

# CoroCut® 3

## Shallow parting off and precision grooving

### Application

- Parting off
- Circlip grooving
- External grooving
- Profiling
- Optimized for parting off bearing rings

### ISO application area:



### Benefits and features

- Precision grooving down to the smallest widths
- Maximum versatility – one holder for all insert widths
- Cost efficient due to three cutting edges
- Stable interface
- Three-edge inserts with very close insert indexing tolerance
- Tailor Made inserts available

Right hand style shown unless otherwise stated

[www.sandvik.coromant.com/corocut3](http://www.sandvik.coromant.com/corocut3)

### Inserts

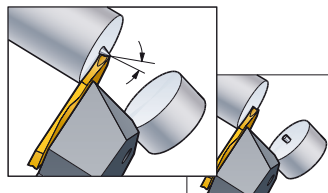
- GC1125: One versatile grade in four different geometries:
- CM for parting off in the medium feed area
- CS for parting off in extremely low feed machining
- GS for precision grooving at low feed
- RS for profiling and grooving at low feed

### Tools

- Coromant Capto®
- QS Shank tools
- Rectangular shank holders
- CoroTurn® SL cutting heads

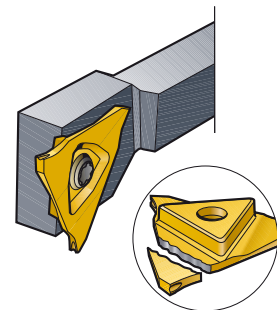
### Front angled inserts

Inserts available with front angle for pip and burr free parting off.



### Independent insert location if breakages occur

Inserts can be indexed directly in the machine by unscrewing two turns. If insert breakage occurs, the clamping mechanism will not be affected - just index the insert and re-start the machine.



B72







B72





H35

## B Inserts

	Parting		Grooving	Profiling
				
	<b>123-CM</b>	<b>123-CS</b>	<b>123-GS</b>	<b>123-RS</b>
Insert width, mm	1.00-2.00	1.00-2.00	0.50-3.18	0.50-3.00
Page	B73	B73	B75	B76

## C

## D Tools

		
<b>Tool holding</b>	<b>Parting and grooving</b>	<b>Grooving</b>
Coromant Capto®	B77	
Shank	B78	
CoroTurn® SL cutting head		B79

## E

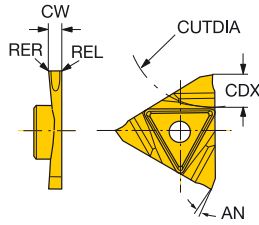
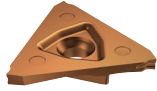
## F

## G

## H

# CoroCut® 3 insert for parting

Shallow parting



							P	M	K	N	S	Dimensions, mm					
		SSC	CW	REL	RER	CDX	Ordering code	1125	1125	1125	1125	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing		T	1.00	0.00	0.00	4.3	N123T3-0100-0000-CS	*	*	*	*	7°	50.00	-0.050	0.030	0.000	0.050
			1.50	0.00	0.00	6.4	N123T3-0150-0000-CS	*	*	*	*	7°	100.00	-0.050	0.030	0.000	0.050
			2.00	0.00	0.00	6.4	N123T3-0200-0000-CS	*	*	*	*	7°	100.00	-0.050	0.030	0.000	0.050
		U	1.00	0.00	0.00	4.3	N123U3-0100-0000-CS	*	*	*	*	7°	50.00	-0.050	0.030	0.000	0.050
			1.50	0.00	0.00	6.4	N123U3-0150-0000-CS	*	*	*	*	7°	100.00	-0.050	0.030	0.000	0.050
			2.00	0.00	0.00	6.4	N123U3-0200-0000-CS	*	*	*	*	7°	100.00	-0.050	0.030	0.000	0.050
Medium		T	1.00	0.10	0.10	4.3	N123T3-0100-0001-CM	*	*	*	*	7°	50.00	-0.030	0.030	-0.050	0.050
			1.50	0.10	0.10	6.4	N123T3-0150-0001-CM	*	*	*	*	7°	100.00	-0.030	0.030	-0.050	0.050
			2.00	0.10	0.10	6.4	N123T3-0200-0001-CM	*	*	*	*	7°	100.00	-0.030	0.030	-0.050	0.050
		U	1.00	0.10	0.10	4.3	N123U3-0100-0001-CM	*	*	*	*	7°	50.00	-0.030	0.030	-0.050	0.050
			1.50	0.10	0.10	6.4	N123U3-0150-0001-CM	*	*	*	*	7°	100.00	-0.030	0.030	-0.050	0.050
			2.00	0.10	0.10	6.4	N123U3-0200-0001-CM	*	*	*	*	7°	100.00	-0.030	0.030	-0.050	0.050

SSC = To correspond with SSC on holder.

T = Right hand cutting insert, U = Left hand cutting insert.

N = Neutral



B72



B114



B131



B128



H36



H35



H17

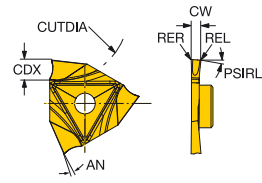
# CoroCut® 3 insert for parting

## Shallow parting

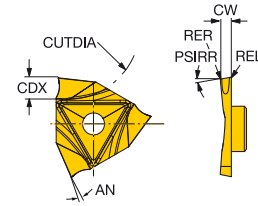
B



L123T3-CS



R123T3-CS



C

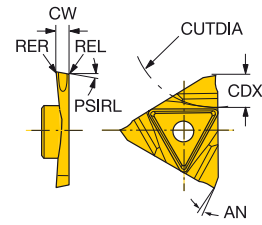
								Dimensions, mm												
		SSC	CW	REL	RER	CDX	PSIRL	PSIRR	Ordering code	P	M	K	N	S	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU
										1125	1125	1125	1125							
Finishing		T	1.00	0.00	0.00	4.2	5.0		L123T3-0100-0500-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			1.00	0.00	0.00	4.2	10.0		L123T3-0100-1000-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			2.00	0.00	0.00	6.3	10.0		L123T3-0200-1000-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			2.00	0.00	0.00	6.3	15.0		L123T3-0200-1500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			1.00	0.00	0.00	4.2		5.0	R123T3-0100-0500-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			1.00	0.00	0.00	4.2		10.0	R123T3-0100-1000-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			1.00	0.00	0.00	4.2		15.0	R123T3-0100-1500-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			1.50	0.00	0.00	6.3		5.0	R123T3-0150-0500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			1.50	0.00	0.00	6.3		10.0	R123T3-0150-1000-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			1.50	0.00	0.00	6.3		15.0	R123T3-0150-1500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			2.00	0.00	0.00	6.3		5.0	R123T3-0200-0500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			2.00	0.00	0.00	6.3		10.0	R123T3-0200-1000-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			2.00	0.00	0.00	6.3		15.0	R123T3-0200-1500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050

D

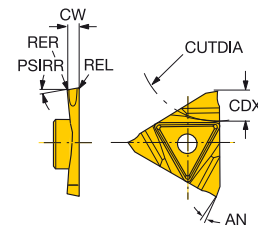
E



L123U3-CS



R123U3-CS



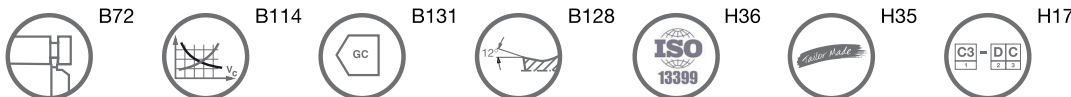
F

								Dimensions, mm												
		SSC	CW	REL	RER	CDX	PSIRL	PSIRR	Ordering code	P	M	K	N	S	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU
										1125	1125	1125	1125							
Finishing		U	1.00	0.00	0.00	4.2	5.0		L123U3-0100-0500-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			1.00	0.00	0.00	4.2	10.0		L123U3-0100-1000-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			1.00	0.00	0.00	4.2	15.0		L123U3-0100-1500-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			1.50	0.00	0.00	6.3	5.0		L123U3-0150-0500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			1.50	0.00	0.00	6.3	10.0		L123U3-0150-1000-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			1.50	0.00	0.00	6.3	15.0		L123U3-0150-1500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			2.00	0.00	0.00	6.3	5.0		L123U3-0200-0500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			2.00	0.00	0.00	6.3	10.0		L123U3-0200-1000-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			2.00	0.00	0.00	6.3	15.0		L123U3-0200-1500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			1.00	0.00	0.00	4.2		5.0	R123U3-0100-0500-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			1.00	0.00	0.00	4.2		10.0	R123U3-0100-1000-CS	*	*	*	*	*	7°	50.00	-0.100	0.000	0.000	0.050
			1.50	0.00	0.00	6.3		5.0	R123U3-0150-0500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			1.50	0.00	0.00	6.3		10.0	R123U3-0150-1000-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
			1.50	0.00	0.00	6.3		15.0	R123U3-0150-1500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050
	2.00	0.00	0.00	6.3		5.0	R123U3-0200-0500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050		
	2.00	0.00	0.00	6.3		10.0	R123U3-0200-1000-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050		
	2.00	0.00	0.00	6.3		15.0	R123U3-0200-1500-CS	*	*	*	*	*	7°	100.00	-0.100	0.000	0.000	0.050		

SSC = To correspond with SSC on holder.  
T = Right hand cutting insert, U = Left hand cutting insert.

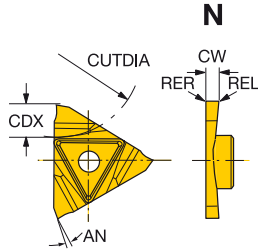
R = Right hand, L = Left hand

H

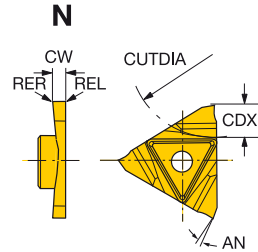


# CoroCut® 3 insert for grooving

## Grooving



							Dimensions, mm											
		SSC	CW	REL	RER	CDX	Ordering code	P	M	K	N	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU	
											1125	1125	1125	1125				
Finishing		T	0.50	0.00	0.00	1.5	N123T3-0050-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			0.60	0.00	0.00	1.6	N123T3-0060-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			0.70	0.00	0.00	1.7	N123T3-0070-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			0.80	0.00	0.00	1.8	N123T3-0080-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			0.90	0.00	0.00	2.0	N123T3-0090-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.00	0.00	0.00	2.2	N123T3-0100-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.20	0.00	0.00	2.3	N123T3-0120-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.40	0.00	0.00	2.7	N123T3-0140-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.50	0.00	0.00	3.0	N123T3-0150-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.60	0.00	0.00	3.2	N123T3-0160-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.70	0.00	0.00	3.3	N123T3-0170-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.95	0.00	0.00	3.9	N123T3-0195-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			2.00	0.00	0.00	4.0	N123T3-0200-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			2.25	0.00	0.00	4.5	N123T3-0225-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			2.50	0.00	0.00	5.0	N123T3-0250-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
	2.75	0.00	0.00	5.5	N123T3-0275-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050		
	3.00	0.00	0.00	6.0	N123T3-0300-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050		
	3.18	0.00	0.00	6.0	N123T3-0318-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050		



							Dimensions, mm											
		SSC	CW	REL	RER	CDX	Ordering code	P	M	K	N	AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU	
											1125	1125	1125	1125				
Finishing		U	0.50	0.00	0.00	1.5	N123U3-0050-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			0.70	0.00	0.00	1.7	N123U3-0070-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			0.80	0.00	0.00	1.8	N123U3-0080-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			0.90	0.00	0.00	2.0	N123U3-0090-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.00	0.00	0.00	2.2	N123U3-0100-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.20	0.00	0.00	2.3	N123U3-0120-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.40	0.00	0.00	2.7	N123U3-0140-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.50	0.00	0.00	3.0	N123U3-0150-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.60	0.00	0.00	3.2	N123U3-0160-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			1.70	0.00	0.00	3.3	N123U3-0170-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			2.00	0.00	0.00	4.0	N123U3-0200-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			2.25	0.00	0.00	4.5	N123U3-0225-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			2.50	0.00	0.00	5.0	N123U3-0250-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050
			3.00	0.00	0.00	6.0	N123U3-0300-0000-GS	*	*	*	*	*	7°	100.00	-0.020	0.020	0.000	0.050

SSC = To correspond with SSC on holder.

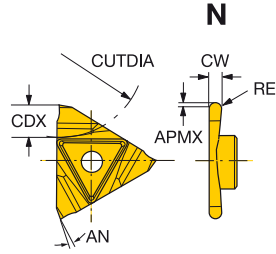
T = Right hand cutting insert, U = Left hand cutting insert.

N = Neutral



# CoroCut® 3 insert for profiling

Grooving/Profiling



B

C

	SSC	CW	RE	CDX	APMX	Ordering code	Dimensions, mm				AN	CUTDIA	CWTOLL	CWTOLU	RETOLL	RETOLU	
							P	M	K	N							
							11/25	11/25	11/25	11/25							
<p>Finishing</p>	T	0.50	0.25	1.5	0.3	N123T3-0050-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050	
		0.80	0.40	1.8	0.5	N123T3-0080-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050	
		1.00	0.50	2.2	0.5	N123T3-0100-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050	
		1.50	0.75	3.3	0.5	N123T3-0150-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050	
		2.00	1.00	4.0	1.0	N123T3-0200-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050	
		2.50	1.25	5.0	1.0	N123T3-0250-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050	
		3.00	1.50	6.0	1.0	N123T3-0300-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050	
		U	0.50	0.25	1.5	0.3	N123U3-0050-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050
			0.80	0.40	1.8	0.5	N123U3-0080-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050
			1.00	0.50	2.2	0.5	N123U3-0100-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050
			1.50	0.75	3.3	0.5	N123U3-0150-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050
			2.00	1.00	4.0	1.0	N123U3-0200-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050
			3.00	1.50	6.0	1.0	N123U3-0300-RS	*	*	*	*	7°	100.00	-0.020	0.020	-0.050	0.050

SSC = To correspond with SSC on holder.  
 T = Right hand cutting insert, U = Left hand cutting insert.

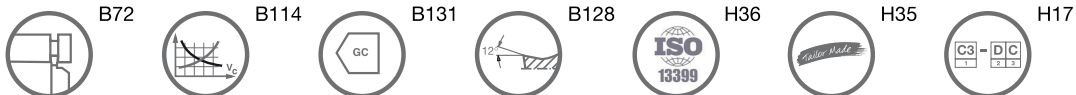
N = Neutral

E

F

G

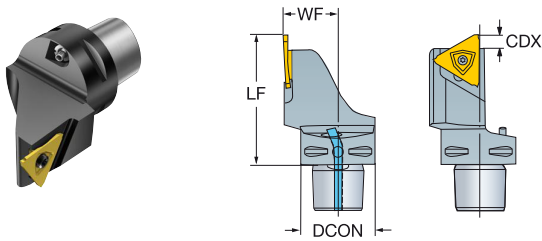
H



# CoroCut® 3 cutting unit for parting and grooving

Screw clamp design

Coromant Capto® - Internal coolant supply



SSC	CZC <sub>MS</sub>	CDX	CNSC	Ordering code	Dimensions, mm						MIID
					DCON	LF	WF	BAR	NM	KG	
T	C3	6.4	3	C3-RF123T06-22045BM	32	45.0	22.0	10	3.0	0.23	N123T3-0150-CM
	C4	6.4	3	C4-RF123T06-27060BM	40	60.0	27.0	10	3.0	0.45	N123T3-0150-CM
U	C3	6.4	3	C3-LF123U06-22045BM	32	45.0	22.0	10	3.0	0.23	N123U3-0150-CM
	C4	6.4	3	C4-LF123U06-27060BM	40	60.0	27.0	10	3.0	0.45	N123U3-0150-CM

SSC = To correspond with SSC on insert.

T = Right hand cutting insert, U = Left hand cutting insert.

R = Right hand, L = Left hand

Spare parts	
Screw	Nozzle
5513 020-62	5691 034-01

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



A

PARTING AND GROOVING

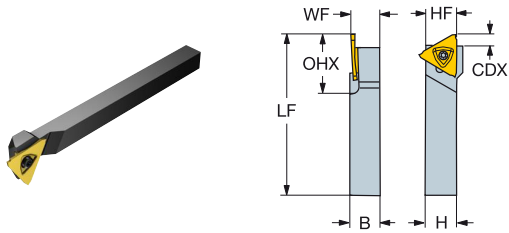
External tools

# CoroCut® 3 shank tool for parting and grooving

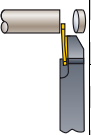
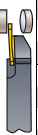
Screw clamp design

ENG

B



C

	SSC	CZC <sub>MS</sub>	CDX	OHX	Ordering code	Dimensions, mm						NM	KG	MIID
						B	H	LF	WF	HF				
	T	20 x 20	6.4	23.0	RF123T06-2020BM	20.0	20.0	125.0	20.0	20.0	3.0	0.39	N123T3-0150-CM	
		25 x 25	6.4	23.0	RF123T06-2525BM	25.0	25.0	150.0	25.0	25.0	3.0	0.71	N123T3-0150-CM	
		32 x 32	6.4	23.0	RF123T06-3232BM	32.0	32.0	170.0	32.0	32.0	3.0	1.31	N123T3-0150-CM	
	U	20 x 20	6.4	23.0	LF123U06-2020BM	20.0	20.0	125.0	20.0	20.0	3.0	0.39	N123U3-0150-CM	
		25 x 25	6.4	23.0	LF123U06-2525BM	25.0	25.0	150.0	25.0	25.0	3.0	0.71	N123U3-0150-CM	
		32 x 32	6.4	23.0	LF123U06-3232BM	32.0	32.0	170.0	32.0	32.0	3.0	1.31	N123U3-0150-CM	

D

SSC = To correspond with SSC on insert.

T = Right hand cutting insert, U = Left hand cutting insert.

R = Right hand, L = Left hand

Spare parts

Screw

5513 020-62

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

E

F

G

H



B72



F2



E3

ISO  
13399

H36



H35



H18

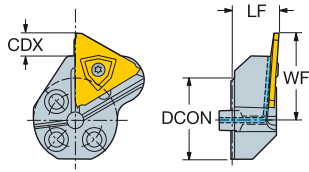
B 78



# CoroCut® 3 head for grooving

Screw clamp design

CoroTurn® SL - Internal coolant supply



	SSC	CZC <sub>MS</sub>	CDX	CNCS	Ordering code	Dimensions, mm						MIID
						DCON	LF	WF	BAR	NM	KG	
	T	25	6.4	1	570-25L123T06B	25	14.0	26.0	10	3.0	0.08	N123T3-0150-CM
		32	6.4	1	570-32L123T06B	32	14.0	28.5	10	3.0	0.11	N123T3-0150-CM
		40	6.4	1	570-40L123T06B	40	14.0	32.5	10	3.0	0.15	N123T3-0150-CM
	U	25	6.4	1	570-25R123U06B	25	14.0	26.0	10	3.0	0.08	N123U3-0150-CM
		32	6.4	1	570-32R123U06B	32	14.0	28.5	10	3.0	0.11	N123U3-0150-CM
		40	6.4	1	570-40R123U06B	40	14.0	32.5	10	3.0	0.15	N123U3-0150-CM

SSC = To correspond with SSC on insert.

R = Right hand, L = Left hand

T = Right hand cutting insert, U = Left hand cutting insert.

Spare parts
Clamping screw
5513 020-62

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

