For other nose radii, see page A 231.

## Main spare parts

Insert size	Main spare parts			
	Lever	Screw	Key (mm)	Shim
<b>12</b>	174.3-848M	174.3-858	174.1-864 (3,0)	171.31-850M
<b>19</b>	174.3-849M	174.3-835	3021 010-040 (4,0)	171.31-851M

*For additional spare parts and accessories, see complete spare part list.*

Inserts

A 14,  
A 20-26,  
A 80-81

Spare parts



A 276

Technical information



A 293

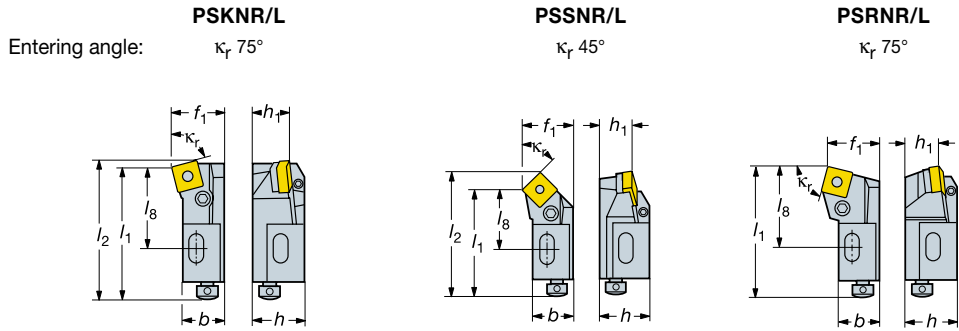


# Cartridges

## T-MAX P lever design



- SNMM
- SNMG
- SNGA, SNMA



Right hand style shown

	Ordering code	Dimensions, mm											Gauge inserts
		$b$	$D_{m1}$ min	$D_{m2}$ min	$f_1$	$h$	$h_1$	$l_1$	$l_2$	$l_8$	$\gamma^1$	$\lambda^2$	
	<b>12</b> PSKNR/L 12CA-12	15	50	–	20	20	12	55	58	35	-6°	-8°	SNM. 12 04 08
	16CA-12	20	55	–	25	25	16	63	66	39	-6°	-7°	
	<b>15</b> PSKNR/L 20CA-15	20	70	–	25	30	20	70	73,7	40	-6°	-8°	SNM. 15 06 12
	<b>12</b> PSSNR/L 12CA-12	15	50	–	20	20	12	47	55,3	27	-10°	-3°	SNM. 12 04 08
	16CA-12	20	55	–	25	25	16	53	61,3	29	-11°	-0°	
	<b>15</b> PSSNR/L 20CA-15	20	70	–	25	30	20	60	70,3	30	-10°	-3°	SNM. 15 06 12
	<b>12</b> PSRRN/L 16CA-12	20	60	75	25	25	16	63	–	39	-10°	-6°	SNM. 12 04 08
	<b>15</b> PSRRN/L 20CA-15	20	70	90	25	30	20	70	–	40	-10°	-6°	

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

Ordering example: 2 pieces PSKNR 12CA-12

Mounting dimensions, see page A 227.  
 Dimensions on master insert with  $r_{\epsilon}$ .  
 For other nose radii, see page A 231.

### Main spare parts

Insert size		Lever				Screw				Key (mm)		Shim	
$b$	$h_1$												
<b>12</b>	12	438.3-841-1				438.3-832M				174.1-863 (2,5)		–	
<b>12</b>	16	174.3-848M				174.3-858				174.1-864 (3,0)		174.3-851M	
<b>15</b>	20	438.3-840				438.3-831				174.1-864 (3,0)		174.3-857	

For additional spare parts and accessories, see complete spare part list.

- Inserts A 34-37, A 84-85
- Spare parts A 276
- Technical information A 293

# Cartridges

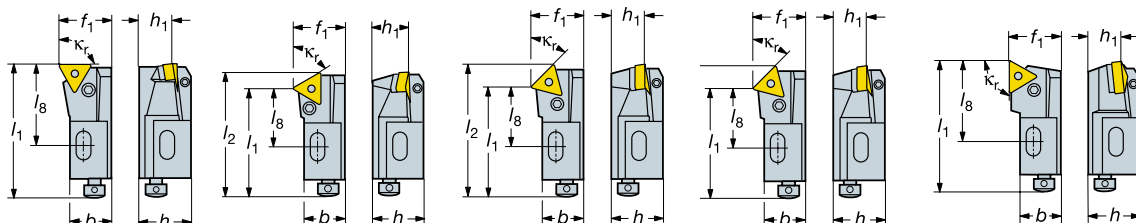
## T-MAX P lever design



Entering angle:

PTFNR/L  
 $\kappa_r 90^\circ$ PTWNR/L  
 $\kappa_r 60^\circ$ PTSNR/L  
 $\kappa_r 45^\circ$ PTTNR/L  
 $\kappa_r 60^\circ$ PTGNR/L  
 $\kappa_r 90^\circ$ 

- TNMM, TNMX
- TNMG
- TNGA, TNMA



Right hand style shown

	Ordering code	Dimensions, mm											Gauge inserts
		$b$	$D_{m1 \min}$	$D_{m2 \min}$	$f_1$	$h$	$h_1$	$l_1$	$l_2$	$l_8$	$\gamma^1$	$\lambda^2$	
	16 PTFNR/L 12CA-16	15	50	-	20	20	12	55	-	35	-6°	-9°	TNM. 16 04 08
	16CA-16	20	55	-	25	25	16	63	-	39	-6°	-8°	
	22 PTFNR/L 20CA-22	20	70	-	25	30	20	70	-	40	-6°	-8°	TNM. 22 04 08
	16 PTWNR/L 12CA-16	15	50	-	20	20	12	47	54,2	27	-6°	-7°	TNM. 16 04 08
	16 PTSNR/L 12CA-16	15	50	-	20	20	12	47	57,2	27	-10°	-3°	TNM. 16 04 08
	16CA-16	20	55	-	25	25	16	53	63,2	29	-11°	0°	
	22 PTSNR/L 20CA-22	20	75	-	25	30	20	60	74,1	30	-11°	0°	TNM. 22 04 08
	16 PTTNR/L 12CA-16	15	50	75	13	20	12	55	-	35	-9°	-2°	TNM. 16 04 08
	16 PTGNR/L 12CA-16	15	50	75	20	20	12	55	-	35	-10°	-6°	TNM. 16 04 08
	16CA-16	20	60	75	25	25	16	63	-	39	-10°	-6°	
	22 PTGNR/L 20CA-22	20	70	90	25	30	20	70	-	40	-8°	-6°	TNM. 22 04 08

1)  $\gamma$  = Rake angle (valid with flat insert).2)  $\lambda$  = Angle of inclination.

Ordering example: 2 pieces PTFNR 12CA-16

## Main spare parts

Insert size	Main spare parts				
$h_1$	Lever	Screw	Key (mm)	Shim	
16	5432 015-011	438.3-830	174.1-870 (1,98)	-	
16	174.3-840M	174.3-820M	170.3-860 (2,5)	179.3-850M	
22	174.3-841M	174.3-821	174.1-864 (3,0)	179.3-852M	

For additional spare parts and accessories, see complete spare part list.

Inserts



Spare parts



Technical information

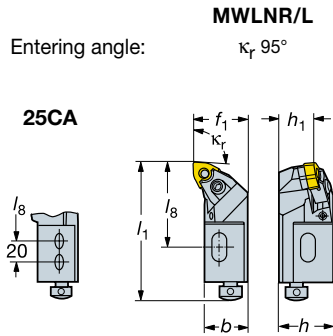
Mounting dimensions, see page A 227.  
Dimensions on master insert with  $r_\epsilon$ .  
For other nose radii, see page A 231.

# Cartridges

## T-MAX P wedge clamp design



- WNMM,
- WNMG
- WNGA, WNMA



Right hand style shown

	Ordering code	Dimensions, mm										Gauge inserts
		$b$	$D_{m \min}$	$D_{m1 \min}$	$f_1$	$h$	$h_1$	$l_1$	$l_8$	$\gamma^1$	$\lambda^2$	
	<b>06</b> MWLNR/L 16CA-06	20	55	75	25	25	16	63	39	-8°	-10°	WNM. 06 04 08
	<b>08</b> MWLNR/L 25CA-08	25	100	115	32	38	25	100	50	-8°	-10°	WNM. 08 04 08

$\kappa_r 95^\circ$

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

**Ordering example: 2 pieces MWLNR 16CA-06**

Mounting dimensions, see page A 227.  
 Dimensions on master insert with  $r_\epsilon$ .  
 For other nose radii, see page A 231.

## Main spare parts

Insert size	Main spare parts			<i>For additional spare parts and accessories, see complete spare part list.</i>
	Wedge clamp set	Key (mm)	Shim	
<b>06</b>	5431 125-011	170.3-860 (2,5)	5322 331-06	
<b>08</b>	5431 125-021	174.1-864 (3,0)	5322 331-09	

Inserts  
 A 16, A 46-49, A 87

Spare parts  
 A 276

Technical information  
 A 293

# Mounting dimensions for CoroTurn™ RC and T-MAX P cartridges

## Calculation of $D_{1a}$ , $D_{\alpha}$ and $D_{1b}$ dimensions

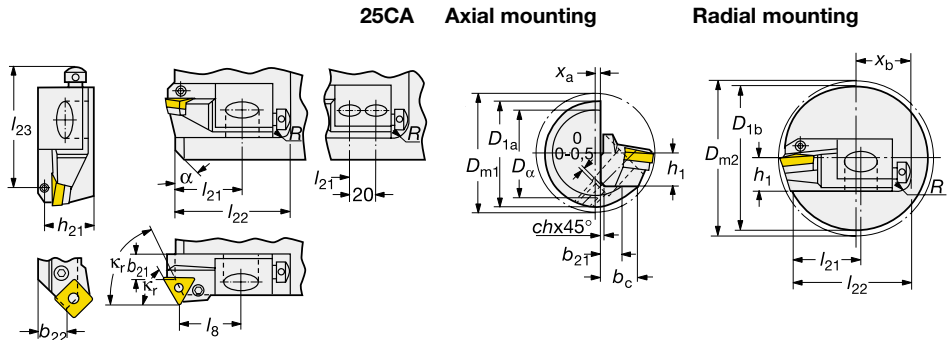
$$D_{1a \max} = 2\sqrt{h_1^2 + (b_{c \max}(\pm) x_a)^2}$$

$$D_{\alpha \max} = 2\sqrt{h_1^2 + (b_{21 \max}(\pm) x)^2}$$

$$x_a = \frac{D_{m1}}{2} - f_1$$

$$D_{1b \max} = 2\sqrt{h_1^2 + (l_{22}(\pm) x_b)^2}$$

$$x_b = l_1 - \frac{D_{m2}}{2}$$



$$\operatorname{tg} \alpha = \frac{(b_c - b_{21}) \times \operatorname{tg}(90^\circ - \kappa_r) \times 2}{D_{1a} - D_{\alpha}}$$

Axial adjust =  $\pm 1$  mm  
Radial adjust =  $+0,5$  mm

Axial adjust =  $+0,5$  mm  
Radial adjust =  $\pm 1$  mm

Cartridge size	Cartridge code	Dimensions, mm													
		$\kappa_r$	$b_c$	$b_{21 \max}$	$b_{22}$	$h_1$	$h_{21}$	$l_8$	$l_{21}$	$l_{22}$	$l_{23}$	$D_{\min 1}$	$D_{\min 2}$	$R_{\max}$	$ch_{\max}$
<b>12CA</b> 	PTFNR/L 12CA-16	90°	–	–	–	–	–	35	33	53	49	–	–	–	–
	PTWNR/L 12CA-16	60°	–	3,5	–	–	–	27	30,5	50,5	46	–	–	–	–
	PTSNR/L 12CA-16	45°	14	6,5	–	12	16	27	33,5	53,5	49	50	–	5	0,4
	PTTNR/L 12CA-16	60°	–	10,5	–	–	–	35	30,5	50,5	49	–	75	–	–
	PTGNR/L 12CA-16	90°	–	–	–	–	–	35	30,5	50,5	45	–	75	–	–
	PSKNR/L 12CA-12	75°	14	1,0	–	12	16	35	36,5	56,5	52	50	–	5	0,4
PSSNR/L 12CA-12	45°	–	–	9	–	–	27	32	52	40,5	–	–	–	–	
<b>16CA</b> 	DTFNR/L 16CA-16	90°	18,5	–	–	16	21,5	39	37,5	61	58	55	–	6	0,4
	PTFNR/L 16CA-16	90°	17,5	–	–	–	–	38	35	60	54	55	–	–	–
	PTSNR/L 16CA-16	45°	17	11,5	–	16	20,5	28	32,5	57,5	54	55	–	6	0,4
	PTGNR/L 16CA-16	90°	18,5	–	–	–	–	38	32	57	52	60	75	–	–
	PSKNR/L 16CA-12	75°	17,5	6	–	–	–	38	38,5	63,5	55	55	–	–	–
	PSSNR/L 16CA-12	45°	17	–	13,3	16	20,5	28	31,5	56,5	41	55	75	6	0,4
	PSRNR/L 16CA-12	75°	19	–	–	–	–	38	27,5	52,5	51	60	75	–	–
	PCLNR/L 16CA-12	95°	17,5	–	–	–	–	38	32	57	54	55	75	–	–
	PCFNR/L 16CA-12	90°	17,5	–	–	16	20,5	38	34	59	55	55	–	6	0,4
	PCGNR/L 16CA-12	90°	18,5	–	–	–	–	38	30,5	55,5	52	60	75	–	–
MWLNLR/L 16CA-06	95°	17,8	–	–	16	20	39	33,4	57,4	38,5	55	75	6	0,4	
<b>20CA</b> 	DWLNLR/L 20CA-08	95°	18,5	–	–	20	27	40	35	65	58	70	90	6	0,4
	PTFNR/L 20CA-22	90°	15,5	–	–	–	–	40	37	67	61	–	–	–	–
	PTSNR/L 20CA-22	45°	15,5	6,9	–	20	25	30	37	67	62	70	–	6	0,4
	PTGNR/L 20CA-22	90°	16	–	–	–	–	40	32,5	62,5	56,7	–	90	–	–
	PSKNR/L 20CA-15	75°	16,5	1,3	–	–	–	40	41	71	67	–	–	–	–
	PSSNR/L 20CA-15	45°	15,5	–	10,2	20	25	30	35	65	52	70	–	6	0,4
PSRNR/L 20CA-15	75°	18	–	–	–	–	40	33	63	60	–	90	–	–	
<b>25CA</b> 	DCLNR/L 25 CA-12	95°	24,3	–	–	25	33	50	43,6	93,5	93,5	100	115	8	0,7
	DCLNR/L 25 CA-16	95°	24,3	–	–	25	33	50	43,6	93,5	93,5	100	115	8	0,7
	DSKNR/L 25CA-12	95°	24,3	–	–	25	33	50	51,6	101,6	96,5	100	–	8	0,7
	PCLNR/L 25CA-19	95°	22,5	–	–	25	32	50	41,5	91,5	88	100	115	8	0,7
	MWLNLR/L 25CA-08	95°	23,3	–	–	25	30	50	42,3	92,3	68	100	115	8	0,7

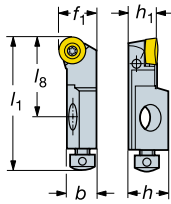
# Cartridges

## CoroTurn™ 107 screw clamp design



RCMT  
RCGX

**SRSCR/L**

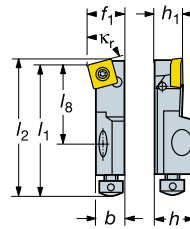


SCMT, SCGX  
SCMW

Entering angle:

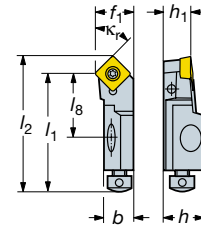
**SSKCR/L**

$\kappa_r 75^\circ$



**SSSCR/L**

$\kappa_r 45^\circ$



Right hand style shown

Insert icon	Ordering code	Dimensions, mm										Gauge inserts
		b	$D_{m\ min}$	$f_1$	h	$h_1$	$l_1$	$l_8$	$\gamma^1$	$\lambda^2$		
 	<b>06</b> SRSCR/L 06CA-06	6,1	20	8	8,5	6	25	13	0°	-4°	RCMT 06 02 M0	
	<b>08</b> SRSCR/L 08CA-08	7,0	25	10	10,0	8	32	26	0°	-4°	RCMT 08 03 M0	
	<b>10</b> SRSCR/L 10CA-10	11,3	40	14	14,9	10	50	30	0°	-4°	RCMT 10 T3 M0	
Insert icon	Ordering code	Dimensions, mm										Gauge inserts
		b	$D_{m\ min}$	$f_1$	h	$h_1$	$l_1$	$l_2$	$l_8$	$\gamma^1$	$\lambda^2$	
 	<b>09</b> SSKCR/L 10CA-09-M	11	40	14	15	10	50	52,2	30	0°	-4°	SCM. 09 T3 08
	<b>12</b> SSKCR/L 12CA-12	15	50	20	20	12	55	58,1	35	0°	-4°	SCM. 12 04 08
	<b>16CA-12</b>	20	55	25	21	16	63	66,1	38	0°	-4°	
 	<b>09</b> SSSCR/L10CA-09-M	11	40	14	15	10	44	50,1	245	-5°	0°	SCM. 09 T3 08
	<b>12</b> SSSCR/L12CA-12	15	50	20	20	12	47	55,3	27	-5°	0°	SCM. 12 04 08

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

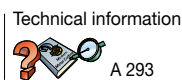
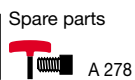
Ordering example: 2 pieces SRSCR 06CA-06

## Main spare parts

Insert size	Insert screw	Shim	Shim screw	Key (Torx Plus)
<b>06</b>	5513 020-03	–	–	5680 051-02 (7IP)
<b>08</b>	5513 020-04	–	–	5680 051-03 (9IP)
<b>10</b>	5513 020-09	5322 110-01	5512 090-01	5680 049-01 (15IP)
<b>09</b>	5513 020-09	–	–	55680 049-01 (15IP)
<b>12</b>	5513 020-17	–	–	5680 049-02 (15IP)
<b>12<sup>1)</sup></b>	5513 020-18	5322 420-02	5512 090-03	5680 049-02 (15IP)

<sup>1)</sup> Only for SSKCR/L

For additional spare parts and accessories, see complete spare part list.



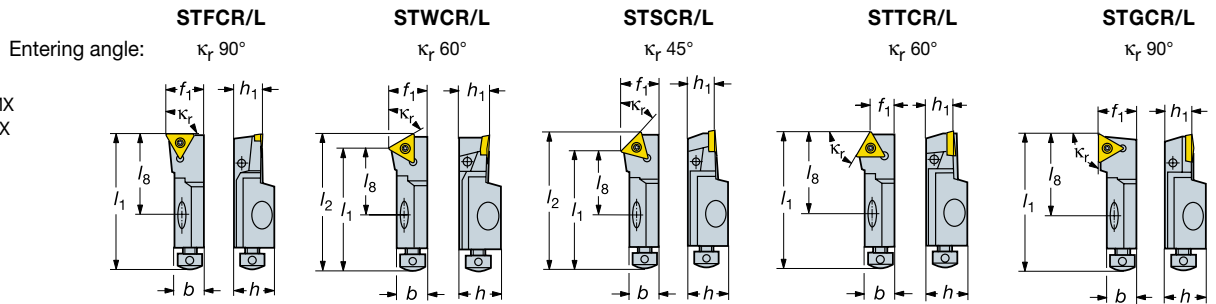
Mounting dimensions, see page A 230.  
 Dimensions on master insert with  $r_E$ .  
 For other nose radii, see page A 231.

# Cartridges

## CoroTurn™ 107 screw clamp design



- TCMT, TCMX
- TCGT, TCGX
- TCMW



Right hand style shown

	Ordering code	Dimensions, mm											Gauge inserts
		$b$	$D_{m \min}$	$D_{m1 \min}$	$f_1$	$h$	$h_1$	$l_1$	$l_2$	$l_8$	$\gamma^1$	$\lambda^2$	
 $\kappa_r$ 90°	06 STFCR/L06CA-06	6	20	–	8	8,5	6	25	–	13	0°	–6°	TC.. 06 T1 02
	09 STFCR/L08CA-09	8	25	–	10	10	8	32	–	15	0°	–6°	TC.. 09 02 04
	11 STFCR/L10CA-11	11	40	–	14	15	10	50	–	30	0°	–3°	TC.. 11 03 04
	16 STFCR/L12CA-16-M	15	50	–	20	20	12	55	–	35	0°	–3°	TC.. 16 T3 08
	16CA-16	20	55	–	25	21	16	63	–	38	0°	–6°	
 $\kappa_r$ 60°	06 STWCR/L 06CA-06	6	20	–	8	8,5	6	21	24,2	9	–3°	–2°	TC.. 06 T1 02
	09 STWCR/L 08CA-09	8	25	–	10	10	8	28	32,3	11	–4°	–4°	TC.. 09 02 04
	11 STWCR/L 10CA-11	11	40	–	14	15	10	44	49,0	24	0°	–4°	TC.. 11 03 04
	16 STWCR/L 12CA-16-M	15	50	–	20	20	12	47	54,4	28	–5°	0°	TC.. 16 T3 08
 $\kappa_r$ 45°	06 STSCR/L06CA-06	6	20	–	8	8,5	6	21	25,5	9	–6°	0°	TC.. 06 T1 02
	09 STSCR/L08CA-09	8	25	–	10	10	8	28	34,1	11	–6°	0°	TC.. 09 02 04
	11 STSCR/L10CA-11	11	40	–	14	15	10	44	51,0	24	–4°	0°	TC.. 11 03 04
	16 STSCR/L12CA-16-M	15	50	–	20	20	12	47	57,2	27	–5°	0°	TC.. 16 T3 08
	STSCR 16CA-16	20	55	–	25	21	16	53	63,2	28	–6°	3°	
 $\kappa_r$ 60°	06 STTCR/L06CA-06	6	20	30	5,5	8,5	6	25	–	13	–9°	0°	TC.. 06 T1 02
	09 STTCR/L08CA-09	8	25	37	6	10	8	32	–	15	–8°	0°	TC.. 09 02 04
	11 STTCR/L10CA-11	11	40	55	9	15	10	50	–	30	–5°	0°	TC.. 11 03 04
	16 STTCR/L12CA-16-M	15	50	75	13	20	12	55	–	35	–3°	0°	TC.. 16 T3 08
	STTCR 16CA-16	20	60	75	15	21	16	63	–	38	–5°	0°	
 $\kappa_r$ 90°	06 STGCR/L 06CA-06	6	20	30	8	8,5	6	25	–	13	–10°	0°	TC.. 06 T1 02
	09 STGCR/L 08CA-09	8	25	37	10	10	8	32	–	15	–8°	0°	TC.. 09 02 04
	11 STGCR/L 10CA-11	11	40	55	14	15	10	50	–	30	–3°	0°	TC.. 11 03 04
	16 STGCR/L 12CA-16-M	15	50	75	20	20	12	55	–	35	–3°	0°	TC.. 16 T3 08
	16CA-16	20	60	75	25	21	16	63	–	38	–5°	–3°	

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

Ordering example: 2 pieces STFCR 06CA-06

## Main spare parts

Insert size	$h_1$	Spare parts				Key (Torx Plus)	For additional spare parts and accessories, see complete spare part list.
		Insert screw	Shim	Shim screw			
06	6	5513 020-27	–	–	5680 051-01 (6IP)		
09	8	5513 020-05	–	–	5680 051-02 (7IP)		
11	10	5513 020-03	–	–	5680 051-02 (7IP)		
16	12	5513 020-10	–	–	5680 049-01 (15IP)		
16	16	5513 020-01	5322 320-01	5512 090-01	5680 049-01 (15IP)		

Inserts



Spare parts



Technical information



Mounting dimensions, see page A 230.  
Dimensions on master insert with  $r_e$ .  
For other nose radii, see page A 231.

# Mounting dimensions for CoroTurn™ 107 cartridges

A

**Calculation of  $D_{1a}$ ,  $D_\alpha$  and  $D_{1b}$  dimensions**

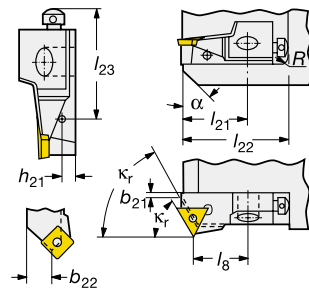
$$D_{1a\max} = 2\sqrt{h_1^2 + (b_{c\max}(\pm)x_a)^2}$$

$$D_{\alpha\max} = 2\sqrt{h_1^2 + (b_{21\max}(\pm)x)^2}$$

$$x_a = \frac{D_{m1}}{2} - f_1$$

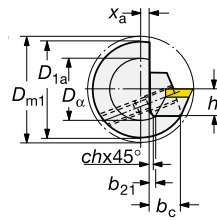
$$D_{1b\max} = 2\sqrt{h_1^2 + (l_{22}(\pm)x_b)^2}$$

$$x_b = l_1 - \frac{D_{m2}}{2}$$



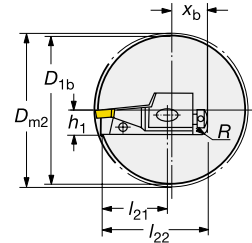
$$\tan \alpha = \frac{(b_c - b_{21}) \times \tan(90^\circ - \kappa_r) \times 2}{D_{1a} - D_\alpha}$$

**Axial mounting**



Axial adjust = ±1 mm  
Radial adjust = +0,5 mm

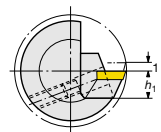
**Radial mounting**



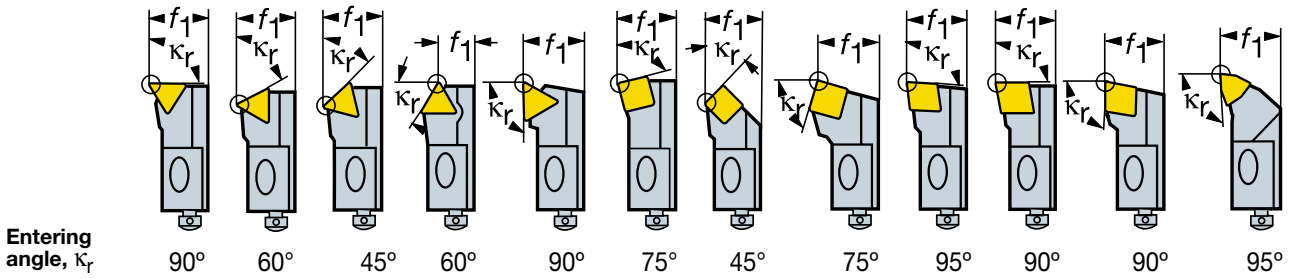
Axial adjust = +0,5 mm  
Radial adjust = ±1 mm

Cartridge size	Cartridge code	Dimensions, mm													
		$\kappa_r$	$b_c$ max	$b_{21}$ max	$b_{22}$	$h_1$	$h_{21}$	$l_8$	$l_{21}$	$l_{22}$	$l_{23}$	$D_{m1}$ min	$D_{m2}$ min	$R$ max	$ch$ max
<b>06CA</b> 	<b>SRSCR/L 06CA-06</b>	-	5,5	-	-	6,0	1,9	-	11,5	23,5	18,0	20	-	-	-
	<b>STFCR/L 06CA-06</b>	90°	-	-	-	-	-	13	12	24	-	-	-	-	
	<b>STWCR/L 06CA-06</b>	60°	-	1,2	-	-	-	9	10,5	22,5	-	-	-	-	
	<b>STSCR/L 06CA-06</b>	45°	5	2,5	-	6,0	2,2	9	11	23	17,5	20	-	1,5	0,3
	<b>STTCR/L 06CA-06</b>	60°	-	3,4	-	-	-	13	11	23	-	-	30	-	-
	<b>STGCR/L 06CA-06</b>	90°	-	-	-	-	-	13	11	23	-	-	30	-	-
<b>08CA</b> 	<b>SRSCR/L 08CA-08</b>	-	6,5	-	-	8,0	2,2	-	12,7	29,7	24,2	25	-	-	-
	<b>STFCR/L 08CA-09</b>	90°	-	-	-	-	-	15	13,5	30,5	-	-	-	-	
	<b>STWCR/L 08CA-09</b>	60°	-	0,8	-	-	-	11	13	30	-	-	-	-	
	<b>STSCR/L 08CA-09</b>	45°	6	2,4	-	8,0	2,5	11	13,5	30,5	21,5	25	-	2,5	0,3
	<b>STTCR/L 08CA-09</b>	60°	-	2,7	-	-	-	15	12,2	29,2	-	-	37	-	-
	<b>STGCR/L 08CA-09</b>	90°	-	-	-	-	-	11	12,2	29,2	-	-	37	-	-
<b>10CA</b> 	<b>SRSCR/L 10CA-10</b>	-	10,6	-	-	10	3,0	-	28,0	48,0	39,5	40	-	-	-
	<b>STFCR/L 10CA-11</b>	90°	-	-	-	-	-	30	27,5	47,5	-	-	-	-	
	<b>STWCR/L 10CA-11</b>	60°	-	1,2	-	-	-	24	27	47	-	-	-	-	
	<b>STSCR/L 10CA-11</b>	45°	9	3	-	10	3	24	29	49	39,5	40 <sup>1)</sup>	-	4	0,4
	<b>STTCR/L 10CA-11</b>	60°	-	6,1	-	-	-	30	28	48	-	-	55	-	-
	<b>STGCR/L 10CA-11</b>	90°	-	-	-	-	-	30	26,5	46,5	-	-	55	-	-
<b>12CA</b> 	<b>SSKCR/L 10CA-09-M</b>	75°	9	0,9	-	10	3	30	30,5	50,5	41,5	40 <sup>1)</sup>	-	4	0,4
	<b>SSSCR/L 10CA-09-M</b>	45°	-	6	-	-	-	24	27	47	38	-	-	-	-
	<b>STFCR/L 12CA-16-M</b>	90°	13	-	-	-	-	35	33,2	53,2	40	-	-	-	-
	<b>STWCR/L 12CA-16-M</b>	60°	13	4,2	-	-	-	27	32	52	40	-	-	-	-
	<b>STSCR/L 12CA-16-M</b>	45°	13	5,4	-	12	5	27	35	55	43	50	-	5	0,4
	<b>STTCR/L 12CA-16-M</b>	60°	13	9,8	-	-	-	35	33	53	40	-	75	-	-
<b>16CA</b> 	<b>STGCR/L 12CA-16-M</b>	90°	15	-	-	-	-	35	31	51	40	-	75	-	-
	<b>SSKCR/L 12CA-12</b>	75°	13,5	3,1	-	12	5	35	36	56	40	50	-	5	0,4
	<b>SSSCR/L 12CA-12</b>	45°	13	-	9,4	-	-	27	31,5	51,5	39	-	75	-	-
	<b>STFCR/L 16CA-16</b>	90°	17	-	-	-	-	38	36	61	52	55	-	-	-
	<b>STWCR/L 16CA-16</b>	60°	16,5	4,9	-	-	-	28	32,5	57,5	46	55	-	-	-
	<b>STSCR/L 16CA-16</b>	45°	16,5	7,1	-	16	5	28	35,5	60,5	48	55	-	6	0,4
<b>16CA</b> 	<b>STTCR/L 16CA-16</b>	60°	17,5	11,5	-	-	-	38	35,5	60,5	48	60	75	-	-
	<b>STGCR/L 16CA-16</b>	90°	18,5	-	-	-	-	38	32	57	48	60	75	-	-
	<b>SSKCR/L 16CA-12</b>	75°	16,5	6	-	16	5	38	34	60	49	55	-	6	0,4

1) According to ISO the min hole diameter is 40 mm but by mounting the cartridge 1 mm above centre, as shown in the sketch, a 32 mm diameter hole can be machined.



### $f_1$ -dimensions for ISO cartridges



$\kappa_r$	Cartridge		$f_1$ -dimensions, mm						
	CoroTurn™ RC T-MAX P	CoroTurn™ 107	$r_e = 0,0$	$r_e = 0,2$	$r_e = 0,4$	$r_e = 0,8$	$r_e = 1,2$	$r_e = 1,6$	$r_e = 2,4$
90°	-	STFCR/L 06CA-06	8,4	8,0	7,9	7,6	-	-	-
60°	-	STWCR/L 06CA-06	8,2	8,0	7,8	7,4	-	-	-
45°	-	STSCR/L 06CA-06	8,2	8,0	7,8	7,4	-	-	-
60°	-	STTCR/L 06CA-06	5,4	5,5	5,6	5,8	-	-	-
90°	-	STGCR/L 06CA-06	8,0	8,0	8,0	8,0	-	-	-
90°	-	STFCR/L 08CA-09	10,3	10,1	10,0	9,7	-	-	-
60°	-	STWCR/L 08CA-09	10,4	10,2	10,0	9,6	-	-	-
45°	-	STSCR/L 08CA-09	10,4	10,2	10,0	9,6	-	-	-
60°	-	STTCR/L 08CA-09	5,8	5,9	6,0	6,2	-	-	-
90°	-	STGCR/L 08CA-09	10,0	10,0	10,0	10,0	-	-	-
90°	-	STFCR/L 10CA-11	14,29	14,14	14,0	13,71	-	-	-
60°	-	STWCR/L 10CA-11	14,40	14,20	14,0	13,60	-	-	-
45°	-	STSCR/L 10CA-11	14,37	14,19	14,0	13,63	-	-	-
60°	-	STTCR/L 10CA-11	8,77	8,89	9,0	9,23	-	-	-
90°	-	STGCR/L 10CA-11	14,0	14,0	14,0	14,0	-	-	-
75°	-	SSKCR/L 10CA-09-M	14,18	14,13	14,09	14,0	-	-	-
45°	-	SSSCR/L 10CA-09-M	14,33	14,25	14,16	14,0	-	-	-
90°	PTFNR/L 12CA-16	-	20,56	-	20,28	20,0	19,72	19,44	-
	-	STFCR/L 12CA-16-M	20,58	-	20,29	20,0	19,71	-	-
60°	PTWNR/L 12CA-16	-	20,78	-	20,39	20,0	19,61	19,22	-
	-	STWCR/L 12CA-16	20,80	-	20,40	20,0	19,60	-	-
45°	PTSNR/L 12CA-16	-	20,76	-	20,38	20,0	19,62	19,24	-
	-	STSCR/L 12CA-16-M	20,74	-	20,37	20,0	19,63	-	-
60°	PTTNR/L 12CA-16	STTCR/L 12CA-16-M	12,54	-	12,77	13,0	13,23	13,46	-
90°	PTGNR/L 12CA-16	STGCR/L 12CA-16-M	20,01	-	20,0	20,0	20,0	19,99	-
75°	PSKNR/L 12CA-12	SSKCR/L 12CA-12	20,18	20,13	20,09	20,0	19,91	19,82	19,64
45°	PSSNR/L 12CA-12	-	20,32	-	20,16	20,0	19,84	19,68	19,35
	-	SSSCR/L 12CA-12	20,33	20,25	20,16	20,0	19,84	-	-
90°	DTFNR/L 16CA-16	-	25,52	-	25,24	24,96	24,68	24,40	-
90°	PTFNR/L 16CA-16	-	25,56	-	25,28	25,0	24,72	24,44	-
	-	STFCR/L 16CA-16	25,57	-	25,29	25,0	24,71	-	-
60°	-	STWCR/L 16CA-16	25,79	-	25,40	25,0	24,60	-	-
45°	PTSNR/L 16CA-16	STSCR/L 16CA-16	25,74	-	25,37	25,0	24,63	24,26	-
90°	PTGNR/L 16CA-16	STGCR/L 16CA-16	25,01	-	25,00	25,00	25,00	24,99	-
75°	PSKNR/L 16CA-12	-	25,17	-	25,09	25,0	24,91	24,83	24,66
	-	SSKCR/L 16CA-12	25,78	-	25,09	25,00	24,91	-	-
45°	PSSNR/L 16CA-12	-	25,33	-	25,16	25,00	24,84	24,67	24,35
75°	PSRNR/L 16CA-12	-	24,96	-	24,98	25,00	25,02	25,04	25,08
95°	MWLNRL 16CA-06	-	25,07	-	25,03	25,0	-	-	-
95°	PCLNR/L 16CA-12	-	25,07	-	25,03	25,00	24,97	24,93	-
90°	PCFNR/L 16CA-12	-	25,14	-	25,07	25,00	24,93	24,86	-
90°	PCGNRL 16CA-12	-	25,00	-	25,00	25,00	25,00	25,00	-
95°	DWLNRL 20CA-08	-	25,03	-	25,00	24,96	24,92	24,89	-
90°	PTFNR/L 20CA-22	-	25,56	-	25,28	25,00	24,72	24,44	-
45°	PTSNR/L 20CA-22	-	25,74	-	25,37	25,00	24,63	24,26	-
90°	PTGNR/L 20CA-22	-	25,01	-	25,00	25,00	25,00	24,99	-
75°	PSKNR/L 20CA-15	-	25,25	-	25,17	25,08	25,00	24,92	24,75
45°	PSSNR/L 20CA-15	-	25,49	-	25,32	25,16	25,00	24,84	24,51
75°	PSRNR/L 20CA-15	-	24,93	-	24,95	24,98	25,00	25,02	25,07
95°	DCLNR/L 25CA-12	-	32,03	-	32,00	31,96	31,92	31,89	31,81
95°	DCLNR/L 25CA-16	-	32,07	-	32,03	32,00	31,96	32,92	31,85
75°	DSKNR/L 25CA-12	-	32,13	-	32,05	31,96	31,87	31,79	31,61
95°	MWLNRL 25CA-08	-	32,07	-	32,03	32,0	31,97	31,93	-
95°	PCLNR/L 25CA-19	-	32,11	-	-	32,04	32,00	31,96	31,89

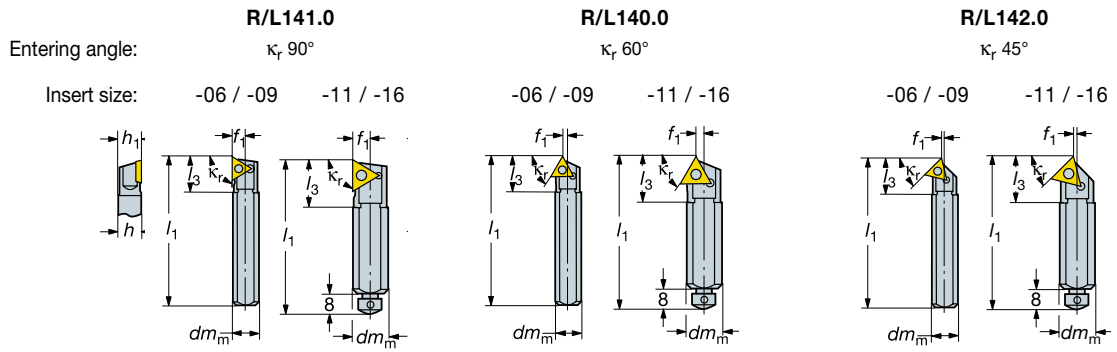


# Round shank boring tools

## CoroTurn™ 107 screw clamp design



- TCMT, TCMX  
TCGT, TCGX
- TCMW



Right hand style shown

	Ordering code	Dimensions, mm								Gauge inserts
		$dm_m$	$f_1$	$h$	$h_1$	$l_1$	$l_3$	$\gamma^1$	$\lambda^2$	
	<b>06</b> R/L 141.0-8-06	8	4,0	7	7	30	10,5	0°	0°	TC.. 06 T1 02
	<b>09</b> R/L 141.0-10-09	10	5,1	8,5	8,5	50	14,0	0°	0°	TC.. 09 02 04
	<b>11</b> R/L 141.0-12-11 16-11	12 16	6,0 7,5	10,5 14,0	10,5 14,0	68 98	15,3 15,3	0°	0°	TC.. 11 02 04
	<b>16</b> R/L 141.0-20-16	20	10,7	17,0	17,0	128	19,0	0°	0°	TC.. 16 T3 08
	<b>06</b> R/L 140.0-8-06	8	1,47	7	7	30	10,6	0°	0°	TC.. 06 T1 02
	<b>09</b> R/L 140.0-10-09	10	1,7	8,5	8,5	50	13,4	0°	0°	TC.. 09 02 04
	<b>11</b> R/L 140.0-12-11 16-11	12 16	2,2 2,2	10,5 14,0	10,5 14,0	68 98	15,4 15,4	0°	0°	TC.. 11 02 04
	<b>16</b> R/L 140.0-20-16	20	2,4	17,0	17,0	128	19,0	0°	0°	TC.. 16 T3 08
	<b>06</b> R/L 142.0-8-06	8	0,39	7	7	30	10,6	0°	0°	TC.. 06 T1 02
	<b>09</b> R/L 142.0-10-09	10	-0,23	8,5	8,5	50	13,4	0°	0°	TC.. 09 02 04
	<b>11</b> R/L 142.0-12-11 16-11	12 16	0,5 0,5	10,5 14,0	10,5 14,0	68 98	15,4 15,4	0°	0°	TC.. 11 02 04
	<b>16</b> R/L 142.0-20-16	20	-0,7	17,0	17,0	128	19,0	0°	0°	TC.. 16 T3 08

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

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

Ordering example: 2 pieces R 141.0-8-06

### Main spare parts

Insert size	Insert screw	Shim	Shim screw	Key (Torx Plus)	Length adjusting screw	For additional spare parts and accessories, see complete spare part list.
<b>06</b>	5513 020-27	-	-	5680 051-01 (6IP)	-	
<b>09</b>	5513 020-05	-	-	5680 051-02 (7IP)	-	
<b>11</b>	5513 020-03	-	-	5680 051-02 (7IP)	438.3-824	
<b>16</b>	5513 020-01	5322 320-01	5512 090-01	5680 049-01 (15IP)	438.3-825	

#### Inserts



A 18,  
A 62-65,  
A 90

#### Spare parts



A 279

#### Technical information



A 293

# SPARE PARTS

## External machining

*Shank tools and Coromant Capto® units*

### Holders for negative inserts

- CoroTurn RC rigid clamp **A 234**
- T-MAX P lever **A 238**
- T-MAX P, screw and top clamp **A 242**
- T-MAX P wedge clamp **A 244**

### Holders for positive inserts

- CoroTurn 107 screw clamp **A 246**

### Holders for ceramic inserts

- CoroTurn RC RC rigid clamp **A 252**
- T-MAX top clamp **A 256**

## Internal machining

*Shank tools and Coromant Capto® units*

### Boring bars for negative inserts

- CoroTurn RC rigid clamp **A 260**
- T-MAX P lever **A 262**
- T-MAX P wedge clamp **A 264**
- T-MAX P screw and top clamp **A 264**

### Boring bars for positive inserts

- CoroTurn 107 screw clamp **A 266**
- CoroTurn 111 screw clamp **A 270**

### Boring bars for ceramic inserts

- T-MAX top clamp **A 271**

### Cutting heads for negative inserts

- T-MAX P lever clamp **A 272**

### Cutting heads for positive inserts

- CoroTurn 107 screw clamp **A 273**
- CoroTurn 111 screw clamp **A 272**

## Build-in tools

### Cartridges for negative inserts

- CoroTurn RC rigid clamp **A 274**
- T-MAX P lever clamp **A 276**
- T-MAX P wedge clamp **A 276**

### Cartridges for positive inserts

- CoroTurn 107 screw clamp **A 278**
- Round shank boring tools, screw clamp **A 279**

## Anti-vibration bars

- Type 570-2C and 570-3C **A 280**

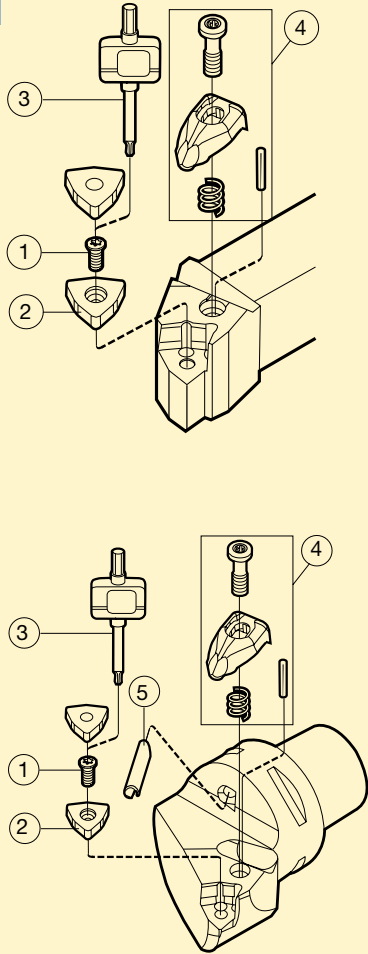
### Cross reference list – Torx keys **A 281**

## Obsolete parts

- Table of content **A 282**

**CoroTurn™ RC rigid clamp design**

**A**



Tool type		Standard parts Delivered with the tool				
Shank holders		Coromant Capto®		1	2	3
				Shim screw	Shim (For insert thickness)	Key (Torx Plus)
80°						
DCLNR/L 2020K12 2525M12 3225P12	C4-DCLNR/L-27050-12 C5-DCLNR/L-35060-12 C6-DCLNR/L-45065-12	5513 020-02	5322 234-01 (4,76)	5680 049-01 (15IP)		
DCLNR/L 2525M16 3225P16 3232P16	C4-DCLNR/L-27055-16 C5-DCLNR/L-35060-16 C6-DCLNR/L-45065-16 C8-DCLNR/L-55080-16	5513 020-07	5322 234-03 (6,35)	5680 043-14 (20IP)		
DCLNR/L 3232P19	C5-DCLNR/L-35060-19 C6-DCLNR/L-45065-19 C8-DCLNR/L-55080-19	5513 020-07	5322 236-01 (6,35)	5680 043-14 (20IP)		
DCBNR/L 2525M12 3225P12	C4-DCRNR/L-22050-12 C5-DCRNR/L-27060-12 C6-DCRNR/L-35065-12	5513 020-02	5322 234-01 (4,76)	5680 049-01 (15IP)		
DCBNR/L 2525M16 3225P16	C5-DCRNR/L-27060-16 C6-DCRNR/L-35065-16 C8-DCRNR/L-55080-16	5513 020-07	5322 234-03 (6,35)	5680 043-14 (20IP)		
DCBNR/L 3232P19	C5-DCRNR/L-27060-19 C6-DCRNR/L-35065-19 C8-DCRNR/L-55080-19	5513 020-07	5322 236-01 (6,35)	5680 043-14 (20IP)		
DCKNR/L 2525M12 3225P12	C4-DCKNR/L-27050-12 C5-DCKNR/L-35060-12 C6-DCKNR/L-45065-12	5513 020-02	5322 234-01 (4,76)	5680 049-01 (15IP)		
	C5-DCKNR/L-35060-16 C6-DCKNR/L-45065-16	5513 020-07	5322 234-03 (6,35)	5680 043-14 (20IP)		
	C6-DCKNR/L-45065-19	5513 020-07	5322 236-01 (6,35)	5680 043-14 (20IP)		
55°						
	C4-DDHNR/L-27055-15 C5-DDHNR/L-35060-15	5513 020-02	5322 266-02 (6,35)	5680 049-01 (15IP)		
DDJNR/L 2020K11 2525M11 3225P11	C4-DDJNR/L-27050-11 C5-DDJNR/L-35060-11 C6-DDJNR/L-45065-11	5513 020-04	5322 267-01 (4,76)	5680 051-03 (9IP)		
DDJNR/L 2020K15 2525M15 3225P15 3232P15	C4-DDJNR/L-27055-15 C5-DDJNR/L-35060-15 C6-DDJNR/L-45065-15 C8-DDJNR/L-55080-15	5513 020-02	5322 266-02 (6,35)	5680 049-01 (15IP)		
	C5-DDUNR/L-35060-15 C6-DDUNR/L-45065-15 C8-DDUNR/L-55080-15	5513 020-02	5322 266-02 (6,35)	5680 049-01 (15IP)		
DSDNN 2020K12 2525M12 3225P12	C4-DSDNN-00050-12 C5-DSDNN-00060-12 C6-DSDNN-00065-12	5513 020-02	5322 425-01 (4,76)	5680 049-01 (15IP)		
	C5-DSDNN-00060-15 C6-DSDNN-00065-15	5513 020-07	5322 425-03 (6,35)	5680 043-14 (20IP)		
DSDNN 3225P19 3232P19	C5-DSDNN-00065-19 C6-DSDNN-00070-19	5513 020-07	5322 425-04 (6,35)	5680 043-14 (20IP)		
	C8-DSDNN-00080-25	5513 020-08	5322 425-07 (7,94)	5680 043-15 (25IP)		
DSKNR/L 2525M12 3225P12	C4-DSKNR/L-27050-12 C5-DSKNR/L-35060-12 C6-DSKNR/L-45065-12	5513 020-02	5322 425-01 (4,76)	5680 049-01 (15IP)		
	C5-DSKNR/L-35060-15 C6-DSKNR/L-45065-15	5513 020-07	5322 425-03 (6,35)	5680 043-14 (20IP)		
	C6-DSKNR/L-45065-19 C8-DSKNR/L-55080-19	5513 020-07	5322 425-04 (6,35)	5680 043-14 (20IP)		
	C8-DSKNR/L-55080-25	5513 020-08	5322 425-07 (7,94)	5680 043-15 (25IP)		
DSBNR/L 2525M12 3225P12	C4-DSRNR/L-22050-12 C5-DSRNR/L-27060-12 C6-DSRNR/L-35065-12	5513 020-02	5322 425-01 (4,76)	5680 049-01 (15IP)		
DSBNR/L 3232P15	C5-DSRNR/L-27060-15 C6-DSRNR/L-35065-15	5513 020-07	5322 425-03 (6,35)	5680 043-14 (20IP)		
DSBNR/L 3232P19 4040S19	C6-DSRNR/L-35065-19 C8-DSRNR/L-45080-19	5513 020-07	5322 425-04 (6,35)	5680 043-14 (20IP)		
	C8-DSRNR/L-45080-25	5513 020-08	5322 425-07 (7,94)	5680 043-15 (25IP)		

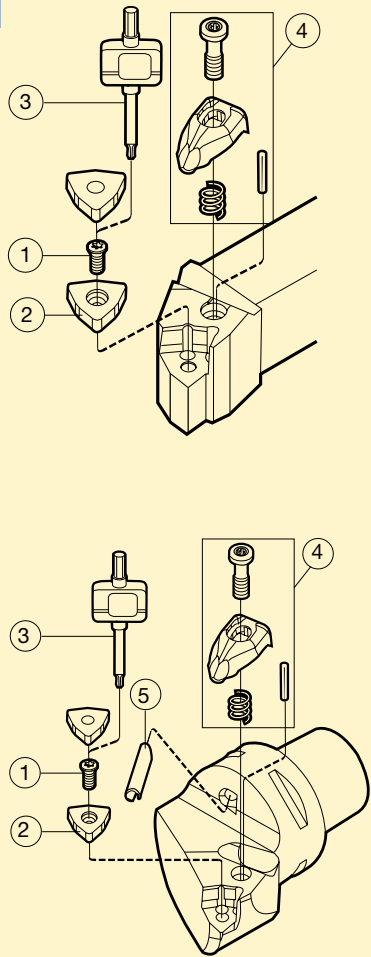
		<b>Optional parts</b> Delivery to separate order					
4	5	4	4	2	2		
Complete clamp set	Coolant nozzle	Clamp sets for ceramic inserts without hole <sup>1)</sup>	Clamp sets for ceramic inserts with hole <sup>1)</sup>	Shim	For insert thickness	Shim	For insert thickness
5412 028-021	5691 045-01	5412 034-021	5412 032-021	5322 234-02	7,94	-	-
5412 028-031	5691 045-01	5412 034-031	5412 032-031	5322 234-04	7,94	-	-
5412 028-041	5691 045-01	-	-	-	-	-	-
5412 028-021	5691 045-01	5412 034-021	5412 032-021	5322 234-02	7,94	-	-
5412 028-031	5691 045-01	5412 034-031	5412 032-031	5322 234-04	7,94	-	-
5412 028-041	5691 029-09 5691 045-01 5691 045-01	-	-	-	-	-	-
5412 028-021	5691 029-08 5691 029-09 5691 029-09	5412 034-021	5412 032-021	5322 234-02	7,94	-	-
5412 028-031	5691 045-01 5691 029-09	5412 034-031	5412 032-031	5322 234-04	7,94	-	-
5412 028-041	5691 029-09	-	-	-	-	-	-
5412 028-021	5691 045-01	5412 034-021	5412 032-021	5322 266-01	4,76	5322 266-03	7,94
5412 028-011	5691 045-01 5691 045-01 5691 029-09	-	-	-	-	-	-
5412 028-021	5691 045-01 5691 045-01 5691 029-09 5691 029-10	5412 034-021	5412 032-021	5322 266-01	4,76	5322 266-03	7,94
5412 028-021	5691 029-09 5691 029-09 5691 029-10	5412 034-021	5412 032-021	5322 266-01	4,76	5322 266-03	7,94
5412 028-021	5691 045-01	5412 034-021	5412 032-021	5322 425-02	7,94	-	-
5412 028-031	5691 045-01	5412 034-031	5412 032-031	5322 425-05	7,94	-	-
5412 028-041	5691 045-01	-	-	-	-	-	-
5412 028-051	5691 045-01	-	-	5322 425-08	9,52	-	-
5412 028-021	5691 029-08 5691 029-09 5691 029-09	5412 034-021	5412 032-021	5322 425-02	7,94	-	-
5412 028-031	5691 029-09	5412 034-031	5412 032-031	5322 425-05	7,94	-	-
5412 028-041	5691 029-09 5691 045-01	-	-	-	-	-	-
5412 028-051	5691 045-01	-	-	5322 425-08	9,52	-	-
5412 028-021	5691 045-01	5412 034-021	5412 032-021	5322 425-02	7,94	-	-
5412 028-031	5691 045-01	5412 034-031	5412 032-031	5322 425-05	7,94	-	-
5412 028-041	5691 045-01	-	-	-	-	-	-
5412 028-051	5691 045-01	-	-	5322 425-08	9,52	-	-

<sup>1)</sup> For clamp set parts, see pages A 236-A 237.

Ordering example: 10 pieces 5513 020-02

**CoroTurn™ RC rigid clamp design**

**A**



Tool type		Standard parts Delivered with the tool			
		1	2	3	
Shank holders	Coromant Capto®	Shim screw	Shim (For insert thickness)	Key (Torx Plus)	
	<b>DSSNR/L</b> 2020K12 2525M12 3225P12	C4-DSSNR/L-27042-12 C5-DSSNR/L-35052-12 C6-DSSNR/L-45056-12	5513 020-02	5322 425-01 (4,76)	5680 049-01 (15IP)
	<b>DSSNR/L</b> 2525M15 3225P15 3232P15	C4-DSSNR/L-27045-15 C5-DSSNR/L-35050-15 C6-DSSNR/L-45054-15	5513 020-07	5322 425-03 (6,35)	5680 043-14 (20IP)
	<b>DSSNR/L</b> 3232P19	C5-DSSNR/L-35048-19 C6-DSSNR/L-45052-19	5513 020-07	5322 425-04 (6,35)	5680 043-14 (20IP)
		C8-DSSNR/L-55070-25	5513 020-08	5322 425-07 (7,94)	5680 043-15 (25IP)
	<b>DTFNR/L</b> 2020K16 2525M16	C4-DTFNR/L-27050-16 C5-DTFNR/L-35060-16 C6-DTFNR/L-45065-16	5513 020-04	5322 315-02 (4,76)	5680 051-03 (9IP)
	<b>DTFNR/L</b> 2525M22 3225P22 3232P22	C4-DTFNR/L-27050-22 C5-DTFNR/L-35060-22 C6-DTFNR/L-45065-22	5513 020-02	5322 315-04 (4,76)	5680 049-01 (15IP)
	<b>DTGNR/L</b> 2020K16 2525M16 3225P16	C4-DTGNR/L-27050-16 C5-DTGNR/L-35060-16 C6-DTGNR/L-45065-16	5513 020-04	5322 315-02 (4,76)	5680 051-03 (9IP)
	<b>DTGNR/L</b> 2525M22 3225P22 3232P22	C4-DTGNR/L-27050-22 C5-DTGNR/L-35060-22 C6-DTGNR/L-45065-22	5513 020-02	5322 315-04 (4,76)	5680 049-01 (15IP)
		C4-DTJNR/L-27050-16 C5-DTJNR/L-35060-16 C6-DTJNR/L-45065-16	5513 020-04	5322 315-02 (4,76)	5680 051-03 (9IP)
		C4-DTJNR/L-27050-22 C5-DTJNR/L-35060-22 C6-DTJNR/L-45065-22	5513 020-02	5322 315-04 (4,76)	5680 049-01 (15IP)
	<b>DTTNR/L</b> 2020K16		5513 020-04	5322 315-02 (4,76)	5680 051-03 (9IP)
	<b>DTTNR/L</b> 2525M22 3225P22		5513 020-02	5322 315-04 (4,76)	5680 049-01 (15IP)
	<b>DWLNRL/L</b> 2020K06 2525M06 3225P06	C4-DWLNRL/L-27050-06 C5-DWLNRL/L-35060-06 C6-DWLNRL/L-45065-06	5513 020-04	5322 328-01 (4,76)	5680 051-03 (9IP)
	<b>DWLNRL/L</b> 2020K08 2525M08 3225P08	C4-DWLNRL/L-27050-08 C5-DWLNRL/L-35060-08 C6-DWLNRL/L-45065-08 C8-DWLNRL/L-55080-08	5513 020-02	5322 331-12 (4,76)	5680 049-01 (15IP)

**CoroTurn™ RC clamp set parts**

Standard clamp set for carbide inserts	Clamp set for ceramic insert with hole	Clamp set for ceramic flat insert without hole	
5412 028-011	-	-	
5412 028-021	← →	5412 032-021	← → 5412 034-021
5412 028-031	← →	5412 032-031	← → 5412 034-031
5412 028-041	-	-	
5412 028-051	-	-	

		<b>Optional parts</b> Delivery to separate order			
4	5	4	4	2	
Complete clamp set <sup>1)</sup>	Coolant nozzle	Clamp sets for ceramic inserts without hole <sup>1)</sup>	Clamp sets for ceramic inserts with hole <sup>1)</sup>	Shim	For insert thickness
5412 028-021	5691 045-01 5691 029-09 5691 045-01	5412 034-021	5412 032-021	5322 425-02	7,94
5412 028-031	5691 045-01 5691 029-09 5691 045-01	5412 034-031	5412 032-031	5322 425-05	7,94
5412 028-041	5691 029-09	-	-	-	-
5412 028-051	5691 045-01	-	-	5322 425-08	9,52
5412 028-011	5691 045-01	-	-	-	-
5412 028-021	5691 045-01	5412 034-021	5412 032-021	-	-
5412 028-011	5691 045-01	-	-	-	-
5412 028-021	5691 045-01	5412 034-021	5412 032-021	-	-
5412 028-011	5691 045-01	-	-	-	-
5412 028-021	5691 045-01	5412 034-021	5412 032-021	-	-
5412 028-011	-	-	-	-	-
5412 028-021	-	5412 034-021	5412 032-021	-	-
5412 028-011	5691 045-01	-	-	-	-
5412 028-021	5691 045-01	5412 034-021	5412 032-021	-	-

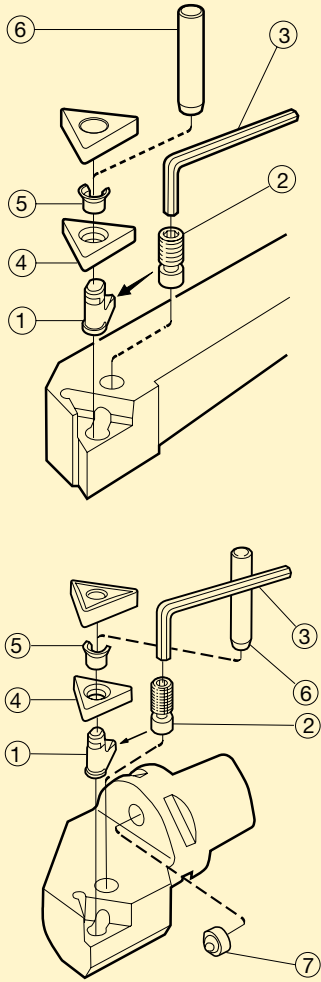
<sup>1)</sup> For clamp set parts, see below.

Ordering example: 10 pieces 5513 020-02

## CoroTurn™ RC clamp set parts

Complete clamp set	Clamp set parts							
	1	2	3	4	5	6	7	8
	Pin	Clamp	Compression spring	Screw	Pressure plate	Hook	Screw	Torx Plus® key
5412 028-011	3113 030-255	5412 028-01	5561 001-57	5512 086-01	-	-	-	-
5412 028-021	3113 030-307	5412 028-02	5561 001-58	5512 086-02	-	-	-	-
5412 028-031	3113 030-307	5412 028-03	5561 001-59	5512 086-03	-	-	-	-
5412 028-041	3113 030-307	5412 028-04	5561 001-59	5512 086-03	-	-	-	-
5412 028-051	3113 030-307	5412 028-05	5561 001-61	5512 086-04	-	-	-	-
5412 032-021	3113 030-307	5412 032-02	5561 001-58	5512 086-02	5192 030-02	5411 012-01	5512 097-01	5680 051-02 (7IP)
5412 032-031	3113 030-307	5412 032-03	5561 001-59	5512 086-03	5192 030-03	5411 012-01	5512 097-01	5680 051-02 (7IP)
5412 034-021	3113 030-307	5412 034-02	5561 001-58	5512 086-02	5192 030-02	5411 012-01	5512 097-01	5680 051-02 (7IP)
5412 034-031	3113 030-307	5412 034-03	5561 001-59	5512 086-03	5192 030-03	5411 012-01	5512 097-01	5680 051-02 (7IP)

**T-MAX P lever design**



Nozzle for Coromant Capto cutting units	
Cutting unit size	Nozzle
C3-C4	5691 029-01
C5-C6	5691 029-02
C8	5691 029-03

Tool type		Standard parts		
		Delivered with the tool		
Shank holders		1	2	3
Coromant Capto®		Lever	Screw	Key (mm)
<b>80°</b>				
PCBNR/L 2525M12		174.3-841M	174.3-821	174.1-864 (3,0)
PCBNR/L 2525M16 3225P16 3232P16		438.3-840	438.3-831	174.1-864 (3,0)
PCBNR/L 3232P19 4040S19		174.3-842M	174.3-822M	3021 010-040 (4,0)
PCLNR/L 1616H09 2020K09 2525M09	C3-PCLNR/L-22040-09 C4-PCLNR/L-27050-09 C5-PCLNR/L-35060-09	174.3-840M	174.3-820M	170.3-860 (2,5)
PCLNR/L 1616H12-M		174.3-848M	174.3-858	174.1-864 (3,0)
PCLNR/L 2020K12 2525M12 3225P12	C3-PCLNR/L-22040-12 C4-PCLNR/L-27050-12 C5-PCLNR/L-35060-12 C6-PCLNR/L-45065-12 C8-PCLNR/L-55080-12	174.3-841M	174.3-821	174.1-864 (3,0)
PCLNR/L 2525M16 3225P16 3232P16	C4-PCLNR/L-27050-16 C5-PCLNR/L-35060-16 C6-PCLNR/L-45065-16 C8-PCLNR/L-55080-16	438.3-840	438.3-831	174.1-864 (3,0)
PCLNR/L 2525M19 3225P19 3232P19 4040S19	C5-PCLNR/L-35060-19 C6-PCLNR/L-45065-19 C8-PCLNR/L-55080-19	174.3-842M	174.3-822M	3021 010-040 (4,0)
PCLNR/L 4040S25 5050T25	C8-PCLNR/L-55080-25	174.3-844M	174.3-827	3021 010-050 (5,0)
	C3-PCNR/L-17040-12 C4-PCNR/L-22050-12 C5-PCNR/L-27060-12 C6-PCNR/L-35065-12	174.3-841M	174.3-821	174.1-864 (3,0)
	C4-PCNR/L-22050-16 C5-PCNR/L-27060-16 C6-PCNR/L-35065-16	438.3-840	438.3-831	174.1-864 (3,0)
	C5-PCNR/L-27060-19 C6-PCNR/L-35065-19	174.3-842M	174.3-822M	3021 010-040 (4,0)
<b>55°</b>				
PDJNR/L 1616H11 2020K11 2525M11 3225P11	C3-PDJNR/L-22045-11 C4-PDJNR/L-27050-11 C5-PDJNR/L-35060-11 C6-PDJNR/L-45065-11	5432 001-01	174.3-820M	174.1-863 (2,5)
PDJNR/L 2020K15 2525M15 3225P15 3232P15	C4-PDJNR/L-27055-15 C5-PDJNR/L-35060-15 C6-PDJNR/L-45065-15 C8-PDJNR/L-55080-15	174.3-847M	174.3-830	174.1-864 (3,0)
R/L171.35-4025-15 5032-15		174.3-847M	174.3-830	174.1-864 (3,0)
<b>Neg.</b>				
PRGNR/L 2020K09		174.3-840M	174.3-820M	170.3-860 (2,5)
PRGNR/L 2525M12		174.3-841M	174.3-821	174.1-864 (3,0)
PRGNR/L 3225P15		174.3-843M	174.3-825	174.1-864 (3,0)
PRGNR/L 3232P19		174.3-842M	174.3-822M	3021 010-040 (4,0)
PRGNR/L 4040S25		174.3-844M	174.3-827	3021 010-050 (5,0)
<b>Pos.</b>				
PRGCR/L 2020K10 2525M10		176.39-840	174.3-834	170.3-864 (1,98)
PRGCR/L 2020K12 2525M12 3225P12		5432 005-01	174.3-820M	170.3-860 (2,5)
PRGCR/L 2525M16 3225P16		176.39-842	174.3-833	170.3-860 (2,5)
PRGCR/L 3232P20	C8-PRSCR/L-55080-20	176.39-843	174.3-825	174.1-864 (3,0)
PRGCR/L 4040S25	C6-PRSCR/L-45065-25 C8-PRSCR/L-55080-25	176.39-844	174.3-832	3021 010-040 (4,0)
PRGCR/L 5050T32	C8-PRSCR/L-55080-32	176.39-845	174.3-827	3021 010-050 (5,0)

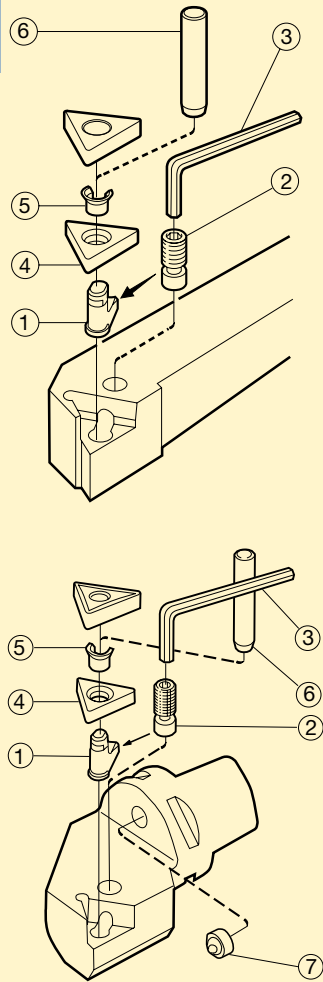
					<b>Optional parts</b>			
					Delivery to separate order			
4			5	6	4	5		
Shim	For insert Thickness	Radius	Shim pin	Shim pin punch	Shim	Shim pin	For insert Thickness	Radius
171.31-850M	4,76	0,4-1,6	174.3-861	174.3-871	-	-	-	-
171.31-852	6,35	0,4-2,4	174.3-864	174.3-873	-	-	-	-
171.31-851M	6,35	0,4-2,4	174.3-862	174.3-872	-	-	-	-
5322 230-02	3,18	0,4-1,2	174.3-863	174.3-870	-	-	-	-
171.31-850M	4,76	0,4-1,6	174.3-861	174.3-871	-	-	-	-
171.31-850M	4,76	0,4-1,6	174.3-861	174.3-871	-	-	-	-
171.31-852	6,35	0,4-2,4	174.3-864	174.3-873	-	-	-	-
171.31-851M	6,35	0,4-2,4	174.3-862	174.3-872	-	-	-	-
5322 230-01	9,52	2,4-3,2	174.3-865	174.3-874	-	-	-	-
171.31-850M	4,76	0,4-1,6	174.3-861	174.3-871	-	-	-	-
171.31-852	6,35	0,4-2,4	174.3-864	174.3-873	-	-	-	-
171.31-851M	6,35	0,4-2,4	174.3-862	174.3-872	-	-	-	-
5322 255-01	4,76	0,4-0,8	174.3-860	174.3-870	5322 255-02	-	4,76	1,2-1,6
171.35-851M	6,35	0,4-0,8	174.3-861	174.3-871	171.35-850M	-	6,35	1,2-1,6
					171.35-855	-	4,76	0,4-0,8
					171.35-855	-	4,76	1,2-1,6
171.35-851M	6,35	0,4-0,8	174.3-861	174.3-871	171.35-850M	-	6,35	1,2-1,6
					171.35-856	-	4,76	0,4-0,8
					171.35-855	-	4,76	1,2-1,6
176.3-850	3,18	-	174.3-863	174.3-870	-	-	-	-
176.3-851M	4,76	-	174.3-861	174.3-871	-	-	-	-
176.3-854M	6,35	-	174.3-864	174.3-873	-	-	-	-
176.3-852M	6,35	-	174.3-862	174.3-872	-	-	-	-
176.3-853M	9,52	-	174.3-865	174.3-874	-	-	-	-
176.39-850	3,18	-	174.3-860	174.3-870	5322 150-01 <sup>1)</sup>	174.3-860	3,97	-
176.39-851	4,76	-	174.3-863	174.3-870	-	-	-	-
176.39-852	6,35	-	174.3-867	174.3-871	-	-	-	-
176.39-853	6,35	-	174.3-864	174.3-873	-	-	-	-
176.39-854	7,94	-	174.3-862	174.3-872	-	-	-	-
176.39-855	9,52	-	174.3-865	174.3-874	-	-	-	-

<sup>1)</sup> For insert RCMT 10T3M0

Ordering example: 10 pieces 174.3-841M



**T-MAX P lever design**



Nozzle for Coromant Capto cutting units	
Cutting unit size	Nozzle
<b>C3-C4</b>	5691 029-01
<b>C5-C6</b>	5691 029-02
<b>C8</b>	5691 029-03

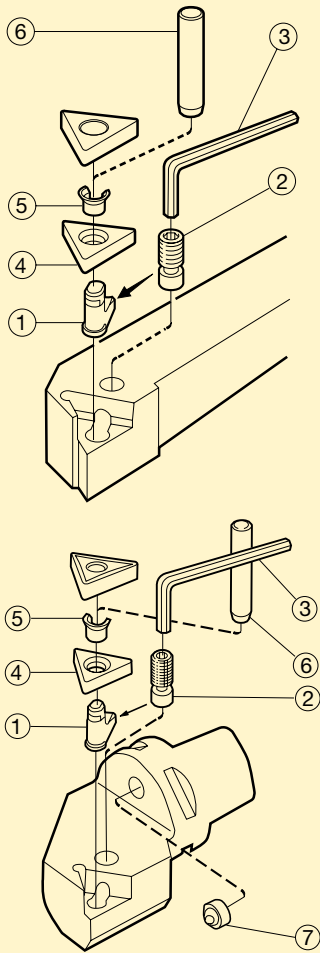
Tool type		Standard parts			
Shank holders		Delivered with the tool			
		1	2	3	
Coromant Capto®		Lever	Screw	Key (mm)	
<b>Pos.</b>					
N 176.39-2020-10		176.39-840	174.3-834	170.3-864 (1,98)	
N 176.39-2525-12 N 176.39-3225-12		5432 005-01	174.3-820M	170.3-860 (2,5)	
N 176.39-3225-16		176.39-842	174.3-833	170.3-860 (2,5)	
N 176.39-3232-20		176.39-843	174.3-825	174.1-864 (3,0)	
N 176.39-4040-25		<b>C6-PRDCN-00065-25A</b> <b>C8-PRDCN-00080-25A</b>	176.39-844	174.3-832	3021 010-040 (4,0)
N 176.39-5050-32		<b>C8-PRDCN-00065-32A</b>	176.39-845	174.3-827	3021 010-050 (5,0)
<b>PSRNR/L 1212F09</b>		174.3-845-1	174.3-829	174.1-870 (1,98)	
<b>PSBNR/L 1616H09</b> <b>2020K09</b> <b>2525M09</b>		<b>C3-PSRNR/L-17040-09</b> <b>C4-PSRNR/L-22050-09</b>	174.3-840M	174.3-820M	170.3-860 (2,5)
<b>PSBNR/L 2020K12</b> <b>2525M12</b> <b>3225P12</b>		<b>C3-PSRNR/L-17040-12</b> <b>C4-PSRNR/L-22050-12</b> <b>C5-PSRNR/L-27060-12</b> <b>C6-PSRNR/L-35065-12</b>	174.3-841M	174.3-821	174.1-864 (3,0)
<b>PSBNR/L 2525M15</b> <b>3225P15</b> <b>3232P15</b>		<b>C4-PSRNR/L-22050-15</b> <b>C5-PSRNR/L-27060-15</b> <b>C6-PSRNR/L-35065-15</b>	438.3-840	438.3-831	174.1-864 (3,0)
<b>PSBNR/L 3232P19</b> <b>4040S19</b>		<b>C5-PSRNR/L-27060-19</b> <b>C6-PSRNR/L-35065-19</b> <b>C8-PSRNR/L-45080-19</b>	174.3-842M	174.3-822M	3021 010-040 (4,0)
<b>PSBNR/L 4040S25</b> <b>5050T25</b>		<b>C8-PSRNR/L-45080-25</b>	174.3-844M	174.3-827	3021 010-050 (5,0)
<b>PSSNR/L 1616H09</b> <b>2020K09</b> <b>2525M09</b>			174.3-840M	174.3-820M	170.3-860 (2,5)
<b>PSSNR/L 2020K12</b> <b>2525M12</b> <b>3225P12</b>		<b>C3-PSSNR/L-22032-12</b> <b>C4-PSSNR/L-27042-12</b> <b>C5-PSSNR/L-35052-12</b> <b>C6-PSSNR/L-45065-12</b>	174.3-841M	174.3-821	174.1-864 (3,0)
<b>PSSNR/L 2525M15</b> <b>3225P15</b> <b>3232P15</b>		<b>C4-PSSNR/L-27040-15</b> <b>C5-PSSNR/L-35050-15</b> <b>C6-PSSNR/L-45054-15</b>	438.3-840	438.3-831	174.1-864 (3,0)
<b>PSSNR/L 3232P19</b> <b>4040S19</b>		<b>C6-PSSNR/L-35048-19</b> <b>C8-PSSNR/L-45052-19</b>	174.3-842M	174.3-822M	3021 010-040 (4,0)
<b>PSSNR/L 4040S25</b>			174.3-844M	174.3-827	3021 010-050 (5,0)
<b>PSDNN 1010E09</b> <b>PSDNN 1212F09</b>			174.3-845-1	174.3-829	174.1-870 (1,98)
<b>PSDNN 1616H09</b>			174.3-840M	174.3-820M	170.3-860 (2,5)
<b>PSDNN 2020K12</b> <b>2525M12</b> <b>3225P12</b>		<b>C3-PSDNN- 00040-12</b> <b>C4-PSDNN- 00050-12</b> <b>C5-PSDNN- 00060-12</b> <b>C6-PSDNN- 00065-12</b>	174.3-841M	174.3-821	174.1-864 (3,0)
		<b>C4-PSDNN- 00050-15</b> <b>C5-PSDNN- 00060-15</b> <b>C6-PSDNN- 00065-15</b>	438.3-840	438.3-831	174.1-864 (3,0)
<b>PSDNN 3225P19</b> <b>3232P19</b>		<b>C5-PSDNN- 00060-19</b> <b>C6-PSDNN- 00065-19</b>	174.3-842M	174.3-822M	3021 010-040 (4,0)
<b>PSDNN 4040S25</b>		<b>C6-PSDNN- 00065-25</b> <b>C8-PSDNN- 00080-25</b>	174.3-844M	174.3-827	3021 010-050 (5,0)
<b>PSKNR/L 1616H09</b> <b>2020K09</b>		<b>C3-PSKNR/L-22040-09</b> <b>C4-PSKNR/L-27050-09</b>	174.3-840M	174.3-820M	170.3-860 (2,5)
<b>PSKNR/L 2020K12</b> <b>2525M12</b> <b>3225P12</b>		<b>C3-PSKNR/L-22040-12</b> <b>C4-PSKNR/L-27050-12</b> <b>C5-PSKNR/L-35060-12</b> <b>C6-PSKNR/L-45065-12</b>	174.3-841M	174.3-821	174.1-864 (3,0)
<b>PSKNR/L 2525M15</b>		<b>C4-PSKNR/L-27050-15</b> <b>C5-PSKNR/L-35060-15</b> <b>C6-PSKNR/L-45065-15</b>	438.3-840	438.3-831	174.1-864 (3,0)
<b>PSKNR/L 3232P19</b> <b>4040S19</b>		<b>C5-PSKNR/L-35060-19</b> <b>C6-PSKNR/L-45065-19</b> <b>C8-PSKNR/L-55080-19</b>	174.3-842M	174.3-822M	3021 010-040 (4,0)
<b>PSKNR/L 5050T25</b>		<b>C8-PSKNR/L-55080-25</b>	174.3-844M	174.3-827	3021 010-050 (5,0)

					<b>Optional parts</b>			
					Delivery to separate order			
4	For insert		5	6	4	5	For insert	
Shim	Thickness	Radius	Shim pin	Shim pin punch	Shim	Shim pin	Thickness	Radius
176.39-850	3,18	-	174.3-860	174.3-870	5322 150-01 <sup>1)</sup>	174.3-860	3,97	-
176.39-851	4,76	-	174.3-863	174.3-870	-	-	-	-
176.39-852	6,35	-	174.3-867	174.3-871	-	-	-	-
176.39-853	6,35	-	174.3-864	174.3-873	-	-	-	-
176.39-854	7,94	-	174.3-862	174.3-872	-	-	-	-
176.39-855	9,52	-	174.3-865	174.3-874	-	-	-	-
-	-	-	-	-	-	-	-	-
174.3-850	3,18	0,4 – 1,2	174.3-863	174.3-870	-	-	-	-
174.3-851M	4,76	0,4 – 1,2	174.3-861	174.3-871	174.3-856	-	4,76	1,6 – 2,4
174.3-857	6,35	0,4 – 2,4	174.3-864	174.3-873	-	-	-	-
174.3-852M	6,35	0,8 – 2,4	174.3-862	174.3-872	-	-	-	-
174.3-853M	7,94	1,6 – 3,2	174.3-865	174.3-874	-	-	-	-
174.3-850	3,18	0,4 – 1,2	174.3-863	174.3-870	-	-	-	-
174.3-851M	4,76	0,4 – 1,2	174.3-861	174.3-871	174.3-856	-	4,76	1,6 – 2,4
174.3-857	6,35	0,4 – 2,4	174.3-864	174.3-873	-	-	-	-
174.3-852M	6,35	0,8 – 2,4	174.3-862	174.3-872	-	-	-	-
174.3-853M	7,94	1,6 – 3,2	174.3-865	174.3-874	-	-	-	-
-	-	-	-	-	-	-	-	-
174.3-850	3,18	0,4 – 1,2	174.3-863	174.3-870	-	-	-	-
174.3-851M	4,76	0,4 – 1,2	174.3-861	174.3-871	174.3-856	-	4,76	1,6 – 2,4
174.3-857	6,35	0,4 – 2,4	174.3-864	174.3-873	-	-	-	-
174.3-852M	6,35	0,8 – 2,4	174.3-862	174.3-872	-	-	-	-
174.3-853M	7,94	1,6 – 3,2	174.3-865	174.3-874	-	-	-	-
174.3-850	3,18	0,4 – 1,2	174.3-863	174.3-870	-	-	-	-
174.3-851M	4,76	0,4 – 1,2	174.3-861	174.3-871	174.3-856	-	4,76	1,6 – 2,4
174.3-857	6,35	0,4 – 2,4	174.3-864	174.3-873	-	-	-	-
174.3-852M	6,35	0,8 – 2,4	174.3-862	174.3-872	-	-	-	-
174.3-853M	7,94	1,6 – 3,2	174.3-865	174.3-874	-	-	-	-

1) For insert RCMT 10T3M0

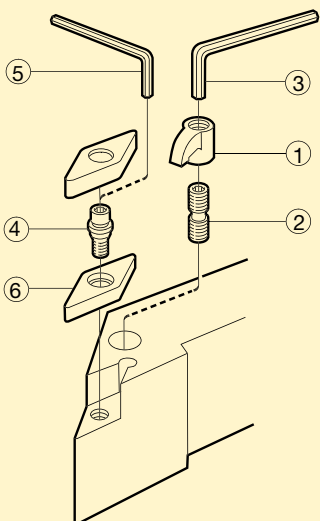
Ordering example: 10 pieces 176.39-840

### T-MAX P lever design



Nozzle for Coromant Capto cutting units	
Cutting unit size	Nozzle
C3-C4	5691 029-01
C5-C6	5691 029-02
C8	5691 029-03

Tool type		Standard parts		
		Delivered with the tool		
		1	2	3
Shank holders	Coromant Capto®	Lever	Screw	Key (mm)
PTDNR/L 2525M22		174.3-841M	174.3-821	174.1-864 (3,0)
PTFNR/L 1212F11		174.3-846-1	174.3-829	170.3-864 (1,98)
PTFNR/L 1616H16 2020K16 2525M16	C3-PTFNR/L 22040-16 C4-PTFNR/L 27050-16 C5-PTFNR/L 35060-16 C6-PTFNR/L 45065-16	174.3-840M	174.3-820M	170.3-860 (2,5)
PTFNR/L 2525M22 3225P22 3232P22	C4-PTFNR/L 27050-22 C5-PTFNR/L 35060-22 C6-PTFNR/L 45065-22	174.3-841M	174.3-821	174.1-864 (3,0)
PTFNR/L 3232P27 4040S27	C6-PTFNR/L 45065-27	174.3-843M	174.3-825	174.1-864 (3,0)
PTFNR/L 4040S33		174.3-842M	174.3-822M	3021 010-040 (4,0)
PTGNR/L 1010E11 1212F11 1616H11 2020K11 2525M11	C3-PTGNR/L 22040-11 C4-PTGNR/L 27050-11	174.3-846-1	174.3-829	170.3-864 (1,98)
PTGNR/L 1616H16 2020K16 2525M16 3225P16	C3-PTGNR/L 22040-16 C4-PTGNR/L 27050-16 C5-PTGNR/L 35060-16 C6-PTGNR/L 45065-16	174.3-840M	174.3-820M	170.3-860 (2,5)
PTGNR/L 2525M22 3225P22 3232P22	C4-PTGNR/L 27050-22 C5-PTGNR/L 35060-22 C6-PTGNR/L 45065-22	174.3-841M	174.3-821	174.1-864 (3,0)
PTGNR/L 3232P27 4040S27	C6-PTGNR/L 45065-27	174.3-843M	174.3-825	174.1-864 (3,0)
	C3-PTJNR/L 22040-11 C4-PTJNR/L 27050-11	174.3-846-1	174.3-829	170.3-864 (1,98)
	C3-PTJNR/L 22040-16 C4-PTJNR/L 27050-16 C5-PTJNR/L 35060-16 C6-PTJNR/L 45065-16	174.3-840M	174.3-820M	170.3-860 (2,5)
	C4-PTJNR/L 27050-22 C5-PTJNR/L 35060-22 C6-PTJNR/L 45065-22	174.3-841M	174.3-821	174.1-864 (3,0)
PTTNR/L 1010E11 1212F11		174.3-846-1	174.3-829	170.3-864 (1,98)
PTTNR/L 1616H16 2020K16	C4-PTTNR/L 22050-16 C5-PTTNR/L 27060-16	174.3-840M	174.3-820M	170.3-860 (2,5)
PTTNR/L 2525M22 3225P22	C5-PTTNR/L 27060-22 C6-PTTNR/L 35065-22	174.3-841M	174.3-821	174.1-864 (3,0)
R/L 177.3-1010F-11		174.3-846-1	174.3-829	170.3-864 (1,98)



### T-MAX P screw and top clamp design

Tool type		Standard parts		
		Delivered with the tool		
		1	2	3
Shank holders	Coromant Capto®	Clamp	Clamp screw	Key (mm)
35°				
MVJNR/L 2020K16 2525M16 3225P16	C4-MVJNR/L-27050-16 C5-MVJNR/L-35060-16	MC-12	MS-510	3021 011-532 (3,96)

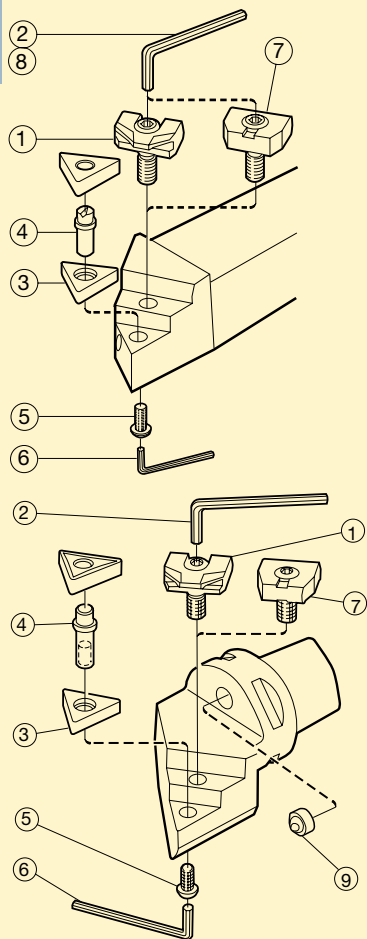
					<b>Optional parts</b>			
					Delivery to separate order			
4			5		6			
Shim	For insert Thickness	Radius	Shim pin	Shim pin punch	Shim	Shim pin	For insert Thickness	Radius
179.3-852M	4,76	1,2 – 1,6	174.3-861	174.3-871	179.3-853M	–	4,76	0,4 – 0,8
–	–	–	–	–	–	–	–	–
179.3-850M	4,76	0,4 – 0,8	174.3-860	174.3-870	179.3-858	–	4,76	1,2 – 1,6
179.3-852M	4,76	1,2 – 1,6	174.3-861	174.3-871	179.3-853M	–	4,76	0,4 – 0,8
179.3-854M	6,35	0,8 – 1,2	174.3-864	174.3-873	179.3-857	–	6,35	1,6 – 2,4
179.3-855M	7,94	1,6 – 2,4	174.3-866	174.3-872	–	–	–	–
–	–	–	–	–	–	–	–	–
179.3-850M	4,76	0,4 – 0,8	174.3-860	174.3-870	179.3-858	–	4,76	1,2 – 1,6
179.3-852M	4,76	1,2 – 1,6	174.3-861	174.3-871	179.3-853M	–	4,76	0,4 – 0,8
179.3-854M	6,35	0,8 – 1,2	174.3-864	174.3-873	179.3-857	–	6,35	1,6 – 2,4
–	–	–	–	–	–	–	–	–
179.3-850M	4,76	0,4 – 0,8	174.3-860	174.3-870	179.3-858M	–	4,76	1,2 – 1,6
179.3-852M	4,76	1,2 – 1,6	174.3-861	174.3-871	179.3-853M	–	4,76	0,4 – 0,8
–	–	–	–	–	–	–	–	–
179.3-850M	4,76	0,4 – 0,8	174.3-860	174.3-870	179.3-858M	–	4,76	1,2 – 1,6
179.3-852M	4,76	1,2 – 1,6	174.3-861	174.3-871	179.3-853M	–	4,76	0,4 – 0,8
–	–	–	–	–	–	–	–	–

Ordering example: 10 pieces 174.3-841M




4		5		6	
Lock pin	Key (mm)	Shim	For insert Thickness	Radius	
MN-34L	174.1-870 (1,98)	MVN-322	4,76	0,4 – 1,2	

Ordering example: 10 pieces MC-12

### T-MAX P wedge clamp design



Nozzle for Coromant Capto cutting units	
Cutting unit size	9 Nozzle
C3-C4	5691 029-01
C5-C6	5691 029-02
C8	5691 029-03

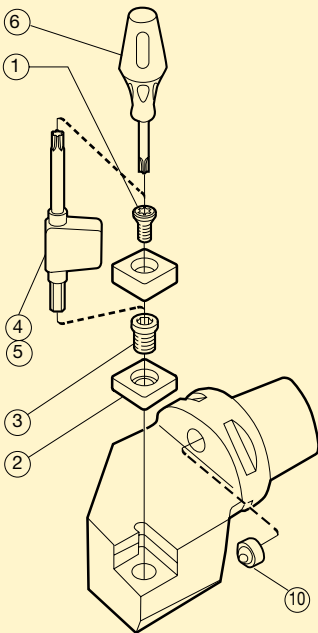
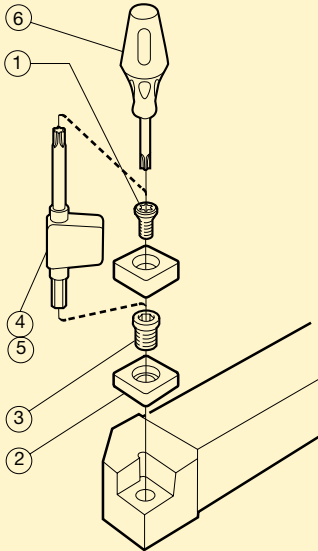
Tool type		Standard parts		
		Delivered with the tool		
		1	2	3
Shank holders	Coromant Capto®	Wedge clamp set	Key (mm)	Shim
				
MSSNR/L 2525M12		181.38-824-1	174.1-864 (3,0)	181.38-850
MSSNR/L 3232P19		181.38-825-1	3021 010-040 (4,0)	181.38-851
MSSNR/L 4040S25	-	181.38-826-1	3021 010-050 (5,0)	181.38-852
	<b>C8-MSSNR/L 55070-25</b>	181.38-826-1	3021 010-050 (5,0)	181.38-852
				
MTJNR/L 2020K16M1 2525M16M1 3225P16M1		170.38-820-1	174.1-863 (2,5)	170.3-852
	<b>C3-MTJNR/L 22040-16 C4-MTJNR/L 27050-16 C5-MTJNR/L 35060-16</b>	170.38-820-1	174.1-863 (2,5)	170.3-852
MTJNR/L 2525M22M1 3225P22M1		170.38-821-1	174.1-864 (3,0)	170.3-855
	<b>C4-MTJNR/L 27050-22 C5-MTJNR/L 35060-22 C6-MTJNR/L 45065-22</b>	170.38-821-1	174.1-864 (3,0)	170.3-855
	<b>C6-MTJNR/L 45065-27</b>	170.38-822-1	174.1-864 (3,0)	170.3-854
MTGNR/L 2525M22M1 3225P22M1 3232P22M1		170.38-821-1	174.1-864 (3,0)	170.3-855
MTENN 2525M22M1 3225P22M1 3232P22M1		170.38-821-1	174.1-864 (3,0)	170.3-855
R/L 170.38-4025-16M1		170.38-820-1	174.1-863 (2,5)	170.3-852
L 170.38-4025-22M1 R 170.38-5032-22M1		170.38-821-1	174.1-864 (3,0)	170.3-855
				
MWLNLR/L 2020K06 2525M06	<b>C3-MWLNLR/L-22040-06 C4-MWLNLR/L-27050-06</b>	5431 125-011	170.3-860 (2,5)	5322 331-06
MWLNLR/L 2020K08 2525M08 3225P08	<b>C4-MWLNLR/L-27050-08 C5-MWLNLR/L-35060-08</b>	5431 125-021	174.1-864 (3,0)	5322 331-07

For insert					Optional parts				
Thickness	Radius	4	5	6	Delivery to separate order		3	For insert	
		Pin	Screw	Key (mm)	7	8	Shim	Thickness	Radius
					Wedge set	Key (mm)			
4,76	0,4 – 0,8	181.38-840	3212 010-255	174.1-864 (3,0)	181.38-820-1	-	-	-	-
6,35	0,8 – 2,4	181.38-841	3212 010-306	174.1-864 (3,0)	181.38-821-1	-	-	-	-
7,94	1,6 – 2,4	181.38-842	3212 100-357	3021 010-040 (4,0)	181.38-822-1	-	181.38-853	9,52	2,4 – 3,2
7,94	1,6 – 2,4	181.38-842	3212 100-357	3021 010-040 (4,0)	-	-	181.38-853 5322 420-04 5322 420-03	9,52 7,94 9,52	2,4 3,2 3,2
4,76	0,4 - 1,6	5313 021-02	3212 010-206	174.1-863 (2,5)	170.38-823-1	174.1-864 (3,0)	-	-	-
4,76	0,4 -1,6	5313 021-02	3212 010-206	174.1-863 (2,5)	170.38-823-1	174.1-864 (3,0)	-	-	-
4,76	1,2 - 1,6	181.38-840	3212 010-255	174.1-864 (3,0)	170.38-824-1	3021 010-040 (4,0)	170.3-856	4,76	0,4 – 0,8
4,76	1,2 - 1,6	181.38-840	3212 010-255	174.1-864 (3,0)	170.38-824-1	3021 010-040 (4,0)	170.3-856	4,76	0,4 – 0,8
6,35	0,8 – 1,6	5313 021-04	3212 100-307	3021 010-040 (4,0)	170.38-825-1	3021 010-040 (4,0)	170.3-857		2,4
4,76	1,2 - 1,6	181.38-840	3212 010-255	174.1-864 (3,0)	170.38-824-1	3021 010-040 (4,0)	170.3-856	4,76	0,4 – 0,8
4,76	1,2 - 1,6	181.38-840	3212 010-255	174.1-864 (3,0)	170.38-824-1	3021 010-040 (4,0)	170.3-856	4,76	0,4 – 0,8
4,76	0,4 - 1,6	5313 021-02	3212 010-206	174.1-863 (2,5)	170.38-823-1	174.1-864 (3,0)	-	-	-
4,76	1,2 - 1,6	181.38-840	3212 010-255	174.1-864 (3,0)	170.38-824-1	3021 010-040 (4,0)	170.3-856	4,76	0,4 – 0,8
-	-	5313 022-01	5512 030-03	170.3-864 (1,98)	-	-	-	-	-
4,76	0,4 – 0,8	5313 022-03	3212 010-255	174.1-864 (3,0)	-	-	5322 331-08	4,76	1,2 – 1,6

Ordering example: 10 pieces 181.38-824-1

**CoroTurn™ 107 screw clamp design**

**A**



Tool type		Standard parts			
		Delivered with the tool			
		1	2		
Shank holders	Coromant Capto®	Insert screw (thread)	Shim	For insert thickness	Radius
<b>80°</b>					
SCLCR/L 0808D06 1010E06		5513 020-03 (M2,5)	-	-	-
SCLCR/L 1212F09-M		5513 020-10 (M3,5)	-	-	-
SCLCR/L 1616H09 2020K09	C3-SCLCR/L-22040-09 C4-SCLCR/L-27050-09 C5-SCLCR/L-35060-09 C6-SCLCR/L-45065-09	5513 020-01 (M3,5)	5322 232-01	3,97	0,2-0,8
SCLCR/L 2020K12 2525M12	C3-SCLCR/L-22040-12 C4-SCLCR/L-27050-12 C5-SCLCR/L-35060-12 C6-SCLCR/L-45065-12	5513 020-18 (M4x0,5)	5322 232-02	4,76	0,4-1,2
<b>55°</b>					
SDJCR/L 1010E07 1212F07 1616H07 2020K07	C3-SDJCR/L-22040-07 C4-SDJCR/L-27050-07	5513 020-03 (M2,5)	-	-	-
SDJCR/L 1616H11 2020K11 2525M11	C3-SDJCR/L-22040-11 C4-SDJCR/L-27050-11 C5-SDJCR/L-35060-11 C6-SDJCR/L-45065-11	5513 020-01 (M3,5)	5322 263-01	3,97	0,4-0,8
SDNCN 1010E07 1212F07		5513 020-03 (M2,5)	-	-	-
SDNCN 1616H11 2020K11 2525M11	C3-SDNCN-00040-11 C4-SDNCN-00050-11 C5-SDNCN-00060-11	5513 020-01 (M3,5)	5322 263-01	3,97	0,4-0,8
<b>Neg.</b>					
SRDCN 1010E05	C3-SRDCN-00040-05A C4-SRDCN-00050-05A C5-SRDCN-00060-05A	5513 020-05 (M2,2)	-	-	-
SRDCN 1212F06	C3-SRDCN-00040-06A C4-SRDCN-00050-06A C5-SRDCN-00060-06A	5513 020-03 (M2,5)	-	-	-
SRDCN 1616 H08	C3-SRDCN-00040-08A C4-SRDCN-00050-08A C5-SRDCN-00060-08A	5513 020-04 (M3,0)	-	-	-
SRDCN 2020K10-A 2525M10-A	C3-SRDCN-00040-10A C4-SRDCN-00050-10A C5-SRDCN-00060-10A C6-SRDCN-00065-10A	5513 020-10 (M3,5)	5322 110-01	3,97	-
SRDCN 2525M12-A 3225P12-A	C4-SRDCN-00050-12A C5-SRDCN-00060-12A C6-SRDCN-00065-12A	5513 020-01 (M3,5)	5322 110-02	4,76	-
SRDCN 3225P16-A	C5-SRDCN-00060-16A C6-SRDCN-00065-16A	5513 020-26 (M5,0)	5322 110-03	6,35	-
SRDCN 3232P20-A	C5-SRDCN-00060-20A C6-SRDCN-00065-20A	5513 020-14 (M6,0)	5322 110-04	6,35	-
SRDCR/L 3225P05-A		5513 020-05 (M2,2)	-	-	-
SRDCR/L 2020K06-A 3225P06-A		5513 020-03 (M2,5)	-	-	-
SRDCR/L 2020K08-A 2525M08-A 3225P08-A		5513 020-04 (M3,0)	-	-	-

Nozzle for Coromant Capto cutting units	
Cutting unit size	10 Nozzle
C3-C4	5691 029-01
C5-C6	5691 029-02
C8	5691 029-03

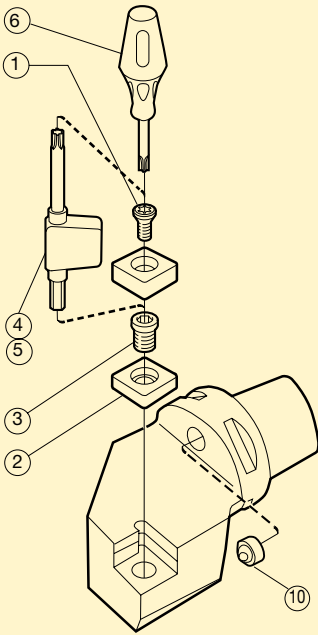
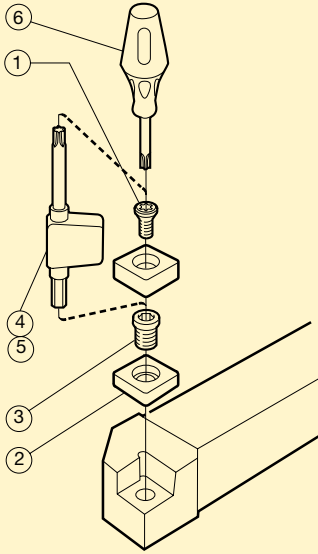
3	4	5	Optional parts			
			Delivery to separate order			
Shim screw	Key (Torx Plus)	Key (mm)	2 Shim	For insert thickness	Radius	6 Screwdriver (Torx Plus)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 049-01(15IP)	-	-	-	-	5680 046-02 (15IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
5512 090-03	5680 049-02 (15IP)	5680 049-02 (4,0)	-	-	-	5680 046-03 (15IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01(3,5)	5322 263-02	3,97	1,2	5680 046-02 (15IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01(3,5)	5322 263-02	3,97	1,2	5680 046-02 (15IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 051-03 (9IP)	-	-	-	-	5680 046-04 (9IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
5512 090-06	5680 043-14 (20IP)	3021 010-050 (5,0)	-	-	-	5680 046-06 (20IP)
5512 090-08	5680 043-15 (25IP)	3021 010-060 (6,0)	-	-	-	5680 046-07 (25IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 051-03 (9IP)	-	-	-	-	5680 046-04 (9IP)

Ordering example: 10 pieces 5513 020-03



**CoroTurn™ 107 screw clamp design**

**A**



Nozzle for Coromant Capto cutting units	
Cutting unit size	10 Nozzle
C3–C4	5691 029-01
C5–C6	5691 029-02
C8	5691 029-03

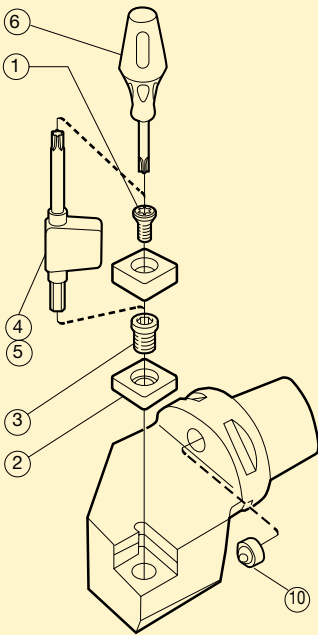
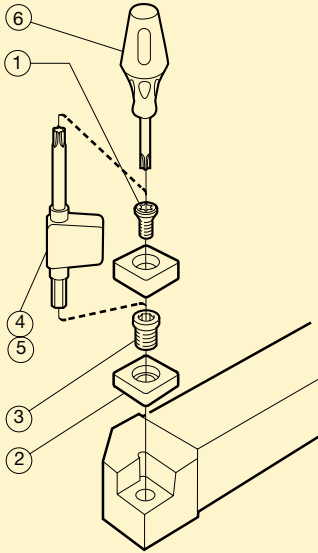
Tool type		Standard parts			
		Delivered with the tool			
		1	2		
Shank holders	Coromant Capto®	Insert screw (thread)	Shim	For insert thickness /radius	
<b>● Neg.</b>					
SRSCR/L 3225P05		5513 020-05 (M2,2)	-	-	-
SRSCR/L 3225P06	C3-SRSCR/L-22040-06 C4-SRSCR/L-27050-06 C5-SRSCR/L-35060-06	5513 020-03 (M2,5)	-	-	-
SRSCR/L 3225P08	C3-SRSCR/L-22040-08 C4-SRSCR/L-27050-08 C5-SRSCR/L-35060-08	5513 020-04 (M3,0)	-	-	-
SRSCR/L 2020K10 2525M10	C3-SRSCR/L-22040-10 C4-SRSCR/L-27050-10 C5-SRSCR/L-35060-10 C6-SRSCR/L-45065-10	5513 020-10 (M3,5)	5322 110-01	3,97	-
SRSCR/L 2525M12 3225P12	C4-SRSCR/L-27050-12 C5-SRSCR/L-35060-12 C6-SRSCR/L-45065-12	5513 020-01 (M3,5)	5322 110-02	4,76	-
SRSCR/L 3225P16	C5-SRSCR/L-35060-16 C6-SRSCR/L-45065-16	5513 020-26 (M5,0)	5322 110-03	6,35	-
SRSCR/L 3232P20	C5-SRSCR/L-35060-20 C6-SRSCR/L-45065-20	5513 020-14 (M6,0)	5322 110-04	6,35	-
<b>■</b>					
SSBCR/L 1616H09	C3-SSRCR/L-17040-09	5513 020-01 (M3,5)	5322 420-01	3,97	0,4–0,8
SSBCR/L 2020K12 2525M12	C4-SSRCR/L-22050-12 C5-SSRCR/L-27060-12	5513 020-18 (M4x0,5)	5322 420-02	4,76	0,4–1,2
SSDCR/L 1616H09 2020K09		5513 020-01 (M3,5)	5322 420-01	3,97	0,4–0,8
SSDCR/L 2020K12 2525M12		5513 020-18 (M4x0,5)	5322 420-02	4,76	0,4–1,2
SSDCN 1212F09-M		5513 020-10 (M3,5)	-	-	-
SSDCN 1616H09		5513 020-01 (M3,5)	5322 420-01	3,97	0,4–0,8
SSKCR/L 1616H09		5513 020-01 (M3,5)	5322 420-01	3,97	0,4–0,8
<b>▲</b>					
STDCR/L 1010E09		5513 020-05 (M2,2)	-	-	-
STDCR/L 1212F11 1212F11-B1 1616H11 1616H11-B1		5513 020-03 (M2,5)	-	-	-
STDCR/L 1616H16 2020K16 2525M16		5513 020-01 (M3,5)	5322 320-01	3,97	0,4–1,2
STFCR/L 1010E09		5513 020-05 (M2,2)	-	-	-
STFCR/L 1212F11 1212F11-B1 1616H11 1616H11-B1 2020K11-A 2020K11-AB1		5513 020-03 (M2,5)	-	-	-
STFCR/L 1616H16 2020K16 2525M16 2525M16-A		5513 020-01 (M3,5)	5322 320-01	3,97	0,4–1,2
STGCR/L 0808D09 1010E09		5513 020-05 (M2,2)	-	-	-
STGCR/L 1212F11 1212F11-B1 1616H11 1616H11-B1	C3-STGCR/L- 22040-11 C3-STGCR/L- 22040-11-B1 C4-STGCR/L- 27050-11 C4-STGCR/L- 27050-11-B1 C5-STGCR/L- 35060-11	5513 020-03 (M2,5)	-	-	-
STGCR/L 1616H16 2020K16 2525M16	C3-STGCR/L- 22040-16 C4-STGCR/L- 27050-16 C5-STGCR/L- 35060-16 C6-STGCR/L- 45065-16	5513 020-01 (M3,5)	5322 320-01	3,97	0,4–1,2
STTCR/L 1616H11 1616H11-B1	C3-STJCR/L- 22040-11 C3-STJCR/L- 22040-11-B1 C4-STJCR/L- 27050-11 C4-STJCR/L- 27050-11-B1	5513 020-03 (M2,5)	-	-	-
STTCR/L 1616H16 2020K16 2525M16	C3-STJCR/L- 22040-16 C4-STJCR/L- 27050-16 C5-STJCR/L- 35060-16	5513 020-01 (M3,5)	5322 320-01	3,97	0,4–1,2


3	4	5	Optional parts			
			Delivery to separate order			
Shim screw	Key (Torx Plus)	Key (mm)	2 Shim	For insert thickness	Radius	6 Screwdriver (Torx Plus)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 051-03 (9IP)	-	-	-	-	5680 046-04 (9IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-03 (15IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
5512 090-06	5680 043-14 (20IP)	3021 010-050 (5,0)	-	-	-	5680 046-06 (20IP)
5512 090-08	5680 043-15 (25IP)	3021 010-060 (6,0)	-	-	-	5680 046-07 (25IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
5512 090-03	5680 049-02 (15IP)	5680 049-02 (4,0)	-	-	-	5680 046-02 (15IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
5512 090-03	5680 049-02 (15IP)	5680 049-02 (4,0)	-	-	-	5680 046-02 (15IP)
-	5680 049-01 (15IP)	-	-	-	-	5680 046-02 (15IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01(3,5)	-	-	-	5680 046-02 (15IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	-	-	-	5680 046-02 (15IP)

Ordering example: 10 pieces 5513 020-03

**CoroTurn™ 107 screw clamp design**

**A**



Tool type		Standard parts			
		Delivered with the tool			
		1	2		
Shank holders	Coromant Capto®	Insert screw (thread)	Shim	For insert thickness/radius	
 35°					
	C3-SVHBR/L-22040-11 C4-SVHBR/L-27050-11 C5-SVHBR/L-35060-11 C3-SVHBR/L-22040-11-B1 C4-SVHBR/L-27050-11-B1	5513 020-03 (M2,5)	-	-	-
SVHBR/L 2020K16 2525M16 3225P16	C4-SVHBR/L-27050-16 C5-SVHBR/L-35060-16 C6-SVHBR/L-45065-16	5513 020-01 (M3,5)	5322 270-01	4,76	0,4-0,8
SVHCR/L 2525M22-R2		5513 020-18 (M4x0,5)	5322 270-03	4,76	2,0
SVJBR/L 1212F11 1616H11 2020K11 2525M11	C3-SVJBR/L-22040-11 C4-SVJBR/L-27050-11 C5-SVJBR/L-35060-11 C3-SVJBR/L-22040-11-B1 C4-SVJBR/L-27050-11-B1	5513 020-03	-	-	-
SVJBR/L 1212F11-B1 1616H11-B1 2020K11-B1 2525M11-B1					
SVJBR/L 2020K16 2525M16 3225P16	C4-SVJBR/L-27050-16 C5-SVJBR/L-35060-16 C6-SVJBR/L-45065-16	5513 020-01 (M3,5)	5322 270-01	4,76	0,4-0,8
SVVBN 1212F11 1616H11 2020K11 2525M11	C3-SVVBN-00040-11 C4-SVVBN-00050-11 C3-SVVBN-00040-11-B1 C4-SVVBN-00050-11-B1	5513 020-03 (M2,5)	-	-	-
SVVBN 1212F11-B1 1616H11-B1 2020K11-B1 2525M11-B1					
SVVBN 2020K16 2525M16 3225P16	C4-SVVBN-00050-16 C5-SVVBN-00060-16 C6-SVVBN-00065-16	5513 020-01 (M3,5)	5322 270-01	4,76	0,4-0,8

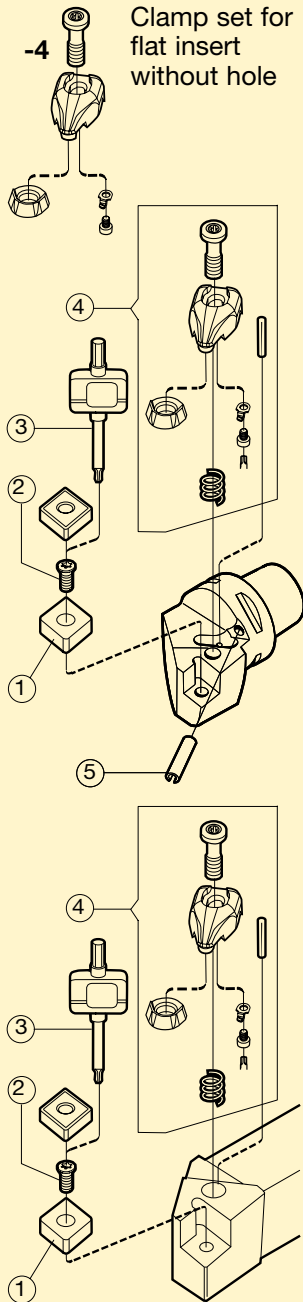
Nozzle for Coromant Capto cutting units	
Cutting unit size	10 Nozzle
C3-C4	5691 029-01
C5-C6	5691 029-02
C8	5691 029-03





			<b>Optional parts</b>			
3	4	5	Delivery to separate order			
Shim screw	Key (Torx Plus)	Key (mm)	2	For insert thickness	Radius	6
			Shim			Screwdriver (Torx Plus)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	5322 270-02	4,76	1,2	5680 046-02 (15IP)
5512 090-03	5680 049-02 (15IP)	-	5322 270-04 <sup>1)</sup>	4,76	3,0	5680 046-02 (15IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01(3,5)	5322 270-02	4,76	1,2	5680 046-02(15IP)
-	5680 051-02 (7IP)	-	-	-	-	5680 046-03 (7IP)
5512 090-01	5680 049-01 (15IP)	5680 049-01 (3,5)	5322 270-02	4,76	1,2	5680 046-02 (15IP)

<sup>1)</sup> For insert VCGX 22 05 30-AL.

**Ordering example: 10 pieces 5513 020-03**

**CoroTurn™ RC rigid clamp design for ceramic inserts**



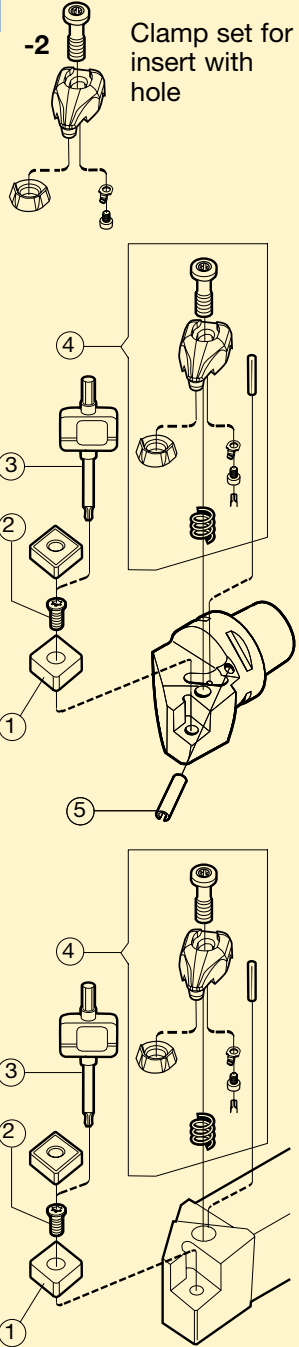
Tool type		Standard parts			
		Delivered with the tool			
		1	2	3	4
		Shim (For insert thickness)	Shim screw	Key (Torx Plus <sup>1</sup> )	Complete clamp set <sup>1</sup>
<b>Shank holders</b>		<b>Coromant Capto®</b>			
 80°					
<b>CCBNR/L</b> 2525M12-4 3225P12-4	<b>C4-CCRNR/L-22050-12-4</b> <b>C5-CCRNR/L-27060-12-4</b> <b>C6-CCRNR/L-35065-12-4</b>	5322 234-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 034-021
<b>CCBNR/L</b> 3225P16-4	<b>C5-CCRNR/L-27060-16-4</b> <b>C6-CCRNR/L-35065-16-4</b>	5322 234-04 (7,94)	5513 020-07	5680 043-14 (20IP)	5412 034-031
<b>CCLNR/L</b> 2525M12-4 3225P12-4	<b>C4-CCLNR/L-27050-12-4</b> <b>C5-CCLNR/L-35060-12-4</b> <b>C6-CCLNR/L-45065-12-4</b>	5322 234-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 034-021
<b>CCLNR/L</b> 2525M16-4 3225P16-4 3232P16-4	<b>C5-CCLNR/L-35060-16-4</b> <b>C6-CCLNR/L-45065-16-4</b>	5322 234-04 (7,94)	5513 020-07	5680 043-14 (20IP)	5412 034-031
 55°					
<b>CDJNR/L</b> 2525M15-4 3225P15-4 3232P15-4	<b>C5-CDJNR/L-35060-15-4</b> <b>C6-CDJNR/L-45065-15-4</b>	5322 266-03 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 034-021
<b>CDNLR/L</b> 3225P15-4		5322 266-03 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 034-021
					
<b>CSBNR/L</b> 2525M12-4		5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 034-021
<b>CSDNN</b> 2525M12-4 3225P12-4	<b>C4-CSDNN-00050-12-4</b> <b>C5-CSDNN-00060-12-4</b> <b>C6-CSDNN-00065-12-4</b>	5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 034-021
	<b>C5-CSDNN-00060-15-4</b> <b>C6-CSDNN-00065-15-4</b>	5322 425-05 (7,94)	5513 020-07	5680 043-14 (20IP)	5412 034-031
<b>CSKNR/L</b> 2525M12-4	<b>C4-CSKNR/L-27050-12-4</b> <b>C5-CSKNR/L-35060-12-4</b> <b>C6-CSKNR/L-45065-12-4</b>	5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 034-021
<b>CSRNR/L</b> 2525M12-4 3225P12-4	<b>C4-CSRNR/L-22050-12-4</b> <b>C5-CSRNR/L-27060-12-4</b> <b>C6-CSRNR/L-35065-12-4</b>	5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 034-021
	<b>C5-CSRNR/L-27060-15-4</b> <b>C6-CSRNR/L-35065-15-4</b>	5322 425-05 (7,94)	5513 020-07	5680 043-14 (20IP)	5412 034-031
<b>CSSNR/L</b> 2525M12-4 3225P12-4	<b>C4-CSSNR/L-27042-12-4</b> <b>C5-CSSNR/L-35052-12-4</b> <b>C6-CSSNR/L-45056-12-4</b>	5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 034-021
	<b>C5-CSSNR/L-35050-15-4</b> <b>C5-CSSNR/L-45054-15-4</b>	5322 425-05 (7,94)	5513 020-07	5680 043-14 (20IP)	5412 034-031
					
<b>CTGRN/L</b> 3232P22-4	<b>C4-CTGRN/L-27050-22-4</b> <b>C5-CTGRN/L-35060-22-4</b> <b>C6-CTGRN/L-45065-22-4</b>	5322 315-04 (4,76)	5513 020-02	5680 049-01 (15IP)	5412 034-021

5	<b>Optional parts</b>			
	Delivery to separate order			
Coolant nozzle	4	4	1	1
	Clamp set for ceramic inserts with hole <sup>1)</sup>	Clamp set for carbide inserts <sup>1)</sup>	Shim (For insert thickness)	Shim (For insert thickness)
5691 045-01	5412 032-021	5412 028-021	5322 234-01 (4,76)	
5691 045-01	5412 032-031	5412 028-031	5322 234-03 (6,35)	
5691 045-01	5412 032-021	5412 028-021	5322 234-01 (4,76)	
5691 045-01	5412 032-031	5412 028-031	5322 234-03 (6,35)	
5691 045-01	5412 032-021	5412 028-021	5322 266-01 (4,76)	5322 266-02 (6,35)
–	5412 032-021	5412 028-021	5322 266-01 (4,76)	5322 266-02 (6,35)
–	5412 032-021	5412 028-021	5322 425-01 (4,76)	
5691 045-01	5412 032-021	5412 028-021	5322 425-01 (4,76)	
5691 045-01	5412 032-031	5412 028-031	5322 425-03 (6,35)	
5691 045-01	5412 032-021	5412 028-021	5322 425-01 (4,76)	
5691 045-01	5412 032-021	5412 028-021	5322 425-01 (4,76)	
5691 045-01	5412 032-031	5412 028-031	5322 425-03 (6,35)	
5691 045-01	5412 032-021	5412 028-021	5322 425-01 (4,76)	
5691 029-09 5691 045-01	5412 032-031	5412 028-031	5322 425-03 (6,35)	
5691 045-01	5412 032-021	5412 028-021		

<sup>1)</sup> For clamp set parts, see pages A 236-A 237.

Ordering example: 10 pieces 5513 020-02

# CoroTurn™ RC rigid clamp design for ceramic inserts

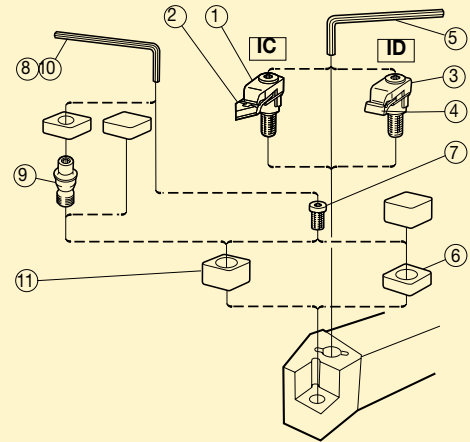


Tool type	Shank holders	Coromant Capto®	Standard parts			
			Delivered with the tool			
			1	2	3	4
			Shim (For insert thickness)	Shim screw	Key (Torx Plus <sup>1</sup> )	Complete clamp set <sup>1</sup>
<b>DCBNR/L</b> 2525M12-2 3225P12-2	<b>C4-DCRNR/L-22050-12-2</b> <b>C5-DCRNR/L-27060-12-2</b> <b>C6-DCRNR/L-35065-12-2</b>		5322 234-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 032-021
<b>DCBNR/L</b> 3225P16-2	<b>C5-DCRNR/L-27060-16-2</b> <b>C6-DCRNR/L-35065-16-2</b>		5322 234-04 (7,94)	5513 020-07	5680 043-14 (20IP)	5412 032-031
<b>DCLNR/L</b> 2525M12-2 3225P12-2	<b>C4-DCLNR/L-27050-12-2</b> <b>C5-DCLNR/L-35060-12-2</b> <b>C6-DCLNR/L-45065-12-2</b>		5322 234-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 032-021
<b>DCLNR/L</b> 2525M16-2 3225P16-2 3232P16-2	<b>C5-DCLNR/L-35060-16-2</b> <b>C6-DCLNR/L-45065-16-2</b>		5322 234-04 (7,94)	5513 020-07	5680 043-14 (20IP)	5412 032-031
<b>DDJNR/L</b> 2525M15-2 3225P15-2 3232P15-2	<b>C5-DDJNR/L-35060-15-2</b> <b>C6-DDJNR/L-45065-15-2</b>		5322 266-03 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 032-021
<b>DDNR/L</b> 3225P15-2			5322 266-03 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 032-021
<b>DSBNR/L</b> 2525M12-2			5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 032-021
<b>DSDNN</b> 2525M12-2 3225P12-2	<b>C4-DSDNN-00050-12-2</b> <b>C5-DSDNN-00060-12-2</b> <b>C6-DSDNN-00065-12-2</b>		5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 032-021
<b>DSKNR/L</b> 2525M12-2	<b>C4-DSKNR/L-27050-12-2</b> <b>C5-DSKNR/L-35060-12-2</b> <b>C6-DSKNR/L-45065-12-2</b>		5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 032-021
<b>DSRNR/L</b> 2525M12-2 3225P12-2	<b>C4-DSRNR/L-22050-12-2</b> <b>C5-DSRNR/L-27060-12-2</b> <b>C6-DSRNR/L-35065-12-2</b>		5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 032-021
<b>DSSNR/L</b> 2525M12-2 3225P12-2	<b>C4-DSSNR/L-27042-12-2</b> <b>C5-DSSNR/L-35052-12-2</b> <b>C6-DSSNR/L-45056-12-2</b>		5322 425-02 (7,94)	5513 020-02	5680 049-01 (15IP)	5412 032-021
<b>DTGRN/L</b> 3232P22-2	<b>C4-DTGRN/L-27050-22-2</b> <b>C5-DTGRN/L-35060-22-2</b> <b>C6-DTGRN/L-45065-22-2</b>		5322 315-04 (4,76)	5513 020-02	5680 049-01 (15IP)	5412 032-021

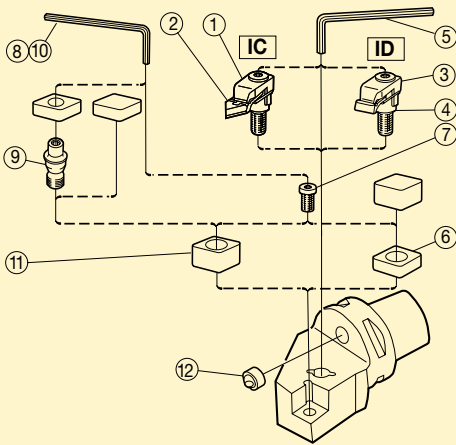




**T-MAX top clamp design for ceramic inserts**



Tool type		Standard parts					
		Delivered with the tool					
		1	2			3	4
Shank holders		Clamp (IC)	Chipbreaker (IC)	Neutral	Left hand	Clamp (ID)	Pressure plate (ID)
Coromant Capto®		Right hand					
80°							
CCBNR/L 3225P12-IC		5412 125-01	5192 022-05	-	5192 022-06	-	-
CCLNR/L 2525M12-IC	C3-CCLNR/L-22040-12IC	5412 125-01	-	5192 022-04	-	-	-
CCLNR/L 3225P12-IC	C4-CCLNR/L-27050-12IC C5-CCLNR/L-35060-12IC C6-CCLNR/L-45065-12IC	5412 125-02	-	5192 022-04	-	-	-
CCLNR/L 3225P16-IC	C5-CCLNR/L-35060-16IC C6-CCLNR/L-45065-16IC	5412 125-02	-	5192 022-02	-	-	-
	C3-CCRNR/L-17040-12IC	5412 125-02	5192 022-05	-	5192 022-06	-	-
	C4-CCRNR/L-22050-12IC	5412 125-01	5192 022-05	-	5192 022-06	-	-
	C5-CCRNR/L-27060-12IC C6-CCRNR/L-35065-12IC	5412 125-01	5192 022-05	-	5192 022-06	-	-
	C5-CCRNR/L-27060-16IC C6-CCRNR/L-35065-16IC	5412 125-02	5192 022-02	-	5192 022-03	-	-
55°							
CDJNR/L 2525M15-IC 3225P15-IC	C5-CDJNR/L-35060-15IC C6-CDJNR/L-45065-15IC	5412 125-02	5192 021-01	-	5192 021-02	-	-
CDNNN 5040T15-ID		-	-	-	-	5412 125-02	5192 020-01
CDNNR/L 3225P15-IC		5412 125-02	5192 021-01	-	5192 021-02	-	-
CRDNN 2525M09-ID		-	-	-	-	5412 127-01	-
CRDNN 2525M12-ID 3225P12-ID		-	-	-	-	5412 125-01	5192 020-01
CRSNR/L 2525M09-ID	C3-CRSNR/L-22040-09ID	-	-	-	-	5412 127-01	-
CRSNR/L 2525M12-ID 3225P12-ID	C4-CRSNR/L-27050-12ID C5-CRSNR/L-35060-12ID C6-CRSNR/L-45065-12ID	-	-	-	-	5412 125-01	5192 020-01
CRSNR/L 3232P15-ID		-	-	-	-	5412 125-01	5192 020-01
CRSNR/L 3232P19-ID		-	-	-	-	5412 125-01	5192 020-01
CRSNR/L 5040T25-ID		-	-	-	-	5412 125-02	5192 020-01
CSRNR/L2525M09-ID	C3-CSRNR/L-17040-09ID	-	-	-	-	5412 127-01	-
CSRNR/L 2525M12-IC	C4-CSRNR/L-22050-12IC	5412 125-01	5192 022-05	-	5192 022-06	-	-
CSRNR/L 3225P12-IC	C5-CSRNR/L-27060-12IC C6-CSRNR/L-35065-12IC	5412 125-02	5192 022-05	-	5192 022-06	-	-
CSRNR/L 3225P15-IC	C5-CSRNR/L-27060-15IC C6-CSRNR/L-35065-15IC	5412 125-02	5192 022-02	-	5192 022-03	-	-
CSRNR/L 3232P19-IC		5412 125-02	5192 022-02	-	5192 022-03	-	-
CSSNR/L 2525M12-IC 3225P12-IC	C4-CSSNR/L-27047-12IC C5-CSSNR/L-35062-12IC C6-CSSNR/L-45056-12IC	5412 125-02	5192 022-05	-	5192 022-06	-	-
	C5-CSSNR/L-35062-15IC C6-CSSNR/L-45054-15IC	5412 125-02	5192 022-02	-	5192 022-03	-	-
CSDNN 2525M12-IC 3225P12-IC	C4-CSDNN-00055-12IC C5-CSDNN-00060-12IC C6-CSDNN-00065-12IC	5412 125-02	-	5192 022-04	-	-	-
	C5-CSDNN-00060-15IC C6-CSDNN-00065-15IC	5412 125-02	-	5192 022-01	-	-	-



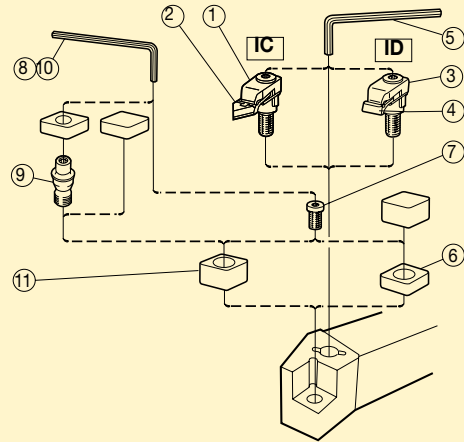
Nozzle for Coromant Capto cutting units



Cutting unit size	12 Nozzle
C3-C4	5691 029-01
C5-C6	5691 029-02
C8	5691 029-03

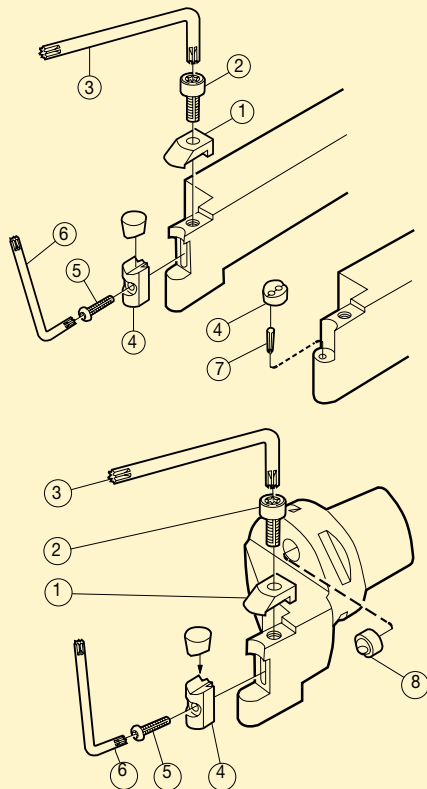
				Optional parts				
5	6	7	8	Delivery to separate order		9	11	10
Key (mm)	Shim (For insert thickness)	Shim screw	Key (mm/ Torx Plus)	3	4	Centre pin (IP)	Shim (For insert thickness)	Key (mm)
				Clamp (ID)	Pressure plate (ID)			
3021 010-040 (4,0)	5322 233-01 (7,97)	5513 013-02	5680 043-14 (20IP)	5412 125-01	5192 020-01	5313 032-02	5322 233-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 233-01 (7,97)	5513 013-02	5680 043-14 (20IP)	5412 125-01	5192 020-01	5313 032-02	5322 233-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 233-01 (7,97)	5513 013-02	5680 043-14 (20IP)	5412 125-02	5192 020-01	5313 032-02	5322 233-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 233-03 (7,97)	5513 013-03	174.1-864 (3,0)	5412 125-02	5192 020-01	5313 032-03	-	174.1-864 (3,0)
3021 010-040 (4,0)	5322 233-01 (7,97)	5513 013-02	174.1-863 (3,0)	-	5192 020-01	5313 032-03	5322 233-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 233-01 (7,97)	5513 013-02	5680 043-14 (20IP)	-	5192 020-01	5313 032-02	5322 233-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 233-01 (7,97)	5513 013-02	5680 043-14 (20IP)	-	5192 020-01	5313 032-02	5322 233-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 233-03 (7,97)	5513 013-03	174.1-864 (3,0)	-	5192 020-01	5313 032-03	-	174.1-864 (3,0)
3021 010-040 (4,0)	5322 264-01 (7,97)	5513 013-02	5680 043-14 (20IP)	5412 125-02	5192 020-01	5313 032-02	5322 264-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 264-01 (7,97)	5513 013-02	5680 043-14 (20IP)	-	-	-	5322 264-02 (4,76)	-
3021 010-040 (4,0)	5322 264 01 (7,97)	5513 013 02	5680 043-14 (20IP)	5412 125-02	5192 020-01	5313 032-02	5322 264-02 (4,76)	174.1.863 (2,5)
3021 010-040 (4,0)	5321 215-01 (7,97)	3212 100-206	174.1-870 (2,0)	-	-	-	-	-
3021 010-040 (4,0)	5322 141-01 (7,97)	5513 013-02	5680 043-14 (20IP)	-	-	5313 032-02	5322 141-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5321 215-01 (7,97)	3212 100-206	174.1-870 (2,0)	-	-	-	-	-
3021 010-040 (4,0)	5322 141-01 (7,97)	5513 013-02	5680 043-14 (20IP)	-	-	5313 032-02	5322 141-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5321 215-02 (7,97)	3212 100-206	174.1-870 (2,0)	-	-	-	-	-
3021 010-040 (4,0)	5321 215-03 (7,97)	3212 100-257	174.3-863 (2,5)	-	-	-	-	-
3021 010-040 (4,0)	5322 141-05	5513 013-03	174.1-864 (3,0)	-	-	-	-	-
3021 010-040 (4,0)	5321 220-01 (3,18)	3212 100-206	174.1-870 (2,0)	-	-	-	-	-
3021 010-040 (4,0)	5322 421-01 (7,97)	5513 013-02	5680 043-14 (20IP)	5412 125-01	5192 020-01	5313 032-02	5322 421-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 421-01 (7,97)	5513 013-02	5680 043-14 (20IP)	5412 125-02	5192 020-01	5313 032-02	5322 421-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 421-03 (7,97)	5513 013-03	174.1-864 (3,0)	5412 125-02	5192 020-01	-	-	-
3021 010-040 (4,0)	5321 220-02 (7,97)	3212 100-257	174.3-863 (2,5)	5412 125-02	5192 020-01	-	-	-
3021 010-040 (4,0)	5322 421-01 (7,97)	5513 013-02	5680 043-14 (20IP)	5412 125-02	5192 020-01	5313 032-02	5322 421-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 421-03	5513 013-03	174.1-864 (3,0)	-	5192 020-01	-	-	-
3021 010-040 (4,0)	5322 421-01 (7,97)	5513 013-02	5680 043-14 (20IP)	5412 125-02	5192 020-01	5313 032-02	5322 421-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 421-03	5513 013-03	174.1-864 (3,0)	-	5192 020-01	5313 032-03	5322 421-04 (4,76)	174.1-864 (3,0)

Ordering example: 10 pieces 5412 125-02


**T-MAX top clamp design for ceramic inserts**

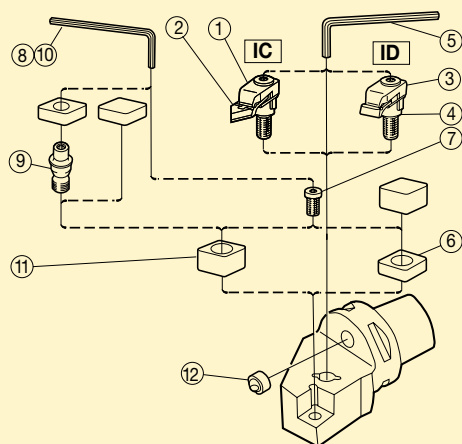


Tool type		Standard parts					
		Delivered with the tool					
		1	2			3	4
Shank holders	Coromant Capto®	Clamp (IC)	Chipbreaker (IC) Right hand	Neutral	Left hand	Clamp (ID)	Pressure plate (ID)
	<b>CSRPR/L 3225P12-IC</b>	5412 125-01	5192 022-05	-	5192 022-06	-	-
	<b>C4-CSKNR/L-27050-12IC</b>	5412 125-02	5192 022-06	-	5192 022-05	-	-
	<b>C5-CSKNR/L-35060-12IC</b>	5412 125-02	5192 022-06	-	5192 022-05	-	-
	<b>C6-CSKNR/L-45065-12IC</b>						
	<b>CTGNR/L 2525M11-ID</b>	<b>C3-CTGNR/L-22040-11ID</b>	-	-	-	5412 127-01	-
	<b>CTGNR/L 2525M16-ID</b>	<b>C4-CTGNR/L-27050-16ID</b>	-	-	-	5412 125-01	5192 020-01
	<b>3225P16-ID</b>	<b>C5-CTGNR/L-35060-16ID</b>					
		<b>C6-CTGNR/L-45065-16ID</b>					
	<b>CTGNR/L 3232P22-ID</b>	<b>C4-CTGNR/L-27050-22ID</b>	-	-	-	5412 125-01	5192 020-01
		<b>C5-CTGNR/L-35060-22ID</b>					
		<b>C6-CTGNR/L-45065-22ID</b>					
	<b>CTGPR/L 2525M11-ID</b>		-	-	-	5412 127-01	-
	<b>CTGPR/L 3225P16-ID</b>		-	-	-	5412 125-01	5192 020-01



**T-MAX top clamp design for ceramic RCGX/RPGX inserts**

Tool type		Standard parts	
		Delivered with the tool	
		1	2
Shank holders	Coromant Capto®	Clamp	Clamp screw
	<b>CRDCN 3225P06-A</b>	5412 105-01	3212 036-506
	<b>CRDCN 3225P09-A</b>	<b>C5-CRDCN-00060-09AV</b>	5412 100-01 3212 035-452
	<b>CRDCN 3225P12-A</b>	<b>C5-CRDCN-00060-12AV</b>	5412 100-02 3212 036-504
	<b>CRDCN 5040T12-ID</b>		5412 100-02 3212 036-504
	<b>CRDCN 5040T15-ID</b>		5412 126-01 -
	<b>CRDCN 5040T19-ID</b>		5412 126-02 -
	<b>CRDCN 5040T25-ID</b>		5412 126-02 -
	<b>CRDCR/L 3225P09-A</b>	5412 100-01	3212 035-452
	<b>CRDCR/L 3225P12-A</b>	5412 100-02	3212 036-504
		<b>C5-CRSCR/L-35060-09V</b>	5412 100-01 3212 035-452
		<b>C5-CRSCR/L-35060-12V</b>	5412 100-02 3212 036-504
	<b>R 176.9-3226-06</b>	5412 110-02	3212 036-506
	<b>L 176.9-3226-06</b>	5412 110-01	3212 036-506



Nozzle for Coromant Capto cutting units

Cutting unit size	12 Nozzle
C3–C4	5691 029-01
C5–C6	5691 029-02
C8	5691 029-03

				Optional parts				
				Delivery to separate order				
5	6	7	8	3	4	9	11	10
Key (mm)	Shim (For insert thickness)	Shim screw	Key (mm/Torx Plus)	Clamp (ID)	Pressure plate (ID)	Centre pin (IP)	Shim (For insert thickness)	Key (mm)
3021 010-040 (4,0)	5321 221-01 (4,76)	3212 100-206	174.1-870 (2,0)	5412 125-01	5192 020-01	–	–	–
3021 010-040 (4,0)	5322 421-01	5513 013-02	5680 043-14 (20IP)	–	5192 020-01	5313 032-02	5322 421-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5322 421-01	5513 013-02	5680 043-14 (20IP)	–	5192 020-01	5313 032-02	5322 421-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5321 225-01 (3,18)	5512 030-05	3021 012-015 (1,5)	–	–	–	–	–
3021 010-040 (4,0)	5322 329-01 (7,97)	5513 013-01	174.1-870 (2,0)	–	–	5313 032-01	5322 329-02 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5321 225-02 (7,97)	5513 013-02	5680 043-14 (20IP)	–	–	5313 032-02	5321 225-03 (4,76)	174.1-863 (2,5)
3021 010-040 (4,0)	5321 226-01(3,18)	3113 035-306 <sup>1)</sup>	–	–	–	–	–	–
3021 010-040 (4,0)	5321 226-02 (3,18)	3212 100-206	174.1-870 (2,0)	–	–	–	–	–

<sup>1)</sup> Shim pin

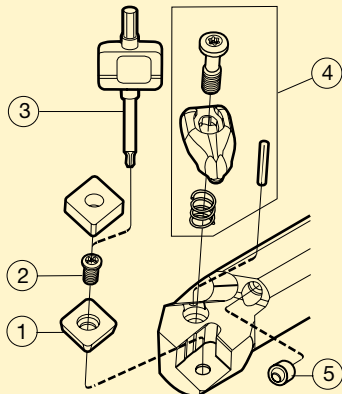
Ordering example: 10 pieces 5412 125-02





3	4	5	6	7	8
Key (Torx Plus/mm)	Seat	Seat screw	Key (mm/Torx Plus)	Seat pin	Nozzle
5680 043-17 (30IP)	5321 066-01	3212 010-157	174.1-870 (2,0)	–	–
5680 043-16 (27IP)	5321 065-01	3212 106-352	5680 043-12 (10IP)	–	5691 029-02
5680 043-17 (30IP)	5321 065-02	3212 105-453	5680 043-15 (25IP)	–	5691 029-02
5680 043-17 (30IP)	5321 210-02	–	–	3113 030-355	–
3021 010-040 (4,0)	5321 210-03	–	–	3113 030-355	–
3021 010-040 (4,0)	5321 210-04	–	–	3113 030-406	–
3021 010-040 (4,0)	5321 210-05	–	–	3113 030-406	–
5680 043-16 (27IP)	5321 065-01	3212 106-352	5680 043-12 (10IP)	–	–
5680 043-17 (30IP)	5321 065-02	3212 105-453	5680 043-15 (25IP)	–	–
5680 043-16 (27IP)	5321 065-01	3212 106-352	5680 043-12 (10IP)	–	5691 029-02
5680 043-17 (30IP)	5321 065-02	3212 105-453	5680 043-15 (25IP)	–	5691 029-02
5680 043-17 (30IP)	5321 066-01	3212 010-157	174.1-870 (2,0)	–	–
5680 043-17 (30IP)	5321 066-01	3212 010-157	174.1-870 (2,0)	–	–

Ordering example: 10 pieces 5412 105-01

## CoroTurn™ RC rigid clamp design

A



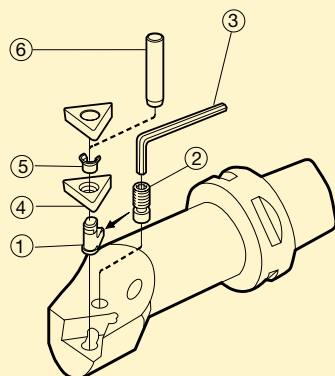
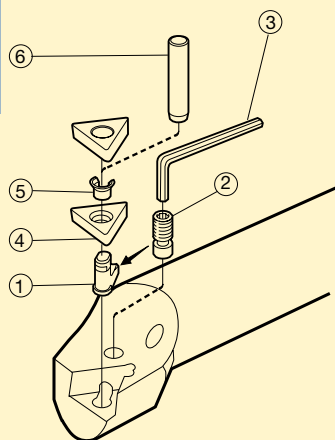
Tool type	Standard parts		
	Delivered with the tool		
	1	2	3
<b>Shank holders</b>	Shim screw	Shim	Key (Torx Plus)
 80°			
A25T-DCLNR/L 09	5322 236-04	5513 020-04	5680 051-03
A25T-DCLNR/L 12 A32U-DCLNR/L 12	5322 236-03	5513 020-02	5680 049-01
A40V-DCLNR/L 12	5322 234-01	5513 020-02	5680 049-01
A50W-DCLNR/L 16	5322 234-03	5513 020-07	5680 043-14
 55°			
A25T-DDUNR/L 11 A32U-DDUNR/L 11	5322 267-01	5513 020-04	5680 051-03
A40V-DDUNR/L 15 A50W-DDUNR/L 15	5322 266-02	5513 020-02	5680 049-01
			
A25T-DSKNR/L 09	5322 426-01	5513 020-04	5680 051-03
A25T-DSKNR/L 12 A32U-DSKNR/L 12	5322 426-02	5513 020-02	5680 049-01
A40V-DSKNR/L 12	5322 425-01	5513 020-02	5680 049-01
			
A25T-DTFNR/L 16 A32U-DTFNR/L 16	5322 316-01	5513 020-04	5680 051-03
A40V-DTFNR/L 22 A50W-DTFNR/L 22	5322 315-04	5513 020-02	5680 049-01




		<b>Optional parts</b>					
		Delivery to separate order					
4	5	4	4	1		1	
Complete clamp set <sup>1)</sup>	Coolant nozzle	Clamp sets for ceramic inserts without hole <sup>1)</sup>	Clamp sets for ceramic inserts with hole <sup>1)</sup>	Shim	For insert thickness	Shim	For insert thickness
5412 028-011	5691 029-06	-	-	-		-	
5412 028-021	5691 029-06	5412 032-021	5412 034-021	-		-	
	-						
5412 028-021	-	5412 032-021	5412 034-021	5322 234-02	7,97	-	
5412 028-031	-	5412 032-031	5412 034-031	5322 234-04	7,97	-	
5412 028-011	5691 029-06	-	-	-		-	
	-						
5412 028-021	-	5412 0328-021	5412 034-021	5322 266-01	4,76	5322 266-03	7,97
5412 028-011	5691 029-06	-	-	-		-	
	-						
5412 028-021	5691 029-06	5412 032-021	5412 034-021	-		-	
	-						
5412 028-021	-	5412 032-021	5412 034-021	5322 425-02	7,97	-	
5412 028-011	5691 029-06	-	-	-		-	
	-						
5412 028-021	-	5412 032-021	5412 034-021	-		-	

<sup>1)</sup> For clamp set parts, see pages A 236-A 237.

**Ordering example: 10 pieces 5513 020-02**

**T-MAX P lever design**



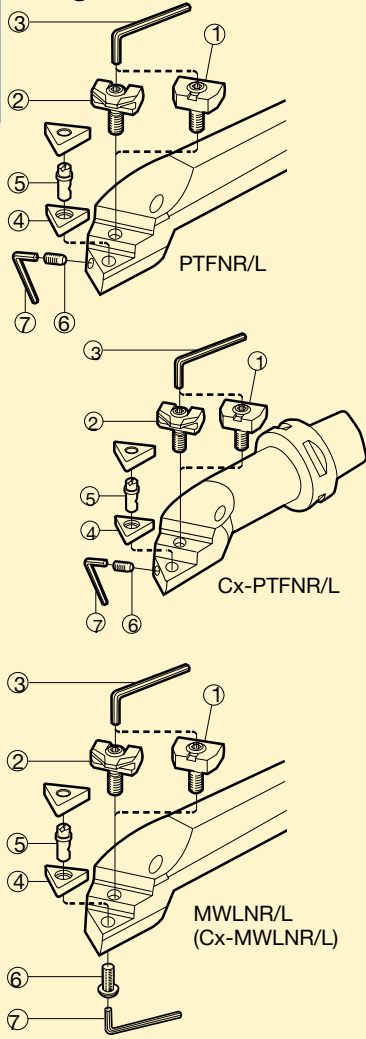
Tool type		Standard parts			
		Delivered with the tool			
		1	2	3	
Shank holders		Lever Screw Key (mm)			
Coromant Capto®					
 80° <b>S16R-PCLNR/L 09</b> <b>S20S-PCLNR/L 09</b> <b>S25T-PCLNR/L 09</b>		<b>C3-PCLNR/L- 13075-09</b> <b>C3-PCLNR/L- 17090-09</b> <b>C4-PCLNR/L- 13080-09</b> <b>C4-PCLNR/L- 17090-09</b> <b>C5-PCLNR/L- 13080-09</b> <b>C5-PCLNR/L- 17090-09</b>	174.3-845-1	174.3-829	170.3-864 (1,98)
<b>S25T-PCLNR/L 12</b>		<b>C3-PCLNR/L- 17090-12</b> <b>C4-PCLNR/L- 17090-12</b> <b>C5-PCLNR/L- 17090-12</b> <b>C6-PCLNR/L- 17100-12</b>	438.3-841-1	483.3-832M	174.1-863 (2,5)
<b>S32U-PCLNR/L 12</b>			174.3-848M	174.3-858	174.1-864 (3,0)
<b>S40V-PCLNR/L 12</b>		<b>C3-PCLNR/L- 22064-12</b> <b>C3-PCLNR/L- 22096-12</b> <b>C4-PCLNR/L- 22110-12</b> <b>C4-PCLNR/L- 27080-12</b> <b>C4-PCLNR/L- 27120-12</b> <b>C5-PCLNR/L- 22110-12</b> <b>C5-PCLNR/L- 27140-12</b> <b>C5-PCLNR/L- 35100-12</b> <b>C6-PCLNR/L- 22110-12</b>	174.3-841M	174.3-821	174.1-864 (3,0)
<b>S50W-PCLNR/L 16</b>		<b>C5-PCLNR/L- 35150-16</b> <b>C6-PCLNR/L- 27140-16</b> <b>C6-PCLNR/L- 35175-16</b>	438.3-840	438.3-831	174.1-864 (3,0)
<b>S50W-PCLNR/L 19</b>			174.3-849M	174.3-822M	3021 010-040 (4,0)
 55° <b>S25T-PDUNR/L 11</b>		<b>C3-PDUNR/L-17090-11</b> <b>C4-PDUNR/L-17090-11</b> <b>C5-PDUNR/L-17090-11</b> <b>C6-PDUNR/L-17100-11</b>	5432 015-021	438.3-830	174.1-870 (1,98)
<b>S32U-PDUNR/L 11</b>		<b>C3-PDUNR/L-22064-11</b> <b>C3-PDUNR/L-22096-11</b> <b>C4-PDUNR/L-22110-11</b> <b>C5-PDUNR/L-22110-11</b>	5432 001-01	174.3-820M	174.1-863 (2,5)
<b>S40V-PDUNR/L 15</b>			174.3-847M	174.3-830	174.1-864 (3,0)
<b>S50W-PDUNR/L 15</b>		<b>C4-PDUNR/L-27080-15</b> <b>C4-PDUNR/L-27120-15</b> <b>C5-PDUNR/L-27140-15</b> <b>C5-PDUNR/L-35100-15</b> <b>C5-PDUNR/L-35150-15</b> <b>C6-PDUNR/L-22110-15</b> <b>C6-PDUNR/L-27140-15</b> <b>C6-PDUNR/L-35175-15</b>	174.3-847M	174.3-830	174.1-864 (3,0)
<b>S25T-PSKNR/L 12</b>		<b>C3-PSKNR/L-17090-12</b> <b>C4-PSKNR/L-17090-12</b> <b>C5-PSKNR/L-17090-12</b>	438.3-841-1	438.3-832M	174.1-863 (2,5)
<b>S32U-PSKNR/L 12</b>			174.3-848M	174.3-858	174.1-864 (3,0)
<b>S40V-PSKNR/L 12</b>		<b>C3-PSKNR/L-22064-12</b> <b>C3-PSKNR/L-22096-12</b> <b>C4-PSKNR/L-22110-12</b> <b>C4-PSKNR/L-27080-12</b> <b>C4-PSKNR/L-27120-12</b> <b>C5-PSKNR/L-22110-12</b> <b>C5-PSKNR/L-27140-12</b> <b>C6-PSKNR/L-22110-12</b>	174.3-841M	174.3-821	174.1-864 (3,0)
		<b>C5-PSKNR/L-35100-15</b> <b>C5-PSKNR/L-35150-15</b> <b>C6-PSKNR/L-27140-15</b> <b>C6-PSKNR/L-35175-15</b>	438.3-840	438.3-831	174.1-864 (3,0)
 <b>S16R-PTFNR/L 11</b> <b>S20S-PTFNR/L 11</b> <b>S25T-PTFNR/L 11</b>		<b>C3-PTFNR/L-13075-11</b> <b>C4-PTFNR/L-13080-11</b> <b>C5-PTFNR/L-13080-11</b>	174.3-846-1	174.3-829	170.3-864 (1,98 mm)

					<b>Optional parts</b>		
					Delivery to separate order		
4			5	6	4		
Shim	For insert Thickness	Radius	Shim pin	Shim pin punch	Shim	For insert Thickness	Radius
-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-
171.31-850M	4,76	0,4 – 1,6	174.3-861	174.3-871	-	-	-
171.31-850M	4,76	0,4 – 1,6	174.3-861	174.3-871	-	-	-
171.31-852	6,35	0,4 – 2,4	174.3-864	174.3-873	-	-	-
171.31-851M	6,35	0,4 – 2,4	174.3-868	174.3-872	-	-	-
-	-	-	-	-	-	-	-
5322 255-01	4,76	0,4-0,8	174.3-860	174.3-870	5322 255-02	6,35	1,2 – 1,6
171.35-851M	6,35	0,4-0,8	174.3-861	174.3-871	171.35-850M 171.35-856 171.35-855	6,35 4,76 4,76	1,2 – 1,6 0,4 – 0,8 1,2 – 1,6
171.35-851M	6,35	0,4-0,8	174.3-861	174.3-871	171.35-850M 171.35-856 171.35-855	6,35 4,76 4,76	1,2 – 1,6 0,4 – 0,8 1,2 – 1,6
-	-	-	-	-	-	-	-
174.3-851M	4,76	0,4 – 1,2	174.3-861	174.3-871	174.3-856	4,76	1,6 – 2,4
174.3-851M	4,76	0,4 – 1,2	174.3-861	174.3-871	174.3-856	4,76	1,6 – 2,4
174.3-857	6,35	0,4 – 2,4	174.3-864	174.3-873	-	-	-
-	-	-	-	-	-	-	-

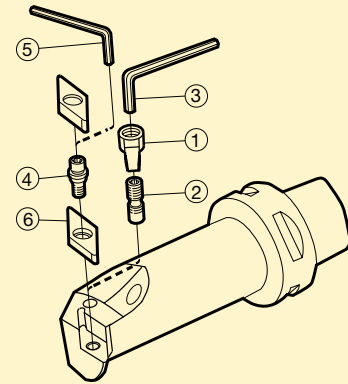
Ordering example: 10 pieces 174.3-845-1



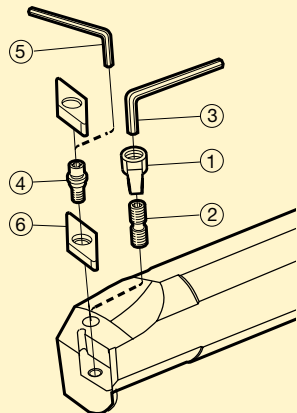
**T-MAX P wedge design**



Tool type		Standard parts				
Round shank tools		Delivered with the tool				
		1	2	3	4	
Coromant Capto®		Wedge set	Wedge clamp set	Key (mm)	Shim	
 S25T-PTFNR/L 16-W S32U-PTFNR/L 16-W S40V-PTFNR/L 16-W	C3-PTFNR/L-17090-16-W C4-PTFNR/L-17090-16-W C5-PTFNR/L-17090-16-W	170.38-823-2	-	174.1-864 (3,0)	-	
	C3-PTFNR/L-22096-16-W C4-PTFNR/L-22110-16-W C4-PTFNR/L-27120-16-W C5-PTFNR/L-22110-16-W C5-PTFNR/L-27140-16-W C6-PTFNR/L-22110-16-W C6-PTFNR/L-27140-16-W	170.38-823-1	-	174.1-864 (3,0)	170.3-852	
	S50W-PTFNR/L 16-W S40V-PTFNR/L 22-W S50W-PTFNR/L 22-W	170.38-823-1 170.38-824-1	- -	174.1-864 (3,0) 3021 010-040 (4,0)	170.3-852 170.3-855	
	C5-PTFNR/L-27140-22-W C6-PTFNR/L-27140-22-W	170.38-823-1	-	3021 010-040 (4,0)	170.3-852	
 A20S-MWLNR/L 06 A25T-MWLNR/L 06 A32U-MWLNR/L 06 A25T-MWLNR/L 08 A32U-MWLNR/L 08 A40V-MWLNR/L 08 A50W-MWLNR/L 08	C3-MWLNR/L-13075-06M1 C3-MWLNR/L-17090-06M1 C4-MWLNR/L-13075-06M1 C4-MWLNR/L-17090-06	-	5431 125-011	170.3-860 (2,5)	-	
	A25T-MWLNR/L 06	-	5431 125-011	170.3-860 (2,5)	5322 331-11	
	A32U-MWLNR/L 06	-	5431 125-011	170.3-860 (2,5)	5322 331-06	
	A25T-MWLNR/L 08	C4-MWLNR/L-17090-08 C5-MWLNR/L-17090-08	-	5431 125-021	174.1-864 (3,0)	5322 331-09
	A32U-MWLNR/L 08	-	-	5431 125-021	174.1-864 (3,0)	5322 331-07
	A40V-MWLNR/L 08 A50W-MWLNR/L 08	C4-MWLNR/L-22110-08 C4-MWLNR/L-27120-08 C5-MWLNR/L-22110-08 C5-MWLNR/L-27140-08	-	5431 125-021	174.1-864 (3,0)	5322 331-07



**T-MAX P screw and top clamp design**



Tool type		Standard parts		
Shank holders		Delivered with the tool		
		1	2	3
Coromant Capto®		Clamp	Clamp screw	Key (mm)
35° S40V-MVUNR/L 16	C4-MVUNR/L-27120-16 C5-MVUNR/L-27140-16 C5-MVUNR/L-35150-16 C6-MVUNR/L-22120-16 C6-MVUNR/L-27145-16 C6-MVUNR/L-35175-16	MC-12	MS-510	3021 011-532 (3,96)

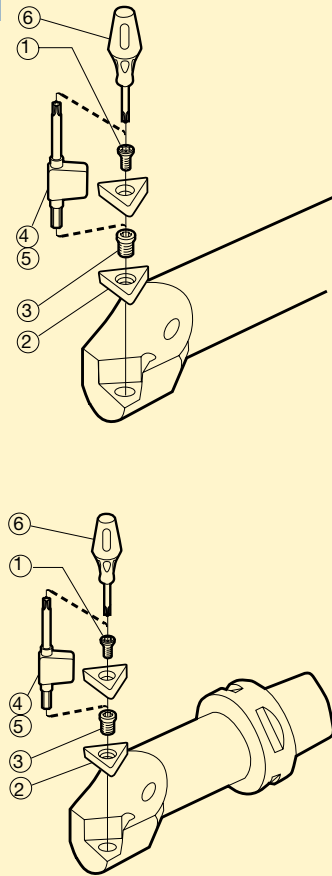
					<b>Optional parts</b>				
					Delivery to separate order				
		5	6	7	2	3	4		
For insert Thickness	Radius	Pin	Screw	Key (mm/Torx Plus)	Wedge clamp set	Key	Shim	For insert Thickness	Radius
-	-	5313 021-01	5512 031-01	5680 051-03 (9IP)	-	-	-	-	-
4,76	0,4 – 0,8	5313 021-02	5512 031-01	5680 051-03 (9IP)	170.38-820-1	174.1-863 (2,5)	-	-	-
4,76	0,4 – 0,8	5313 021-02	3212 100-206	174.1-870 (1,98)	170.38-820-1	174.1-863 (2,5)	-	-	-
4,76	1,2 – 1,6	5313 021-03	5512 031-02	5680 049-02 (15IP)	170.38-821-1	174.1-864 (3,0)	170.3-856	4,76	0,4 – 0,8
4,76	1,2 – 1,6	5321 021-02	5512 031-01	5680 051-03 (9IP)	-	-	-	-	-
-	-	5313 022-02	-	170.3-864 (1,98)	-	-	-	-	-
4,76	0,4 – 0,8	5313 022-02	-	170.3-864 (1,98)	-	-	-	-	-
4,76	0,4 – 0,8	5313 022-01	5512 030-03	170.3-864 (1,98)	-	-	-	-	-
4,76	0,4 – 0,8	5313 022-03	-	-	-	-	5322 331-10	4,76	1,2 – 1,6
4,76	0,4 – 0,8	5313 022-03	-	-	-	-	5322 331-08	4,76	1,2 – 1,6
4,76	0,4 – 0,8	5313 022-03	5512 030-04	174.1-863 (2,5)	-	-	5322 331-08	4,76	1,2 – 1,6

Ordering example: 10 pieces 170.38-823-2

4	5	6		
Lock pin	Key (mm)	Shim	For insert Thickness	Radius
MN-34L	174.1-870 (1,98)	MVN-322	4,76	0,4 – 1,2

Ordering example: 10 pieces MC-12

**CoroTurn™ 107**  
screw clamp design



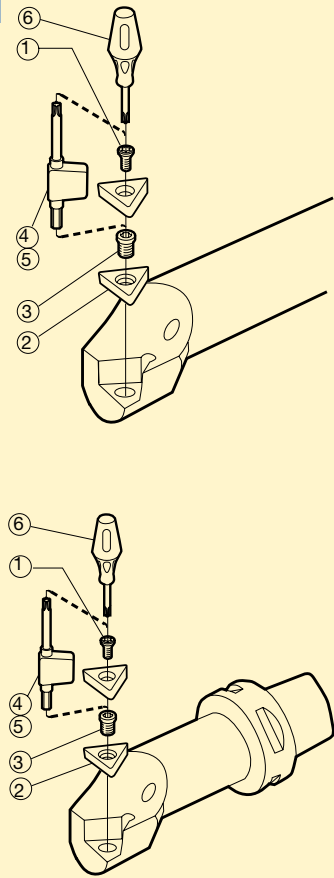
Tool type		Standard parts			
		Delivered with the tool			
		1	2		
Shank holders	Coromant Capto®	Insert screw (thread)	Shim	For insert thickness	
<b>80°</b>					
S08K-SCLCR/L 06 S10M-SCLCR/L 06	-	5513 020-01			
S12M-SCLCR/L 06 S16R-SCLCR/L 06	-	5513 020-03 (M2,5)	-		
S16R-SCLCR/L 09-M S20S-SCLCR/L 09-M	C3-SCLCR/L-11065-09 C4-SCLCR/L-11070-09 C5-SCLCR/L-11070-09 C3-SCLCR/L-13075-09 C4-SCLCR/L-13080-09 C5-SCLCR/L-13080-09	5513 020-09 (M3,5)	-		
S25T-SCLCR/L 09-M	C3-SCLCR/L-17090-09 C4-SCLCR/L-17090-09 C5-SCLCR/L-17090-09	5513 020-10 (M3,5)	-		
	C4-SCLCR/L-27080-09 C5-SCLCR/L-35100-09	5513 020-01 (M3,5)	5322 232-01		3,97
S25T-SCLCR/L 12	C3-SCLCR/L-17090-12 C4-SCLCR/L-17090-12 C5-SCLCR/L-17090-12	5513 020-17 (M4×0,5)	-		
S32U-SCLCR/L 12 S40V-SCLCR/L 12	C3-SCLCR/L-22064-12 C3-SCLCR/L-22096-12 C4-SCLCR/L-22110-12 C4-SCLCR/L-27080-12 C5-SCLCR/L-22110-12 C5-SCLCR/L-27140-12 C5-SCLCR/L-35100-12	5513 020-18 (M4×0,5)	5322 232-02		4,76
<b>55°</b>					
A10K-SDUCR/L 07-ER A12M-SDUCR/L 07-ER E10M-SDUCR/L 07-ER E12Q-SDUCR/L 07-ER E16R-SDUCR/L 07-ER F10M-SDUCR/L 07-ER F12Q-SDUCR/L 07-ER S10K-SDUCR/L 07 S12M-SDUCR/L 07 S16R-SDUCR/L 07 S16R-SDUCR/L 07-EX S20S-SDUCR/L 07-EX S25T-SDUCR/L 07-DX S20S-SDUCR/L 11-M	C3-SDUCR/L-11065-07 C4-SDUCR/L-11070-07 C5-SDUCR/L-11070-07 C3-SDUCR/L-13070-07X C3-SDUCR/L-15080-07X C4-SDUCR/L-13070-07X C4-SDUCR/L-15080-07X C4-SDUCR/L-18090-07X C5-SDUCR/L-15080-07X C5-SDUCR/L-18090-07X	5513 020-03 (M2,5)	-		
S25T-SDUCR/L 11-M	C3-SDUCR/L-13075-11 C3-SDUCR/L-17090-11 C4-SDUCR/L-13080-11 C5-SDUCR/L-13080-11 C4-SDUCR/L-17090-11 C5-SDUCR/L-17090-11	5513 020-10 (M3,5)	-		
S32U-SDUCR/L 11-X	C3-SDUCR/L-22064-11 C3-SDUCR/L-22096-11 C4-SDUCR/L-22110-11 C4-SDUCR/L-27080-11 C5-SDUCR/L-22110-11 C5-SDUCR/L-35100-11	5513 020-01 (M3,5)	5322 263-01 5322 263-02 <sup>1)</sup>		3,97 3,97
S16R-SSKCR/L 09-M S20S-SSKCR/L 09-M	C3-SSKCR/L-11065-09 C3-SSKCR/L-13075-09 C4-SSKCR/L-13080-09 C5-SSKCR/L-13080-09	5513 020-09 (M3,5)	-		
	C3-SSKCR/L-17090-09 C4-SSKCR/L-17090-09	5513 020-10 (M3,5)	-		
S25T-SSKCR/L 12	C5-SSKCR/L-17090-12 C3-SSKCR/L-22064-12 C4-SSKCR/L-22110-12 C5-SSKCR/L-22110-12	5513 020-17 (M4×0,5)	-		
S32U-SSKCR/L 12	C4-SSKCR/L-27080-12 C5-SSKCR/L-35100-12	5513 020-18 (M4×0,5)	5322 420-02		4,76




<sup>1)</sup> Optional parts must be ordered separately.

			<b>Optional parts</b>
Radius	3 Shim screw (thread)	4/5 Key (Torx Plus/mm)	Delivery to separate order 6 Screwdriver (Torx Plus)
-	-	5680 051-02 (7IP)	
		5680 051-02 (7IP)	5680 046-03 (7IP)
-	-	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
-	-	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
0,2-0,8	5512 090-01 (M5x0,5)	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
-	-	5680 049-02 (15IP/4,0)	5680 046-02 (15IP)
0,4-1,2	5512 090-03 (M6x0,75)	5680 049-02 (15IP/4,0)	5680 046-02 (15IP)
-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
-	-	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
-	-	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
0,4-0,8 1,2	5512 090-01 (M5x0,5/3,5)	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
-	-	5680 049-01 (15IP/3,5)	416.1-864 (T15)
-	-	5680 049-01 (15IP/3,5)	416.1-864 (T15)
-	-	5680 049-02 (15IP/4,0)	416.1-864 (T15)
0,4-1,2	5512 090-03 (M6x0,75)	5680 049-02 (15IP/4,0)	416.1-864 (T15)

Ordering example: 10 pieces 5513 020-03

**CoroTurn™ 107**  
screw clamp design



Tool type		Standard parts				
		Delivered with the tool				
		1	2			
Shank holders	Coromant Capto®	Insert screw (thread)	Shim	For insert thickness		
 A06F-STFCR/L 06-R E06H-STFCR/L 06-R S06H-STFCR/L 06		-	5513 020-28 (M2)	-	-	
A08H-STFCR/L 06-R E08K-STFCR/L 06-R S08K-STFCR/L 06		-	5513 020-27 (M2)	-	-	
A10K-STFCR/L 09-R A12M-STFCR/L 09-R E10M-STFCR/L 09-R E12Q-STFCR/L 09-R F10M-STFCR/L 09-R F12Q-STFCR/L 09-R S10K-STFCR/L 09 S12M-STFCR/L 09		-	5513 020-05 (M2,2)	-	-	
A12M-STFCR/L 11-B1 A16R-STFCR/L 11-B1 A20S-STFCR/L 11-B1 E16R-STFCR/L 11-R E16R-STFCR/L 11-RB1 S12M-STFCR/L 11 S16R-STFCR/L 11 S20S-STFCR/L 11		C3-STFCR/L-11065-11 C3-STFCR/L-13075-11 C4-STFCR/L-11070-11 C4-STFCR/L-13080-11 C5-STFCR/L-11070-11 C5-STFCR/L-13080-11	5513 020-03 (M2,5)	-	-	
S25T-STFCR/L 16-M		C3-STFCR/L-17090-16 C4-STFCR/L-17090-16 C5-STFCR/L-17090-16	5513 020-10 (M3,5)	-	-	
S32U-STFCR/L 16 S40V-STFCR/L 16		C4-STFCR/L-22110-16 C5-STFCR/L-22110-16	5513 020-01 (M3,5)	5322 320-01	3,97	
 35°						
A16R-SVUBR/L 11-EB1 A20S-SVUBR/L 11-EB1 A25T-SVUBR/L 11-DB1 S16R-SVUBR/L 11-E S20S-SVUBR/L 11-E S25T-SVUBR/L 11-D		-	5513 020-03 (M2,5)	-	-	
S25T-SVUBR/L 16-D		-	5513 020-10 (M3,5)	-	-	
S32U-SVUBR/L 16 S40V-SVUBR/L 16		-	5513 020-01 (M3,5)	5322 270-01 5322 270-02 <sup>1)</sup>	4,76 4,76	
A16R-SVQBR/L 11-EB1 A20S-SVQBR/L 11-EB1 A25T-SVQBR/L 11-EB1 S16R-SVQBR/L 11-E S20S-SVQBR/L 11-E S25T-SVQBR/L 11-D		C3-SVQBR/L-13070-11 C3-SVQBR/L-15080-11 C4-SVQBR/L-13070-11 C4-SVQBR/L-15080-11 C5-SVQBR/L-15080-11	5513 020-03 (M2,5)	-	-	
S25T-SVQBR/L 16-D		C3-SVQBR/L-18090-16 C4-SVQBR/L-18090-16 C5-SVQBR/L-18090-16	5513 020-10 (M3,5)	-	-	
S32U-SVQBR/L 16 S40V-SVQBR/L 16		C3-SVQBR/L-22064-16 C3-SVQBR/L-22096-16 C4-SVQBR/L-22110-16 C4-SVQBR/L-27080-16 C4-SVQBR/L-27120-16 C5-SVQBR/L-22110-16 C5-SVQBR/L-27140-16 C5-SVQBR/L-35100-16 C5-SVQBR/L-35150-16 C6-SVQBR/L-22120-16 C6-SVQBR/L-27145-16 C6-SVQBR/L-35175-16	5513 020-01 (M3,5)	5322 270-01 5322 270-02 <sup>1)</sup>	4,76 4,76	
<b>Coromant Capto® for vertical lathes</b>						
 Neg.						
C6-SRSCR/L 4506512D120		5513 020-01 (M3,5)	5322 110-02	4,76		

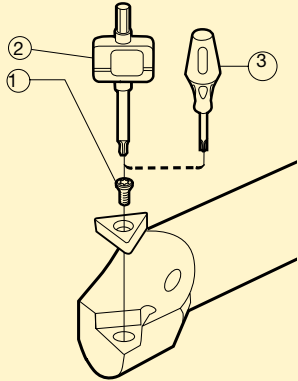
<sup>1)</sup> Optional parts must be ordered separately.

			<b>Optional parts</b>
Radius	3 Shim screw (thread)	4/5 Key (Torx Plus/ mm)	Delivery to separate order 6 Screwdriver (Torx Plus)
-	-	5680 051-01 (6IP)	-
-	-	5680 051-01 (6IP)	-
-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
-	-	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
0,4-1,2	5512 090-01 (M5x0,5)	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
-	-	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
0,4-0,8 1,2	5512 090-01 (M5x0,5)	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
-	-	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
0,4-0,8 1,2	5512 090-01 (M5x0,5)	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
-	5512 090-01 (M5x0,5/3,5)	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)

Ordering example: 10 pieces 5513 020-28

**CoroTurn™ 111 screw clamp design**

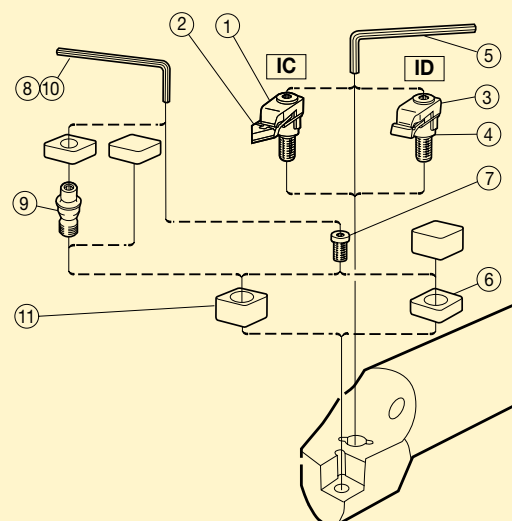
**A**



Tool type	Standard parts		Optional parts
	Delivered with the tool		Delivery to separate order
	1	2	3
Boring bars	Insert screw (thread)	Key (Torx Plus)	Screwdriver (Torx Plus)
<p>80°</p> <p>A08K-SCLPR/L 06 A10K-SCLPR/L 06 A08K-SCLPR/L 06-R A10K-SCLPR/L 06-R E08K-SCLPR/L 06-R E10M-SCLPR/L 06-R</p>	5513 020-21 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A12M-SCLPR/L 06 A12M-SCLPR/L 06-R E12Q-SCLPR/L 06-R</p>	5513 020-46 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>55°</p> <p>A10K-SDUPR/L 07-E A10K-SDUPR/L 07-ER E10M-SDUPR/L 07-ER F10M-SDUPR/L 07-ER</p>	5513 020-48 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A12M-SDUPR/L 07-E A12M-SDUPR/L 07-ER A16R-SDUPR/L 07 A16R-SDUPR/L 07-R A16R-SDUPR/L 07-ERX A16R-SDUPR/L 07-EX E12Q-SDUPR/L 07-ER E16R-SDUPR/L 07-R E16R-SDUPR/L 07-ERX F12Q-SDUPR/L 07-ER</p>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A20S-SDUPR/L 11 A20S-SDUPR/L 11-R A25T-SDUPR/L 11</p>	5513 020-09 (M3,5)	5680 049-01 (15IP)	5680 046-02 (15IP)
<p>A16R-SDXPR/L 07-E A16R-SDXPR/L 07-ER</p>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A06H-STFPR/L 06 A06F-STFPR/L 06-R E06H-STFPR/L 06-R</p>	5513 020-44 (M2,0)	5680 051-01 (6IP)	–
<p>A08K-STFPR/L 06 A08H-STFPR/L 06-R E08K-STFPR/L 06-R</p>	5513 020-28 (M2,0)	5680 051-01 (6IP)	–
<p>A10K-STFPR/L 09 A10K-STFPR/L 09-R A12M-STFPR/L 09 A12M-STFPR/L 09-R E10M-STFPR/L 09-R E12Q-STFPR/L 09-R F10M-STFPR/L 09-R F12Q-STFPR/L 09-R</p>	5513 020-47 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A12M-STFPR/L 11 A12M-STFPR/L 11-R E12Q-STFPR/L 11-R</p>	5513 020-48 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A16R-STFPR/L 11 A16R-STFPR/L 11-R E16R-STFPR/L 11-R</p>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A20S-STFPR/L 16 A20S-STFPR/L 16-R</p>	5513 020-09 (M3,5)	5680 049-01 (15IP)	5680 046-02 (15IP)
<p>A25S-STFPR/L 16</p>	5513 020-10 (M3,5)	5680 049-01 (15IP)	5680 046-02 (15IP)
<p>35°</p> <p>A16R-SVUCR/L 11-E A16R-SVUCR/L 11-ER E16R-SVUCR/L 11-ER</p>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A16R-SVQCR/L 11-E A16R-SVQCR/L 11-ER E16R-SVQCR/L 11-ER</p>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A05F-SWLPR/L 02-R E05H-SWLPR/L 02-R</p>	5513 020-53 (M2,0)	5680 051-01 (6IP)	–
<p>A06F-SWLPR/L 02 A06F-SWLPR/L 02-R A08H-SWLPR/L 02 A08H-SWLPR/L 02-R E06H-SWLPR/L 02-R E08K-SWLPR/L 02-R</p>	5513 020-44 (M2,0)	5680 051-01 (6IP)	–
<p>A10K-SWLPR/L 04 A10K-SWLPR/L 04-R E10M-SWLPR/L 04-R</p>	5513 020-21 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<p>A12M-SWLPR/L 04 A12M-SWLPR/L 04-R E12Q-SWLPR/L 04-R</p>	5513 020-46 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)

Ordering example: 10 pieces 5513 020-03

## T-MAX top clamp design for ceramic inserts



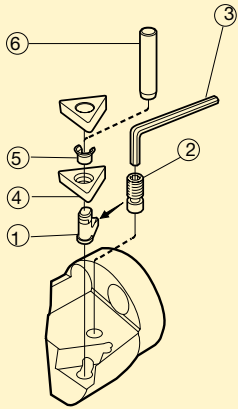
Tool type	Standard parts						
	Delivered with the tool						
Round shank tool	1	2	3	4	5		
	Clamp (IC)	Chipbreaker (IC) Right hand	Neutral	Left hand	Clamp (ID)	Pressure plate (ID)	Key (mm)
80°							
<b>S40T-CCLNR/L 12-IC</b> <b>S50U-CCLNR/L 12-IC</b>	5412 125-02	-	5192 022-04	-	-	-	3021 010-040 (4,0)
<b>S25T-CRSPR/L 09-ID</b>	-	-	-	-	5412 127-01	-	3021 010-040 (4,0)
<b>S40T-CRSNR/L 12-ID</b>	-	-	-	-	5412 125-01	5192 020-01	3021 010-040 (4,0)
<b>S40T-CSKNR/L 12-IC</b>	5412 125-02	5192 022-06	-	5192 022-05	-	-	3021 010-040 (4,0)

	Standard parts			Optional parts				
	Delivered with the tool			Delivery to separate order				
	6	7	8	3	4	9	11	10
	Shim (For insert thickness)	Shim screw	Key (Torx Plus)	Clamp (ID)	Pressure plate (ID)	Centre pin (IP)	Shim (For insert thickness)	Key (mm)
<b>S40T-CCLNR/L 12-IC</b> <b>S50U-CCLNR/L 12-IC</b>	5322 233-01	5513 013-02 (20IP)	5680 043-14	5412 125-02	5192 020-01	5313 032-02	5322 233-02 (2,5)	174.1-863 (2,5)
<b>S25T-CRSPR/L 09-ID</b>	-	-	-	-	-	-	-	-
<b>S40T-CRSNR/L 12-ID</b>	5322 141-01 (7,97)	5513 013-02	5680 043-14 (20IP)	-	-	5313 032-02	5322 141-02 (4,76)	174.1-863 (2,5)
<b>S40T-CSKNR/L 12-IC</b>	5322 421-01 (7,97)	5513 013-02	5680 043-14 (20IP)	5412 125-02	5192 020-01	5313 032-02	5322 421-02 (4,76)	174.1-863 (2,5)

Ordering example: 10 pieces 5412 125-02



**T-MAX P lever design**

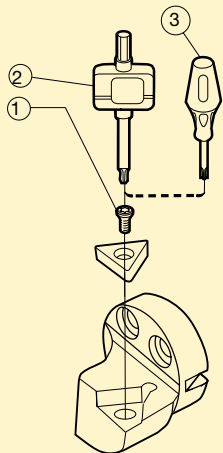


Tool type	Standard parts					
	Delivered with the tool					
Cutting heads	1	2	3	4	5	6
	Lever	Screw	Key (mm)	Shim	For insert Thickness (radius)	Shim pin Shim pin punch
80°						
<b>R/L 571.31C -323222-12</b>	174.3-848M	174.3-858	174.1-864 (3,0)	171.31-850M	4,76 (0,4 – 1,6)	174.3-861 174.3-871
<b>R/L 571.31C -403227-12</b>	174.3-841M	174.3-821	174.1-864 (3,0)	171.31-850M	4,76 (0,4 – 1,6)	174.3-861 174.3-871
<b>R/L 571.31C -504035-16 -604043-16</b>	438.3-840	438.3-831	174.1-864 (3,0)	171.31-852	6,35 (0,4 – 2,4)	174.3-864 174.3-873
55°						
<b>R/L 571.35C -403227-15 -504035-15 -604043-15</b>	174.3-847M	174.3-830	174.1-864 (3,0)	171.35-851M	6,35 (0,4-0,8)	174.3-861 174.3-871

Ordering example: 10 pieces 174.3-848M

Cutting heads	Optional parts	
	Delivery to separate order	
	4	For insert Thickness (Radius)
<b>R/L 571.35C -403227-15 -504035-15 -604043-15</b>	Shim	Thickness (Radius)
	171.35-850M	6,35 (1,2 – 1,6)
	171.35-856	4,76 (0,4 – 0,8)
	171.35-855	4,76 (1,2 – 1,6)

**CoroTurn™ 111 screw clamp design**

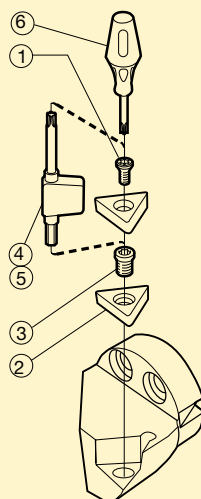





Tool type	Standard parts		Optional parts
	Delivered with the tool		
Cutting heads	1	2	3
	Insert screw (thread)	Key (Torx Plus)	Screwdriver (Torx Plus)
80°			
<b>570-SCLPR/L-16-06</b>	5513 020-46 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
55°			
<b>570-SDUPR/L-16-07</b> <b>570-SDUPR/L-20-07</b>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<b>570-SDUPR/L-25-11</b>	5513 020-09 (M3,5)	5680 049-01 (15IP)	
<b>570-SDXPR/L-16-07-E</b> <b>570-SDXPR/L-20-07-E</b> <b>570-SDXPR/L-25-07-E</b>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<b>570-SDXPR/L-16-07-EX</b> <b>570-SDXPR/L-20-07-EX</b> <b>570-SDXPR/L-25-07-EX</b>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
570-STFPR/L-16-11 <b>570-STFPR/L-20-11</b> <b>570-STFPR/L-25-11</b>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<b>570-SVQPR/L-20-11-E</b> <b>570-SVQPR/L-25-11-D</b>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<b>570-SVUPR/L-20-11-E</b> <b>570-SVUPR/L-25-11-D</b>	5513 020-03 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)
<b>570-SWLPR/L-16-04</b>	5513 020-46 (M2,5)	5680 051-02 (7IP)	5680 046-03 (7IP)

1) Optional parts must be ordered separately.

Ordering example: 10 pieces 5513 020-03

## CoroTurn™ 107 screw clamp design

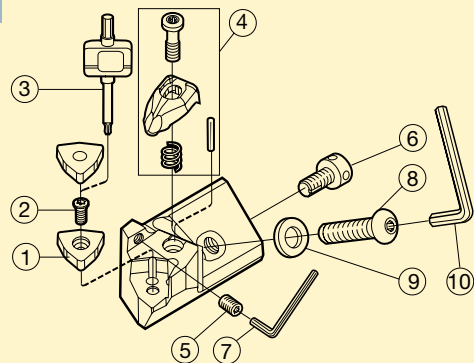


Tool type	Standard parts				Optional parts	
	Delivered with the tool				Delivery to separate order	
Cutting heads	1 Insert screw (thread)	2 Shim	3 For insert thickness (radius)	4/5 Shim screw (thread)	Key (Torx Plus/mm)	6 Screwdriver (Torx Plus)
 80°						
R/L571.01C-162011-06	5513 020-03 (M2,5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
R/L571.01C-202013-09	5513 020-09 (M3,55)	–	–	–	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
R/L571.01C-252017-09	5513 020-10 (M3,5)	–	–	–	5680 049-01 (15IP/3,5)	5680 046-02 (T15)
 55°						
R/L571.05C-162011-07 R/L571.05C-161513-07X R/L571.05C-201515-07X R/L571.05C-251518-07X R/L576.05C-161513-07 R/L576.05C-201515-07 R/L576.05C-251518-07	5513 020-03 (M2,5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
R/L571.05C-202013-11	5513 020-09 (M3,5)	–	–	–	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
R/L571.05C-252017-11	5513 020-10 (M3,5)	–	–	–	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
R/L571.05C-323222-11 R/L571.05C-322022-11X R/L571.05C-402027-11X	5513 020-01 (M3,5/)	5322 263-01 5322 263-02 <sup>1)</sup>	3,97 (0,4-0,8) 3,97 (1,2)	5512 090-01	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
R/L571.05C-503035-11X R/L571.05C-603043-11X	5513 020-01 (M3,5)	5322 263-01 5322 263-02 <sup>1)</sup>	3,97 (0,4-0,8) 3,97 (1,2)	5512 090-01	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
R/L576.05C-322022-11	5513 020-01 (M3,5)	5322 263-01 5322 263-02 <sup>1)</sup>	3,97 (0,4-0,8) 3,97 (1,2)	5512 090-01	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
R/L576.05C-402027-11	5513 020-01 (M3,5)	5322 263-01 5322 263-02 <sup>1)</sup>	3,97 (0,4-0,8) 3,97 (1,2)	5512 090-01	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
R/L576.05C-503035-11 R/L576.05C-603043-11	5513 020-01 (M3,5)	5322 263-01 5322 263-02 <sup>1)</sup>	3,97 (0,4-0,8) 3,97 (1,2)	5512 090-01	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
						
R/L579.0C-162011-09	5513 020-05 (M2,2)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
R/L579.0C-162011-11-B1 R/L579.0C-202013-11 R/L579.0C-202013-11-B1 R/L579.0C-252017-11 R/L579.0C-252017-11-B1	5513 020-03 (M2,5)	–	–	–	5680 051-02 (7IP)	5680 046-03 (7IP)
R/L579.0C-323222-16	5513 020-01 (M3,5)	5322 320-01	3,97 (0,4-1,2)	5512 090-01 (M5x0,5/3,5)	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
R/L579.0C-403227-16	5513 020-01 (M3,5)	5322 320-01	3,97 (0,4-1,2)	5512 090-01 (M5x0,5/3,5)	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)
R/L579.0C-504035-16 R/L579.0C-604043-16	5513 020-01 (M3,5)	5322 320-01	3,97 (0,4-1,2)	5512 090-01 (M5x0,5/3,5)	5680 049-01 (15IP/3,5)	5680 046-02 (15IP)

<sup>1)</sup> Optional parts must be ordered separately.

Ordering example: 10 pieces 5513 020-03

## CoroTurn™ RC rigid clamp design



Tool type	Standard parts		
	Delivered with the tool		
	1	2	3
<b>Shank holders</b>	Shim screw	Shim	Key (Torx Plus)
80°			
<b>DCLNR/L 25CA-12</b>	5513 020-02	5322 234-01	5680 049-01 (15IP)
<b>DCLNR/L 25CA-16</b>	5513 020-07	5322 234-03	5680 043-14 (20IP)
<b>DSKNR/L 25CA-12</b>	5513 020-02	5322 425-01	5680 049-01 (15IP)
<b>DTFNR/L 16CA-16</b>	5513 020-04	5322 316-01	5680 051-03 (9IP)
<b>DWLNRL 20CA-08</b>	5513 020-02	5322 331-12	5680 049-01 (15IP)

## Setting and clamping

CoroTurn RC,  
ISO cartridges

Cartridge	Standard parts					Optional parts
	Delivered with the tool					
	5	6	7	8	9	
	Adjusting screws		Key (mm)	Mounting screw	Washer	10 Key (mm)
	Axial	Radial				
<b>DCLNR/L 25CA-12</b>	3214 010-305	5519 095-03	174.1-863 (2,5)	434.9-822	3411 010-105	3021 010-060 (6,0)
<b>DCLNR/L 25CA-16</b>	3214 010-305	5519 095-03	174.1-863 (2,5)	434.9-822	3411 010-105	3021 010-060 (6,0)
<b>DSKNR/L 25CA-12</b>	3214 010-305	5519 095-03	174.1-863 (2,5)	434.9-822	3411 010-105	3021 010-060 (6,0)
<b>DTFNR/L 16CA-16</b>	438.3-820	5519 095-02	174.1-870 (1,98)	434.9-830	3411 011-084	3021 010-050 (5,0)
<b>DWLNRL 20CA-08</b>	3214 010-305	5519 095-01	174.1-863 (2,5)	434.9-830	3411 011-084	3021 010-050 (5,0)

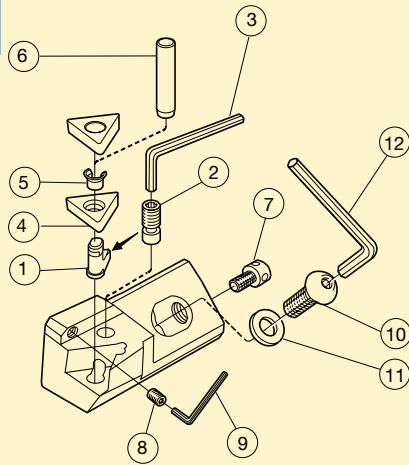
Ordering example: 10 pieces 3214 010-305

4	<b>Optional parts</b>			
	Delivery to separate order			
Complete clamp set <sup>1)</sup>	4	4	2	
	Clamp sets for ceramic inserts without hole <sup>1)</sup>	Clamp sets for ceramic inserts with hole <sup>1)</sup>	Shim	For insert thickness
5412 028-021	5412 032-021	5412 034-021	5322 234-02	7,97
5412 028-031	5412 032-031	5412 034-031	5322 234-04	7,97
5412 028-021	5412 032-021	5412 034-021	5322 425-02	7,97
5412 028-011	-	-	-	
5412 028-021	-	-	-	

<sup>1)</sup> For clamp set parts, see pages A 236-A 237.

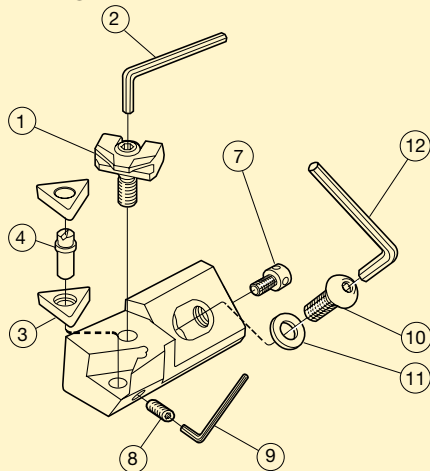
**Ordering example: 10 pieces 5513 020-02**

### T-MAX P lever design



Tool type	Standard parts				For insert Thickness (Radius)
	1	2	3	4	
<b>Cartridge</b>	Lever	Screw	Key (mm)	Shim	
80°					
<b>PCLNR/L 16CA-12</b>	174.3-848M	174.3-858	174.1-864 (3,0)	171.31-850M	4,76 (0,4 – 1,6)
<b>PCLNR/L 25CA-19</b>	174.3-849M	174.3-835	3021 010-040 (4,0)	171.31-851M	6,35 (0,4 – 2,4)
<b>PCFNR/L 16CA-12</b>	174.3-848M	174.3-858	174.1-864 (3,0)	171.31-850M	4,76 (0,4 – 1,6)
<b>PCGNR/L 16CA-12</b>	174.3-848M	174.3-858	174.1-864 (3,0)	171.31-850M	4,76 (0,4 – 1,6)
<b>PSKNR/L 12CA-12</b>	438.3-841-1	438.3-832M	174.1-863 (2,5)	-	-
<b>PSKNR/L 16CA-12</b>	174.3-848M	174.3-858	174.1-864 (3,0)	174.3-851M	4,76 (0,4 – 1,2)
<b>PSKNR/L 20CA-15</b>	438.3-840	438.3-831	174.1-864 (3,0)	174.3-857	6,35 (0,4 – 2,4)
<b>PSSNR/L 12CA-12</b>	438.3-841-1	438.3-832M	174.1-863 (2,5)	-	-
<b>PSSNR/L 16CA-12</b>	174.3-848M	174.3-858	174.1-864 (3,0)	174.3-851M	4,76 (0,4 – 1,2)
<b>PSSNR/L 20CA-15</b>	438.3-840	438.3-831	174.1-864 (3,0)	174.3-857	6,35 (0,4 – 2,4)
<b>PSRNR/L 16CA-12</b>	174.3-848M	174.3-858	174.1-864 (3,0)	174.3-851M	4,76 (0,4 – 1,2)
<b>PSRNR/L 20CA-15</b>	438.3-840	438.3-831	174.1-864 (3,0)	174.3-857	6,35 (0,4 – 2,4)
<b>PTFNR/L 12CA-16</b>	5432 015-011	438.3-830	174.1-870 (1,98)	-	-
<b>PTFNR/L 16CA-16</b>	174.3-840M	174.3-820M	170.3-860 (2,5)	179.3-850M	4,76 (0,4 – 0,8)
<b>PTFNR/L 20CA-22</b>	174.3-841M	174.3-821	174.1-864 (3,0)	179.3-852M	4,76 (1,2 – 1,6)
<b>PTWNR/L 12CA-16</b>	5432 015-011	438.3-830	174.1-870 (1,98)	-	-
<b>PTSNR/L 12CA-16</b>	5432 015-011	438.3-830	174.1-870 (1,98)	-	-
<b>PTSNR/L 16CA-16</b>	174.3-840M	174.3-820M	170.3-860 (2,5)	179.3-850M	4,76 (0,4 – 0,8)
<b>PTSNR/L 20CA-22</b>	174.3-841M	174.3-821	174.1-864 (3,0)	179.3-852M	4,76 (1,2 – 1,6)
<b>PTTNR/L 12CA-16</b>	5432 015-011	438.3-830	174.1-870 (1,98)	-	-
<b>PTGNR/L 12CA-16</b>	5432 015-011	438.3-830	174.1-870 (1,98)	-	-
<b>PTGNR/L 16CA-16</b>	174.3-840M	174.3-820M	170.3-860 (2,5)	179.3-850M	4,76 (0,4 – 0,8)
<b>PTGNR/L 20CA-22</b>	174.3-841M	174.3-821	174.1-864 (3,0)	179.3-852M	4,76 (1,2 – 1,6)

### T-MAX P wedge clamp design



Tool type and size	Standard parts			For insert Thickness (Radius)
	1	2	3	
<b>Cartridge</b>	Wedge clamp set	Key (mm)	Shim	
80°				
<b>MWLNRL 16CA-06</b>	5431 125-011	170.3-860 (2,5)	5322 331-06	- -
<b>MWLNRL 25CA-08</b>	5431 125-021	174.1-864 (3,0)	5322 331-09	4,76 (0,4 – 0,8)

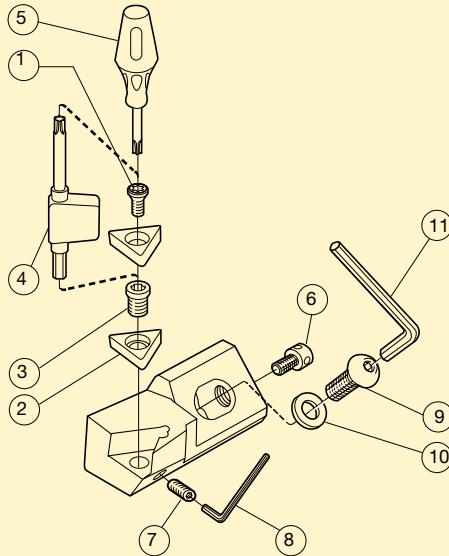
				Setting and clamping					
5	6	Optional parts		Standard parts					Optional parts
		Delivery to separate order		7	8	9	10	11	12
Shim pin	Shim pin punch	Shim	For insert Thickness (Radius)	Adjusting screws Axial	Adjusting screws Radial	Key (mm)	Mounting screw	Washer	Key (mm)
174.3-861	174.3-871	–	–	438.3-828	438.3-821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
174.3-868	174.3-872	–	–	438.3-825	438.3-822	174.1-864 (3,0)	434.9-822	3411 010-105	3021 010-060 (6,0)
174.3-861	174.3-871	–	–	438.3-828	438.3-821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
174.3-861	174.3-871	–	–	438.3-828	438.3-821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
–	–	–	–	438.3-824	438.820	174.1-870 (1,98)	434.9-824	3411 011-064	3021 010-040 (4,0)
174.3-861	174.3-871	174.3-856	4,76 (1,6 – 2,4)	438.3-828	438.3-821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
174.3-864	174.3-873	–	–	438.3-839	438.3-821	174.1-863 (2,5)	434.9-830	3411 011-084	3021 010-050 (5,0)
–	–	–	–	438.3-824	438.820	174.1-870 (1,98)	434.9-824	3411 011-064	3021 010-040 (4,0)
174.3-861	174.3-871	174.3-856	4,76 (1,6 – 2,4)	438.3-828	438.3-821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
174.3-864	174.3-873	–	–	438.3-839	438.3-821	174.1-863 (2,5)	434.9-830	3411 011-084	3021 010-050 (5,0)
174.3-861	174.3-871	174.3-856	4,76 (1,6 – 2,4)	438.3-828	438.3-821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
174.3-864	174.3-873	–	–	438.3-839	438.3-821	174.1-863 (2,5)	434.9-830	3411 011-084	3021 010-050 (5,0)
–	–	–	–	438.3-824	438.820	174.1-870 (1,98)	434.9-824	3411 011-064	3021 010-040 (4,0)
174.3-860	174.3-870	179.3-858	4,76 (1,2 – 1,6)	438.3-828	438.3-821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
174.3-861	174.3-871	179.3-853M	4,76 (0,4 – 0,8)	438.3-839	438.3-821	174.1-863 (2,5)	434.9-830	3411 011-084	3021 010-050 (5,0)
–	–	–	–	438.3-824	438.820	174.1-870 (1,98)	434.9-824	3411 011-064	3021 010-040 (4,0)
–	–	–	–	438.3-824	438.820	174.1-870 (1,98)	434.9-824	3411 011-064	3021 010-040 (4,0)
174.3-860	174.3-870	179.3-858	4,76 (1,2 – 1,6)	438.3-828	438.3-821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
174.3-861	174.3-871	179.3-853M	4,76 (0,4 – 0,8)	438.3-839	438.3-821	174.1-863 (2,5)	434.9-830	3411 011-084	3021 010-050 (5,0)
–	–	–	–	438.3-824	438.820	174.1-870 (1,98)	434.9-824	3411 011-064	3021 010-040 (4,0)
–	–	–	–	438.3-824	438.820	174.1-870 (1,98)	434.9-824	3411 011-064	3021 010-040 (4,0)
174.3-860	174.3-870	179.3-858	4,76 (1,2 – 1,6)	438.3-828	438.3-821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
174.3-861	174.3-871	179.3-853M	4,76 (0,4 – 0,8)	438.3-839	438.3-821	174.1-863 (2,5)	434.9-830	3411 011-084	3021 010-050 (5,0)

Ordering example: 10 pieces 174.3-848M

				Setting and clamping					
4	Optional parts		Standard parts					Optional parts	
	Delivery to separate order		7	8	9	10	11	12	
Pin	Shim	For insert Thickness (Radius)	Adjusting screws Axial	Adjusting screws Radial	Key (mm)	Mounting screw	Washer	Key (mm)	
5313 022-01	–	–	438.3-828	434.9-836	174.1-870 (1,98)	434.9-830	3411-011-084	3021 010-050 (5,0)	
5313 022-03	5322 331-10	4,76 (1,2 – 1,6)	438.3-825	434.9-838	174.1-864 (3,0)	434.9-822	3411 010-105	3021 010-060 (6,0)	

Ordering example: 10 pieces 5431 125-011

**CoroTurn™ 107 screw clamp design**



Spare parts for setting and clamping, see next page.

Tool type	Standard parts Delivered with the tool						Optional parts Delivery to separate order
	1	2	3		4	5	
Cartridge	Insert screw (Thread)	Shim	For insert Thickness	Radius	Shim screw	Key (Torx Plus)	Screw driver (Torx Plus)
●	<b>SRSCR/L 06CA-06</b>	5513 020-03 (M2,5)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>08CA-08</b>	5513 020-04 (M3,0)	-	-	-	5680 051-03 (9IP)	5680 046-04 (9IP)
	<b>10CA-10</b>	5513 020-09 (M3,5)	5322 110-01	3,97	-	5512 090-01	5680 049-01 (15IP)
■	<b>SSKCR/L 10CA-09-M</b>	5513 020-09 (M3,5)	-	-	-	5680 049-01 (15IP)	5680 046-02 (15IP)
	<b>12CA-12</b>	5513 020-17 (M4x0,5)	-	-	-	5680 049-02 (15IP)	5680 046-02 (15IP)
	<b>16CA-12</b>	5513 020-18 (M4x0,5)	5322 420-02	4,76	0,4 – 1,2	5512 090-03	5680 049-02 (15IP)
■	<b>SSSCR/L 10CA-09-M</b>	5513 020-09 (M3,5)	-	-	-	5680 049-01 (15IP)	5680 046-02 (15IP)
	<b>12CA-12</b>	5513 020-17 (M4x0,5)	-	-	-	5680 049-02 (15IP)	5680 046-02 (15IP)
▲	<b>STFCR/L 06CA-06</b>	5513 020-27 (M2)	-	-	-	5680 051-01 (6IP)	-
	<b>08CA-09</b>	5513 020-05 (M2,2)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>10CA-11</b>	5513 020-03 (M2,5)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>12CA-16-M</b>	5513 020-10 (M3,5)	-	-	-	5680 049-01 (15IP)	5680 046-02 (15IP)
	<b>16CA-16</b>	5513 020-01 (M3,5)	5322 320-01	3,97	0,4 – 1,2	5512 090-01	5680 049-01 (15IP)
■	<b>STGCR/L 06CA-06</b>	5513 020-27 (M2)	-	-	-	5680 051-01 (6IP)	-
	<b>08CA-09</b>	5513 020-05 (M2,2)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>10CA-11</b>	5513 020-03 (M2,5)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>12CA-16-M</b>	5513 020-10 (M3,5)	-	-	-	5680 049-01 (15IP)	5680 046-02 (15IP)
	<b>16CA-16</b>	5513 020-01 (M3,5)	5322 320-01	3,97	0,4 – 1,2	5512 090-01	5680 049-01 (15IP)
■	<b>STWCR/L 06CA-06</b>	5513 020-27 (M2)	-	-	-	5680 051-01 (6IP)	-
	<b>08CA-09</b>	5513 020-05 (M2,2)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>10CA-11</b>	5513 020-03 (M2,5)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>12CA-16-M</b>	5513 020-10 (M3,5)	-	-	-	5680 049-01 (15IP)	5680 046-02 (15IP)
■	<b>STSCR/L 06CA-06</b>	5513 020-27 (M2)	-	-	-	5680 051-01 (6IP)	-
	<b>08CA-09</b>	5513 020-05 (M2,2)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>10CA-11</b>	5513 020-03 (M2,5)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>12CA-16-M</b>	5513 020-10 (M3,5)	-	-	-	5680 049-01 (15IP)	5680 046-02 (15IP)
	<b>16CA-16</b>	5513 020-01 (M3,5)	5322 320-01	3,97	0,4 – 1,2	5512 090-01	5680 049-01 (15IP)
■	<b>STTCR/L 06CA-06</b>	5513 020-27 (M2)	-	-	-	5680 051-01 (6IP)	-
	<b>08CA-09</b>	5513 020-05 (M2,2)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>10CA-11</b>	5513 020-03 (M2,5)	-	-	-	5680 051-02 (7IP)	5680 046-03 (7IP)
	<b>12CA-16-M</b>	5513 020-10 (M3,5)	-	-	-	5680 049-01 (15IP)	5680 046-02 (15IP)
	<b>16CA-16</b>	5513 020-01 (M3,5)	5322 320-01	3,97	0,4 – 1,2	5512 090-01	5680 049-01 (15IP)

Ordering example: 10 pieces 5513 020-03

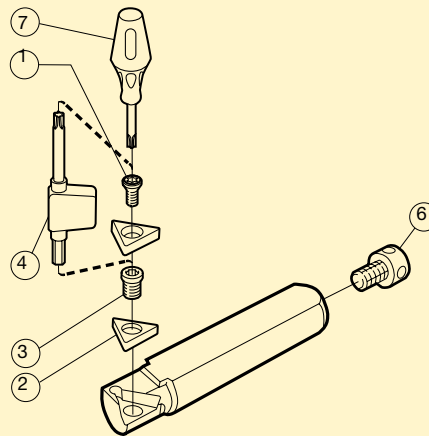
## Setting and clamping

CoroTurn 107, ISO cartridges

Cartridge size	Standard parts Delivered with the tool						Optional parts
	6	7	8	9	10	11	
	Adjusting screws		Key (mm)	Mounting screw	Washer	Key (Torx Plus)	Key (mm)
CoroTurn 107	Axial	Radial					
<b>06 CA</b>	5512 050-01	3214 010-203	3021 010-015 (1,5)	5512 031-04	-	5680 043-08 (T8)	-
<b>08 CA</b>	5512 050-02	3214 010-203	3021 010-015 (1,5)	5512 031-03	-	5680 043-09 (T15)	-
<b>10 CA</b>	438.3-824	434.9-835	174.1-870 (1,98)	434.9-826	170.38-834	-	3021 010-040 (4,0)
<b>12 CA</b>	438.3-824	434.9-836	174.1-870 (1,98)	434.9-824	3411 011-064	-	3021 010-040 (4,0)
<b>16 CA</b>	438.3-828	434.9-836	174.1-870 (1,98)	434.9-830	3411 011-084	-	3021 010-050 (5,0)

Ordering example: 10 pieces 5512 050-01

## CoroTurn™ 107 round shank boring tools



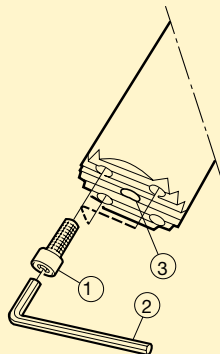
Tool type	Standard parts Delivered with the tool							Optional parts Delivery to separate order
	1	2	3		4	6	7	
Round shank tool	Insert screw (Thread)	Shim	For insert Thickness	Radius	Shim screw	Key (Torx Plus)	Length adjusting screw	Screw driver (Torx Plus)
<b>▲ R/L 140.0-8-06</b>	5513 020-27 (M2)	-	-	-	-	5680 051-01 (6IP)	-	-
10-09	5513 020-05 (M2,2)	-	-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
12-11	5513 020-03 (M2,5)	-	-	-	-	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
16-11	5513 020-03 (M2,5)	-	-	-	-	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
20-16	5513 020-01 (M3,5)	5322 320-01	3,97	0,4 – 1,2	5512 090-01	5680 049-01 (15IP)	438.3-825	5680 046-02 (15IP)
<b>R/L 141.0-8-06</b>	5513 020-27 (M2)	-	-	-	-	5680 051-01 (6IP)	-	-
10-09	5513 020-05 (M2,2)	-	-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
12-11	5513 020-03 (M2,5)	-	-	-	-	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
16-11	5513 020-03 (M2,5)	-	-	-	-	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
20-16	5513 020-01 (M3,5)	5322 320-01	3,97	0,4 – 1,2	5512 090-01	5680 049-01 (15IP)	438.3-825	5680 046-02 (15IP)
<b>R/L 142.0-8-06</b>	5513 020-27 (M2)	-	-	-	-	5680 051-01 (6IP)	-	-
10-09	5513 020-05 (M2,2)	-	-	-	-	5680 051-02 (7IP)	-	5680 046-03 (7IP)
12-11	5513 020-03 (M2,5)	-	-	-	-	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
16-11	5513 020-03 (M2,5)	-	-	-	-	5680 051-02 (7IP)	438.3-824	5680 046-03 (7IP)
20-16	5513 020-01 (M3,5)	5322 320-01	3,97	0,4 – 1,2	5512 090-01	5680 049-01 (15IP)	438.3-825	5680 046-02 (15IP)

Ordering example: 10 pieces 5513 020-27



**Bars type 570-2C and 570-3C**






**A**



Tool type		Standard parts		
		Delivered with the tool	1	2
Shank holders	Coromant Capto®	Screw	Key (mm)	O-ring
		570-2C 16 105	C3-570-2C 16 045 C4-570-2C 16 048	3212 030-301
570-2C 20 140	C3-570-2C 20 050 C4-570-2C 20 058 C5-570-2C 20 059	3212 030-351	3021 011-764 (2,78)	–
570-2C 25 200	C3-570-2C 25 064 C4-570-2C 25 064 C5-570-2C 25 067	3212 010-258	174.1-864 (3,0)	–
570-2C 32 218	C3-570-2C 32 053 C4-570-2C 32 074 C5-570-2C 32 075 C6-570-2C 32 081	3212 010-308	3021 010-040 (4,0)	3671 010-113
570-2C 40 283	C4-570-2C 40 073 C5-570-2C 40 094 C6-570-2C 40 092 C8-570-2C 40 105	3212 010-358	3021 010-050 (5,0)	3671 010-113
570-2C 50 360	C5-570-2C 50 090 C6-570-2C 50 114 C8-570-2C 50 115	3212 010-409	3021 010-060 (6,0)	3671 010-115
570-2C 60 460	C6-570-2C 60 137 C8-570-2C 60 140	3212 010-409	3021 010-060 (6,0)	3671 010-119
570-3C 16 156 570-3C 16 204 CR	C3-570-3C 16 082 C4-570-3C 16 088	3212 030-301	265.2-818 (2,38)	–
570-3C 20 200 570-3C 20 260 CR	C3-570-3C 20 101 C4-570-3C 20 107 C5-570-3C 20 109	3212 030-351	3021 011-764 (2,78)	–
570-3C 25 255 570-3C 25 330	C3-570-3C 25 125 C4-570-3C 25 132 C5-570-3C 25 133	3212 010-258	174.1-864 (3,0)	–
570-3C 32 320 570-3C 32 416	C3-570-3C 32 133 C4-570-3C 32 154 C5-570-3C 32 154 C6-570-3C 32 159	3212 010-308	3021 010-040 (4,0)	3671 010-113
570-3C 40 408 570-3C 40 528	C4-570-3C 40 173 C5-570-3C 40 194 C6-570-3C 40 198	3212 010-358	3021 010-050 (5,0)	3671 010-113
570-3C 50 510 570-3C 50 660	C5-570-3C 50 215 C6-570-3C 50 239	3212 010-409	3021 010-060 (6,0)	3671 010-115
570-3C 60 620 570-3C 60 800	C6-570-3C 60 287	3212 010-409	3021 010-060 (6,0)	3671 010-119
<b>Coromant KM</b>				
KM40-570-2C 16048		3212 030-301	265.2-818 (2,38)	–
KM40-570-2C 20058		3212 030-351	3021 011-764 (2,78)	–
KM40-570-2C 25064		3212 010-258	174.1-864 (3,0)	–
KM40-570-2C 32074		3212 010-308	3021 010-040 (4,0)	3671 010-113
KM40-570-2C 40073		3212 010-358	3021 010-050 (5,0)	3671 010-113
KM50-570-2C 20059		3212 030-351	3021 011-764 (2,78)	–
KM50-570-2C 25067		3212 010-258	174.1-864 (3,0)	–
KM50-570-2C 32075		3212 010-308	3021 010-040 (4,0)	3671 010-113
KM50-570-2C 40094		3212 010-358	3021 010-050 (5,0)	3671 010-113
KM50-570-2C 50090		3212 010-409	3021 010-060 (6,0)	3671 010-115

Ordering example: 10 pieces 3212 030-301

**Cross reference list — Torx to Torx Plus** (For more information, see sektion K)

Type of key	Old Torx keys			New Torx Plus keys		Comments
	Torx size	Code	Torx designation	Code	Torx Plus designation	
T-keys 	15 10 20 20 25 25 30	5680 045-02 5680 045-06 5680 045-03 5680 045-01 5680 045-05 5680 045-04 5680 045-07	T15 T10 T20 T20 T25 T25 T30	<b>5680 048-01</b> <b>5680 048-02</b> <b>5680 048-03</b> <b>5680 048-04</b> <b>5680 048-05</b> <b>5680 048-06</b> <b>5680 048-07</b>	<b>15IP</b> <b>10IP</b> <b>20IP</b> <b>20IP</b> <b>25IP</b> <b>25IP</b> <b>30IP</b>	Length 53 mm Length 90 mm Length 70 mm Length 110 mm
Flag keys 	6 7 9 9 15 15	5680 041-02 5680 041-01 5680 016-03 170.3-865 5680 016-01 5680 016-02	T6 T7 T9 T9 T15 T15	<b>5680 051-01</b> <b>5680 051-02</b> <b>5680 049-03</b> <b>5680 051-03</b> <b>5680 049-01</b> <b>5680 049-02</b>	<b>6IP</b> <b>7IP</b> <b>9IP</b> <b>9IP</b> <b>15IP</b> <b>15IP</b>	Combination key – 9IP and hex 3,5 mm  Combination key – 15IP and hex 3,5 mm Combination key – 15IP and hex 4,0 mm
Drivers 	7 8 9 10 15 20 25 30	416.1-860 416.1-861 416.1-862 416.1-863 416.1-864 416.1-865 416.1-866 416.1-867	T7 T8 T9 T10 T15 T20 T25 T30	<b>5680 046-03</b> <b>5680 046-01</b> <b>5680 046-04</b> <b>5680 046-05</b> <b>5680 046-02</b> <b>5680 046-06</b> <b>5680 046-07</b> –	<b>7IP</b> <b>8IP</b> <b>9IP</b> <b>10IP</b> <b>15IP</b> <b>20IP</b> <b>25IP</b>	
L-keys 	8 9 10 15 20 25 27 30	5680 043-08 5680 043-01 5680 043-05 5680 043-09 5680 043-03 5680 043-04 5680 043-06 5680 043-07	T8 T9 T10 T15 T20 T25 T27 T30	<b>5680 043-10</b> <b>5680 043-11</b> <b>5680 043-12</b> <b>5680 043-13</b> <b>5680 043-14</b> <b>5680 043-15</b> <b>5680 043-16</b> <b>5680 043-17</b>	<b>8IP</b> <b>9IP</b> <b>10IP</b> <b>15IP</b> <b>20IP</b> <b>25IP</b> <b>27IP</b> <b>30IP</b>	
Bits 	7 8 9 10 15 – 20 – 25 30	5680 081-01 5680 081-02 5680 081-03 5680 081-04 5680 081-05 – 5680 081-06 – 5680 081-07 5680 081-08	T7 T8 T9 T10 T15 – T20 – T25 T30	<b>5680 084-04</b> <b>5680 084-01</b> <b>5680 084-05</b> <b>5680 084-06</b> <b>5680 084-02</b> <b>5680 084-03</b> <b>5680 084-07</b> <b>5680 084-08</b> <b>5680 084-09</b> <b>5680 084-10</b>	<b>7IP</b> <b>8IP</b> <b>9IP</b> <b>10IP</b> <b>15IP</b> <b>15IP</b> <b>20IP</b> <b>20IP</b> <b>25IP</b> <b>30IP</b>	Length 50 mm Length 50 mm Length 50 mm Length 50 mm Length 50 mm Length 89 mm Length 50 mm Length 89 mm Length 89 mm Length 89 mm
Bits set	7 – 25	5680 082-01	T7 – T25	–	–	

**Note!**

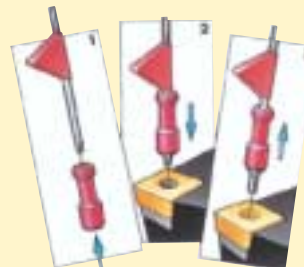
We want to point out to all our customers that the new Torx Plus keys and screwdrivers do NOT fit into the standard Torx screws.

However, the standard Torx keys and screw-drivers will fit the new Torx Plus screws.

**Magnetic sleeve for keys and screwdrivers**

Key/screwdriver size	
	 Magnetic sleeve
All sizes	5680 047-01

Ordering example: 10 pieces 5680 047-01

**Instructions for use of the magnetic sleeve**

Place the magnetic sleeve over the key.

Locate the key in the Torx-grip of the screw.

Press the magnet down towards the insert.

Unscrew, and both the screw and the insert (in most cases), will come out with the key.

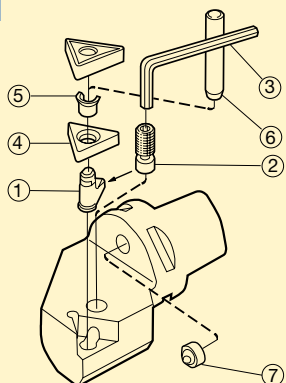
To be used for Torx keys of all sizes.

EXTERNAL		INTERNAL		
Tool code	Spare part Page	Tool code	Spare part Page	Setting and clamping Page
<b>T-MAX P wedge clamp</b>		<b>T-MAX bars type 570</b>		
MTJNR/L	A 284	570-2	A 292	
MTGNR/L	A 284	570-3	A 292	
MTENN	A 284			
R/L 170.38	A 284			
<b>T-MAX lever, for vertical lathes</b>		<b>Setting ring for boring bars</b>		
C6-PCLNR/L-4506512D120	A 284	470-	A 292	
C6-PCLNR/L-4506519D120	A 284			
C6-PCLNR/L-3506512D195	A 284			
C6-PDJNR/L-4506515D120	A 284			
C6-PDUNR/L-4506512D120	A 284			
C6-PRSCR/L-4506525D120	A 284			
C6-PSKNR/L-4506512D120	A 284			
C6-PSKNR/L-4506519D195	A 284			
C6-PSKNR/L-3506519D195	A 284			
C6-PTFNR/L-4506522D120	A 284			
C6-PTGNR/L-4506522D120	A 284			
<b>T-MAX S top clamp</b>		<b>T-MAX U cutting heads</b>		
CSDPR/L	A 286	R/L 479.0	A 283	A 291
CSDPN	A 286			
CSKPR/L	A 286			
CSRPR/L	A 286			
CSBPR/L	A 286			
CSSPR/L	A 286			
CSTPR/L	A 286			
CTBPR/L	A 286			
CTDPR/L	A 286			
CTFPR/L	A 286			
CTGPR/L	A 286			
CTSPR/L	A 286			
CTTPR/L	A 286			
177.9	A 286			
<b>T-MAX copying</b>		<b>T-MAX S cutting heads</b>		
CKJNR/L	A 288	R/L 474.9	A 286	A 286
R/L 171.5	A 288	R/L 477.9	A 286	A 286
R/L 170.5	A 288	R/L 479.9	A 286	A 286
<b>T-MAX top clamp</b>		<b>T-MAX copying cutting heads</b>		
R/L 174.1	A 288	R/L 471.5	A 288	A 291
R/L 174.2	A 288			
R/L 178.1	A 288			
R/L 172.1	A 288			
R/L 172.2	A 288			
R/L 173.4	A 288			
R/L 173.5	A 288			
R/L 175.1	A 288			
R/L 175.2	A 288			
R/L 179.1	A 288			
R/L 179.2	A 288			
R/L 177.1	A 288			
R/L 177.2	A 288			
<b>INTERNAL</b>		<b>BUILD-IN TOOLS</b>		
<b>T-MAX S top clamp</b>		<b>T-MAX S top clamp cartridges</b>		
CSKPR/L	A 286	CSKPR/L	A 286	A 286
CTFPR/L	A 286	CSSPR/L	A 286	A 286
CTKPR/L	A 286	CTFPR/L	A 286	A 286
R/L 131.9	A 286	CTGPR/L	A 286	A 286
R/L 136.9	A 286	CTSPR/L	A 286	A 286
		CTTPR/L	A 286	A 286
		CTWPR/L	A 286	A 286
<b>T-MAX copying</b>		<b>T-MAX AI top clamp cartridges</b>		
CKUNR/L	A 288	CSKER/L	A 286	A 286
		CSSER/L	A 286	A 286
		CTFER/L	A 286	A 286
		CTGER/L	A 286	A 286
		CTSER/L	A 286	A 286
		CTTER/L	A 286	A 286
		CTWER/L	A 286	A 286
<b>T-MAX bars type 470</b>		<b>T-MAX P copying cartridges</b>		
470-1	A 290	R/L 441.31	A 283	A 288
470-2	A 290	R/L 439.35	A 283	A 288
470-3	A 290	R/L 437.9	A 283	A 288
		R/L 439.38	A 283	A 288
		R/L 437.38	A 283	A 288
		<b>T-MAX and T-MAX S copying cartridges</b>		
		R/L 439.5	A 286	A 286
		R/L 437.9	A 286	A 286
		<b>T-MAX S seating units</b>		
		R/L 431.9	A 286	A 287
		R/L 432.9	A 286	A 287
		R/L 433.9	A 286	A 287
		R/L 434.9	A 286	A 287
		R/L 437.9	A 286	A 287
		R/L 438.9	A 286	A 287

## T-MAX P and T-MAX U cartridges and cutting heads

T-MAX P Lever		For exploded picture see page A 277, A 288							
		1	2	3	4	Insert thickness, radius		5	6
		Lever	Screw	Key (mm)	Shim			Shim pin	Shim pin punch
<b>Cutting heads</b>									
80°	R/L 471.31- 323422-12 404028-12 505036-12	174.3-841M	174.3-821	174.3-864 (3,0)	171.31-850M	4,76	0,4-1,6	174.3-861	174.3-871
	R/L 471.31- 636345-19 808056-19	174.3-842M	174.3-822M	3021 010-040 (4,0)	171.31-851M	6,35	0,4-2,4	174.3-862	174.3-872
	R/L 474 .3-636345-19	174.3-842M	174.3-822M	3021 010-040 (4,0)	174.31-851M	6,35	0,8-2,4	174.3-862	174.3-872
	R/L 474.3-808056-25	174.3-844M	174.3-827	3021 010-050 (5,0)	174.3-853M	7,94	1,6-3,2	174.3-865	174.3-874
<b>Cartridges for axial machining</b>									
80°	R/L 441.31- 2030-1211	174.3-841M	174.3-821	174,1-864 (3,0)	171.31-850M	4,76	0,4-1,6	174.3-861	174.3-871
	R/L 441.31- 2030-1911	174.3-849M	174.3-835	3021 010-040 (4,0)	171.31-851M	6,35	0,4-2,4	174.3-868	174.3-872
55°	R/L 439.35-2030-1511	174.3-847M	174.3-830	174,1-864 (3,0)	171.35-850M 171.35-851M 171.35-856 171.35-855	6,35 6,35 4,76 4,76	1,2-1,6 0,4-0,8 0,4-0,8 1,2-1,6	174.3-861	174.3-871
<b>T-MAX P Wedge</b>		For exploded picture see page A 264							
		1	3	4	Insert thickness, radius		5	6	7
		Wedge set	Key (mm)	Shim			Pin	Screw	Key (Torx Plus)/mm
<b>Cutting heads</b>									
▲	R/L 471.38- 404028-16	170.38-823-1	174.1-864 (3,0)	170.3-852	4,76	0,4-0,8	5313 021-02	5512 031-01	5680 051-03 (9IP)
	505036-16	170.38-823-1	174.1-864 (3,0)	170.3-852	4,76	0,4-0,8	5313 021-02	3212 100-206	174.1-870 (1,98)
	R/L 471.38- 636345-22M1 L 471.38- 808056-22M1	170.38-824-1 170.38-824-1	3021 010-040 (4,0) 3021 010-040 (4,0)	170.3-855M 170.3-855M	4,76	1,2-1,6	5313 021-03 181.38-840	3212 030-04 3212 030-04	174.1-863 (2,5) 174.1-863 (2,5)
	R/L 479 .38-404028-16	170.38-823-1	174.1-864 (3,0)	170.3-852	4,76	0,4-0,8	5313 021-02	5512 031-01	5680 051-03 (9IP)
	505036-16	170.38-823-1	174.1-864 (3,0)	170.3-852	4,76	0,4-0,8	5313 021-02	3212 100-206	174.1-870 (1,98)
	R/L 479 .38- 636345-22M1 L 479 .38- 808056-27M1	170.38-824-1 170.38-825-1	3021 010-040 (4,0) 3021 010-040 (4,0)	170.3-855 170.3-854	4,76 4,76	1,2-1,6 1,2-1,6	5313 021-03 5313 021-04	3212 030-04 3212 100-307	174.1-863 (2,5) 3021 010-040(4,0)
<b>Cartridges for axial machining</b>		Wedge clamp set (2)							
▲	R/L 439.38-2030-2211M1	170.38-821-1	174.1-864 (3,0)	170.3-855	4,76	1,2-1,6	181.38-840	3212 010-255	174.1-864 (3,0)
<b>Cartridges for radial machining</b>									
▲	R/L 437.38-2033-2211M1	170.38-821-1	174.1-864 (3,0)	170.3-855	4,76	1,2-1,6	181.38-840	3212 010-255	174.1-864 (3,0)
<b>T-MAX U Screw</b>		For exploded picture see page A 266							
		1	2	4	Insert thickness, radius		5	6	
		Insert screw (Thread)	Key (mm/Torx Plus)	Shim			Shim screw	Key	
<b>Cutting heads</b>									
▲	R/L 479.0- 252818-11	5513 020-03 (M2,5)	5680 051-02 (7IP)	-			-	-	
	R/L 479.0- 323422-16 404028-16 505036-16	5513 020-01 (M3,5)	5680 049-01 (15IP)	5322 320-01	3,97	0,4-1,2	5512 090-01	5680 049-01 (3,5)	

### T-MAX P lever design for vertical lathes

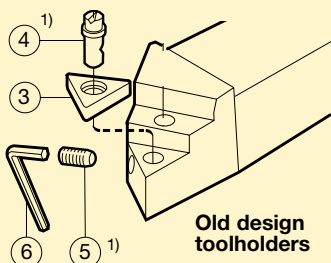


Nozzle for Coromant Capto cutting units

Cutting unit size	7 Nozzle
C3-C4	5691 029-01
C5-C6	5691 029-03
C8	5691 029-03

Tool type	Standard parts		
	1	2	3
<b>Coromant Capto®</b>	Lever	Screw	Key (size, mm)
80°			
<b>C6-PCLNR/L-4506512D120</b>	174.3-841M	174.3-821	174.1-864 (3,0)
<b>C6-PCLNR/L-4506519D120</b>	174.3-842M	174.3-822M	3021 010-040 (4,0)
<b>C6-PCRNR/L-3506519D195</b>	174.3-842M	174.3-822M	3021 010-040 (4,0)
55°			
<b>C6-PDJNR/L-4506515D120</b>	174.3-847M	174.3-830	174.1-864 (3,0)
<b>C6-PDUNR/L-4506515D120</b>	174.3-847M	174.3-830	174.1-864 (3,0)
<b>C6-PRSCR/L-4506525D120</b>	174.39-844	174.3-832	3021 010-040 (4,0)
<b>C6-PSKNR/L-4506512D120</b>	174.3-841M	174.3-821	174.1-864 (3,0)
<b>C6-PSKNR/L-4506519D195</b>	174.3-842M	174.3-822M	3021 010-040 (4,0)
<b>C6-PSRNR/L-3506519D195</b>	174.3-842M	174.3-822M	3021 010-040 (4,0)
<b>C6-PTFNR/L-4506522D120</b>	174.3-841M	174.3-821	174.1-864 (3,0)
<b>C6-PTGNR/L-4506522D120</b>	174.3-841M	174.3-821	174.1-864 (3,0)

### T-MAX P wedge clamp design



Tool type	Standard parts		
	1	2	3
<b>Shank holders</b>	Wedge clamp set	Key (mm)	Shim
<b>MTJNR/L 2020K16 2525M16 3225P16</b>	170.38-820-1	174.1-863 (2,5)	170.3-852
<b>MTJNR/L 2525M22 3225P22</b>	170.38-821-1	174.1-864 (3,0)	170.3-855
<b>MTGNR/L 2525M22 3225P22 3232P22</b>	170.38-821-1	174.1-864 (3,0)	170.3-855
<b>MTENN 2525M22 3225P22 3232P22</b>	170.38-821-1	174.1-864 (3,0)	170.3-855
<b>R/L 170.38-4025-16</b>	170.38-820-1	174.1-863 (2,5)	170.3-852
<b>L 170.38-4025-22 R 170.38-5032-22</b>	170.38-821-1	174.1-864 (3,0)	170.3-855

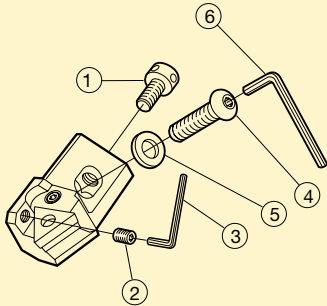
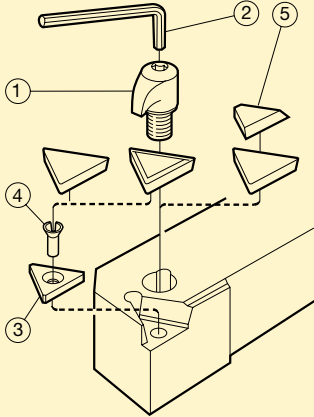
					Optional parts			
4		5		6	4			
Shim	For insert Thickness	Radius	Shim pin	Shim pin punch	Shim	For insert Thickness	Radius	
171.31-850M	4,76	0,4-1,6	174.3-861	174.3-871	-	-	-	
171.31-851M	6,35	0,4-2,4	174.3-862	174.3-872	-	-	-	
171.31-851M	6,35	0,4-2,4	174.3-862	174.3-872	-	-	-	
171.35-851M	6,35	0,4-0,8	174.3-861	174.3-871	171.35-850M 171.35-855 171.35-855	6,35 4,76 4,76	1,2-1,6 0,4-0,8 1,2-1,6	
171.35-851M	6,35	0,4-0,8	174.3-861	174.3-871	171.35-850M 171.35-856 171.35-855	6,35 4,76 4,76	1,2-1,6 0,4-0,8 1,2-1,6	
176.3-854	7,94	-	174.3-862	174.3-872	-	-	-	
174.3-851M	4,76	0,4 - 1,2	174.3-861	174.3-871	174.3-856	4,76	1,6 - 2,4	
174.3-852M	6,35	0,8 - 2,4	174.3-862	174.3-872	-	-	-	
174.3-852M	6,35	0,8 - 2,4	174.3-862	174.3-872	-	-	-	
179.3-852M	4,76	1,2 - 1,6	174.3-861	174.3-871	179.3-853M	4,76	0,4 - 0,8	
179.3-852M	4,76	1,2 - 1,6	174.3-861	174.3-871	179.3-853M	4,76	0,4 - 0,8	

Ordering example: 10 pieces 174.3-841M

					Optional parts						
		4		5	6	7		8	3		
For insert Thickness	Radius	Pin	Screw	Key (mm)	Wedge set	Key (mm)	Shim	For insert Thickness	Radius		
4,76	0,4 - 1,6	170.3-870	170.38-845	174.1-863 (2,5)	170.38-823-1	174.1-864 (3,0)	-	-	-		
4,76	1,2 - 1,6	170.3-871	170.38-845	174.1-864 (3,0)	170.38-824-1	3021 010-040 (4,0)	170.3-856	4,76	0,4 - 0,8		
4,76	1,2 - 1,6	170.3-871	170.38-845	174.1-864 (3,0)	170.38-824-1	3021 010-040 (4,0)	170.3-856	4,76	0,4 - 0,8		
4,76	1,2 - 1,6	170.3-871	170.38-845	174.1-864 (3,0)	170.38-824-1	3021 010-040 (4,0)	170.3-856	4,76	0,4 - 0,8		
4,76	0,4 - 1,6	170.3-870	170.38-845	174.1-863 (2,5)	170.38-823-1	174.1-864 (3,0)	-	-	-		
4,76	1,2 - 1,6	170.3-871	170.38-845	174.1-864 (3,0)	170.38-824-1	3021 010-040 (4,0)	170.3-856	4,76	0,4 - 0,8		

Ordering example: 10 pieces 181.38-824-1

## T-MAX S top clamp design

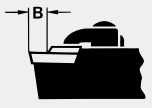


Cutting edge length	Shank size				Standard parts		
	External	Internal $dm_m=$	Cartridges	Seating units	1 Clamp set	2 Key (mm)	
09	-	-	10 CA	-	172.9-826-1	174.1-863 (2,5)	
	-	16-20	-	1018	174.9-830-1	174.1-863 (2,5)	
	-	25	-	-	174.9-830-2	174.1-863 (2,5)	
	1212-2020	-	-	-	174.9-830-2	174.1-863 (2,5)	
12	-	-	12 CA	-	172.9-827-1	174.1-864 (3,0)	
	-	25	-	-	174.9-832-1	174.1-864 (3,0)	
	-	-	16 CA	-	172.9-827-1	174.1-864 (3,0)	
	-	32	-	1325	174.9-832-1	174.1-864 (3,0)	
	2020-2525	40-50	-	-	174.9-832-2	174.1-864 (3,0)	
06	-	10	-	-	172.9-825-1	174.1-862 (1,5)	
	09	0808-1010	12	-	172.9-825-1	174.1-862 (1,5)	
	11	-	12	10 CA	-	172.9-826-1	174.1-863 (2,5)
		-	16-20	-	1018	174.9-830-1	174.1-863 (2,5)
		1212-2020	25	-	174.9-830-2 172.9-826-1 <sup>1)</sup>	174.1-863 (2,5)	
	16	-	-	12 CA	-	172.9-827-1	174.1-864 (3,0)
		-	25	-	-	174.9-832-1	174.1-864 (3,0)
		-	32	-	1325	174.9-832-1	174.1-864 (3,0)
			2020-2525	40-50	-	174.9-832-2 172.9-827-1 <sup>1)</sup>	174.1-864 (3,0)
		-	-	16 CA	-	172.9-827-1	174.1-864 (3,0)
22	-	-	2019	-	174.9-835-1	3021 010-040 (4,0)	

### Setting and clamping of T-MAX S and AL cartridges

Cartridge size	Standard parts						Optional parts
	1 Adjusting screws	2 Radial	3 Key (mm)	4 Mounting screw	5 Washer	6 Key (Torx/mm)	
T-MAX S and -AL	Axial	Radial					
06 CA	5512 050-01	3214 010-203	3021 012-015 (1,5)	5512 031-04	-	5680 043-08 (T8)	
08 CA	5512 050-02	3214 010-203	3021 012-015 (1,5)	5512 031-03	-	5680 043-09 (T15)	
10 CA	438.3-824	434.9-835	174.1-870 (1,98)	434.9-826	170.38-834		3021 010-040 (4,0)
12 CA	438.3-824	434.9-836	174.1-870 (1,98)	434.9-824	3411 011-064		3021 010-040 (4,0)
16 CA	438.3-828	434.9-836	174.1-870 (1,98)	434.9-830	3411 011-084		3021 010-050 (5,0)
2019		-	-	434.9-830	3411 011-084		3021 010-050 (5,0)

Ordering example: 10 pieces 5512 050-01

For T-MAX S inserts and plain positive inserts without loose chipbreakers				Optional parts For use with inserts and loose chipbreakers only							
3		4		1	2	5					
For insert Shim		Thickness	Radius	Shim pin	Clamp set	Key (mm)	Chipbreaker				
							B=0 mm	B=1,2 mm	B=2,0 mm	B=3,0 mm	
-	-	-	-	-	-	-	-	-	-	-	
-	-	-	-	174.9-831-1	174.1-863 (2,5)	DP2001H35	DP2121H35 DL2121H35 <sup>6)</sup>	DP2201H35 DL2201H35 <sup>6)</sup>	-	-	
-	-	-	-	174.9-831-2	174.1-863 (2,5)	DP2001H35	DP2121H35	DP2201H35	-	-	
174.2-853	3,18	0,4-0,8	174.1-865 174.1-869 <sup>4)</sup>	174.9-831-2	174.1-863 (2,5)	DP2001H35	DP2121H35	DP2201H35	-	-	
-	-	-	-	-	-	-	-	-	-	-	
-	-	-	-	174.9-833-1	174.1-864 (3,0)	DP300H35	DP312H35	DP320H35	DP330H35	-	
174.2-850	3,18	0,4-1,2	174.1-869	-	-	-	-	-	-	-	
174.2-850	3,18	0,4-1,2	174.1-865 174.1-869 <sup>4)</sup>	174.9-833-1	174.1-864(3,0)	DP300H5	DP312H35	DP320H35	DP330H35	-	
174.2-850	3,18	0,4-1,2	174.1-865 174.1-869 <sup>5)</sup>	174.9-833-2	174.1-864 (3,0)	DP300H35 DL300H35 <sup>7)</sup>	DP312H35 DL312H35 <sup>7)</sup>	DP320H35 DL320H35 <sup>7)</sup>	DP330H35	-	
-	-	-	-	-	-	-	-	-	-	-	
-	-	-	-	-	-	-	-	-	-	-	
-	-	-	-	-	-	-	-	-	-	-	
-	-	-	-	174.9-831-1	174.1-863 (2,5)	D01001H35	D01121H35	D01201H35	-	-	
-	-	-	-	174.9-831-2	174.1-863 (2,5)	D01001H35	D01121H35	D01201H35	-	-	
-	-	-	-	-	-	-	-	-	-	-	
-	-	-	-	174.9-833-1	174.1-864 (3,0)	D0200H35	D0212H35	D0220H35	D0230H35	-	
175.2-850	3,18	0,4-1,2	174.1-865 174.1-869 <sup>2)</sup>	174.9-833-1	174.1-864 (3,0)	D0200H35	D0212H35	D0220H35	D0230H35	-	
175.2-850	3,18	0,4-1,2	174.1-865 174.1-869 <sup>3)</sup>	174.9-833-2	174.1-864 (3,0)	D0200H35	D0212H35	D0220H35	D0230H35	-	
175.2-850	3,18	0,4-1,2	174.1-869	-	-	-	-	-	-	-	
175.2-851	4,76	0,4-1,6	174.1-866	174.9-834M-1	3021 010-040 (4,0)	-	D0325H35 (B=2,5 mm)	D0320H35	D0330H35	-	

1) For toolholder 177.9. Optional clamp set and loose chipbreakers cannot be used in this toolholder.

2) For cutting heads R/L 477.9, R/L 479.9 and for seating units.

3) For toolholder 177.9, cutting heads R/L 477.9, R/L 479.9 and for round shank boring tools.

4) For toolholders CSBPR/L, CSKPR/L, cutting head R/L 474.9 and for seating units.

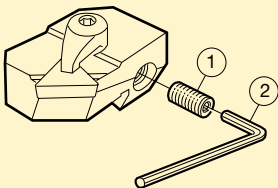
5) For cutting head R/L 474.9.

6) For seating unit R/L 434.9.

7) For toolholder CSDPN.

Ordering example: 10 pcs 172.9-826-1

## Setting of T-MAX S seating units



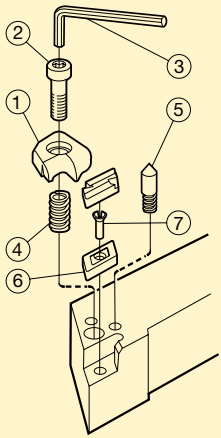
Unit size	Standard parts	
	1	2
	Adjusting screw	Key (mm)
1018	434.9-837	174.1-863 (2,5)
1325	434.9-838	174.1-864 (3,0)

Ordering example: 10 pieces 434.9-837



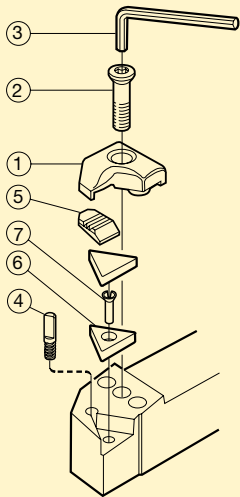
### T-MAX copying

A



Cutting edge length	Shank size			Standard parts		
	External	Internal	Cartridges	1 Clamp Right hand	2 Left hand	Screw
16	2525-5032	-	-	170.5-824	170.5-825	170.5-865
	-	32-80	-	170.5-825	170.5-824	170.5-865
	-	-	2030	170.5-824	170.5-825	170.5-865

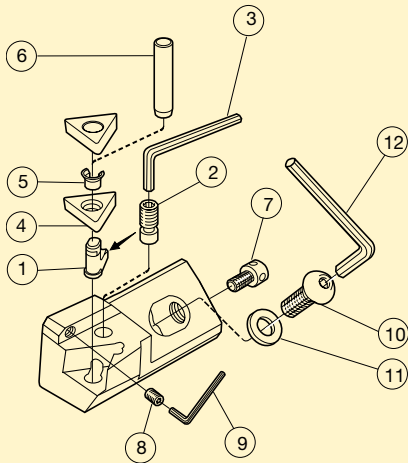
### T-MAX top clamp design with adjustable chipbreaker



Cutting edge length	Shank size		Standard parts				
	External	Type	1 Clamp Right hand	2 Left hand	3 Screw	4 Key (mm)	5 Spring and pin
12	2525	R/L 174.1	178.1-823M	178.1-822M	174.1-830	3021 010-040 (4,0)	174.1-840
		R/L 178.1	178.1-822M	178.1-823M	174.1-830	3021 010-040 (4,0)	174.1-840
12	2525	R/L 174.2	178.1-823M	178.1-822M	174.1-830	3021 010-040 (4,0)	174.1-841
16	2525	R/L 175.1	175.1-826M	175.1-827M	174.1-830	3021 010-040 (4,0)	174.1-840
		R/L 179.1	179.1-822	179.1-823	174.1-830	3021 010-040 (4,0)	174.1-840
		R/L 172.1	172.1-822M	179.1-823M	174.1-830	3021 010-040 (4,0)	174.1-840
		R/L 173.4	173.4-820M	173.4-821M	174.1-830	3021 010-040 (4,0)	174.1-840
		R/L 177.1	175.1-827M	175.1-826M	174.1-830	3021 010-040 (4,0)	174.1-840
16	2525	R/L 175.2	175.1-826M	175.1-827M	174.1-830	3021 010-040 (4,0)	174.1-841
		R/L 179.2	179.1-822	179.1-823	174.1-830	3021 010-040 (4,0)	174.1-841
		R/L 172.2	173.4-822M	173.4-823M	174.1-830	3021 010-040 (4,0)	174.1-841
		R/L 173.5	173.4-820M	173.4-821M	174.1-830	3021 010-040 (4,0)	174.1-841
		R/L 177.2	175.1-827M	175.1-826M	174.1-830	3021 010-040 (4,0)	174.1-841

### Setting and clamping

T-MAX P, ISO cartridges

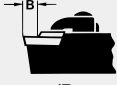


Cartridge size	Standard parts					Optional parts
	7 Adjusting screws	8 Adjusting screws	9 Key (mm)	10 Mounting screw	11 Washer	
T-MAX P	Axial	Radial				
12 CA	438.3-824	438.820	174.1-870 (1,98)	434.9-824	3411 011-064	3021 010-040 (4,0)
16 CA	438.3-828	438.3.821	174.1-863 (2,5)	434.9-830	3411-011-084	3021 010-050 (5,0)
20 CA	438.3-839	438.3-821	174.1-863 (2,5)	434.9-830	3411 011-084	3021 010-050 (5,0)
25 CA	438.3-825	438.3-822	174.1-864 (3,0)	434.9-822	3411 010-105	3021 010-060 (6,0)

Ordering example: 10 pieces 438.3-824

								Optional parts			
3	4	5	6		7		6				
Key (mm)	Spring	Spring and pin	Shim Right hand	Left hand	For insert Thickness	Radius	Shim pin	Shim Right hand	Left hand	For insert Thickness	Radius
3021 010-040 (4,0)	170.5-848	170.5-841	R170.5-851	L170.5-851	4,76	1,0	174.1-866	R170.5-852 R170.5-850	L170.5-852 L170.5-850	4,76 4,76	0,5 1,5
3021 010-040 (4,0)	170.5-848	471.5-821	L170.5-851	R170.5-851	4,76	1,0	174.1-866	L170.5-852 L170.5-850	R170.5-852 R170.5-850	4,76 4,76	0,5 1,5
3021 010-040 (4,0)	170.5-848	437.5-821	R170.5-851	L170.5-851	4,76	1,0	174.1-866	R170.5-852 R170.5-850	L170.5-852 L170.5-850	4,76 4,76	0,5 1,5

Ordering example: 10 pieces 170.5-824

							Optional parts				
5			6	7		5					
Adjustable chipbreaker (R)	(L)	(B, mm)	Shim	For insert Thickness	Radius	Shim pin	Adjustable chipbreaker <sup>1)</sup> (R)	(L)	Shim	For insert Thickness	Radius
BC1H35	BD1H35	(2,6 4,3 6,0)	174.1-850	4,76	0,8-1,6	174.1-866	BC10H35	BD10H35	174.1-851	3,18	0,4-1,2
BD1H35	BC1H35	(2,6 4,3 6,0)	174.1-850	4,76	0,8-1,6	174.1-866	BD10H35	BC10H35	174.1-851	3,18	0,4-1,2
BC1H35	BD1H35	(2,6 4,3 6,0)	174.2-850	4,76	0,8-1,6	174.1-865	BC10H35	BD10H35	-	-	-
BC1H35	BD1H35	(2,3 4,0 5,7)	175.1-850	4,76	0,8-1,6	174.1-866	BC10H35	BD10H35	175.1-851	3,18	0,4-1,2
BC1H35	BD1H35	(2,3 4,0 5,7)	175.1-850	4,76	0,8-1,6	174.1-866	BC10H35	BD10H35	175.1-851	3,18	0,4-1,2
BC1H35	BD1H35	(2,6 4,3 6,0)	175.1-850	4,76	0,8-1,6	174.1-866	BC10H35	BD10H35	175.1-851	3,18	0,4-1,2
BC7H35	BC7H35	(1,8 3,3 5,0)	175.1-850	4,76	0,8-1,6	174.1-866	BC13H35	BC13H35	175.1-851	3,18	0,4-1,2
BD1H35	BC1H35	(2,3 4,0 5,7)	175.1-850	4,76	0,8-1,6	174.1-866	BD10H35	BC10H35	175.1-851	3,18	0,4-1,2
BC1H35	BD1H35	(2,3 4,0 5,7)	175.2-850	3,18	0,2-1,2	174.1-865	BC10H35	BD10H35	-	-	-
BC1H35	BD1H35	(2,3 4,0 5,7)	175.2-850	3,18	0,2-1,2	174.1-865	BC10H35	BD10H35	-	-	-
BC1H35	BD1H35	(2,6 4,3 6,0)	175.2-850	3,18	0,2-1,2	174.1-865	BC10H35	BD10H35	-	-	-
BC7H35	BC7H35	(1,8 3,3 5,0)	175.2-850	3,18	0,2-1,2	174.1-865	BC13H35	BC13H35	-	-	-
BD1H35	BC1H35	(2,3 4,0 5,7)	175.2-850	3,18	0,2-1,2	174.1-865	BD10H35	BC10H35	-	-	-

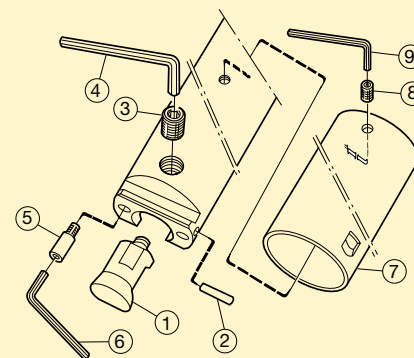
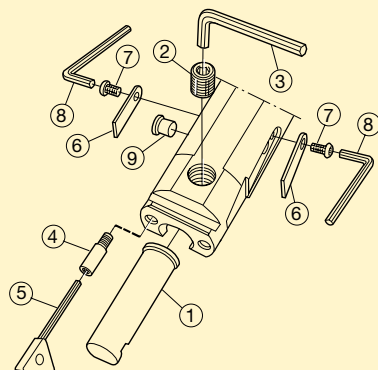
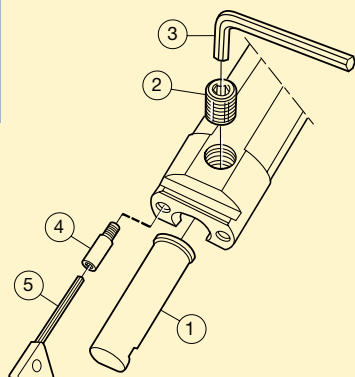
<sup>1)</sup> The front V-groove gives chipbreaker width B=1,9 mm. The other two V-grooves are intended for specially ground chipbreakers.

Ordering example: 10 pieces 178.1-823M

**T-MAX solid bars 470-1**

**Coolant bars 470-2**

**Tuned anti-vibration bars 470-3**



470-1 470-2  Bar size d	Standard parts								
	1 Locking arm	2 Screw	3 Key (mm)	4 Stop screw	5 <sup>1)</sup> Key (mm)	6 Coolant deflector	7 Screw	8 <sup>2)</sup> Key (mm)	9 Plug
25	470-820-1	470-830	3021 010-040 (4,0)	470-880	170.3-861 (3,0)	470-846	3212 100-205	174.1-870 (1,98)	470-886
30	470-821-1	470-831	3021 010-040 (4,0)	470-880	170.3-861 (3,0)	470-846	3212 100-206	174.1-870 (1,98)	470-886
32	470-821-1	470-831	3021 010-040 (4,0)	470-880	170.3-861 (3,0)	470-846	3212 100-206	174.1-870 (1,98)	470-886
40	470-822-1	470-832	3021 010-050 (5,0)	470-881	170.3-861 (3,0)	470-847	3212 100-206	174.1-870 (1,98)	470-887
50	470-823-1	470-833	3021 010-050 (5,0)	470-881	170.3-861 (3,0)	470-847	3212 100-206	174.1-870 (1,98)	470-887
60	470-824-1	470-834	3021 010-060 (6,0)	470-882	170.3-861 (3,0)	470-848	3212 100-206	174.1-870 (1,98)	470-888
63	470-824-1	470-834	3021 010-060 (6,0)	470-882	170.3-861 (3,0)	470-848	3212 100-206	174.1-870 (1,98)	470-888
80	470-825-1	470-835	3021 010-060 (6,0)	470-882	170.3-861 (3,0)	470-849	3212 100-206	174.1-870 (1,98)	470-888

<sup>1)</sup> Also used for radial setting of cutting head.

<sup>2)</sup> Available separately.

Ordering example: 10 pieces 470-820-1

470-3  Bar size d	Standard parts								
	1 Locking arm	2 Pin	3 Screw	4 Key <sup>1)</sup> (mm)	5 Stop screw	6 Key <sup>2)</sup> (mm)	7 Coolant deflector	8 Screw	9 Key (mm)
25	470-814-1	3111 020-509	437.5-822	174.1-864 (3,0)	470-880	174.1-864 (3,0)	470-829 <sup>3)</sup> 5691 010-01 <sup>4)</sup>	3214 040-254	174.1-870 (1,98)
32	470-815-1	470-865	470-871	174.1-864 (3,0)	470-880	174.1-864 (3,0)	470-826 <sup>3)</sup> 5691 010-02 <sup>4)</sup>	3214 040-254	174.1-870 (1,98)
40	470-816-1	470-866	470-872	3021 010-040 (4,0)	470-881	174.1-864 (3,0)	470-827 <sup>3)</sup> 5691 010-03 <sup>4)</sup>	3214 040-254	174.1-870 (1,98)
50	470-817-1	470-867	470-873	3021 010-040 (4,0)	470-881	174.1-864 (3,0)	470-828 <sup>3)</sup> 5691 010-04 <sup>4)</sup>	3214 040-254	174.1-870 (1,98)
60	470-818-1	470-868	470-874	3021 010-050 (5,0)	470-882	174.1-864 (3,0)	470-802 <sup>3)</sup> 5691 010-05 <sup>4)</sup>	3214 040-254	174.1-870 (1,98)
63	470-818-1	470-868	470-874	3021 010-050 (5,0)	470-882	174.1-864 (3,0)	470-802 <sup>3)</sup> 5691 010-05 <sup>4)</sup>	3214 040-254	174.1-870 (1,98)
80	470-819-1	470-869	470-875	3021 010-050 (5,0)	470-882	174.1-864 (3,0)	470-803 <sup>3)</sup> 5691 010-06 <sup>4)</sup>	3214 040-254	174.1-870 (1,98)

<sup>1)</sup> Also used for anti-vibration adjustment.

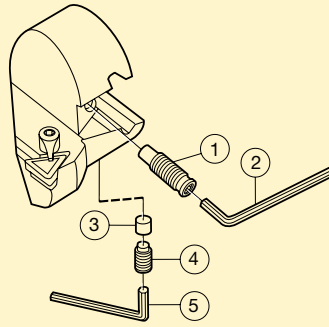
<sup>2)</sup> Also used for radial setting of cutting head.

<sup>3)</sup> For long design boring bars.

<sup>4)</sup> For short design boring bars.

Ordering example: 10 pieces 470-814-1

## Spare parts for clamping and setting adjustable cutting heads

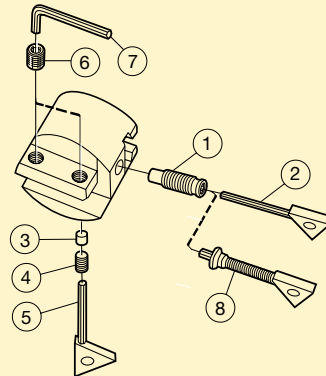


Bar size	Standard parts					
	1	2	3	4	5	2
d	Adjusting screw	Key (mm)	Locking plug	Locking screw	Key (mm)	Key <sup>1)</sup> (mm)
25	471.5-830	170.3-861 (3,0)	470-841	3214 010-355	170.3-861 (3,0)	-
32	471.5-831	170.3-861 (3,0)	470-841	3214 010-355	170.3-861 (3,0)	-
40	471.5-832	170.3-861 (3,0)	470-841	3214 010-358	170.3-861 (3,0)	-
50	471.5-833	170.3-861 (3,0)	470-841	3214 010-358	170.3-861 (3,0)	470-842 (3,0)
63	471.5-834	170.3-861 (3,0)	470-841	3214 010-360	170.3-861 (3,0)	470-842 (3,0)
80	471.5-835	170.3-861 (3,0)	470-841	3214 010-360	170.3-861 (3,0)	470-842 (3,0)

<sup>1)</sup> With scale marks for more exact setting.  
Recommended for cutting head dia d=50–80 mm.

Ordering example: 10 pieces 471.5–830

## Cutting heads R/L 470- for toolholders



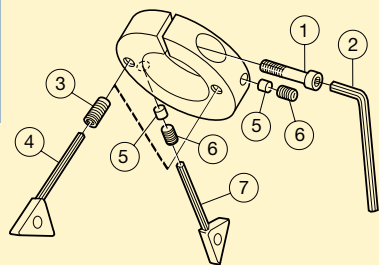
Bar size	Standard parts							
	1	2	3	4	5	6	7	8
d	Adjusting screw	Key <sup>1)</sup> (mm)	Locking plug	Screw	Key <sup>1)</sup> (mm)	Screw	Key (mm)	Key <sup>2)</sup> (mm)
32	471.5-831	170.3-861 (3,0)	470-841	3214 010-355	170.3-861 (3,0)	437.5-822	174.1-864 (3,0)	-
40	471.5-832	170.3-861 (3,0)	470-841	3214 010-358	170.3-861 (3,0)	437.5-822	174.1-864 (3,0)	-
50	471.5-833	170.3-861 (3,0)	470-841	3214 010-358	170.3-861 (3,0)	437.5-822	174.1-864 (3,0)	470-842 (3,0)
63	471.5-834	170.3-861 (3,0)	470-841	3214 010-360	170.3-861 (3,0)	174.32-832	3021 010-040 (4,0)	470-842 (3,0)
80	471.5-835	170.3-861 (3,0)	470-841	3214 010-360	170.3-861 (3,0)	470-874	3021 010-050 (5,0)	470-842 (3,0)

<sup>1)</sup> Delivered with boring bar.

<sup>2)</sup> With scale marks for more exact setting.  
Recommended for cutting head dia d=50–80 mm.

Ordering example: 10 pieces 471.5–831

## Length setting ring 470- for boring bars

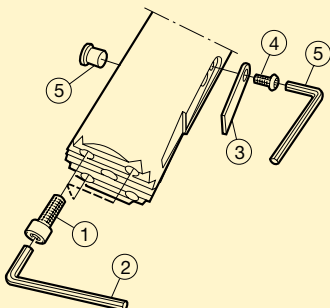


Bar size	Standard parts						
	1	2	3	4	5	6	7
d	Screw	Key <sup>1)</sup> (mm)	Adjusting screw	Key <sup>1)</sup> (mm)	Locking plug	Screw	Key <sup>1)</sup> (mm)
25-32	3212 010-312	3021 010-040 (4,0)	3214 010-359	170.3-861 (3,0)	470-841	3214 010-355	170.3-861 (3,0)
40-50	3212 010-362	3021 010-050 (5,0)	3214 010-359	170.3-861 (3,0)	470-841	3214 010-355	170.3-861 (3,0)
60-80	3212 010-413	3021 010-060 (6,0)	3214 010-359	170.3-861 (3,0)	470-841	3214 010-355	170.3-861 (3,0)

1) Supplied as standard with each boring bar.

Ordering example: 10 pieces 3212 010-312

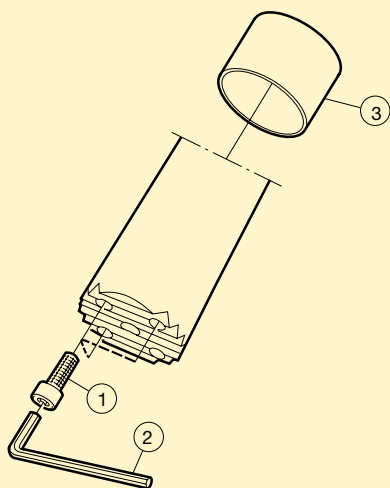
## Boring bars with coolant supply, type 570-2



Bar size	Standard parts				
	1	2	3	4	5
	Screw	Key (mm)	Coolant deflector	Screw	Key (mm)
16	3212 030-301	265.2-818 (2,381)	-	-	-
20	3212 030-351	3021 011-764 (2,778)	-	-	-
25	3212 010-258	174.1-864 (3,0)	470-846	3212 100-205	174.1-870 (1,98)
32	3212 010-308	3021 010-040 (4,0)	470-846	3212 100-206	174.1-870 (1,98)
40	3212 010-358	3021 010-050 (5,0)	470-847	3212 100-206	174.1-870 (1,98)
50	3212 010-409	3021 010-060 (6,0)	470-847	3212 100-206	174.1-870 (1,98)
60	3212 010-409	3021 010-060 (6,0)	470-848	3212 100-206	174.1-870 (1,98)

Ordering example: 10 pieces 3212 010-301

## Tuned anti-vibration bars and coolant bars type 570-3



Bar size	Standard parts		
	1	2	3
	Screw	Key (mm)	Coolant deflector
16	3212 030-301	265.2-818 (2,381)	-
20	3212 030-351	3021 011-764 (2,778)	-
25	3212 010-258	174.1-864 (3,0)	5691 011-03
32	3212 010-308	3021 010-040 (4,0)	5691 011-04
40	3212 010-358	3021 010-050 (5,0)	5691 011-05
50	3212 010-409	3021 010-060 (6,0)	5691 011-06
60	3212 010-409	3021 010-060 (6,0)	5691 011-07

Ordering example: 10 pieces 3212 030-301

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