

# CoroThread® 266

For circlip grooving and other shallow grooves

B

## Application

- Shallow grooving
- Circlip grooving
- Low to medium feeds

C

## ISO application area:



D

## Benefits and features

- High indexing repeatability
- Stable solution with low risk of vibrations
- Cost efficient solution with three cutting edges
- External and internal grooves
- Sharp cutting edges for high quality grooves

E

[www.sandvik.coromant.com/corothread266](http://www.sandvik.coromant.com/corothread266)

### Inserts

- Inserts in grade GC1135
- Positive geometry for low cutting force

### Tools

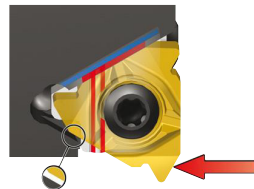
- Coromant Capto® cutting units
- Shank tools
- Boring bars
- CoroTurn® SL heads

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G

### Secure iLock™ clamping

The slotted insert sits rigidly on the T-rails in the pocket eliminating any insert movement caused by cutting force variations.



The inserts can be used in CoroThread 266 tool holders. For correct inclination angle, a 0° shim must be used.



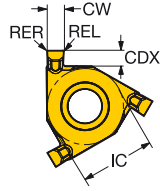
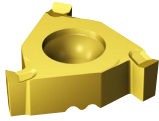
Right hand style shown unless otherwise stated

H



# CoroThread® 266 insert for grooving

For circlip grooving and machining in shallow grooves



	CW	REL	RER	CDX	Ordering code	P	M	K	N	S	Dimensions, mm					
						1135	1135	1135	1135	1135	AN	CWTOLL	CWTOLU	RETOLL	RETOLU	
Medium	16	1.10	0.08	0.08	1.3	254R/LG-16CC01-110	*	*	*	*	*	0°	0.050	0.130	-0.080	0.020
		1.30	0.08	0.08	1.6	254R/LG-16CC01-130	*	*	*	*	*	0°	0.050	0.130	-0.080	0.020
		1.60	0.08	0.08	1.9	254R/LG-16CC01-160	*	*	*	*	*	0°	0.050	0.130	-0.080	0.020
		1.85	0.08	0.08	1.9	254R/LG-16CC01-185	*	*	*	*	*	0°	0.050	0.130	-0.080	0.020
		2.15	0.08	0.08	1.9	254R/LG-16CC01-215	*	*	*	*	*	0°	0.050	0.130	-0.080	0.020
	22	2.15	0.08	0.08	2.2	254R/LG-22CC01-215	*	*	*	*	*	0°	0.050	0.130	-0.080	0.020
		2.65	0.15	0.15	2.2	254R/LG-22CC01-265	*	*	*	*	*	0°	0.050	0.130	-0.080	0.020
		3.15	0.15	0.15	2.2	254R/LG-22CC01-315	*	*	*	*	*	0°	0.050	0.130	-0.080	0.020
		4.15	0.15	0.15	2.6	254R/LG-22CC01-415	*	*	*	*	*	0°	0.050	0.130	-0.080	0.020

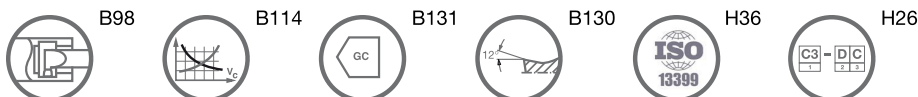
SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand

**Note!**

The right hand insert can be used in right hand external and left hand internal holders, and the left hand insert in left hand external and right hand internal holders.

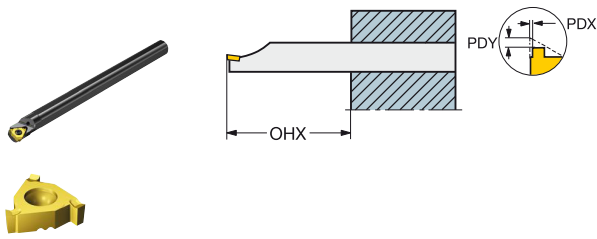
When using CoroThread® 266 boring bars for these inserts, a shim giving an angle of inclination of 0° must be used, see page C75



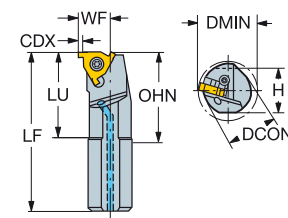
# CoroThread® 266 boring bar for grooving

Screw clamp design dedicated for circlip grooves

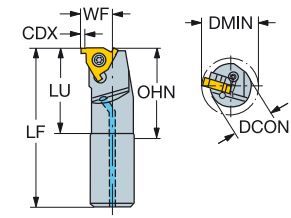
Internal coolant supply



254R/LKF






254R/LKF-R






266R/LL,  
254R/LG

Cylindrical with flats

	CZC <sub>MS</sub>	CDX	DMIN <sub>1</sub>	LU	OHX	OHN	CNCS	Ordering code	Dimensions, mm				MIID				
									DCON	H	LF	WF					
	16	16	1.3	20.0	27.0	48.0	27.0	1	254R/LKF-16-16	16	15.0	201.0	12.0	10	3.0	0.30	254RG-16CC..
	22	20	2.2	25.0	34.2	60.0	34.2	1	254R/LKF-20-22	20	18.0	251.0	15.0	10	5.0	0.53	254RG-22CC..

Cylindrical

	CZC <sub>MS</sub>	CDX	DMIN <sub>1</sub>	LU	OHX	OHN	CNCS	Ordering code	Dimensions, mm				MIID		
									DCON	LF	WF				
	16	16	1.3	20.0	48.0	27.0	1	254R/LKF-16-16-R	16	125.0	12.0	10	3.0	0.20	254RG-16CC..
	22	20	2.2	25.0	48.0	27.0	1	254R/LKF-20-22-R	20	141.0	15.0	10	5.0	0.32	254RG-22CC..

SSC = To correspond with SSC on insert.


R = Right hand, L = Left hand

 No shims used

For PDX/PDY values - see insert page.

For larger bar diameters, use bars type 266R/LKF with shim 0°.

When using CoroThread 266 circlip grooving inserts type 254R/LG, the right hand round shank tool uses a left hand insert and the left hand round shank tool a right hand insert.

Spare parts		
	CZC <sub>MS</sub>	Screw
16	16	5513 020-02
22	20	5513 020-07

For complete list of spare parts, see [www.sandvik.coromant.com](http://www.sandvik.coromant.com)

