

# CoroTurn® TR

For stable external profiling and internal profiling

B

**Application**

- Profiling
- Medium to finishing

**ISO application area:**

C



**Benefits and features**

- Stable insert clamping (iLock) ensures good repeatability and accuracy while allowing for high cutting data
- Precision coolant improves chip control and tool life
- Easy coolant connection and tool changes with plug and play adaptors or QS stops (QS shanks)



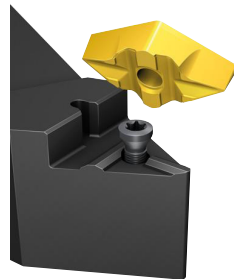
D

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

E

**iLock™ locking interface**

The T-rail on the holder and corresponding groove on the insert lock the insert precisely and securely.



F

- High stability and tolerances
- High indexing repeatability

**Inserts**

TR-DC.. A17	TR-VB.. A18

**Tools**

External machining				Internal machining	
Coromant Capto® cutting units	Shank tools	QS™ shank tools	CoroTurn® SL cutting heads	CoroTurn® SL cutting heads	CoroTurn® SL cutting heads for back boring
A19-A22	A23-A24	A25-A26	A27-A28	A29-A32	A33

Right hand style shown unless otherwise stated

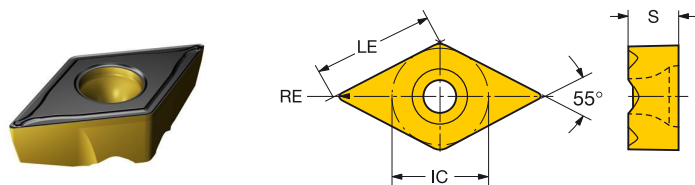
G

H



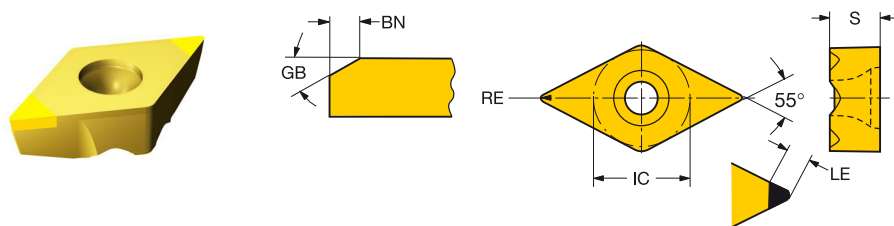
# CoroTurn® TR insert for turning

D-style insert (Rhombic 55°)



	LE	S	RE	ISO CODE	P		M				K		S		
					1525	4315	4325	1115	1125	2025	2220	HT3A	1105	1115	1125
Finishing F	13	12.6	5.53	0.40	TR-DC1304-F	☆	★	☆	☆	☆	★	★	☆	☆	☆
		12.2	5.53	0.79	TR-DC1308-F	☆	★	☆	☆	☆	★	★	☆	☆	☆
Medium M	13	12.2	5.53	0.79	TR-DC1308-M	☆	★	☆	☆	☆	☆	☆	★	☆	
		11.8	5.53	1.19	TR-DC1312-M	☆	★	☆	☆	★	☆	☆	★	☆	

## Advanced cutting materials



	LE	S	RE	GB	BN	ISO CODE	H				
							7015	7025	7105	7115	
Finishing F	13	3.1	5.53	0.4	20°	0.10	TR-DC1304S01020F	☆	☆	☆	★
		3.1	5.53	0.8	20°	0.10	TR-DC1308S01020F	☆	☆	☆	★



A19



A29



A262



A278



H36



H16

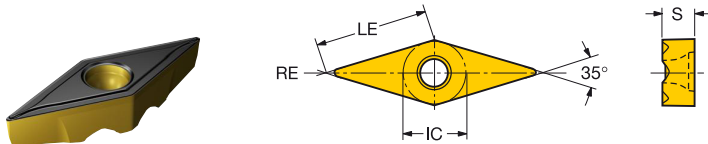


H3

# CoroTurn® TR insert for turning

V-style insert (Rhombic 35°)

B

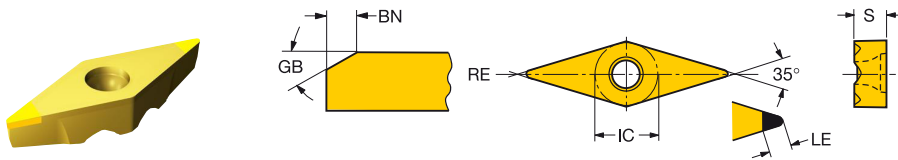


C

		LE	S	RE	ISO CODE	P		M		K	S		
						1525	4815	4825	1115	1125	2025	2220	H13A
Finishing	F	13	12.8	4.53	0.20	TR-VB1302-F	☆	★	☆	☆	★	★	★
		12.6	4.53	0.40	TR-VB1304-F	☆	★	☆	☆	★	★	★	★
		12.2	4.53	0.79	TR-VB1308-F	☆	★	☆	☆	★	★	★	★
		11.8	4.53	1.19	TR-VB1312-F	☆	★	☆	☆	★	★	★	★

## Advanced cutting materials

D



E

		LE	S	RE	GB	BN	ISO CODE	H				
								7015	7025	7105	7115	
Finishing	F	13	3.1	4.53	0.4	20°	0.10	TR-VB1304S01020F	☆	☆	☆	★
		3.1	4.53	0.8	20°	0.10	TR-VB1308S01020F	☆	☆	☆	★	

F

G

H



# CoroTurn® TR cutting unit for turning

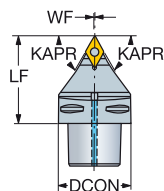
Screw clamp design

Coromant Capto® - Internal coolant supply

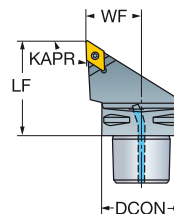


KAPR

TR-Cx-D13NCN  
62.5°



TR-Cx-D13JCR/L  
93.0°



					Dimensions, mm							
		CZC <sub>MS</sub>	RMPX	CNSC	Ordering code	DCON	LF	WF	BAR	NM	KG	MIID
	13	C4	27°	3	TR-C4-D13JCR/L-27050	40	50.0	27.0	10	3.0	0.30	TR-DC1308
		C5	27°	3	TR-C5-D13JCR/L-35060	50	60.0	35.0	10	3.0	0.68	TR-DC1308
		C6	27°	3	TR-C6-D13JCR/L-45065	63	65.0	45.0	10	3.0	1.15	TR-DC1308
	13	C4	57°	3	TR-C4-D13NCN-00050	40	50.0	0.5	10	3.0	0.34	TR-DC1308
		C5	57°	3	TR-C5-D13NCN-00060	50	60.0	0.5	10	3.0	0.61	TR-DC1308
		C6	57°	3	TR-C6-D13NCN-00065	63	65.0	0.5	10	3.0	1.08	TR-DC1308

N = Neutral, R = Right hand, L = Left hand

Spare parts			
	CZC <sub>MS</sub>	Screw	Nozzle
13	C4	5513 020-01	5691 034-01
13	C5-C6	5513 020-01	5691 034-02

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



A17



F2



E3



G2



H36



H35



H16



H5

# CoroTurn® TR cutting unit for turning

Screw clamp design

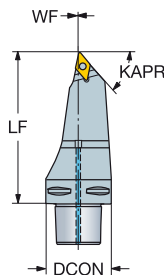
Coromant Capto® - Internal coolant supply

B



KAPR

48.0°



C



TR-DC

D

				Dimensions, mm								
	CZC <sub>MS</sub>	RMPX	CNCS	Ordering code	DCON	LF	WF	<span style="border: 1px solid black; border-radius: 50%; padding: 2px;">BAR</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">NM</span> <span style="border: 1px solid black; border-radius: 50%; padding: 2px;">KG</span>			MIID	
	13	C5	72°	3	TR-C5-D13MCL-00115	50	115.0	0.0	10	3.0	1.07	TR-DC1308
		C6	72°	3	TR-C6-D13MCL-00130	63	130.0	0.0	10	3.0	1.83	TR-DC1308

L = Left hand

Spare parts	
Screw	Nozzle
5513 020-01	5691 034-03

E

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

F

G

H



# CoroTurn® TR cutting unit for turning

Screw clamp design

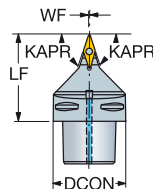
Coromant Capto® - Internal coolant supply



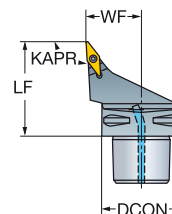
TR-VB

KAPR

TR-Cx-V13VBN  
72.5°



TR-Cx-V13JBR/L  
93.0°



					Dimensions, mm							
		CZC <sub>MS</sub>	RMPX	CNSC	Ordering code	DCON	LF	WF	BAR	NM	KG	MIID
	13	C4	50°	3	TR-C4-V13JBR/L-27050	40	50.0	27.0	10	2.0	0.34	TR-VB1308
		C5	50°	3	TR-C5-V13JBR/L-35060	50	60.0	35.0	10	2.0	0.60	TR-VB1308
		C6	50°	3	TR-C6-V13JBR/L-45065	63	65.0	45.0	10	2.0	1.07	TR-VB1308
	13	C4	70°	3	TR-C4-V13VBN-00050	40	50.0	0.5	10	2.0	0.33	TR-VB1308
		C5	70°	3	TR-C5-V13VBN-00060	50	60.0	0.5	10	2.0	0.60	TR-VB1308
		C6	70°	3	TR-C6-V13VBN-00065	63	65.0	0.5	10	2.0	1.04	TR-VB1308

N = Neutral, R = Right hand, L = Left hand

Spare parts			
	CZC <sub>MS</sub>	Screw	Nozzle
13	C4	5513 020-64	5691 034-01
13	C5-C6	5513 020-64	5691 034-02

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



A17



F2



E3



G2



H36



H35



H16

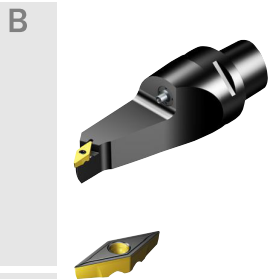


H5

# CoroTurn® TR cutting unit for turning

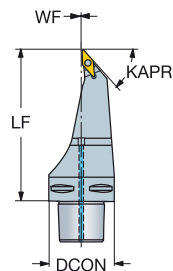
Screw clamp design

Coromant Capto® - Internal coolant supply



KAPR

50.0°



				Dimensions, mm								
D	CZC <sub>MS</sub>	RMPX	CNCS	Ordering code	DCON	LF	WF	MID				
								BAR	NM	KG		
	13	C5	47°	3	TR-C5-V13MBL-00115	50	115.0	0.0	10	2.0	1.00	TR-VB1308
		C6	47°	3	TR-C6-V13MBL-00130	63	130.0	0.0	10	2.0	1.71	TR-VB1308

L = Left hand

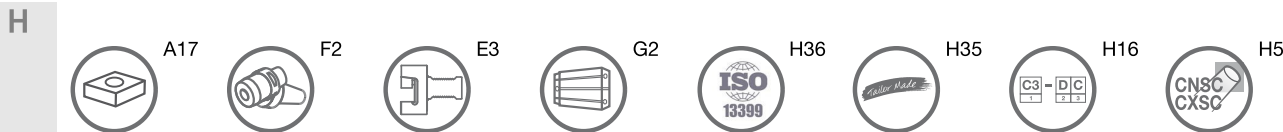
Spare parts

Screw	Nozzle
5513 020-64	5691 034-03

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

F

G



# CoroTurn® TR shank tool for turning

Screw clamp design

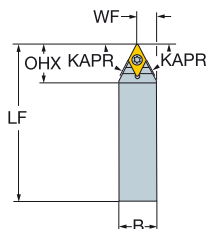


TR-DC

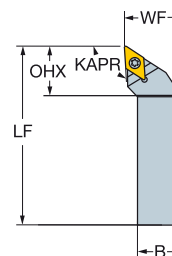
KAPR



TR-D13NCN  
62.5°



TR-D13JCR/L  
93.0°



						Dimensions, mm								
		CZC <sub>MS</sub>	RMPX	OHX	Ordering code	B	H	LF	WF	HF			MIID	
	13	16 x 16	27°	28.5	TR-D13JCR/L 1616K-S	16.0	16.0	125.0	16.0	16.0	3.0	0.27	TR-DC1308	
		20 x 20	27°	28.5	TR-D13JCR/L 2020K	20.0	20.0	125.0	25.0	20.0	3.0	0.40	TR-DC1308	
		25 x 25	27°	28.5	TR-D13JCR/L 2525M	25.0	25.0	150.0	32.0	25.0	3.0	0.73	TR-DC1308	
		32 x 25	27°	28.5	TR-D13JCR/L 3225P	25.0	32.0	170.0	32.0	32.0	3.0	1.05	TR-DC1308	
	13	16 x 16	57°	26.0	TR-D13NCN1616K-S	16.0	16.0	125.0	8.3	16.0	3.0	0.30	TR-DC1308	
		20 x 20	57°	26.0	TR-D13NCN 2020K	20.0	20.0	125.0	10.5	20.0	3.0	0.40	TR-DC1308	
		25 x 25	57°	26.0	TR-D13NCN 2525M	25.0	25.0	150.0	13.0	25.0	3.0	0.70	TR-DC1308	
		32 x 25	57°	26.0	TR-D13NCN 3225P	25.0	32.0	170.0	13.0	32.0	3.0	1.03	TR-DC1308	

N = Neutral, R = Right hand, L = Left hand

Spare parts
Screw
5513 020-01

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



A17



F2



E3



H36



H35



H16

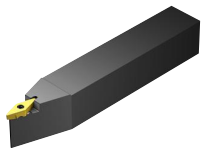




# CoroTurn® TR shank tool for turning

Screw clamp design

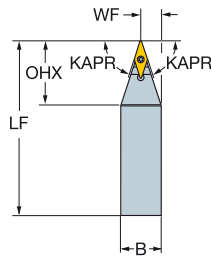
B



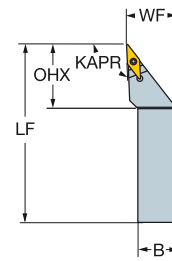
KAPR



TR-V13VBN  
72.5°



TR-V13JBR/L  
93.0°



C



TR-VB

D

		Dimensions, mm										
CZC <sub>MS</sub>	RMPX	OHX	Ordering code		B	H	LF	WF	HF	NM	KG	MIID
			13	16 x 16								
	20 x 20	70°	31.8	TR-V13VBN 2020K	20.0	20.0	125.0	10.5	20.0	2.0	0.40	TR-VB1308
	25 x 25	70°	39.7	TR-V13VBN 2525M	25.0	25.0	150.0	13.0	25.0	2.0	0.67	TR-VB1308
	32 x 25	70°	39.7	TR-V13VBN 3225P	25.0	32.0	170.0	13.0	32.0	2.0	1.00	TR-VB1308
13	16 x 16	50°	32.0	TR-V13JBR/L 1616K-S	16.0	16.0	125.0	16.0	16.0	2.0	0.27	TR-VB1308
	20 x 20	50°	32.0	TR-V13JBR/L 2020K	20.0	20.0	125.0	25.0	20.0	2.0	0.40	TR-VB1308
	25 x 25	50°	40.9	TR-V13JBR/L 2525M	25.0	25.0	150.0	32.0	25.0	2.0	0.69	TR-VB1308
	32 x 25	50°	40.9	TR-V13JBR/L 3225P	25.0	32.0	170.0	32.0	32.0	2.0	1.01	TR-VB1308

N = Neutral, R = Right hand, L = Left hand

Spare parts
Screw
5513 020-64

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

F

G

H



# CoroTurn® TR QS shank tool for turning

Screw clamp design

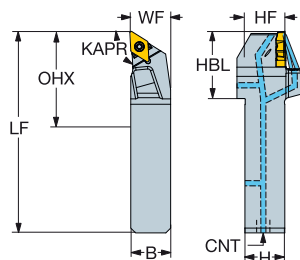
Precision coolant supply



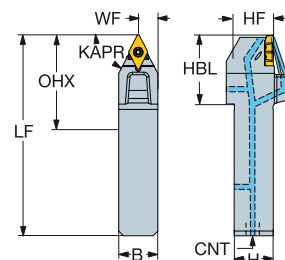
TR-DC

KAPR

QS-TR-D..JCR/L..HP  
93.0°



QS-TR-D..JCN..HP  
62.5°



		Dimensions, mm															
		CZC <sub>MS</sub>	RMPX	OHX	CNSC	Ordering code	B	H	HBL	LF	WF	HF	CNT	BAR	NM	KG	MIID
	13	20 x 20	60°	64.0	3	QS-TR-D13NCN 2020HP	20.0	20.0	44.0	113.0	10.5	20.0	G1/8	150	3.0	0.36	TR-DC1308
		25 x 25	60°	69.0	3	QS-TR-D13NCN 2525HP	25.0	25.0	44.0	128.0	13.0	25.0	G1/8	150	3.0	0.60	TR-DC1308
	13	20 x 20	30°	62.0	3	QS-TR-D13JCR/L 2020HP	20.0	20.0	42.0	111.0	20.5	20.0	G1/8	150	3.0	0.36	TR-DC1308
		25 x 25	30°	67.0	3	QS-TR-D13JCR/L 2525HP	25.0	25.0	42.0	126.0	25.5	25.0	G1/8	150	3.0	0.60	TR-DC1308

N = Neutral, R = Right hand, L = Left hand

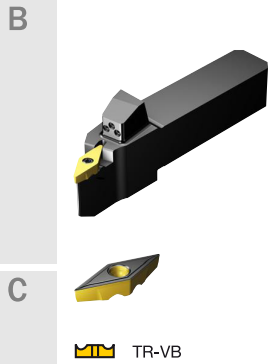
Spare parts					
Insert screw	Nozzle	Coolant screw	Washer	Stop screw	Stop screw
5513 020-01	5691 026-13	5512 104-01	5541 066-01	3214 013-01	3214 012-01

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



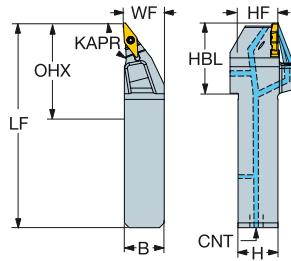
# CoroTurn® TR QS shank tool for turning

Screw clamp design  
Precision coolant supply

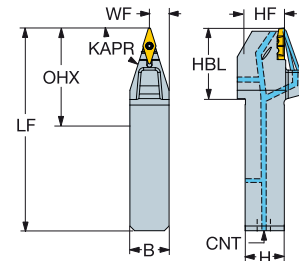


KAPR

QS-TR-V..R/L..HP  
93.0°



QS-TR-V..N..HP  
72.5°



		Dimensions, mm														
D	CZC <sub>MS</sub>	RMPX	OHX	CNSC	Ordering code	B	H	HBL	LF	WF	HF	CNT	BAR	NM	KG	MIID
							13	20 x 20	70°	65.0	3	20.0	20.0	45.0	114.0	10.5
		25 x 25	70°	70.0	3	25.0	25.0	45.0	129.0	13.0	25.0	G1/8	150	2.0	0.57	TR-VB1308
	13	20 x 20	50°	64.0	3	20.0	20.0	44.0	113.0	20.5	20.0	G1/8	150	2.0	0.34	TR-VB1308
		25 x 25	50°	69.0	3	25.0	25.0	44.0	128.0	25.5	25.0	G1/8	150	2.0	0.57	TR-VB1308

N = Neutral, R = Right hand, L = Left hand

Spare parts

Insert screw	Nozzle	Coolant screw	Washer	Stop screw	Stop screw
5513 020-64	5691 026-13	5512 104-01	5541 066-01	3214 013-01	3214 012-01

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

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# CoroTurn® TR head for turning

Screw clamp design

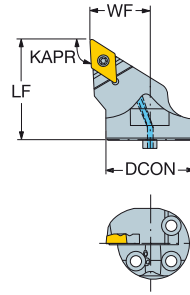
CoroTurn® SL - Precision coolant supply

KAPR

93.0°



TR-DC



						Dimensions, mm							
				Ordering code	DCON	LF	WF				MIID		
		13	32	27°	1	TR-SL-D13JCR/L-32HP-X	32	40.0	22.0	80	3.0	0.14	TR-DC1308
		40	27°	1	TR-SL-D13JCR/L-40HP-X	40	45.0	27.0	80	3.0	0.23	TR-DC1308	

R = Right hand, L = Left hand

Spare parts		
Insert screw	Nozzle	Locating tube
5513 020-01	5691 026-03	5638 031-01

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



# CoroTurn® TR head for turning

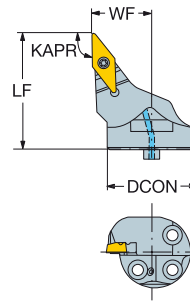
Screw clamp design

CoroTurn® SL - Precision coolant supply



KAPR

93.0°

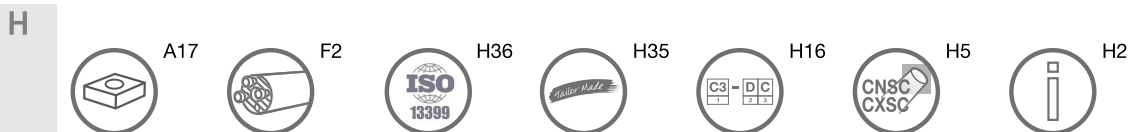


				Dimensions, mm								
D	CZC <sub>MS</sub>	RMPX	CNCS	Ordering code	DCON	LF	WF	Material			MIID	
								BAR	NM	KG		
	13	32	44°	1	TR-SL-V13JBR/L-32HP-X	32	42.0	22.0	80	2.0	0.13	TR-VB1308
		40	44°	1	TR-SL-V13JBR/L-40HP-X	40	42.0	27.0	80	2.0	0.18	TR-VB1308

R = Right hand, L = Left hand

Spare parts		
Insert screw	Nozzle	Locating tube
5513 020-64	5691 026-03	5638 031-01

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



# CoroTurn® TR head for turning

Screw clamp design

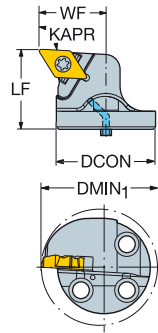
CoroTurn® SL - Precision coolant supply



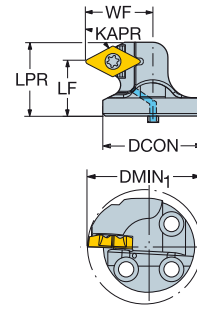
 TR-DC

KAPR

TR-SL-D13UCR/L..HP  
93.0°

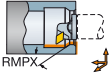
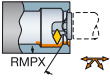


TR-SL-D13XCR/L..HP  
62.5°



B

C

	CZC <sub>MS</sub>	DMIN <sub>1</sub>	RMPX	CN5C	Ordering code	Dimensions, mm						MIID		
						DCON	LPR	LF	WF	BAR	NM		KG	
	13	32	40.0	27°	1	TR-SL-D13UCR/L-32HP	32	38.0	22.0	80	3.0	0.16	TR-DC1308	
	40	50.0	27°	1	TR-SL-D13UCR/L-40HP	40	38.0	27.0	80	3.0	0.23	TR-DC1308		
	40	54.0	27°	1	TR-SL-D13UCR/L-40HP32	40	38.0	32.0	80	3.0	0.24	TR-DC1308		
	40	59.0	27°	1	TR-SL-D13UCR/L-40HP37	40	38.0	37.0	80	3.0	0.24	TR-DC1308		
	40	63.0	27°	1	TR-SL-D13UCR/L-40HP43	40	38.0	43.0	80	3.0	0.27	TR-DC1308		
	13	32	45.0	60°	1	TR-SL-D13XCR-32HP	32	34.0	27.0	27.0	80	3.0	0.16	TR-DC1308
	40	54.0	60°	1	TR-SL-D13XCR/L-40HP32	40	25.7	22.0	32.0	80	3.0	0.20	TR-DC1308	
	40	59.0	60°	1	TR-SL-D13XCR/L-40HP37	40	25.7	22.0	37.0	80	3.0	0.22	TR-DC1308	
	40	63.0	60°	1	TR-SL-D13XCR/L-40HP43	40	25.7	22.0	43.0	80	3.0	0.23	TR-DC1308	
	40	50.0	60°	1	TR-SL-D13XCR-40HP	40	29.5	22.0	29.0	80	3.0	0.19	TR-DC1308	

R = Right hand, L = Left hand

## Spare parts

Insert screw	Nozzle	Locating tube
5513 020-01	5691 026-03	5638 031-01

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

D

E

F

G

H



# CoroTurn® TR head for turning

Screw clamp design

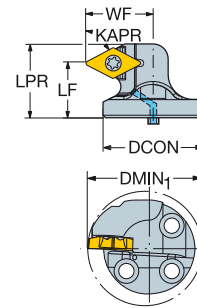
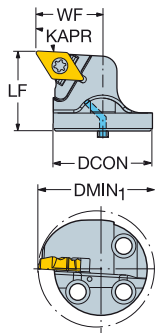
CoroTurn® SL - Internal coolant supply

B

KAPR

TR-SL-D13UCR/L  
93.0°

TR-SL-D13XCR/L  
62.5°



C



TR-DC

D

		Dimensions, mm												
		CZC <sub>MS</sub>	DMIN <sub>1</sub>	RMPX	CNSC	Ordering code	DCON	LPR	LF	WF	BAR	NM	KG	MIID
	13	25	35.0	27°	1	TR-SL-D13UCR/L-25	25	27.0	20.0	10	3.0	0.08	TR-DC1308	
		32	40.0	27°	1	TR-SL-D13UCR/L-32	32	32.0	22.0	10	3.0	0.14	TR-DC1308	
		40	50.0	27°	1	TR-SL-D13UCR/L-40	40	32.0	27.0	10	3.0	0.19	TR-DC1308	
	13	25	35.0	60°	1	TR-SL-D13XCR/L-25	25	23.3	20.0	20.0	10	3.0	0.07	TR-DC1308
		32	40.0	60°	1	TR-SL-D13XCL-32	32	29.2	22.0	22.0	10	3.0	0.13	TR-DC1308
		40	50.0	60°	1	TR-SL-D13XCR/L-40	40	29.2	22.0	27.0	10	3.0	0.17	TR-DC1308

R = Right hand, L = Left hand

E

Spare parts			
	CZC <sub>MS</sub>	Insert screw	Locating tube
13	25	5513 020-01	5552 058-02
13	32-40	5513 020-01	5638 031-01

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

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# CoroTurn® TR head for turning

Screw clamp design

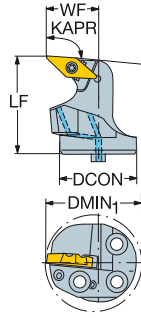
CoroTurn® SL - Precision coolant supply

KAPR

95.0°



TR-VB



							Dimensions, mm						
	CZC <sub>MS</sub>	DMIN <sub>1</sub>	RMPX	CNCS	Ordering code	DCON	LF	WF	BAR	NM	KG	MIID	
	13	32	40.0	45°	1	TR-SL-V13LBR/L-32HP	32	40.0	22.0	80	2.0	0.17	TR-VB1308
		40	50.0	45°	1	TR-SL-V13LBR/L-40HP	40	38.0	27.0	80	2.0	0.22	TR-VB1308

R = Right hand, L = Left hand

Spare parts		
Insert screw	Nozzle	Locating tube
5513 020-64	5691 026-03	5638 031-01

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





# CoroTurn® TR head for turning

Screw clamp design

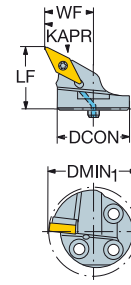
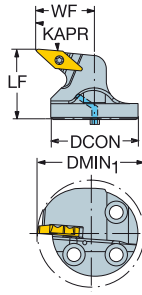
CoroTurn® SL - Internal coolant supply

B

KAPR

TR-SL-V13LBR/L  
95.0°

TR-SL-V13PBR/L  
117.5°



C



TR-VB

D

							Dimensions, mm						
		CZC <sub>MS</sub>	DMIN <sub>1</sub>	RMPX	CNSC	Ordering code	DCON	LF	WF	BAR	NM	KG	MIID
	13	25	35.0	45°	1	TR-SL-V13LBR/L-25	25	27.0	20.0	10	2.0	0.08	TR-VB1308
		32	40.0	45°	1	TR-SL-V13LBR/L-32	32	32.0	22.0	10	2.0	0.13	TR-VB1308
		40	50.0	45°	1	TR-SL-V13LBR/L-40	40	32.0	27.0	10	2.0	0.18	TR-VB1308
	13	25	33.0	25°	1	TR-SL-V13PBR/L-25	25	28.0	17.0	10	2.0	0.07	TR-VB1308
		32	40.0	25°	1	TR-SL-V13PBR/L-32	32	32.0	22.0	10	2.0	0.12	TR-VB1308
		40	50.0	25°	1	TR-SL-V13PBR/L-40	40	32.0	27.0	10	2.0	0.15	TR-VB1308

R = Right hand, L = Left hand

E

Spare parts			
	CZC <sub>MS</sub>	Insert screw	Locating tube
13	25	5513 020-64	5552 058-02
13	32-40	5513 020-64	5638 031-01

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

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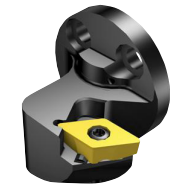
# CoroTurn® TR head for back boring

Screw clamp design

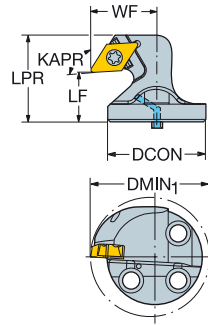
CoroTurn® SL - Internal coolant supply

KAPR

93.0°



TR-DC



		CZC <sub>MS</sub>	DMIN <sub>1</sub>	RMPX	CNSC	Ordering code	Dimensions, mm						MIID	
							DCON	LPR	LF	WF	BAR	NM		KG
	13	25	36.0	27°	1	TR-SL-D13UCR/L-25X	25	32.1	17.0	21.0	10	3.0	0.09	TR-DC1308
		32	40.0	27°	1	TR-SL-D13UCR/L-32X	32	35.1	20.0	22.0	10	3.0	0.14	TR-DC1308
		40	50.0	27°	1	TR-SL-D13UCR/L-40X	40	35.1	20.0	27.0	10	3.0	0.20	TR-DC1308

R = Right hand, L = Left hand

Spare parts			
	CZC <sub>MS</sub>	Insert screw	Locating tube
13	25	5513 020-01	5552 058-02
13	32-40	5513 020-01	5638 031-01

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

