

CoroMill® 210

High feed face and plunge milling

Application

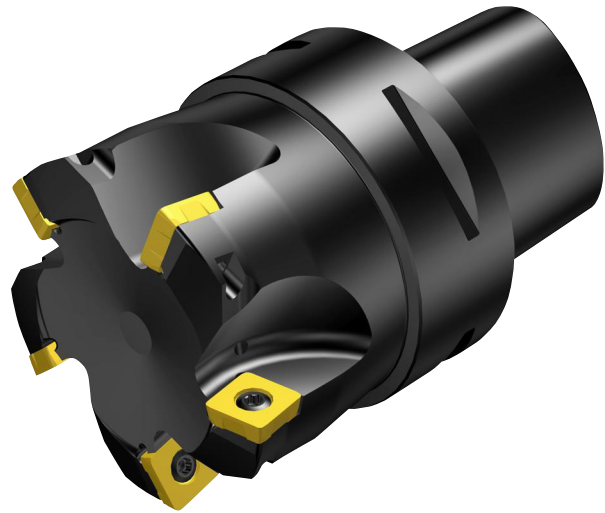
- High feed face milling
- Plunge milling
- Ramping
- Roughing to semi-finishing
- Helical interpolation
- Profiling

ISO application area:



Benefits and features

- High table feed due to the chip thinning effect – high productivity
- First choice face milling cutter in long overhang machining
- Multipurpose tool. Face milling, boring possibilities, ramping and plunge milling
- Internal coolant



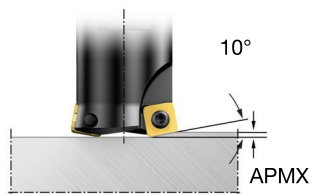
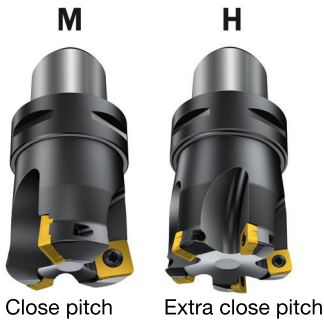
www.sandvik.coromant.com/coromill210

Couplings

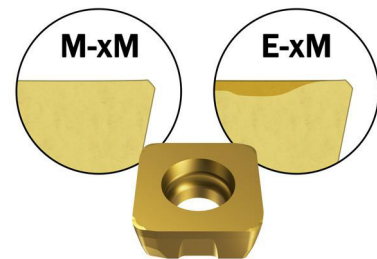
- Coromant Capto®
- Arbor
- Cylindrical shank
- Threaded coupling

Inserts

- Four cutting edges
- Insert geometries and grades for all materials apart from ISO N
- E-xM geometry for excellent performance in titanium



The 10 degree entering angle allows extreme feed rates when face milling.



Recommended feed per tooth (f_z) 1.5 mm for size 09 inserts and 2 mm feed per tooth (f_z) for size 14 inserts.



I21



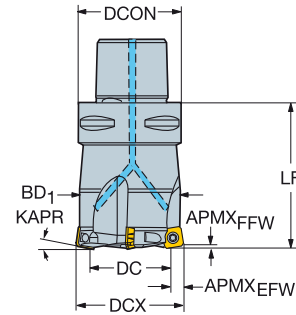
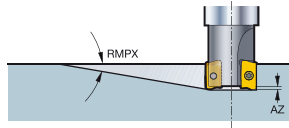
I24

CoroMill® 210 face milling cutter

Coromant Capto® - Internal coolant supply

KAPR

10°



| | | | | | | | | | | Dimensions, mm | | | | | | | | |
|------|----|-------------------|---------------------|---------------------|-------|-----|------|---|----------------|----------------|------|-----------------|------|-----|------|-------|------|---------------|
| DC | | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | | Ordering code | DCON | DCX | BD ₁ | LF | NM | KG | RPMX | CICT | MIID |
| 21.9 | 09 | C3 | 8.0 | 1.20 | 7.00° | 1.8 | 3 | 2 | R210-036C3-09M | 32.0 | 36.0 | 33.0 | 50.0 | 3.0 | 0.44 | 30900 | 2 | R210-090412M- |
| | 09 | C3 | 8.0 | 1.20 | 7.00° | 1.8 | 3 | 3 | R210-036C3-09H | 32.0 | 36.0 | 33.0 | 50.0 | 3.0 | 0.37 | 30900 | 3 | R210-090412M- |
| 27.9 | 09 | C4 | 8.0 | 1.20 | 5.00° | 1.8 | 3 | 3 | R210-042C4-09M | 40.0 | 42.0 | 39.0 | 60.0 | 3.0 | 0.79 | 27600 | 3 | R210-090412M- |
| | 09 | C4 | 8.0 | 1.20 | 5.00° | 1.8 | 3 | 4 | R210-042C4-09H | 40.0 | 42.0 | 39.0 | 60.0 | 3.0 | 0.60 | 27600 | 4 | R210-090412M- |
| 28.0 | 14 | C5 | 13.0 | 2.00 | 5.80° | 2.0 | 3 | 3 | R210-052C5-14M | 50.0 | 52.0 | 47.7 | 70.0 | 5.0 | 1.21 | 20800 | 3 | R210-140512M- |
| | 14 | C5 | 13.0 | 2.00 | 3.30° | 2.0 | 3 | 4 | R210-052C5-14H | 50.0 | 52.0 | 47.7 | 70.0 | 5.0 | 1.21 | 20800 | 4 | R210-140512M- |
| 30.0 | 14 | C5 | 13.0 | 2.00 | 5.60° | 2.0 | 3 | 4 | R210-054C5-14H | 50.0 | 54.0 | 49.7 | 70.0 | 5.0 | 1.35 | 23600 | 4 | R210-140512M- |
| 37.9 | 09 | C5 | 8.0 | 1.20 | 3.30° | 1.8 | 3 | 4 | R210-052C5-09M | 50.0 | 52.0 | 49.0 | 70.0 | 3.0 | 1.26 | 24000 | 4 | R210-090412M- |
| | 09 | C5 | 8.0 | 1.20 | 3.30° | 1.8 | 3 | 5 | R210-052C5-09H | 50.0 | 52.0 | 49.0 | 70.0 | 3.0 | 1.20 | 24000 | 5 | R210-090412M- |
| 39.9 | 09 | C5 | 8.0 | 1.20 | 3.10° | 1.8 | 3 | 5 | R210-054C5-09H | 50.0 | 54.0 | 51.0 | 70.0 | 3.0 | 1.15 | 23600 | 5 | R210-090412M- |
| 42.0 | 14 | C6 | 13.0 | 2.00 | 3.20° | 2.0 | 3 | 4 | R210-066C6-14M | 63.0 | 66.0 | 61.7 | 72.0 | 5.0 | 2.02 | 17700 | 4 | R210-140512M- |
| | 14 | C6 | 13.0 | 2.00 | 3.20° | 2.0 | 3 | 5 | R210-066C6-14H | 63.0 | 66.0 | 61.7 | 72.0 | 5.0 | 2.03 | 17700 | 5 | R210-140512M- |
| 51.9 | 09 | C6 | 8.0 | 1.20 | 2.40° | 1.8 | 3 | 6 | R210-066C6-09M | 63.0 | 66.0 | 63.0 | 72.0 | 3.0 | 2.05 | 21300 | 6 | R210-090412M- |
| 58.0 | 14 | C8 | 13.0 | 2.00 | 2.20° | 2.0 | 3 | 5 | R210-082C8-14M | 80.0 | 82.0 | 77.7 | 80.0 | 5.0 | 3.50 | 15100 | 5 | R210-140512M- |
| | 14 | C8 | 13.0 | 2.00 | 2.30° | 2.0 | 3 | 6 | R210-082C8-14H | 80.0 | 82.0 | 77.7 | 80.0 | 5.0 | 3.46 | 15100 | 6 | R210-140512M- |
| 62.0 | 14 | C8 | 13.0 | 2.00 | 2.20° | 2.0 | 3 | 6 | R210-086C8-14H | 80.0 | 86.0 | 81.7 | 80.0 | 5.0 | 3.67 | 14700 | 6 | R210-140512M- |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 09 | 5513 020-02 |
| 14 | 5513 020-50 |

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



I24



L4



N22



N9



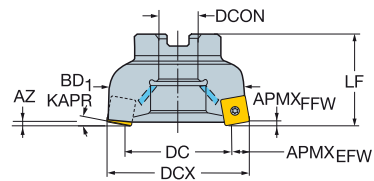
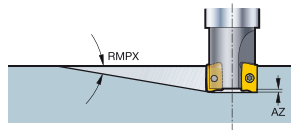
N15

CoroMill® 210 face milling cutter

Arbor - Internal coolant supply

STDNO
KAPR

ISO 6462:2011
10°



| | | | | | | | | | | Dimensions, mm | | | | | | | | | |
|-------|-------------------|---------------------|---------------------|------|-------|------|---------------|---|-----------------|----------------|-----|-----------------|-------|------|-----|------|-------|------|---------------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON | ISO | DCX | BD ₁ | LF | NM | KG | RPMX | CICT | MIID | |
| 35.9 | 09 | 22 | 8.0 | 1.20 | 3.50° | 1.8 | 1 | 4 | R210-050Q22-09M | 22.0 | A | 50.0 | 47.0 | 50.0 | 3.0 | 0.68 | 24500 | 4 | R210-090412M- |
| | 09 | 22 | 8.0 | 1.20 | 3.50° | 1.8 | 1 | 5 | R210-050Q22-09H | 22.0 | A | 50.0 | 47.0 | 50.0 | 3.0 | 0.63 | 24500 | 5 | R210-090412M- |
| 39.0 | 14 | 22 | 13.0 | 2.00 | 3.80° | 2.0 | 1 | 4 | R210-063Q22-14M | 22.0 | A | 63.0 | 58.7 | 50.0 | 5.0 | 0.76 | 18300 | 4 | R210-140512M- |
| | 14 | 27 | 13.0 | 2.00 | 3.80° | 2.0 | 1 | 4 | R210-063Q27-14M | 27.0 | A | 63.0 | 58.7 | 50.0 | 5.0 | 0.81 | 18300 | 4 | R210-140512M- |
| | 14 | 22 | 13.0 | 2.00 | 3.80° | 2.0 | 1 | 5 | R210-063Q22-14H | 22.0 | A | 63.0 | 58.7 | 50.0 | 5.0 | 0.92 | 18300 | 5 | R210-140512M- |
| 48.9 | 09 | 22 | 8.0 | 1.20 | 2.60° | 1.8 | 1 | 5 | R210-063Q22-09M | 22.0 | A | 63.0 | 60.0 | 50.0 | 3.0 | 0.85 | 21800 | 5 | R210-090412M- |
| | 09 | 27 | 8.0 | 1.20 | 2.60° | 1.8 | 1 | 5 | R210-063Q27-09M | 27.0 | A | 63.0 | 60.0 | 50.0 | 3.0 | 1.05 | 21800 | 5 | R210-090412M- |
| | 09 | 22 | 8.0 | 1.20 | 2.60° | 1.8 | 1 | 6 | R210-063Q22-09H | 22.0 | A | 63.0 | 60.0 | 50.0 | 3.0 | 0.86 | 21800 | 6 | R210-090412M- |
| 56.0 | 14 | 27 | 13.0 | 2.00 | 2.40° | 2.0 | 1 | 5 | R210-080Q27-14M | 27.0 | A | 80.0 | 75.7 | 50.0 | 5.0 | 1.10 | 15400 | 5 | R210-140512M- |
| | 14 | 27 | 13.0 | 2.00 | 2.40° | 2.0 | 1 | 6 | R210-080Q27-14H | 27.0 | A | 80.0 | 75.7 | 50.0 | 5.0 | 1.20 | 15400 | 6 | R210-140512M- |
| 76.0 | 14 | 32 | 13.0 | 2.00 | 1.60° | 2.0 | 1 | 6 | R210-100Q32-14M | 32.0 | B | 100.0 | 95.7 | 50.0 | 5.0 | 1.85 | 13400 | 6 | R210-140512M- |
| | 14 | 32 | 13.0 | 2.00 | 1.50° | 2.0 | 1 | 7 | R210-100Q32-14H | 32.0 | B | 100.0 | 95.7 | 50.0 | 5.0 | 1.92 | 13400 | 7 | R210-140512M- |
| 101.0 | 14 | 40 | 13.0 | 2.00 | 1.20° | 2.0 | 1 | 7 | R210-125Q40-14M | 40.0 | B | 125.0 | 120.7 | 63.0 | 5.0 | 3.83 | 11400 | 7 | R210-140512M- |
| 136.0 | 14 | 40 | 13.0 | 2.00 | 1.00° | 2.0 | 1 | 8 | R210-160Q40-14M | 40.0 | B | 160.0 | 155.7 | 63.0 | 5.0 | 5.78 | 10400 | 8 | R210-140512M- |

| Spare parts | |
|-------------|--------------|
| | Insert screw |
| 09 | 5513 020-02 |
| 14 | 5513 020-50 |

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



I24



L4



M2



N22



N9



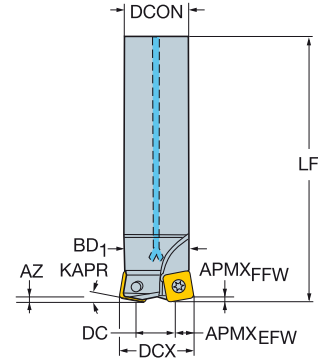
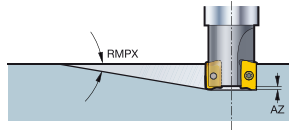
N15

CoroMill® 210 face milling cutter

Cylindrical shank - Internal coolant supply

KAPR

10°

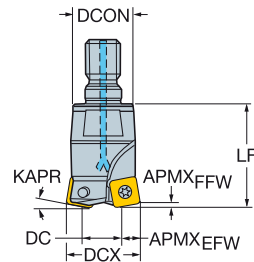
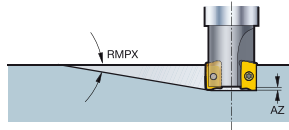


| | | | | | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|--------|------|---------------|---|-----------------|----------------|-----------------|------|-------|-----|------|-------|------|---------------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON | DCX | BD ₁ | LF | NM | KG | RPMX | CICT | MIID | |
| 10.9 | 09 | 20 | 8.0 | 1.20 | 14.50° | 1.8 | 1 | 2 | R210-025A20-09M | 20.0 | 25.0 | 22.0 | 180.0 | 3.0 | 0.54 | 17200 | 2 | R210-090412M- |
| 17.9 | 09 | 25 | 8.0 | 1.20 | 8.00° | 1.8 | 1 | 3 | R210-032A25-09H | 25.0 | 32.0 | 29.0 | 210.0 | 3.0 | 0.88 | 11000 | 3 | R210-090412M- |
| | 09 | 25 | 8.0 | 1.20 | 8.00° | 1.8 | 1 | 2 | R210-032A25-09M | 25.0 | 32.0 | 29.0 | 210.0 | 3.0 | 0.88 | 11000 | 3 | R210-090412M- |
| 20.9 | 09 | 32 | 8.0 | 1.20 | 7.00° | 1.8 | 1 | 3 | R210-035A32-09H | 32.0 | 35.0 | 32.0 | 210.0 | 3.0 | 1.30 | 11000 | 3 | R210-090412M- |
| 27.9 | 09 | 32 | 8.0 | 1.20 | 5.00° | 1.8 | 1 | 3 | R210-042A32-09M | 32.0 | 42.0 | 39.0 | 250.0 | 3.0 | 1.83 | 8000 | 3 | R210-090412M- |
| | 09 | 32 | 8.0 | 1.20 | 5.00° | 1.8 | 1 | 4 | R210-042A32-09H | 32.0 | 42.0 | 39.0 | 250.0 | 3.0 | 1.77 | 8000 | 4 | R210-090412M- |

Threaded coupling - Internal coolant supply

KAPR

10°



| | | | | | | | | | | Dimensions, mm | | | | | | | | |
|------|-------------------|---------------------|---------------------|------|--------|------|---------------|---|-----------------|----------------|-----------------|------|------|-----|------|-------|------|---------------|
| DC | CZC _{MS} | APMX _{EFW} | APMX _{FFW} | RMPX | AZ | CNSC | Ordering code | | DCON | DCX | BD ₁ | LF | NM | KG | RPMX | CICT | MIID | |
| 10.9 | 09 | M12 | 8.0 | 1.20 | 14.50° | 1.8 | 1 | 2 | R210-025T12-09M | 20.8 | 25.0 | 22.0 | 35.0 | 3.0 | 0.24 | 15000 | 2 | R210-090412M- |
| 17.9 | 09 | M16 | 8.0 | 1.20 | 8.00° | 1.8 | 1 | 2 | R210-032T16-09M | 28.8 | 32.0 | 29.0 | 45.0 | 3.0 | 0.36 | 15000 | 2 | R210-090412M- |
| 20.9 | 09 | M16 | 8.0 | 1.20 | 7.00° | 1.8 | 1 | 3 | R210-035T16-09H | 28.8 | 35.0 | 32.0 | 50.0 | 3.0 | 0.37 | 15000 | 3 | R210-090412M- |
| 27.9 | 09 | M16 | 8.0 | 1.20 | 5.00° | 1.8 | 1 | 4 | R210-042T16-09H | 28.8 | 42.0 | 39.0 | 50.0 | 3.0 | 0.44 | 15000 | 4 | R210-090412M- |

Spare parts

Insert screw
5513 020-02

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



I24



L4



N22



N9



N15

