

CoroTurn® Prime

Introducing a completely new turning method

B

Application

- Roughing
- Finishing
- Profiling

C

ISO application area:



Benefits and features

- Higher cutting data gives increased output of components and reduced cost per component
- Chip control and long tool life gives higher security in production
- Reduction in temperature at the cutting edge means improved tool life

D



E

www.sandvik.coromant.com/coroturnprime

A-type

- Versatile and flexible - for light roughing, finishing and profiling
- Three 35° corners
- Wiper (08) for excellent surface finish
- Grades available: GC4325, GC2025, GC1115





B-type

- Stronger insert for rough machining
- Two corners
- Wiper for excellent surface finish
- Grades available: GC4325, GC2025, GC1115






F

Inserts

A-type	B-type
	
A5	A5

Tools

Coromant Capto® cutting unit	Shank tools	QS™ shank tools
		
A6-A7	A8-A9	A10-A11

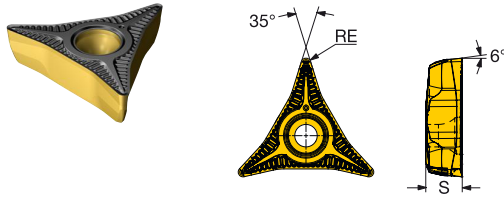
Right hand style shown unless otherwise stated

G

H

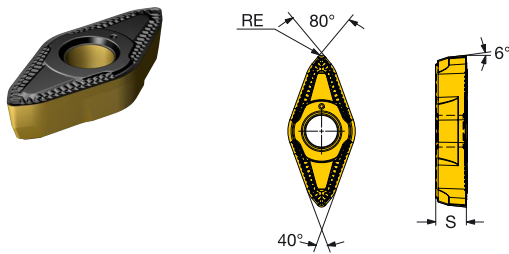
CoroTurn® Prime insert for turning

A-type insert



		SSC	S	RE	ISO CODE	P	M	S
Finishing	L5	CP-A	6.00	0.40	CP-A1104-L5	★	★	★
			6.00	0.79	CP-A1108-L5	★	★	★
	L5W	CP-A	6.00	0.79	CP-A1108-L5W	★	★	★

B-type insert



		SSC	S	RE	ISO CODE	P	M	S
Medium	M5	CP-B	5.00	0.79	CP-B1108-M5	★	★	★
	M5W	CP-B	5.00	0.79	CP-B1108-M5W	★	★	★

SSC = To correspond with SSC on holder.

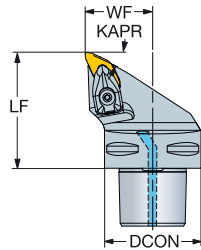


CoroTurn® Prime cutting unit for turning

Rigid clamp design

Coromant Capto® - Precision coolant supply

KAPR 25.0°



C CP-B

						Dimensions, mm							
SSC	CZC _{MS}	APMX	RMPX	CNSC	Ordering code	DCON	LF	WF	BAR	NM	KG	MIID	
	CP-B	C4	4.0	23°	3	C4-CP-25BR/L-27060-11B	40	60.0	27.0	150	3.0	0.51	CP-B1108
		C5	4.0	23°	3	C5-CP-25BR/L-35060-11B	50	60.0	35.0	150	3.0	0.76	CP-B1108
		C6	4.0	23°	3	C6-CP-25BR/L-45065-11B	63	65.0	45.0	150	3.0	1.21	CP-B1108

SSC = To correspond with SSC on holder.

R = Right hand, L = Left hand

Spare parts

Shim screw	Shim	Clamp set
5513 020-04	5322 610-01 S6	5412 028-021

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

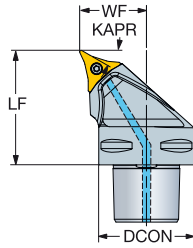


CoroTurn® Prime cutting unit for turning

Screw clamp design

Coromant Capto® - Precision coolant supply

KAPR 30.0°



CP-A

SSC	CZC _{MS}	APMX	RMPX	CNSC	Ordering code	Dimensions, mm							MIID
						DCON	LF	WF	BAR	NM	KG		
	C4	3.0	15°	3	C4-CP-30AR/L-27050-11C	40	50.0	27.0	150	3.0	0.47	CP-A1108	
	C5	3.0	15°	3	C5-CP-30AR/L-35060-11C	50	60.0	35.0	150	3.0	0.79	CP-A1108	
	C6	3.0	15°	3	C6-CP-30AR/L-45065-11C	63	65.0	45.0	150	3.0	1.25	CP-A1108	

SSC = To correspond with SSC on insert.

R = Right hand, L = Left hand

Spare parts	
Insert screw	Nozzle
5513 020-10	5691 026-03

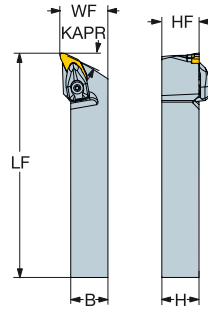
For complete list of spare parts, see www.sandvik.coromant.com



CoroTurn® Prime shank tool for turning

Rigid clamp design

KAPR 25.0°



B

C

CP-B

						Dimensions, mm									
SSC	CZC _{MS}	APMX	RMPX	OHX	OHN	Ordering code	B	H	LF	WF	HF	NM	KG	MIID	
	CP-B	20 x 20	4.0	23°	40.0	37.9	CP-25BR/L-2020-11	20.0	20.0	125.0	25.0	20.0	3.0	0.43	CP-B1108
		25 x 25	4.0	23°	50.0	37.5	CP-25BR/L-2525-11	25.0	25.0	150.0	32.0	25.0	3.0	0.75	CP-B1108
		32 x 32	4.0	23°	64.0	37.3	CP-25BR/L-3232-11	32.0	32.0	170.0	40.0	32.0	3.0	1.38	CP-B1108

D

SSC = To correspond with SSC on insert.

R = Right hand, L = Left hand

Spare parts

Shim screw	Shim	Clamp set
5513 020-04	5322 610-01 S6	5412 028-021

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

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A5



F2



E3



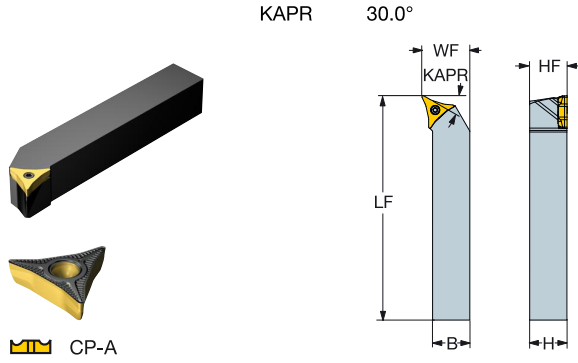
H36



H14

CoroTurn® Prime shank tool for turning

Screw clamp design



SSC	CZC _{MS}	APMX	RMPX	OHX	OHN	Ordering code	Dimensions, mm						NM	KG	MIID
							B	H	LF	WF	HF				
	CP-A	20 x 20	3.0	15°	40.0	23.7	CP-30AR/L-2020-11	20.0	20.0	125.0	25.0	20.0	3.0	0.43	CP-A1108
		25 x 25	3.0	15°	50.0	23.7	CP-30AR/L-2525-11	25.0	25.0	150.0	32.0	25.0	3.0	0.75	CP-A1108
		32 x 32	3.0	15°	64.0	23.7	CP-30AR/L-3232-11	32.0	32.0	170.0	40.0	32.0	3.0	1.36	CP-A1108

SSC = To correspond with SSC on insert.

R = Right hand, L = Left hand

Spare parts
Insert screw
5513 020-10

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

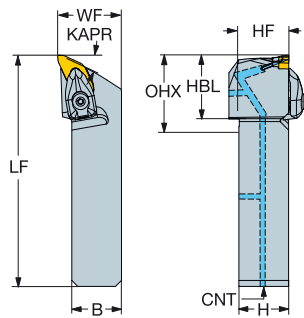


CoroTurn® Prime QS shank tool for turning

Rigid clamp design

Precision coolant supply

KAPR 25.0°



C CP-B

		Dimensions, mm															
SSC	CZC _{MS}	APMX	RMPX	OHX	CNSC	Ordering code	B	H	HBL	LF	WF	HF	CNT	BAR	NM	KG	MID
CP-B	20 x 20	4.0	23°	52.0	3	QS-CP-25BR/L-2020-11B	20.0	20.0	32.0	101.0	25.0	20.0	G1/8"	150	3.0	0.32	CP-B1108
	25 x 25	4.0	23°	57.0	3	QS-CP-25BR/L-2525-11B	25.0	25.0	32.0	116.0	32.0	25.0	G1/8"	150	3.0	0.62	CP-B1108



SSC = To correspond with SSC on insert.

R = Right hand, L = Left hand

Spare parts

Shim screw	Shim	Clamp set	Coolant screw	Sealing plug screw	Sealing plug screw
5513 020-04	5322 610-01 S6	5412 028-021	5512 104-01	3214 013-01	3214 012-01

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

F

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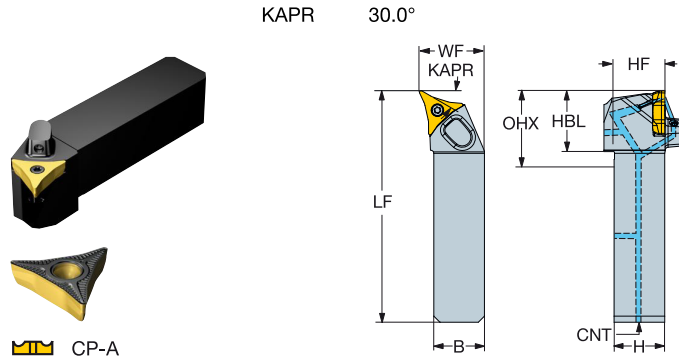
H



CoroTurn® Prime QS shank tool for turning

Screw clamp design

Precision coolant supply



		Dimensions, mm																
SSC	CZC _{MS}	APMX	RMPX	OHX	CNSC	Ordering code	B	H	HBL	LF	WF	HF	CNT	BAR	NM	KG	MIID	
	CP-A	20 x 20	3.0	15°	52.0	3	QS-CP-30AR/L-2020-11C	20.0	20.0	32.0	101.0	25.0	20.0	G1/8"	150	3.0	0.37	CP-A1108
		25 x 25	3.0	15°	55.0	3	QS-CP-30AR/L-2525-11C	25.0	25.0	32.0	114.1	32.0	25.0	G1/8"	150	3.0	0.59	CP-A1108

SSC = To correspond with SSC on insert.

R = Right hand, L = Left hand

Spare parts				
Insert screw	Nozzle	Coolant screw	Sealing plug screw	Sealing plug screw
5513 020-10	5691 026-03	5512 104-01	3214 013-01	3214 012-01

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

