

CoroMill® 331

Multi-purpose side and face milling cutter

Application

- Grooving
- Parting off
- Double half side milling
- Shoulder milling
- Face milling
- Gang milling
- Circular ramping

ISO application area:



Benefits and features

- Wide range of mounting options
- Wedge type cassette locking
- Accuracy, security and stability due to serrations
- Sometimes that exact dimension you require might be missing. If so, simply turn to our Tailor Made service.
- Easy setting for desired width
- Spring-loaded cassette
- Security with pin-controlled setting range



www.sandvik.coromant.com/coromill331

Couplings

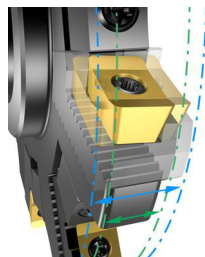
- Bore with keyway
- Arbor
- Cylindrical shank
- Adjustable pockets for high precision
- Fixed pockets for high teeth density

Inserts

- Light cutting insert with H tolerance for most materials
- Round insert options and a vast assortment of corner radii
- Inserts with eight edges for face milling operations available.
- Insert geometries and grades for all materials



Accuracy, security and stability due to serrations.



Wide setting range

Adjustable pockets for flexibility.



I112

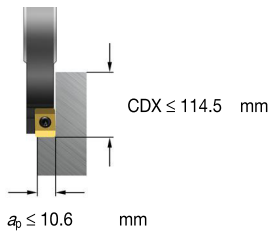


I123

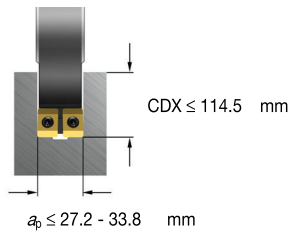


N6

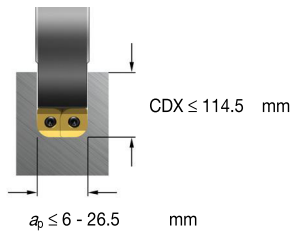
Half side



Double half side



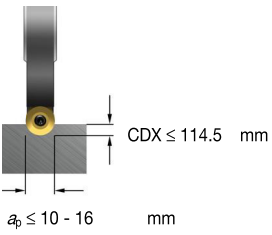
Full slot with radius



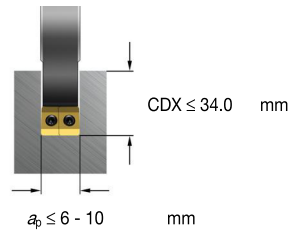
Tailor Made

Cutter bodies for radii inserts available as Tailor made.

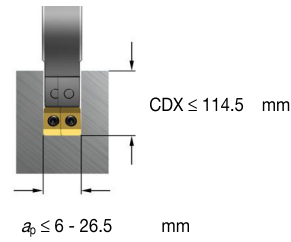
Full radius



Full slot fixed pocket



Full slot cassette



Tailor Made

Cassette cutters are delivered set to min. groove width. Tailor Made for cutters set to other widths.

Cutters for different groove widths and available inserts

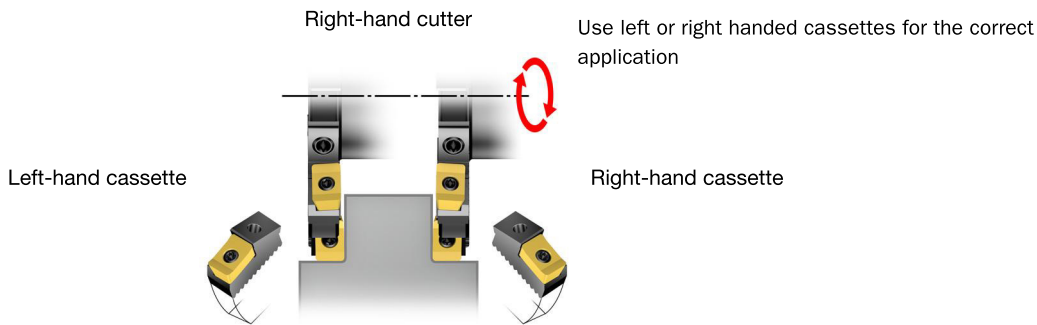
Cutter bodies		Insert size	Neutral inserts		Right and left hand inserts				
Groove width range mm	Cutter versions (end of code)		Radius (RE) 0.5 mm	Radius (RE) 0.8 mm	Radius (RE) 1.52 mm	Radius (RE) 2.29 mm	Radius (RE) 3.05 mm	Radius (RE) 4.83 mm	Radius (RE) 6.35 mm
6-8	CM	04							
8-10	DM	05							
10-12	EM	08							
12-15	FM	08							
15-17.5	KM	11							
17.5-20.5	LM	11							
20.5-23.5	QM	14							
23.5-26.5	RM	14							

Tailor Made

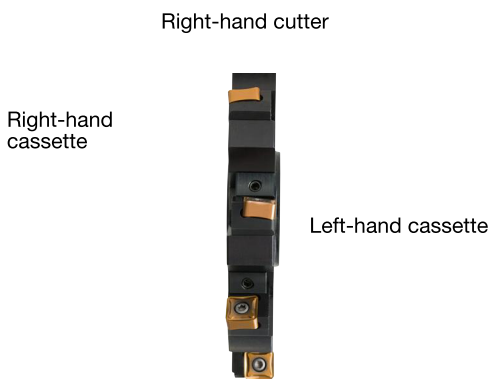
Other insert radii available as Tailor Made.

Cutter bodies, cassettes and inserts to combine for all applications

Half side and face mill



Full side and face mill

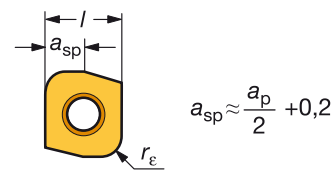
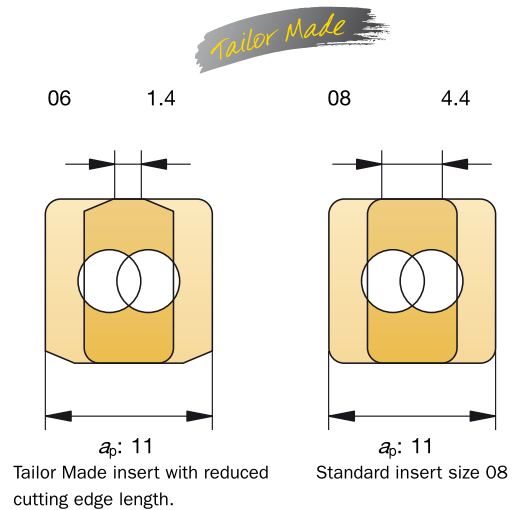


Reduced cutting edge length for Tailor Made inserts

When slotting use the smallest width of the cutter.
The overlap is the most critical factor to optimize.

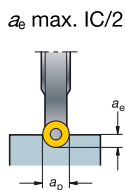
Reduced cutting edge length reduces overlapping, which in turn reduces wear in the overlapping zone, producing better chip control and reducing power consumption by up to 10%.

Tailor Made insert options with reduced cutting edge length and available on request.



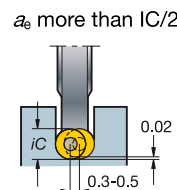
Facilitated chip evacuation

Full slot milling with round insert cutter



Max. axial depth of cut $a_p = IC$
Max. radial depth of cut $a_e = IC/2$

Note: The contact length of the cutting edge is 180°

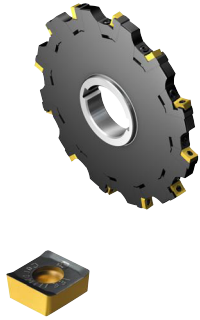


For slots deeper than $IC/2$, a 0.3 - 0.5 mm adjustment of each cassette is recommended. This will widen the slot 0.3 - 0.5 mm and reduce the contact length for each insert to 90°, which produces a more favorable chip formation and evacuation, and reduces vibration and power consumption.

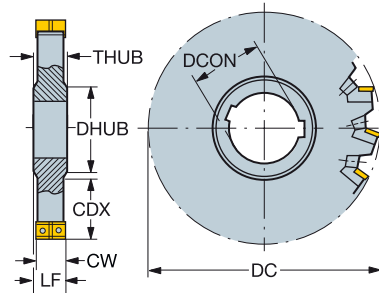
CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway

KAPR 90°



N331.1A



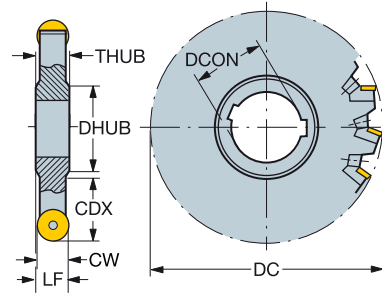
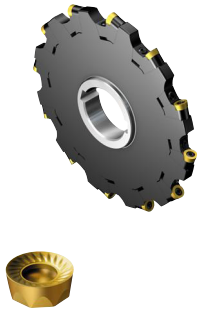
								Dimensions, mm									
CW	CWX	DC	CDX	CZC _{MS}	APMX		Ordering code	DCON	LF	DRVCT	DHUB	THUB		RPMX	CICT	MILD	
6.00	8.0	80	19.5	27	6.0	3	N331.32-080S27CM06.00	27.0	10.00	1	39.0	14.0	0.48	19300	6	N331.1A-04	
		100	25.5	32	6.0	4	N331.32-100S32CM06.00	32.0	10.00	1	47.0	14.0	0.64	17100	8	N331.1A-04	
		125	34.0	40	6.0	5	N331.32-125S40CM06.00	40.0	10.00	2	55.0	14.0	0.80	15100	10	N331.1A-04	
		160	51.5	40	6.0	6	N331.32-160S40CM06.00	40.0	10.00	2	55.0	14.0	1.08	13200	12	N331.1A-04	
		200	64.5	50	6.0	8	N331.32-200S50CM06.00	50.0	10.00	2	69.0	14.0	1.34	11700	16	N331.1A-04	
8.00	10.0	80	19.5	27	8.0	3	N331.32-080S27DM08.00	27.0	12.00	1	39.0	16.0	0.51	15000	6	N331.1A-05	
		100	25.5	32	8.0	4	N331.32-100S32DM08.00	32.0	12.00	1	47.0	16.0	0.72	13200	8	N331.1A-05	
		125	34.0	40	8.0	5	N331.32-125S40DM08.00	40.0	12.00	2	55.0	16.0	0.85	11700	10	N331.1A-05	
		160	51.5	40	8.0	6	N331.32-160S40DM08.00	40.0	12.00	2	55.0	16.0	1.27	10200	12	N331.1A-05	
		200	64.5	50	8.0	8	N331.32-200S50DM08.00	50.0	12.00	2	69.0	16.0	1.67	9100	16	N331.1A-05	
10.00	12.0	80	19.5	27	10.0	3	N331.32-080S27EM10.00	27.0	13.00	1	39.0	16.0	0.56	18100	6	N331.1A-08	
		100	25.5	32	10.0	4	N331.32-100S32EM10.00	32.0	13.00	1	47.0	16.0	0.80	15900	8	N331.1A-08	
		125	34.0	40	10.0	5	N331.32-125S40EM10.00	40.0	13.00	2	55.0	16.0	0.95	14100	10	N331.1A-08	
		160	51.5	40	10.0	6	N331.32-160S40EM10.00	40.0	13.00	2	55.0	16.0	1.50	12400	12	N331.1A-08	
		200	64.5	50	10.0	8	N331.32-200S50EM10.00	50.0	13.00	2	69.0	16.0	1.98	11000	16	N331.1A-08	
12.00	15.0	80	19.5	27	12.0	3	N331.32-080S27FM12.00	27.0	14.00	1	39.0	16.0	0.59	18100	6	N331.1A-08	
		100	25.5	32	12.0	4	N331.32-100S32FM12.00	32.0	14.00	1	47.0	16.0	0.82	15900	8	N331.1A-08	
		125	34.0	40	12.0	5	N331.32-125S40FM12.00	40.0	14.00	2	55.0	16.0	1.07	14100	10	N331.1A-08	
		160	51.5	40	12.0	6	N331.32-160S40FM12.00	40.0	14.00	2	55.0	16.0	1.71	12400	12	N331.1A-08	
		200	64.5	50	12.0	8	N331.32-200S50FM12.00	50.0	14.00	2	69.0	16.0	2.38	11000	16	N331.1A-08	
15.00	17.5	100	25.5	32	15.0	3	N331.32-100S32KM15.00	32.0	16.75	1	47.0	18.5	0.99	14000	6	N331.1A-11	
		125	34.0	40	15.0	4	N331.32-125S40KM15.00	40.0	16.75	1	55.0	18.5	1.25	12400	8	N331.1A-11	
		160	51.5	40	15.0	5	N331.32-160S40KM15.00	40.0	16.75	2	55.0	18.5	2.06	10800	10	N331.1A-11	
		200	64.5	50	15.0	6	N331.32-200S50KM15.00	50.0	16.75	2	69.0	18.5	2.88	9600	12	N331.1A-11	
		250	89.5	50	15.0	8	N331.32-250S50KM15.00	50.0	16.75	2	69.0	18.5	7.74	8500	16	N331.1A-11	
17.50	20.5	125	34.0	40	17.5	4	N331.32-125S40LM17.50	40.0	19.50	1	55.0	21.5	1.43	12400	8	N331.1A-11	
		160	51.5	40	17.5	5	N331.32-160S40LM17.50	40.0	19.50	2	55.0	21.5	2.30	10800	10	N331.1A-11	
		200	64.5	50	17.5	6	N331.32-200S50LM17.50	50.0	19.50	2	69.0	21.5	3.29	9600	12	N331.1A-11	
		250	89.5	50	17.5	8	N331.32-250S50LM17.50	50.0	19.50	2	69.0	21.5	8.42	8500	16	N331.1A-11	
		315	114.5	60	17.5	10	N331.32-315S60LM17.50	60.0	19.50	2	84.0	21.5	12.94	7600	20	N331.1A-11	
20.50	23.5	160	51.5	40	20.5	5	N331.32-160S40QM20.50	40.0	22.50	2	55.0	24.5	2.59	9000	10	N331.1A-14	
		200	64.5	50	20.5	6	N331.32-200S50QM20.50	50.0	22.50	2	69.0	24.5	3.86	8000	12	N331.1A-14	
		250	89.5	50	20.5	8	N331.32-250S50QM20.50	50.0	22.50	2	69.0	24.5	7.10	7100	16	N331.1A-14	
		315	114.5	60	20.5	10	N331.32-315S60QM20.50	60.0	22.50	2	84.0	24.5	14.28	6300	20	N331.1A-14	
23.50	26.5	160	51.5	40	23.5	5	N331.32-160S40RM23.50	40.0	25.50	2	55.0	27.5	2.82	9000	10	N331.1A-14	
		200	64.5	50	23.5	6	N331.32-200S50RM23.50	50.0	25.50	2	69.0	27.5	4.35	8000	12	N331.1A-14	
		250	89.5	50	23.5	8	N331.32-250S50RM23.50	50.0	25.50	2	69.0	27.5	10.16	7100	16	N331.1A-14	
		315	114.5	60	23.5	10	N331.32-315S60RM23.50	60.0	25.50	2	84.0	27.5	19.26	6300	20	N331.1A-14	

For spare parts, visit www.sandvik.coromant.com





CoroMill® 331 adjustable full side and face disc milling cutter

Bore with keyway



RCKT
RCHT

						Dimensions, mm											
CW	DC	CDX	CZC _{MS}	APMX		Ordering code	DCON	LF	DRVCT	DHUB	THUB		RPMX	CICT	MIID		
10.00	82	20.5	27	10.0	6	N331.32-082S27EMQ	27.0	13.00	1	39.0	16.0	0.56	18100	6	RCKT 10 T3 M0		
	102	26.5	32	10.0	8	N331.32-102S32EMQ	32.0	13.00	1	47.0	16.0	0.50	15900	8	RCKT 10 T3 M0		
	127	35.0	40	10.0	10	N331.32-127S40EMQ	40.0	13.00	2	55.0	16.0	1.03	14100	10	RCKT 10 T3 M0		
	162	52.5	40	10.0	12	N331.32-162S40EMQ	40.0	13.00	2	55.0	16.0	1.51	12400	12	RCKT 10 T3 M0		
12.00	202	65.5	50	10.0	16	N331.32-202S50EMQ	50.0	13.00	2	69.0	16.0	2.03	11000	16	RCKT 10 T3 M0		
	82	20.5	27	12.0	6	N331.32-082S27FMQ	27.0	14.00	1	39.0	16.0	0.62	18100	6	RCKT 12 04 M0		
	102	26.5	32	12.0	8	N331.32-102S32FMQ	32.0	14.00	1	47.0	16.0	0.89	15900	8	RCKT 12 04 M0		
	127	35.0	40	12.0	10	N331.32-127S40FMQ	40.0	14.00	2	55.0	16.0	1.15	14100	10	RCKT 12 04 M0		
16.00	162	52.5	40	12.0	12	N331.32-162S40FMQ	40.0	14.00	2	55.0	16.0	1.73	12400	12	RCKT 12 04 M0		
	202	65.5	50	12.0	16	N331.32-202S50FMQ	50.0	14.00	2	69.0	16.0	3.21	11000	16	RCKT 12 04 M0		
	102	26.5	32	16.0	6	N331.32-102S32KMQ	32.0	17.25	1	47.0	18.5	0.96	14000	6	RCKT 16 06 M0		
	127	35.0	40	16.0	8	N331.32-127S40KMQ	40.0	17.25	1	55.0	18.5	1.27	12400	8	RCKT 16 06 M0		
16.00	162	52.5	40	16.0	10	N331.32-162S40KMQ	40.0	17.25	2	55.0	18.5	1.97	10800	10	RCKT 16 06 M0		
	202	65.5	50	16.0	12	N331.32-202S50KMQ	50.0	17.25	2	69.0	18.5	3.20	9600	12	RCKT 16 06 M0		

Spare parts				
CW	DC	Insert screw	Wedge	Screw
10.00	82.00	5513 020-09	5431 105-01	269-832
10.00	102.00-202.00	5513 020-09	5431 105-01	339-831
12.00	82.00	5513 020-09	5431 105-02	269-832
12.00	102.00-202.00	5513 020-09	5431 105-02	339-831
16.00	102.00	5513 020-07	5431 105-04	5516 010-02
16.00	127.00-202.00	5513 020-07	5431 105-04	339-831

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



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L4



N22

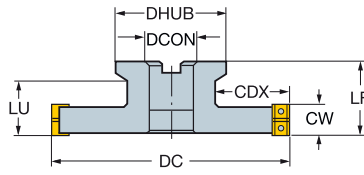


N6



CoroMill® 331 adjustable full side and face disc milling cutter

Arbor

STDNO ISO 6462:2011
KAPR 90°



N331.1A

							Dimensions, mm									
CW	CWX	DC	CDX	CZC _{MS}	APMX		Ordering code	DCON	ISO	DBC	LF	DHUB		RPMX	CICT	MIID
6.00	8.0	80	20.0	27	6.0	3	R331.32-080Q27CM06.00	27.0	A		63.00	54.0	1.08	19300	6	N331.1A-04
		100	22.0	27	6.0	3	R331.32-100Q27CM06.00	27.0	A		63.00	54.0	1.65	17100	6	N331.1A-04
		125	29.5	32	6.0	5	R331.32-125Q32CM06.00	32.0	B		63.00	64.0	1.74	15100	10	N331.1A-04
		160	41.0	40	6.0	6	R331.32-160Q40CM06.00	40.0	B		63.00	76.0	2.32	13200	12	N331.1A-04
		200	51.0	40S	6.0	8	R331.32-200Q40CM06.00	40.0	C	66.7	63.00	96.0	6.70	11700	16	N331.1A-04
8.00	10.0	80	20.0	27	8.0	3	R331.32-080Q27DM08.00	27.0	A		63.10	54.0	1.07	15000	6	N331.1A-05
		100	22.0	27	8.0	4	R331.32-100Q27DM08.00	27.0	A		63.10	54.0	1.62	13200	8	N331.1A-05
		125	29.5	32	8.0	5	R331.32-125Q32DM08.00	32.0	B		63.10	64.0	1.75	11700	10	N331.1A-05
		160	41.0	40	8.0	6	R331.32-160Q40DM08.00	40.0	B		63.10	76.0	2.41	10200	12	N331.1A-05
		200	51.0	40S	8.0	8	R331.32-200Q40DM08.00	40.0	C	66.7	63.10	96.0	8.61	9100	16	N331.1A-05
10.00	12.0	80	20.0	27	10.0	3	R331.32-080Q27EM10.00	27.0	A		63.00	54.0	1.08	18100	6	N331.1A-08
		100	22.0	27	10.0	4	R331.32-100Q27EM10.00	27.0	A		63.00	54.0	1.76	15900	8	N331.1A-08
		125	29.5	32	10.0	5	R331.32-125Q32EM10.00	32.0	B		63.00	64.0	1.93	14100	10	N331.1A-08
		160	41.0	40	10.0	6	R331.32-160Q40EM10.00	40.0	B		63.00	76.0	2.58	12400	12	N331.1A-08
		200	51.0	40S	10.0	8	R331.32-200Q40EM10.00	40.0	C	66.7	63.00	96.0	8.88	11000	16	N331.1A-08
12.00	15.0	80	20.0	27	12.0	3	R331.32-080Q27FM12.00	27.0	A		63.00	54.0	1.20	18100	6	N331.1A-08
		100	22.0	27	12.0	4	R331.32-100Q27FM12.00	27.0	A		63.00	54.0	1.69	15900	8	N331.1A-08
		125	29.5	32	12.0	5	R331.32-125Q32FM12.00	32.0	B		63.00	64.0	1.91	14100	10	N331.1A-08
		160	41.0	40	12.0	6	R331.32-160Q40FM12.00	40.0	B		63.00	76.0	2.86	12400	12	N331.1A-08
		200	51.0	40S	12.0	8	R331.32-200Q40FM12.00	40.0	C	66.7	63.00	96.0	7.64	11000	16	N331.1A-08
15.00	17.5	100	25.5	27	15.0	3	R331.32-100Q27KM15.00	27.0	A		63.00	54.0	1.75	14000	6	N331.1A-11
		125	29.5	32	15.0	4	R331.32-125Q32KM15.00	32.0	B		63.00	64.0	2.06	12400	8	N331.1A-11
		160	41.0	40	15.0	5	R331.32-160Q40KM15.00	40.0	B		63.00	76.0	3.06	10800	10	N331.1A-11
		200	51.0	40S	15.0	6	R331.32-200Q40KM15.00	40.0	C	66.7	63.00	96.0	9.46	9600	12	N331.1A-11
		250	56.0	60	15.0	8	R331.32-250Q60KM15.00	60.0	C	101.6	63.00	136.0	9.50	8500	16	N331.1A-11
17.50	20.5	125	29.5	32	17.5	4	R331.32-125Q32LM17.50	32.0	B		63.00	64.0	2.24	12400	8	N331.1A-11
		160	41.0	40	17.5	5	R331.32-160Q40LM17.50	40.0	B		63.00	76.0	3.27	10800	10	N331.1A-11
		200	51.0	40S	17.5	6	R331.32-200Q40LM17.50	40.0	C	66.7	63.00	96.0	8.44	9600	12	N331.1A-11
		250	56.0	60	17.5	8	R331.32-250Q60LM17.50	60.0	C	101.6	63.00	136.0	10.00	8500	16	N331.1A-11
		315	88.5	60	17.5	10	R331.32-315Q60LM17.50	60.0	C	101.6	63.00	136.0	20.00	7600	20	N331.1A-11
20.50	23.5	160	41.0	40	20.5	5	R331.32-160Q40QM20.50	40.0	B		63.00	76.0	3.58	9000	10	N331.1A-14
		200	51.0	40S	20.5	6	R331.32-200Q40QM20.50	40.0	C	66.7	63.00	96.0	10.30	8000	12	N331.1A-14
		250	56.0	60	20.5	8	R331.32-250Q60QM20.50	60.0	C	101.6	63.00	136.0	13.30	7100	16	N331.1A-14
		315	88.5	60	20.5	10	R331.32-315Q60QM20.50	60.0	C	101.6	63.00	136.0	19.20	6300	20	N331.1A-14
23.50	26.5	160	41.0	40	23.5	5	R331.32-160Q40RM23.50	40.0	B		63.00	76.0	3.80	9000	10	N331.1A-14
		200	51.0	40S	23.5	6	R331.32-200Q40RM23.50	40.0	C	66.7	63.00	96.0	10.80	8000	12	N331.1A-14
		250	56.0	60	23.5	8	R331.32-250Q60RM23.50	60.0	C	101.6	63.00	136.0	14.00	7100	16	N331.1A-14
		315	88.5	60	23.5	10	R331.32-315Q60RM23.50	60.0	C	101.6	63.00	136.0	20.44	6300	20	N331.1A-14

For spare parts, visit www.sandvik.coromant.com

1123



L4



M2



N22

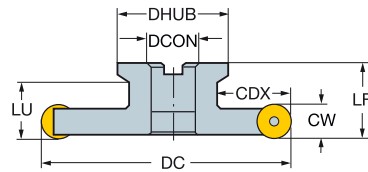




N6

CoroMill® 331 adjustable full side and face disc milling cutter

Arbor

STDNO ISO 6462:2011

RCKT
RCHT

							Dimensions, mm								
CW	DC	CDX	CZG _{MS}	APMX		Ordering code	DCON	ISO	DBC	LF	DHUB		RPMX	CICT	MIID
10.00	82	21.6	27	10.0	4	R331.32-082Q27EMQ	27.0	A		63.00	54.0	1.12	19500	4	RCKT 10 T3 M0
	102	23.0	27	10.0	8	R331.32-102Q27EMQ	27.0	A		63.00	54.0	1.69	15900	8	RCKT 10 T3 M0
	127	30.5	32	10.0	10	R331.32-127Q32EMQ	32.0	B		63.00	64.0	1.80	14100	10	RCKT 10 T3 M0
	162	42.0	40	10.0	12	R331.32-162Q40EMQ	40.0	B		63.00	76.0	2.61	12400	12	RCKT 10 T3 M0
	202	52.0	40S	10.0	16	R331.32-202Q40EMQ	40.0	C	66.7	63.00	96.0	8.79	11000	16	RCKT 10 T3 M0
12.00	82	21.0	27	12.0	6	R331.32-082Q27FMQ	27.0	A		63.00	54.0	1.11	18100	6	RCKT 12 04 M0
	102	23.0	27	12.0	8	R331.32-102Q27FMQ	27.0	A		63.00	54.0	1.72	15900	8	RCKT 12 04 M0
	127	30.5	32	12.0	10	R331.32-127Q32FMQ	32.0	B		63.00	64.0	1.94	14100	10	RCKT 12 04 M0
	162	42.0	40	12.0	12	R331.32-162Q40FMQ	40.0	B		63.00	76.0	2.78	12400	12	RCKT 12 04 M0
	202	52.0	40S	12.0	16	R331.32-202Q40FMQ	40.0	C	66.7	63.00	96.0	9.07	11000	16	RCKT 12 04 M0
16.00	102	26.5	27	16.0	6	R331.32-102Q27KMQ	27.0	A		63.50	54.0	1.60	14000	6	RCKT 16 06 M0
	127	30.5	32	16.0	8	R331.32-127Q32KMQ	32.0	B		63.50	64.0	2.10	12400	8	RCKT 16 06 M0
	162	42.0	40	16.0	10	R331.32-162Q40KMQ	40.0	B		63.50	76.0	3.05	10800	10	RCKT 16 06 M0
	202	52.0	40S	16.0	12	R331.32-202Q40KMQ	40.0	C	66.7	63.50	96.0	10.00	9600	12	RCKT 16 06 M0

		Spare parts		
CW	DC	Insert screw	Wedge	Screw
10.00	82.00	5513 020-09	5431 105-01	269-832
10.00	102.00-202.00	5513 020-09	5431 105-01	339-831
12.00	82.00	5513 020-09	5431 105-02	269-832
12.00	102.00-202.00	5513 020-09	5431 105-02	339-831
16.00	102.00-202.00	5513 020-07	5431 105-04	339-831

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

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L4



M2



N22



N6

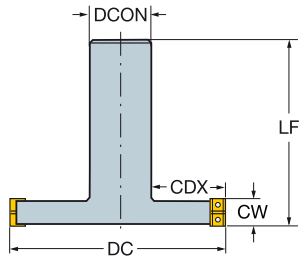
CoroMill® 331 adjustable full side and face disc milling cutter

Cylindrical shank

KAPR 90°



N331.1A



								Dimensions, mm						
CW	CWX	DC	CDX	CZC _{MS}	APMX		Ordering code	DCON	LF		RPMX	CICT	MIID	
6.00	8.0	80	23.0	32	6.0	3	R331.32-080A32CM06.00	32.0	132.00	1.10	19300	6	N331.1A-04	
		100	28.0	42	6.0	4	R331.32-100A42CM06.00	42.0	152.00	2.00	17100	8	N331.1A-04	
8.00	10.0	80	23.0	32	8.0	3	R331.32-080A32DM08.00	32.0	132.10	1.17	15000	6	N331.1A-05	
		100	28.0	42	8.0	4	R331.32-100A42DM08.00	42.0	152.10	2.07	13200	8	N331.1A-05	
10.00	12.0	80	23.0	32	10.0	3	R331.32-080A32EM10.00	32.0	132.00	1.21	18100	6	N331.1A-08	
		100	28.0	42	10.0	4	R331.32-100A42EM10.00	42.0	152.00	2.10	15900	8	N331.1A-08	

Spare parts			
CW	Insert screw	Wedge	Screw
6.00	5513 020-19	5431 105-07	5516 014-06
8.00	5513 020-34	5431 105-06	5516 014-04
10.00	5513 020-24	5431 105-01	339-831

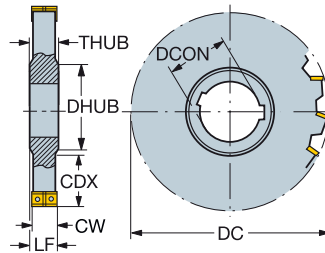
For complete list of spare parts, see www.sandvik.coromant.com



CoroMill® 331 full side and face disc milling cutter

Bore with keyway

KAPR 90°

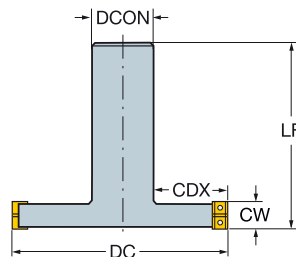


N331.1A

						Dimensions, mm								
CW	DC	CDX	CZC _{MS}	APMX	Ordering code	DCON	LF	DRVCT	DHUB	THUB	RPMX	CICT	MIID	
6.00	100	25.5	32	6.0		N331.35-100S32CM060	32.0	7.00	1	47.0		8.0	0.59	17000
8.00	100	25.5	32	8.0	N331.35-100S32DM080	32.0	9.00	1	47.0	10.0	0.66	13000	10	N331.1A-05
	125	34.0	40	8.0	N331.35-125S40DM080	40.0	9.00	2	55.0	10.0	0.81	15000	12	N331.1A-05
10.00	125	34.0	40	10.0	N331.35-125S40EM100	40.0	11.00	2	55.0	12.0	1.00	11500	12	N331.1A-08

Cylindrical shank

KAPR 90°



N331.1A

						Dimensions, mm								
CW	DC	CDX	CZC _{MS}	APMX	Ordering code	DCON	LF	RPMX	CICT	MIID				
6.00	40	11.0	16	6.0		R331.35-040A16CM060	16.0		120.00	0.31	29500	4	N331.1A-04	
	50	14.0	20	6.0	R331.35-050A20CM060	20.0	130.00	0.60	25000	6	N331.1A-04			
	63	18.0	25	6.0	R331.35-063A25CM060	25.0	140.00	0.99	22000	6	N331.1A-04			
	80	23.0	32	6.0	R331.35-080A32CM060	32.0	150.00	1.50	19000	8	N331.1A-04			
8.00	40	11.0	16	8.0	R331.35-040A16DM080	16.0	120.00	0.32	22300	4	N331.1A-05			
	50	14.0	20	8.0	R331.35-050A20DM080	20.0	130.00	0.60	19500	6	N331.1A-05			
	63	18.0	25	8.0	R331.35-063A25DM080	25.0	140.00	1.09	17000	6	N331.1A-05			
	80	23.0	32	8.0	R331.35-080A32DM080	32.0	150.00	1.50	15000	8	N331.1A-05			
10.00	40	11.0	16	10.0	R331.35-040A16EM100	16.0	120.00	0.34	27000	4	N331.1A-08			
	50	14.0	20	10.0	R331.35-050A20EM100	20.0	130.00	0.59	23500	6	N331.1A-08			
	63	18.0	25	10.0	R331.35-063A25EM100	25.0	140.00	1.10	21000	6	N331.1A-08			
	80	23.0	32	10.0	R331.35-080A32EM100	32.0	150.00	1.44	18000	8	N331.1A-08			

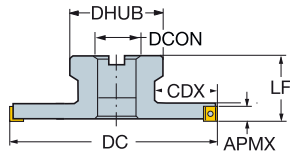
Spare parts	
CW	Insert screw
6.00	5513 020-19
8.00	5513 020-34
10.00	5513 020-24

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



CoroMill® 331 adjustable half side and face disc milling cutter

Arbor

STDNO ISO 6462:2011
KAPR 90°



N331.1A

		Dimensions, mm											
DC	CZC _{MS}	APMX		Ordering code	DCON	ISO	DBC	LF	DHUB		RPMX	CICT	MIID
80	27	7.6	6	R331.52-080Q27FMR	27.0	A		63.00	54.0	1.12	18100	6	N331.1A-08
80	27	7.6	6	R331.52-080Q27EMR	27.0	A		63.00	54.0	0.80	18100	6	N331.1A-08
100	27	10.6	6	R331.52-100Q27KMR	27.0	A		63.00	54.0	1.77	14000	6	N331.1A-11
100	27	7.6	8	R331.52-100Q27FMR	27.0	A		63.00	54.0	1.30	15900	8	N331.1A-08
125	32	7.6	10	R331.52-125Q32FMR	32.0	B		63.00	64.0	1.95	14100	10	N331.1A-08
125	32	7.6	10	R331.52-125Q32EMR	32.0	B		63.00	64.0	1.86	14100	10	N331.1A-08
125	32	10.6	8	R331.52-125Q32KMR	32.0	B		63.00	64.0	2.30	12000	8	N331.1A-11
160	40	7.6	12	R331.52-160Q40EMR	40.0	B		63.00	76.0	2.69	12400	12	N331.1A-08
160	40	10.6	10	R331.52-160Q40KMR	40.0	B		63.00	76.0	3.30	10800	10	N331.1A-11
160	40	7.6	12	R331.52-160Q40FMR	40.0	B		63.00	76.0	2.90	12400	12	N331.1A-08
200	40S	10.6	12	R331.52-200Q40MMR	40.0	C	66.7	63.00	96.0	8.00	9600	12	N331.1A-11
250	60	10.6	16	R331.52-250Q60MMR	60.0	C	101.6	63.00	136.0	14.36	8500	16	N331.1A-11
315	60	10.6	20	R331.52-315Q60NMR	60.0	C	101.6	63.00	136.0	20.30	7600	20	N331.1A-11

Ordering code	Spare parts		
	Insert screw	Wedge	Screw
R331.52-080Q27EMR	5513 020-24	5431 105-01	269-832
R331.52-080Q27FMR	5513 020-24	5431 105-02	269-832
R331.52-100Q27FMR	5513 020-24	5431 105-02	5516 010-02
R331.52-125Q32EMR	5513 020-24	5431 105-01	339-831
R331.52-125Q32FMR	5513 020-24	5431 105-02	339-831
R331.52-160Q40EMR	5513 020-24	5431 105-01	339-831
R331.52-160Q40FMR	5513 020-24	5431 105-02	339-831
R331.52-100Q27KMR	5513 020-29	5431 105-04	339-831
R331.52-125Q32KMR	5513 020-29	5431 105-04	339-831
R331.52-160Q40KMR	5513 020-29	5431 105-04	339-831
R331.52-200Q40MMR	5513 020-29	5431 105-03	339-831
R331.52-250Q60MMR	5513 020-29	5431 105-03	339-831
R331.52-315Q60NMR	5513 020-29	5431 105-04	339-831

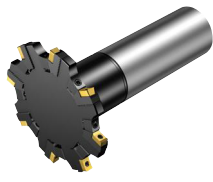
For complete list of spare parts, see www.sandvik.coromant.com



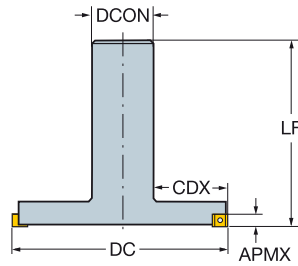
CoroMill® 331 adjustable half side and face disc milling cutter



Cylindrical shank

KAPR 90°



N331.1A



				Dimensions, mm						
DC	CZC _{MS}	APMX		Ordering code	DCON	LF		RPMX	CICT	MIID
80	32	7.6	6	R331.52-080A32EMR	32.0	132.00	1.19	18100	6	N331.1A-08
100	42	7.6	8	R331.52-100A42EMR	42.0	152.00	1.90	15900	8	N331.1A-08

Spare parts

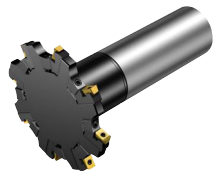
Insert screw	Wedge	Screw
5513 020-24	5431 105-01	339-831

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

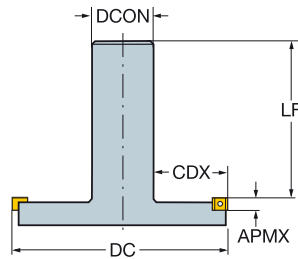
CoroMill® 331 adjustable half side and back face disc milling cutter



Cylindrical shank

KAPR 90°



N331.1A



				Dimensions, mm						
DC	CZC _{MS}	APMX		Ordering code	DCON	LF		RPMX	CICT	MIID
80	32	7.6	6	R331.52-080A32EML	32.0	122.00	1.19	18100	6	N331.1A-08
100	42	7.6	8	R331.52-100A42EML	42.0	142.00	1.90	15900	8	N331.1A-08

Spare parts

Insert screw	Wedge	Screw
5513 020-24	5431 105-01	339-831

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

1123



L4



N22

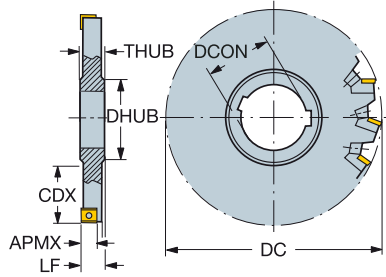


N6

CoroMill® 331 adjustable half side and back face disc milling cutter

Bore with keyway

KAPR 90°



N331.1A

		Dimensions, mm												
DC	CZC _{MS}	APMX		Ordering code	DCON	LF	DRVCT	DHUB	THUB		RPMX	CICT	MIID	
80	27	7.6	6	R/L331.52-080S27FM	27.0	14.00	1	39.0	16.0	0.56	18100	6	N331.1A-08	
80	27	7.6	6	R/L331.52-080S27EM	27.0	13.00	1	39.0	16.0	0.54	18100	6	N331.1A-08	
100	32	7.6	8	R/L331.52-100S32EM	32.0	13.00	1	47.0	16.0	0.84	15900	8	N331.1A-08	
100	32	7.6	8	R/L331.52-100S32FM	32.0	14.00	1	47.0	16.0	0.60	15900	8	N331.1A-08	
100	32	10.6	6	R/L331.52-100S32KM	32.0	16.75	1	47.0	18.5	0.94	14000	6	N331.1A-11	
125	40	7.6	10	R/L331.52-125S40EM	40.0	13.00	2	55.0	16.0	1.02	14100	10	N331.1A-08	
125	40	7.6	10	R/L331.52-125S40FM	40.0	14.00	2	55.0	16.0	1.13	14100	10	N331.1A-08	
125	40	10.6	8	R/L331.52-125S40KM	40.0	16.75	1	55.0	18.5	1.30	12000	8	N331.1A-11	
160	40	7.6	12	R/L331.52-160S40EM	40.0	13.00	2	55.0	16.0	1.50	12400	12	N331.1A-08	
160	40	7.6	12	R/L331.52-160S40FM	40.0	14.00	2	55.0	16.0	1.73	12400	12	N331.1A-08	
160	40	10.6	10	R/L331.52-160S40KM	40.0	16.75	2	55.0	18.5	2.00	10000	10	N331.1A-11	
200	50	10.6	12	R/L331.52-200S50MM	50.0	29.20	2	69.0	31.2	9.90	9600	12	N331.1A-11	
250	50	10.6	16	R/L331.52-250S50MM	50.0	29.20	2	69.0	31.2	12.96	8500	16	N331.1A-11	
315	60	10.6	20	R/L331.52-315S60NM	60.0	32.80	2	84.0	34.8	17.30	7600	20	N331.1A-11	

Spare parts			
Ordering code	Insert screw	Wedge	Screw
R/L331.52-125S40EM	5513 020-24	5431 105-01	339-831
R/L331.52-125S40FM	5513 020-24	5431 105-02	339-831
R/L331.52-160S40EM	5513 020-24	5431 105-01	339-831
R/L331.52-160S40FM	5513 020-24	5431 105-02	339-831
R/L331.52-080S27EM	5513 020-24	5431 105-01	269-832
R/L331.52-080S27FM	5513 020-24	5431 105-02	269-832
R/L331.52-100S32EM	5513 020-24	5431 105-01	339-831
R/L331.52-100S32FM	5513 020-24	5431 105-02	339-831
R/L331.52-160S40KM	5513 020-29	5431 105-04	339-831
R/L331.52-200S50MM	5513 020-29	5431 105-03	339-831
R/L331.52-250S50MM	5513 020-29	5431 105-03	339-831
R/L331.52-315S60NM	5513 020-29	5431 105-04	339-831
R/L331.52-100S32KM	5513 020-29	5431 105-04	5516 010-02
R/L331.52-125S40KM	5513 020-29	5431 105-04	339-831

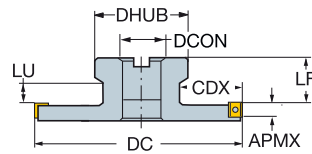
For complete list of spare parts, see www.sandvik.coromant.com





CoroMill® 331 adjustable half side and back face disc milling cutter

Arbor

STDNO ISO 6462:2011
KAPR 90°



N331.1A

				Dimensions, mm											
DC	CZC _{MS}	APMX		Ordering code	DCON	ISO	DBC	LF	DHUB		RPMX	CICT	MIID		
80	27	7.6	6	R331.52-080Q27EML	27.0	A		53.00	54.0	0.80	18100	6	N331.1A-08		
80	27	7.6	6	R331.52-080Q27FML	27.0	A		51.00	54.0	0.98	18100	6	N331.1A-08		
100	27	7.6	8	R331.52-100Q27EML	27.0	A		53.00	54.0	1.20	15900	8	N331.1A-08		
100	27	7.6	8	R331.52-100Q27FML	27.0	A		51.00	54.0	1.30	15900	8	N331.1A-08		
100	27	10.6	6	R331.52-100Q27KML	27.0	A		48.00	54.0	1.77	14000	6	N331.1A-11		
125	32	7.6	10	R331.52-125Q32EML	32.0	B		53.00	64.0	1.81	14100	10	N331.1A-08		
125	32	7.6	10	R331.52-125Q32FML	32.0	B		51.00	64.0	1.95	14100	10	N331.1A-08		
125	32	10.6	8	R331.52-125Q32KML	32.0	B		48.00	64.0	2.09	12000	8	N331.1A-11		
160	40	7.6	12	R331.52-160Q40EML	40.0	B		53.00	76.0	2.60	12400	12	N331.1A-08		
160	40	7.6	12	R331.52-160Q40FML	40.0	B		51.00	76.0	2.90	12400	12	N331.1A-08		
160	40	10.6	10	R331.52-160Q40KML	40.0	B		48.00	76.0	3.02	10800	10	N331.1A-11		
200	40S	10.6	12	R331.52-200Q40MML	40.0	C	66.7	35.80	96.0	11.12	9600	12	N331.1A-11		
250	60	10.6	16	R331.52-250Q60MML	60.0	C	101.6	35.80	136.0	12.70	8500	16	N331.1A-11		
315	60	10.6	20	R331.52-315Q60NML	60.0	C	101.6	32.20	136.0	20.30	7600	20	N331.1A-11		

Ordering code	Spare parts		
	Insert screw	Wedge	Screw
R331.52-080Q27EML	5513 020-24	5431 105-01	269-832
R331.52-080Q27FML	5513 020-24	5431 105-02	269-832
R331.52-100Q27EML	5513 020-24	5431 105-01	5516 010-02
R331.52-100Q27FML	5513 020-24	5431 105-02	5516 010-02
R331.52-125Q32EML	5513 020-24	5431 105-01	339-831
R331.52-125Q32FML	5513 020-24	5431 105-02	339-831
R331.52-160Q40EML	5513 020-24	5431 105-01	339-831
R331.52-160Q40FML	5513 020-24	5431 105-02	339-831
R331.52-100Q27KML	5513 020-29	5431 105-04	339-831
R331.52-125Q32KML	5513 020-29	5431 105-04	339-831
R331.52-160Q40KML	5513 020-29	5431 105-04	339-831
R331.52-200Q40MML	5513 020-29	5431 105-03	339-831
R331.52-250Q60MML	5513 020-29	5431 105-03	339-831
R331.52-315Q60NML	5513 020-29	5431 105-04	339-831

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



1123



L4



M2



N22

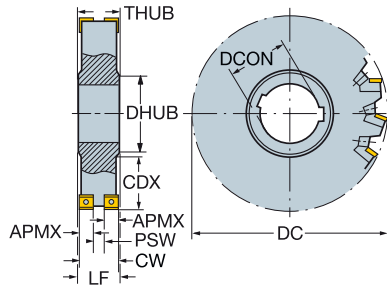
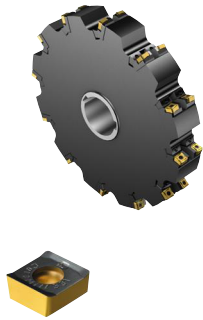


N6

CoroMill® 331 adjustable double half side and face disc milling cutter

Bore with keyway

KAPR 90°

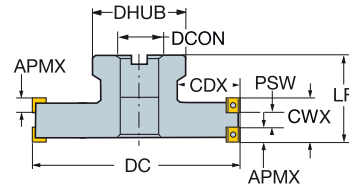


N331.1A

		Dimensions, mm															
CW	CWX	DC	CDX	CZC _{MS}	APMX		Ordering code	DCON	PSW	LF	DRVCT	DHUB	THUB		RPMX	CICT	MIID
27.20	30.2	200	64.5	50	10.6	12	N331.52-200S50MM	50.0	7.0	29.20	2	69.0	31.2	5.90	9600	24	N331.1A-11
30.80	33.8	315	114.5	60	10.6	20	N331.52-250S50MM	50.0	7.0	29.20	2	69.0	31.2	9.50	8500	32	N331.1A-11
							N331.52-315S60NM	60.0	10.6	32.80	2	84.0	34.8	17.30	7600	40	N331.1A-11

Arbor

STDNO ISO 6462:2011
KAPR 90°



N331.1A

		Dimensions, mm															
CW	CWX	DC	CDX	CZC _{MS}	APMX		Ordering code	DCON	ISO	DBC	PSW	LF	DHUB		RPMX	CICT	MIID
27.20	30.2	200	51.0	40S	10.6	12	R331.52-200Q40MM	40.0	C	66.7	7.0	63.00	96.0	8.00	9600	24	N331.1A-11
		250	56.0	60	10.6	16	R331.52-250Q60MM	60.0	C	101.6	7.0	63.00	136.0	12.70	8500	32	N331.1A-11
30.80	33.8	315	88.5	60	10.6	20	R331.52-315Q60NM	60.0	C	101.6	10.6	63.00	136.0	20.30	8500	40	N331.1A-11

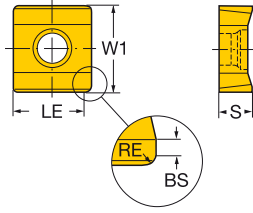
Spare parts			
CW	Insert screw	Wedge	Screw
27.20	5513 020-29	5431 105-03	339-831
30.80	5513 020-29	5431 105-04	339-831

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



CoroMill® 331 insert for slotting

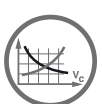
KRINS 90°



	RE	Ordering code	Material Groups												Dimensions, mm																		
			P			M			K			N			S			H			W1	LE	S	BS									
			1130	4230	4240	1025	1040	1130	2030	2040	1020	3040	3220	3330	H13A	1130	530	H10	H13A	1025	1130	H13A	S30T	PS40T	1130	3040	530						
Light	04	0.50	N331.1A-04 35 05E-KL								*	*	*	*															9.5	4.6	3.50	0.4	
		0.50	N331.1A-04 35 05H-ML				*		*	*								*		*										9.5	4.6	3.50	0.4
		0.50	N331.1A-04 35 05H-NL	*		*		*	*	*							*		*	*										9.5	4.6	3.50	0.2
		0.50	N331.1A-04 35 05H-PL	*	*	*		*	*	*							*		*	*				*						9.5	4.6	3.50	0.4
		0.50	N331.1A-04 35 05H-WL	*	*	*	*	*	*	*						*		*	*	*				*						9.5	4.6	3.50	0.4
	05	0.80	N331.1A-05 45 08E-KL									*	*	*	*															9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08H-ML				*		*	*									*		*									9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08H-NL	*		*		*	*	*							*		*	*				*						9.5	5.7	4.45	0.8
		0.80	N331.1A-05 45 08H-PL	*	*	*	*	*	*	*						*		*	*	*				*						9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08H-WL	*	*	*	*	*	*	*						*		*	*	*				*						9.5	5.7	4.45	1.2
	08	0.80	N331.1A-08 45 08E-KL									*	*	*	*															9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08H-ML				*		*	*							*		*	*				*						9.5	7.7	4.45	1.2
	0.80	N331.1A-08 45 08H-NL	*		*		*	*	*						*		*	*	*				*						9.5	7.7	4.45	0.9	
	0.80	N331.1A-08 45 08H-PL	*	*	*	*	*	*	*						*		*	*	*				*						9.5	7.7	4.45	1.2	
	0.80	N331.1A-08 45 08H-WL	*	*	*	*	*	*	*						*		*	*	*				*						9.5	7.7	4.45	1.2	
11	0.80	N331.1A-11 50 08E-KL									*	*	*	*															11.5	10.7	4.95	1.2	
	0.80	N331.1A-11 50 08H-ML				*		*	*							*		*	*				*						11.5	10.7	4.95	1.2	
	0.80	N331.1A-11 50 08H-NL	*		*		*	*	*						*		*	*	*				*						11.5	10.7	4.95	1.3	
	0.80	N331.1A-11 50 08H-PL	*	*	*	*	*	*	*						*		*	*	*				*						11.5	10.7	4.95	1.2	
	0.80	N331.1A-11 50 08H-WL	*	*	*	*	*	*	*						*		*	*	*				*						11.5	10.7	4.95	1.2	
14	0.80	N331.1A-14 50 08E-KL									*	*	*	*															11.5	13.7	4.95	1.2	
	0.80	N331.1A-14 50 08H-ML				*		*	*							*		*	*				*						11.5	13.7	4.95	1.2	
	0.80	N331.1A-14 50 08H-NL	*		*		*	*	*						*		*	*	*				*						11.5	13.7	4.95	1.1	
	0.80	N331.1A-14 50 08H-PL	*	*	*	*	*	*	*						*		*	*	*				*						11.5	13.7	4.95	1.2	
	0.80	N331.1A-14 50 08H-WL	*	*	*	*	*	*	*						*		*	*	*				*						11.5	13.7	4.95	1.2	
Medium	04	0.50	N331.1A-04 35 05H-MM				*	*	*														*						9.5	4.6	3.50	0.4	
		0.50	N331.1A-04 35 05M-KM				*	*	*	*	*	*	*	*										*						9.5	4.6	3.50	0.4
		0.50	N331.1A-04 35 05M-PM	*	*	*		*	*	*																				9.5	4.6	3.50	0.4
	05	0.80	N331.1A-05 45 08E-KM								*	*	*	*										*						9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08H-MM				*		*	*														*						9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08H-PM	*	*	*		*	*	*														*						9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08M-KM	*	*	*	*	*	*	*	*	*	*	*										*						9.5	5.7	4.45	1.2
		0.80	N331.1A-05 45 08M-PM	*	*	*	*	*	*	*						*		*	*	*				*						9.5	5.7	4.45	1.2
	08	0.80	N331.1A-08 45 08E-KM								*	*	*	*										*						9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08H-MM				*		*	*														*						9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08H-PM	*	*	*		*	*	*														*						9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08H-WM	*	*	*	*	*	*	*						*		*	*	*				*						9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08M-KM	*	*	*	*	*	*	*	*	*	*	*										*						9.5	7.7	4.45	1.2
		0.80	N331.1A-08 45 08M-PM	*	*	*	*	*	*	*						*		*	*	*				*						9.5	7.7	4.45	1.2
	11	0.80	N331.1A-11 50 08E-KM								*	*	*	*										*						11.5	10.7	4.95	1.2
		0.80	N331.1A-11 50 08H-MM				*		*	*														*						11.5	10.7	4.95	1.2
		0.80	N331.1A-11 50 08H-PM	*	*	*		*	*	*														*						11.5	10.7	4.95	1.2
		0.80	N331.1A-11 50 08H-WM	*	*	*	*	*	*	*						*		*	*	*				*						11.5	10.7	4.95	1.2
		0.80	N331.1A-11 50 08M-KM	*	*	*	*	*	*	*	*	*	*	*										*						11.5	10.7	4.95	1.2
		0.80	N331.1A-11 50 08M-PM	*	*	*	*	*	*	*						*		*	*	*				*						11.5	10.7	4.95	1.2
	14	0.80	N331.1A-14 50 08E-KM								*	*	*	*										*						11.5	13.7	4.95	1.2
		0.80	N331.1A-14 50 08H-MM				*		*	*														*						11.5	13.7	4.95	1.2
		0.80	N331.1A-14 50 08H-PM	*	*	*	*	*	*	*						*		*	*	*				*						11.5	13.7	4.95	1.2
		0.80	N331.1A-14 50 08H-WM	*	*	*	*	*	*	*						*		*	*	*				*						11.5	13.7	4.95	1.2
	0.80	N331.1A-14 50 08M-KM	*	*	*	*	*	*	*	*	*	*	*										*						11.5	13.7	4.95	1.2	
	0.80	N331.1A-14 50 08M-PM	*	*	*	*	*	*	*						*		*	*	*				*						11.5	13.7	4.95	1.2	



1112



1146



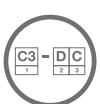
1168



N22



N6

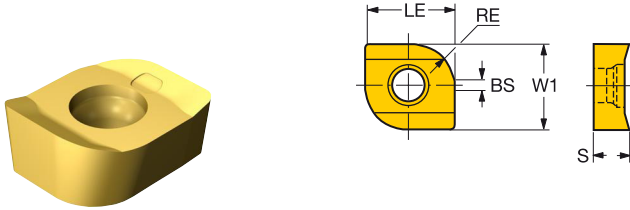


N10

CoroMill® 331 insert for slotting

Cutter bodies for radii inserts available as Tailor made.

KRINS 90°

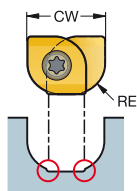


RE	Ordering code	Material										Dimensions, mm						
		P		M		K		N		S		H		W1	LE	S	BS	
		1130	4240	1025	1040	1130	1025	4240	1130	H10F	1025	1040	1130					H10F
04	1.52 L331.1A-04 35 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	4.6	3.50	0.4
	2.29 L331.1A-04 35 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	4.6	3.50	0.4
	1.52 R331.1A-04 35 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	4.6	3.50	0.4
	2.29 R331.1A-04 35 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	4.6	3.50	0.4
05	1.52 L331.1A-05 45 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	5.7	4.45	1.2
	2.29 L331.1A-05 45 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	5.7	4.45	1.2
	3.05 L331.1A-05 45 30H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	5.7	4.45	1.3
	1.52 R331.1A-05 45 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	5.7	4.45	1.2
	2.29 R331.1A-05 45 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	5.7	4.45	1.2
	3.05 R331.1A-05 45 30H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	5.7	4.45	1.3
08	1.52 L331.1A-08 45 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	7.7	4.45	1.2
	2.29 L331.1A-08 45 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	7.7	4.45	1.2
	3.05 L331.1A-08 45 30H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	7.7	4.45	1.3
	1.52 R331.1A-08 45 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	7.7	4.45	1.2
	2.29 R331.1A-08 45 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	7.7	4.45	1.2
	3.05 R331.1A-08 45 30H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	9.5	7.7	4.45	1.3
11	1.52 L331.1A-11 50 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.2
	2.29 L331.1A-11 50 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.2
	3.05 L331.1A-11 50 30H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.3
	4.83 L331.1A-11 50 48H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.5
	6.35 L331.1A-11 50 63H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.6
	1.52 R331.1A-11 50 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.2
	2.29 R331.1A-11 50 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.2
	3.05 R331.1A-11 50 30H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.3
	4.83 R331.1A-11 50 48H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.5
	6.35 R331.1A-11 50 63H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	10.7	4.95	1.6
14	1.52 L331.1A-14 50 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.2
	2.29 L331.1A-14 50 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.2
	3.05 L331.1A-14 50 30H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.3
	4.83 L331.1A-14 50 48H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.5
	6.35 L331.1A-14 50 63H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.6
	1.52 R331.1A-14 50 15H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.2
	2.29 R331.1A-14 50 23H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.2
	3.05 R331.1A-14 50 30H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.3
	4.83 R331.1A-14 50 48H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.5
	6.35 R331.1A-14 50 63H-WL	★	☆	★	☆	★	☆	★	☆	★	☆	★	☆	★	11.5	13.7	4.95	1.6

Limitations when using inserts with large corner radius

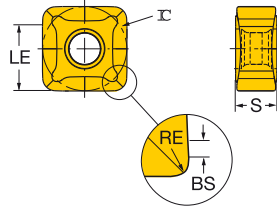
Full slot milling

Insert size	Calculated CW
04	CW = RE + 4.6
05	CW = RE + 6
08	CW = RE + 8
11	CW = RE + 11



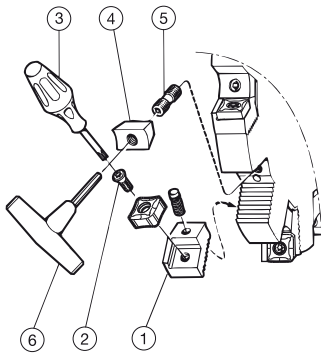
CoroMill® 331 insert for side and face milling

KRINS 88°



	RE	Ordering code	P		M		K		N		S		H		Dimensions, mm							
			1030	4220	4230	4240	1030	4240	1020	3040	3330	1030	1030	4220	IC	LE	S	BS				
Medium	PM	13 0.80	N331.1D-136508E-PM	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	13.4	11.4	6.55	1.2
		0.80	N331.1D-136508M-PM	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	13.4	11.4	6.55	1.2
		1.20	N331.1D-136512M-PM	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	13.4	11.0	6.55	1.2
		2.00	N331.1D-136520E-PM	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	13.4	10.2	6.55	1.2
		2.00	N331.1D-136520M-PM	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	13.4	10.2	6.55	1.2

These double sided inserts need optional cassettes. See below for more information.



Note that the diameter of the cutter increases by 3.2 mm when using the cassettes for double sided inserts.

Cutter type	1	1	2	3	4	5	6	
	Cassette Right	Cassette Left	Screw	Key (Torx Plus)	Torque wrench ¹⁾	Wedge	Screw	Key (mm)
QM (a _φ 20.5–23.5 mm)	5321 260-01	5321 260-02	5513 020-25	5680 046-02 (15IP)	5680 100-06	5431 105-05	339-831	265.2-817 (3.0)
RM (a _φ 23.5–26.5 mm)	5321 260-01	5321 260-02	5513 020-25	5680 046-02 (15IP)	5680 100-06	5431 105-05	339-831	265.2-817 (3.0)

¹⁾ Optional part to be ordered separately.

Note!
Cutter bodies can be ordered separately. For further information contact your Sandvik Coromant sales representative.

