

CoroCut® XS

For external machining of small and slender components

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Application

- Parting off
- External threading
- External grooving
- Turning

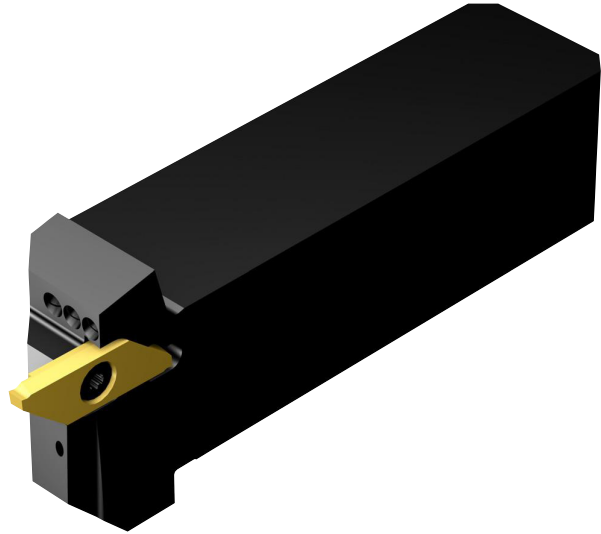
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ISO application area:



Benefits and features

- High precision
- Close tolerances
- Good accessibility when changing inserts
- Wide variety of insert widths
- Sharp cutting edges
- All inserts fit into the same tool holder
- High quality ground inserts and holders
- Full profile inserts for high quality threads in one operation
- Designed to maintain the tool holder intact in case of insert breakage.
- Available with precision coolant



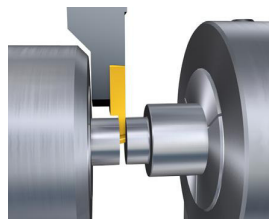
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www.sandvik.coromant.com/corocutxs

HOLDERS

Dedicated holders for parting off close to sub spindle are available in high precision square shank style.



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Inserts

Turning	Back turning	Parting off	Grooving	Profiling	Threading
A261	A261	B81	B101	B105	C56

Tools

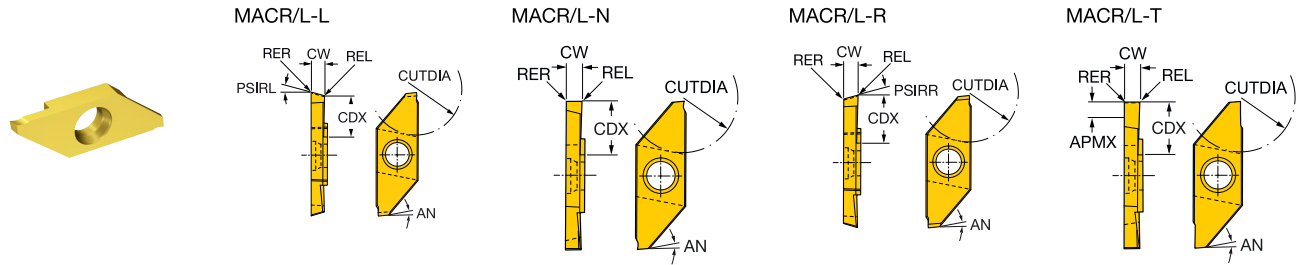
QS™ shank tools	CoroTurn® SL cutting heads
B83	B84

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Right hand style shown unless otherwise stated

CoroCut® XS insert for parting



										Dimensions, mm												
										P	M	K	N	S								
		SSC	CW	REL	RER	CDX	PSIRL	PSIRR	APMX	Ordering code	1025	1105	1025	1105	1025	1105	1025	1105	1025	1105	AN	
Finishing		3	0.7	0.05	0.05	4.3		15°		MACR/L 3 070-R	★	★	★	★	★	★	★	★	★	★	★	6°
			1.0	0.05	0.05	6.3		15°		MACR/L 3 100-R	★	★	★	★	★	★	★	★	★	★	★	6°
			1.5	0.05	0.05	6.3		15°		MACR/L 3 150-R	★	★	★	★	★	★	★	★	★	★	★	6°
			2.0	0.05	0.05	8.5		15°		MACR/L 3 200-R	★	★	★	★	★	★	★	★	★	★	★	6°
		3	0.7	0.05	0.05	4.3				MACR/L 3 070-N	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
			1.0	0.05	0.05	6.3				MACR/L 3 100-N	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
			1.5	0.05	0.05	6.3				MACR/L 3 150-N	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
			2.0	0.05	0.05	8.5				MACR/L 3 200-N	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
		3	0.7	0.05	0.05	4.3		15°		MACR/L 3 070-L	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
			1.0	0.05	0.05	6.3		15°		MACR/L 3 100-L	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
			1.5	0.05	0.05	6.3		15°		MACR/L 3 150-L	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
			1.5	0.05	0.05	6.3		20°		MACR/L 3 150-R20	★	★	★	★	★	★	★	★	★	★	★	6°
			2.0	0.05	0.05	8.5		15°		MACR/L 3 200-L	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
			2.0	0.05	0.05	8.5		20°		MACR/L 3 200-R20	★	★	★	★	★	★	★	★	★	★	★	6°
		3	1.0	0.05	0.05	6.3			1.5	MACR/L 3 100-T	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
			1.5	0.05	0.05	6.3			1.5	MACR/L 3 150-T	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°
		2.0	0.05	0.05	8.2			3.0	MACR/L 3 200-T	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°	
		2.5	0.05	0.05	8.2			3.0	MACR/L 3 250-T	☆	★	☆	★	★	☆	★	☆	★	☆	★	6°	

SSC = To correspond with SSC on tool.

R = Right hand, L = Left hand

Tolerances:

	CWTOLL	CWTOLU	RETOLL	RETOLU
MACR/L-L	-0.020	0.020	-0.03	0.03
MACR/L-N	-0.020	0.020	-0.03	0.03
MACR/L-R	-0.020	0.020	-0.03	0.03
MACR/L-R20	-0.020	0.020	-0.03	0.03
MACR/L-T	-0.020	0.020	-0.03	0.03



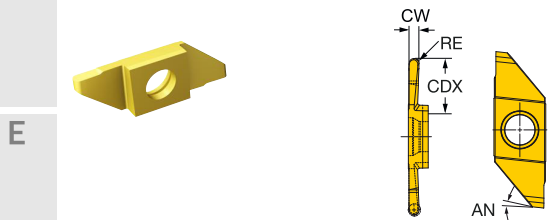
CoroCut® XS insert for grooving



							P	M	K	N	S	Dimensions, mm								
		SSC	CW	REL	RER	CDX	Ordering code	1025	1025	H13A	1025	H13A	1025	H13A	H13A	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing		3	0.50	0.05	0.05	1.3	MAGR/L 3 050	★	★	★	★	★	★	★	★	6°	-0.025	0.025	-0.020	0.020
			0.75	0.05	0.05	2.5	MAGR/L 3 075	★	★	★	★	★	★	★	★	6°	-0.025	0.025	-0.020	0.020
			1.00	0.05	0.05	2.7	MAGR/L 3 100	★	★	★	★	★	★	★	★	6°	-0.025	0.025	-0.020	0.020
			1.25	0.05	0.05	2.7	MAGR/L 3 125	★	★	★	★	★	★	★	★	6°	-0.025	0.025	-0.020	0.020
			1.50	0.05	0.05	3.7	MAGR/L 3 150	★	★	★	★	★	★	★	★	6°	-0.025	0.025	-0.020	0.020
			1.75	0.05	0.05	3.7	MAGR/L 3 175	★	★	★	★	★	★	★	★	6°	-0.025	0.025	-0.020	0.020
			2.00	0.05	0.05	3.7	MAGR/L 3 200	★	★	★	★	★	★	★	★	6°	-0.025	0.025	-0.020	0.020
			2.50	0.05	0.05	3.7	MAGR/L 3 250	★	★	★	★	★	★	★	★	6°	-0.025	0.025	-0.020	0.020



CoroCut® XS insert for profiling



							P	M	K	N	S	Dimensions, mm					
		SSC	CW	RE	CDX	APMX	Ordering code	1025	1025	1025	1025	1025	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
Finishing		3	0.80	0.40	3.8	3.8	MAPL 3 080	★	★	★	★	★	6°	-0.025	0.025	-0.025	0.025
			1.25	0.63	5.0	4.0	MAPL 3 125	★	★	★	★	★	6°	-0.025	0.025	-0.025	0.025
			1.60	0.80	7.5	4.0	MAPL 3 160	★	★	★	★	★	6°	-0.025	0.025	-0.025	0.025
			2.50	1.25	7.5	4.0	MAPL 3 250	★	★	★	★	★	6°	-0.025	0.025	-0.025	0.025

SSC = To correspond with SSC on tool.

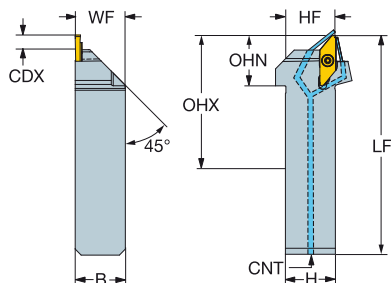
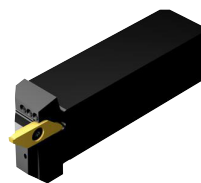
R = Right hand, L = Left hand



CoroCut® XS QS shank tool for parting and grooving

Screw clamp design

Precision coolant supply



						Dimensions, mm									
SSC	CZC _{MS}	CDX	OHX	OHN	CNSC	Ordering code	B	H	LF	WF	HF	BAR	KG	MIID	
3	20 x 20	7.3	45.0	25.0	3	QS-SMALR/L2020X3HP	20.0	20.0	94.1	20.0	20.0	150	0.24	MACL 3 200-N	
	25 x 25	7.3	50.0	25.0	3	QS-SMALR/L2525X3HP	25.0	25.0	109.1	25.0	25.0	150	0.44	MACL 3 200-N	

SSC = To correspond with SSC on insert.

R = Right hand, L = Left hand

Spare parts	
Insert screw	Nozzle
5513 027-01	5691 026-13

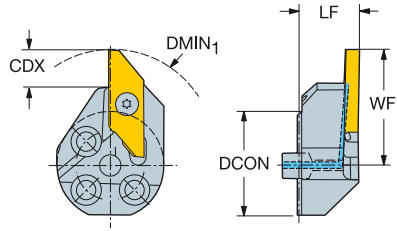
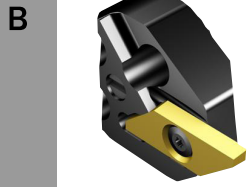
For complete list of spare parts, see www.sandvik.coromant.com



CoroCut® XS head for grooving

Screw clamp design

CoroTurn® SL - Internal coolant supply



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							Dimensions, mm						
SSC	CZC _{MS}	CDX	DMIN ₁	CNSC	Ordering code	DCON	LF	WF	BAR	NM	KG	MIID	
	3	25	8.2	42.0	1	570-25R/LSMAL3	25	14.0	26.8	10	1.2	0.08	MACR 3 200-N
		32	8.2	50.0	1	570-32R/LSMAL3	32	14.0	30.5	10	1.2	0.12	MACR 3 200-N

SSC = To correspond with SSC on insert.

R = Right hand, L = Left hand

D Note: Left hand inserts used in right hand holders, right hand inserts used in left hand holders.

Spare parts
Screw
5513 027-01

For complete list of spare parts, see www.sandvik.coromant.com

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