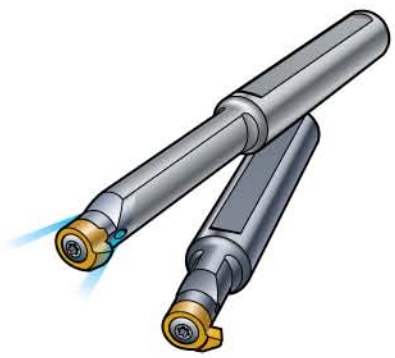
CoroCut® MB

For internal precision machining

For internal grooving, threading and turning of bores from 10 mm



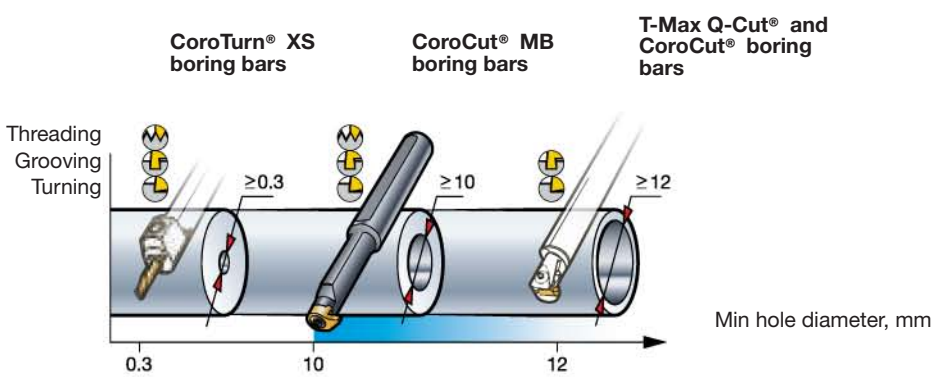
CoroCut® MB boring bars
To increase the stability and accessibility the bars are designed with an eccentric head with oval cross section

Bars are available in two designs
- Steel shank bars for overhang up to 1 x bar diameter
- Carbide shank bars for overhang up to 5.5 x bar diameter

Clamping of bars
- Conventional bars with flats
- EasyFix™ clamping

For accurate machining with less vibration and precise centre height of the insert use cylindrical bars with EasyFix™ sleeves

CoroCut® MB
A system for internal machining of high precision components



CoroCut® MB inserts

Application	Size 07	Size 09
	Min hole 10 mm	Min hole 14 mm
Grooving		
Turning		—
Threading		—

Insert for turning/Back boring

MB	–	07	T	093	–	02	–	10	R
1		2	3	4		5		9	12

Insert for grooving/pre-parting

MB	–	07	G	070	–	00	–	10	R
1		2	3	6		5		9	12

Insert for threading

MB	–	07	TH	050	VM	–	10	R
1		2	3	7	8		9	12

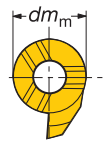
Boring bars

MB	–	A	16	–	16	–	07	R
1		13	14		10		2	15

1 Main code

MB = CoroCut® MB

2 Insert size, mm



07 = 7 mm
09 = 9 mm

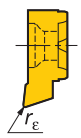
3 Type of operation

B = Back boring
G = Grooving
GX = Pre-parting
R = Profiling full radius
T = Turning
TE = Turning copying, extended f_1-dimension
TH = Threading

4 Entering angle (Turning)

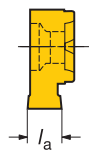
E.g.: 093 = 93°

5 Nose radius, r_ε mm (Turning)



E.g.: 00 = Sharp
02 = 0.2 mm

6 Insert width, l_a mm (Grooving)



E.g.: 100 = 1.00 mm

7 Pitch, mm (Threading)

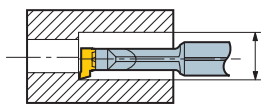
mm: pitch x 100

inch: No. of threads per inch x 10

8 Thread profile (Threading)

V = V profile 60°
M = Metric 60°
W = Withworth 55°
U = UN 60°
NT = NPT 60°
AC = ACME 29°
SA = STUB-ACME

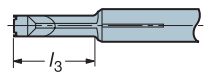
9 Min hole diameter, D_m min. mm



min. hole

E.g.: 10 = 10 mm

10 Penetration depth, l_3 mm (boring bar)



E.g.: 16 = 16 mm

12 Hand of insert

R = Right hand style

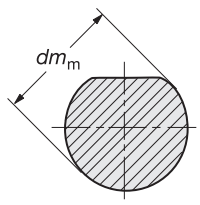
L = Left hand style

13 Type of bar

A = Steel bar with internal coolant supply

E = Carbide shank bar

14 Bar dia, dm_m mm



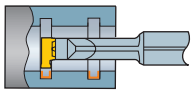
15 Shank type

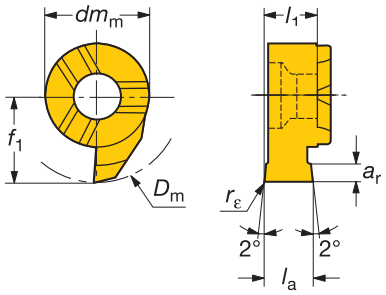
R = Cylindrical

No symbol = With flats

CoroCut® MB inserts

Grooving





Tolerances:
l_a: + 0.05 mm
- 0
r_ε ± 0.02 mm
l_1: ± 0.02 mm
Centre height:
+ 0.05 mm
- 0

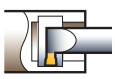
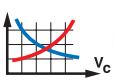
Tolerances for circlip grooves inserts:
l_a + 0.03 mm
- 0
l_1 ± 0.02 mm
Centre height:
+ 0.05 mm
- 0

Right hand style shown

	Selection criteria, mm		Insert size		Dimensions, mm				P GC	M GC	N GC	S GC
	l_a	a_r	dm_m	Ordering code	D_m min	f_1	l_1	r_ε	1025	1025	1025	1025
	1	1.8	07	MB-07G100-00-10R/L	10	5.8	3.9		★	★	★	★
	1.5	1.8		MB-07G150-00-10R/L	10	5.8	3.9		★	★	★	★
	2	1.8		MB-07G200-00-10R/L	10	5.8	3.9		★	★	★	★
	2.5	1.8		MB-07G250-00-10R/L	10	5.8	3.9		★	★	★	★
	3	1.8		MB-07G300-00-10R/L	10	5.8	3.9		★	★	★	★
	3.18	1.8		MB-07G318-00-10R/L	10	5.8	3.9		★	★	★	★
	1	2.8	07	MB-07G100-00-11R/L	11	6.8	3.9		★	★	★	★
	1.5	2.8		MB-07G150-00-11R/L	11	6.8	3.9		★	★	★	★
	2	2.8		MB-07G200-00-11R/L	11	6.8	3.9		★	★	★	★
	2.5	2.8		MB-07G250-00-11R/L	11	6.8	3.9		★	★	★	★
	3	2.8		MB-07G300-00-11R/L	11	6.8	3.9		★	★	★	★
	3.18	2.8		MB-07G318-00-11R/L	11	6.8	3.9		★	★	★	★
	1	3.4	07	MB-07G100-00-12R/L	12	7.4	3.9		★	★	★	★
	1.5	3.4		MB-07G150-00-12R/L	12	7.4	3.9		★	★	★	★
	2	3.4		MB-07G200-00-12R/L	12	7.4	3.9		★	★	★	★
	1.5	4	09	MB-09G150-00-14R/L	14	9	5.3		★	★	★	★
	2	4		MB-09G200-00-14R/L	14	9	5.3		★	★	★	★
	2	4		MB-09G200-02-14R/L	14	9	5.3	0.2	★	★	★	★
	2.5	4		MB-09G250-00-14R/L	14	9	5.3		★	★	★	★
	3	4		MB-09G300-00-14R/L	14	9	5.3		★	★	★	★
	1.5	5.5	09	MB-09G150-00-16R/L	16	10.5	5.2		★	★	★	★
	2	5.5		MB-09G200-00-16R/L	16	10.5	5.2		★	★	★	★
	2	5.5		MB-09G200-02-16R/L	16	10.5	5.2	0.2	★	★	★	★
	2.5	5.5		MB-09G250-02-16R/L	16	10.5	5.2	0.2	★	★	★	★
	3	5.5		MB-09G300-00-16R/L	16	10.5	5.2		★	★	★	★
	3	5.5		MB-09G300-02-16R/L	16	10.5	5.2	0.2	★	★	★	★
	2.5	5.5		MB-09G250-00-16R/L	16	10.5	5.2		★	★	★	★
	1.5	6.5	09	MB-09G150-00-17R/L	17	11.5	5.2		★	★	★	★
	2	6.5		MB-09G200-00-17R/L	17	11.5	5.2		★	★	★	★
	2.5	6.5		MB-09G250-00-17R/L	17	11.5	5.2		★	★	★	★
	3	6.5		MB-09G300-00-17R/L	17	11.5	5.2		★	★	★	★
			For circlip grooves									
	0.73	1.2	07	MB-07G070-00-10R/L	10	5.8	3.8		★	★	★	★
	0.83	1.3		MB-07G080-00-10R/L	10	5.8	3.8		★	★	★	★
	0.93	1.5		MB-07G090-00-10R/L	10	5.8	3.8		★	★	★	★
	1.2	1.8		MB-07G120-00-10R/L	10	5.8	3.9		★	★	★	★
	1.4	1.8		MB-07G140-00-10R/L	10	5.8	3.9		★	★	★	★
	1.7	1.8		MB-07G170-00-10R/L	10	5.8	3.9		★	★	★	★
	0.73	1.2	09	MB-09G070-00-14R/L	14	9	5.2		★	★	★	★
	0.83	1.3		MB-09G080-00-14R/L	14	9	5.2		★	★	★	★
	0.93	1.5		MB-09G090-00-14R/L	14	9	5.2		★	★	★	★
	1.2	4		MB-09G120-00-14R/L	14	9	5.3		★	★	★	★
	1.4	4		MB-09G140-00-14R/L	14	9	5.3		★	★	★	★
	1.7	4		MB-09G170-00-14R/L	14	9	5.3		★	★	★	★
									P25	M25	N25	S25

Ordering example: 10 pieces MB-07G100-00-10R 1025
MB-07G100-00-10L 1025
R = Right hand, L = Left hand

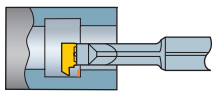
★= First choice

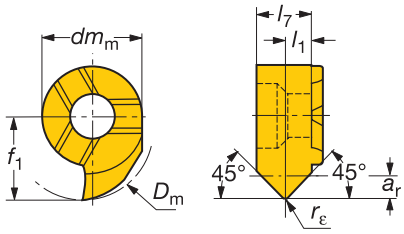
 B91  B117 GC B122  B2

CoroCut® MB inserts

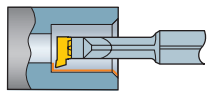
Turning and turning/copying

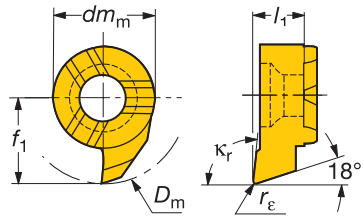
Entering angle 45° **MB-07T 045 Turning/profiling**



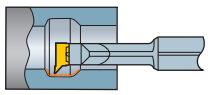


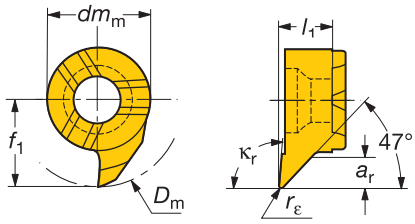
Entering angle 93° **MB-07T 93 Turning**



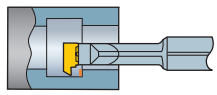


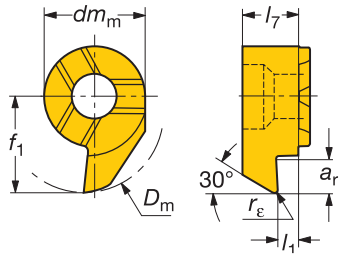
Entering angle 93° **MB-07TE 93 Copying**





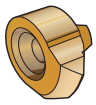
Entering angle 90° **MB-07B Back boring**





Tolerances:
l_a: +0.05/-0 mm
r_ε: ±0.02 mm
l_a: ±0.02 mm
Centre height:
+0.05/-0 mm

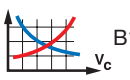
Right hand style shown

	Selection criteria, mm	Insert size		Dimensions, mm					P GC 1025	M GC 1025	N GC 1025	S GC 1025
	a_r max	dm_m	Ordering code	D_m min	f_1	l_1	l_7	r_ε				
	1.5	07	MB-07T045-02-10R/L	10	5.8	2	4.0	0.2	★	★	★	★
		07	MB-07T093-02-10R/L	10	5.6	3.9		0.2	★	★	★	★
	1.8	07	MB-07TE93-02-10R/L[1)]	10	5.8	3.9		0.2	★	★	★	★
	2.6	07	MB-07B030-02-11R/L	11	6.8	1.3	4.0	0.2	★	★	★	★
									P25	M25	N25	S25

[1)] Insert with extended f_1 dimension

Ordering example: 10 pieces MB-07T093-02-10R 1025
MB-07T093-02-10L 1025
R = Right hand, L = Left hand

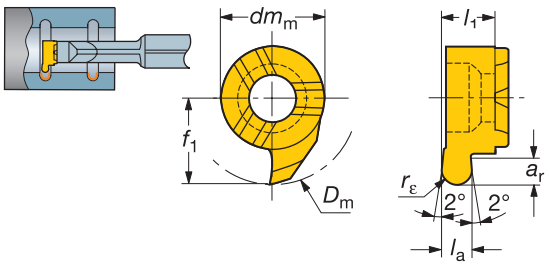
★= First choice

 B91  B117 GC B122  B2

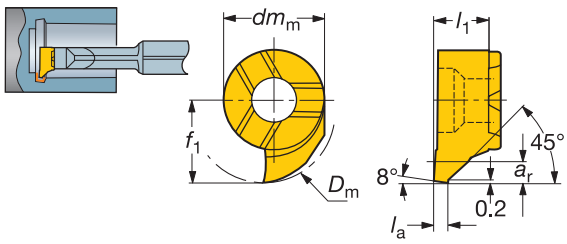
CoroCut® MB inserts

Profiling and pre-parting

MB-07R Profiling



MB-07GX Pre-parting



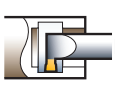
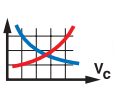
Tolerances:
l_a + 0.05 mm
- 0
r_ε ± 0.02 mm
l_1 ± 0.02 mm
Centre height:
+ 0.05 mm
- 0

Right hand style shown

	Selection criteria, mm		Insert size		Dimensions, mm				P	M	N	S
									GC	GC	GC	GC
	l_a	a_r max	dm_m	Ordering code	D_m min	f_1	l_1	r_ε	1025	1025	1025	1025
	0.8	1.8	07	MB-07R080-04-10R/L	10	5.8	3.9	0.4	★	★	★	★
	1.2	1.8		MB-07R120-06-10R/L	10	5.8	3.9	0.6	★	★	★	★
	1.8	1.8		MB-07R180-09-10R/L	10	5.8	3.9	0.9	★	★	★	★
	2	1.8		MB-07R200-10-10R/L	10	5.8	3.9	1	★	★	★	★
	0.8	1.8	09	MB-09R080-04-14R/L	14	9	5.2	0.4	★	★	★	★
	1.2	4		MB-09R120-06-14R/L	14	9	5.3	0.6	★	★	★	★
	1.8	4		MB-09R180-09-14R/L	14	9	5.3	0.9	★	★	★	★
	2	4		MB-09R200-10-14R/L	14	9	5.3	1	★	★	★	★
	2.2	4		MB-09R220-11-14R/L	14	9	5.3	1.1	★	★	★	★
	3	4		MB-09R300-15-14R/L	14	9	5.3	1.5	★	★	★	★
	1	1.5	07	MB-07GX100-00-10R/L	10	5.8	3.9		★	★	★	★
									P25	M25	N25	S25

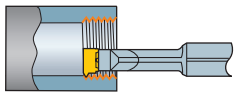
Ordering example: 10 pieces MB-07R080-04-40R 1025
MB-07R080-04-40L 1025
R = Right hand, L = Left hand

★= First choice

 B91  B117 GC B122  B2

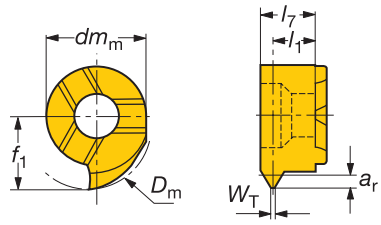
CoroCut® MB inserts

Threading

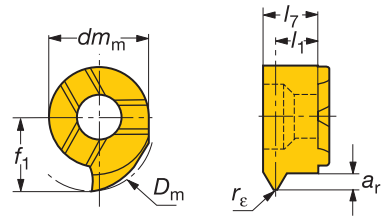


Tolerances:
l_a + 0.05 mm
- 0
r_ε ± 0.02 mm
l_1 ± 0.02 mm
Centre height:
+ 0.05 mm
- 0

V-profile 60°
Metric 60°
UN 60°
NPT 60°



Withworth 55°



Right hand style shown

	Insert size				Dimensions, mm							P GC 1025	M GC 1025	N GC 1025	S GC 1025
	dm_m	Pitch, mm	Pitch, t.p.i.	**Ordering code**	a_r max	D_m min	f_1	l_1	l_3	W_T	r_ε				
V-profile 60°	07	0.50-0.75	32	**MB-07TH050VM-10R/L**	0.41	10	5.8	3.4	3.8	0.06		★	★	★	★
		1.00-1.25	24-28	**MB-07TH100VM-10R/L**	0.55	10	5.8	3.2	3.8	0.12		★	★	★	★
		1.50-1.75	16-20	**MB-07TH150VM-10R/L**	0.81	10	5.8	3	3.8	0.18		★	★	★	★
		2.00-2.25	12-14	**MB-07TH200VM-10R/L**	1.08	10	5.8	2.75	3.8	0.25		★	★	★	★
		2.50	10-11	**MB-07TH250VM-10R/L**	1.35	10	5.8	2.55	3.8	0.31		★	★	★	★
Metric 60°	07	0.50		**MB-07TH050MM-10R/L**	0.27	10	5.8	3.4	3.8	0.06			★	★	★
		1.00		**MB-07TH100MM-10R/L**	0.54	10	5.8	3.2	3.8	0.12		★	★	★	★
		1.50		**MB-07TH150MM-10R/L**	0.81	10	5.8	3	3.8	0.18		★	★	★	★
		1.75		**MB-07TH175MM-10R/L**	0.95	10	5.8	2.9	3.8	0.21		★	★	★	★
		2.00		**MB-07TH200MM-10R/L**	1.08	10	5.8	2.75	3.8	0.25		★	★	★	★
		2.50		**MB-07TH250MM-10R/L**	1.35	10	5.8	2.55	3.8	0.31		★	★	★	★
UN 60°	07		32	**MB-07TH320UN-10R**	0.42	10	5.8	3.4	3.9	0.1		★	★	★	★
			28	**MB-07TH280UN-10R**	0.49	10	5.8	3.4	3.9	0.11		★	★	★	★
			24	**MB-07TH240UN-10R**	0.57	10	5.8	3.3	3.9	0.13		★	★	★	★
			20	**MB-07TH200UN-10R**	0.68	10	5.8	3.2	3.9	0.15		★	★	★	★
			18	**MB-07TH180UN-10R**	0.76	10	5.8	3.2	3.9	0.17		★	★	★	★
			16	**MB-07TH160UN-10R**	0.86	10	5.8	3.1	3.9	0.19		★	★	★	★
			14	**MB-07TH140UN-10R**	0.98	10	5.8	3.2	3.9	0.22		★	★	★	★
Whitworth 55°	07		19	**MB-07TH190WH-10R/L**	0.85	10	5.8	2.8	3.8	0.31	0.18	★	★	★	★
			14	**MB-07TH140WH-10R/L**	1.16	10	5.8	2.6	3.8	0.31	0.24	★	★	★	★
			11	**MB-07TH110WH-10R/L**	1.48	10	5.8	2.3	3.8	0.31	0.31	★	★	★	★
NPT 60°	07		18	**MB-07TH180NT-10R**	1.19	10	5.8	2.9	3.8	0.05		★	★	★	★
			14	**MB-07TH140NT-10R**	1.48	10	5.8	2.7	3.8	0.07		★	★	★	★
												P25	M25	N25	S25

Ordering example: 10 pieces CXS-04TH050VM-4215R 1025
CXS-04TH050VM-4215L 1025
R = Right hand, L = Left hand

★= First choice

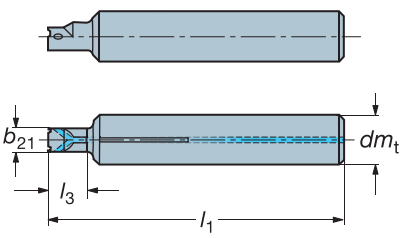
B91 B117 GC B122 B2

SANDVIK Coromant

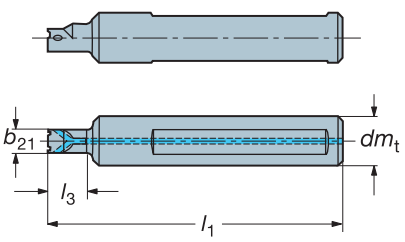
CoroCut® MB

Steel shank boring bars

Cylindrical



Cylindrical with flat



All with internal coolant supply

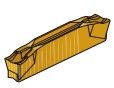
Bar dia. Dimensions, mm

dm_t	Ordering code	b_{21}	l_1	l_3	Insert size
Cylindrical					
16	**MB-A16-16-07R**	7.4	97	16	MB-07..
16	**MB-A16-20-09R**	9.5	100	20	MB-09..
Cylindrical with flats					
16	**MB-A16-16-07**	7.4	97	16	MB-07..
16	**MB-A16-20-09**	9.5	100	20	MB-09..

Ordering example: 2 pieces MB-A16-16-07R
R = Right hand

Main spare parts

Insert size	Insert screw	Key (Torx Plus)	Torque
07	5513 039-01	5680 051-03 (9IP)	1.4
09	5513 039-02	5680 049-01 (15IP)	3.0

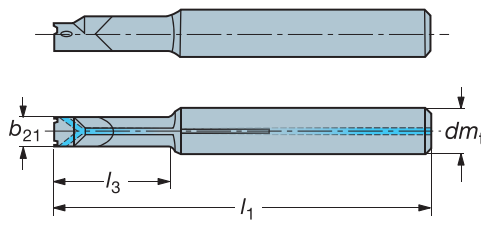
 B6

 G6

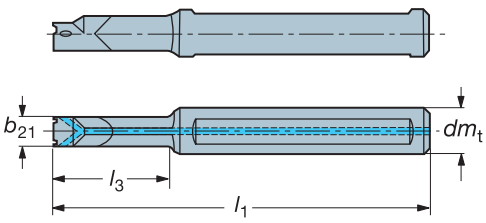
CoroCut® MB

Carbide shank boring bars

Cylindrical



Cylindrical with flat



All with internal coolant supply

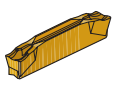
Bar dia. Dimensions, mm

dm_t	Ordering code	b_{21}	l_1	l_3	Insert size
Cylindrical					
12	**MB-E12-24-07R**	7.4	92	24	MB-07..
12	**MB-E12-32-07R**	7.4	100	32	MB-07..
12	**MB-E12-34-09R**	9.5	100	34	MB-09..
12	**MB-E12-45-09R**	9.5	110	45	MB-09..
12	**MB-E12-48-07R**	7.4	115	48	MB-07..
12	**MB-E12-64-09R**	9.5	130	64	MB-09..
16	**MB-E16-34-09R**	9.5	100	34	MB-09..
16	**MB-E16-45-09R**	9.5	110	45	MB-09..
16	**MB-E16-64-09R**	9.5	130	64	MB-09..
Cylindrical with flats					
16	**MB-A16-16-07**	7.4	97	16	MB-07..
12	**MB-E12-24-07**	7.4	92	24	MB-07..
12	**MB-E12-32-07**	7.4	100	32	MB-07..
12	**MB-E12-34-09**	9.5	100	34	MB-09..
12	**MB-E12-45-09**	9.5	110	45	MB-09..
12	**MB-E12-48-07**	7.4	115	48	MB-07..
12	**MB-E12-64-09**	9.5	130	64	MB-09..
16	**MB-E16-34-09**	9.5	100	34	MB-09..
16	**MB-E16-45-09**	9.5	110	45	MB-09..
16	**MB-E16-64-09**	9.5	130	64	MB-09..

Ordering example: 2 pieces MB-E12-24-07R
R = Right hand

Main spare parts

Insert size	Insert screw	Key (Torx Plus)	Torque
07	5513 039-01	5680 051-03 (9IP)	1.4
09	5513 039-02	5680 049-01 (15IP)	3.0

 B6

 G6

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