

# CoroMill® 745

Multi-edge face milling and high feed milling concepts.

## Application

- Face milling
- Roughing to semi-finishing
- High feed milling

## ISO application area:



## Benefits and features

- Multi-edge concept suitable for large batch productions, flexible transfer lines and when maximum tool utilization is important
- CoroMill 745 with 42° entering angle is used in ISO P, K, M and S applications where APMX is 5.2 mm
- CoroMill 745 high feed cutter with 25° entering angle is used as a productivity booster in ISO P and ISO K applications where APMX is 2.8 mm
- Great problem-solving abilities when machining vibration-sensitive components and in weak set-ups with the unique differential MD pitch



[www.sandvik.coromant.com/coromill745](http://www.sandvik.coromant.com/coromill745)

## Couplings

- Coromant Capto®
- Arbor

## Inserts

- 14 cutting edges
- The secure tip seat and the large, robust insert with strong, light-cutting geometries are designed for reliable and predictable machining.

## Ground-breaking technology

Available with 42° entering angle for larger cutting depths and as a high feed version with 25° entering angle for an even higher metal removal rate. Same inserts are used in both cutters.



## Differential MD pitch

The unique differential MD pitch is first choice in roughing operations where light cutting action is required, e.g. in vibration-sensitive and weak set-ups. It is a perfect problem-solver when vibration is a limitation in the production. The length and weight of the cutter body has been reduced in order to boost the performance in low-productive applications. The cutter has a logarithmic differential pitch design, and the insert position is radially compensated to produce an even chip load on every insert.



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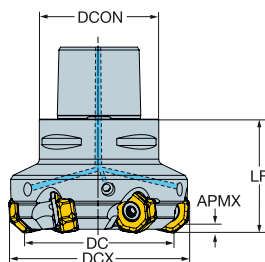


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# CoroMill® 745 face milling cutter

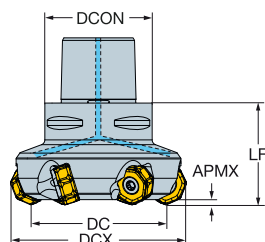
Coromant Capto® - Internal coolant supply

KAPR 42°



						Dimensions, mm								
DC		CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC		Ordering code	DCON	DCX	LF			RPMX	CICT	MIID
63.0	21	C5	5.20	3	5	745-063C5-21M	50.0	78.2	60.0	12.0	1.30	5894	5	745R-2109
	21	C6	5.20	3	5	745-063C6-21M	63.0	78.2	60.0	12.0	1.84	5894	5	745R-2109
	21	C5	5.20	3	7	745-063C5-21H	50.0	78.2	60.0	12.0	1.34	5894	7	745R-2109
80.0	21	C6	5.20	3	7	745-063C6-21H	63.0	78.2	60.0	12.0	1.66	5894	7	745R-2109
	21	C6	5.20	3	6	745-080C6-21M	63.0	95.2	60.0	12.0	2.21	5324	6	745R-2109
	21	C8	5.20	3	6	745-080C8-21M	80.0	95.2	65.0	12.0	3.12	5324	6	745R-2109
100.0	21	C6	5.20	3	9	745-080C6-21H	63.0	95.2	60.0	12.0	2.09	5324	9	745R-2109
	21	C8	5.20	3	9	745-080C8-21H	80.0	95.2	65.0	12.0	3.23	5324	9	745R-2109
	21	C8	5.20	3	7	745-100C8-21M	80.0	115.2	80.0	12.0	3.66	4765	7	745R-2109
	21	C8	5.20	3	11	745-100C8-21H	80.0	115.2	80.0	12.0	3.62	4765	11	745R-2109

KAPR 25°



High feed cutter

						Dimensions, mm								
DC		CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC		Ordering code	DCON	DCX	LF			RPMX	CICT	MIID
63.0	21	C5	2.80	3	5	725-063C5-21M	50.0	86.4	60.0	12.0	1.30	5894	5	745R-2109
	21	C6	2.80	3	5	725-063C6-21M	63.0	86.4	60.0	12.0	1.70	5894	5	745R-2109
	21	C5	2.80	3	7	725-063C5-21H	50.0	86.4	60.0	12.0	1.20	5894	7	745R-2109
80.0	21	C6	2.80	3	7	725-063C6-21H	63.0	86.4	60.0	12.0	1.60	5894	7	745R-2109
	21	C6	2.80	3	6	725-080C6-21M	63.0	103.4	65.0	12.0	2.06	5324	6	745R-2109
	21	C8	2.80	3	6	725-080C8-21M	80.0	103.4	65.0	12.0	3.04	5324	6	745R-2109
100.0	21	C6	2.80	3	9	725-080C6-21H	63.0	103.4	65.0	12.0	1.93	5324	9	745R-2109
	21	C8	2.80	3	9	725-080C8-21H	80.0	103.4	65.0	12.0	2.91	5324	9	745R-2109
	21	C8	2.80	3	7	725-100C8-21M	80.0	123.4	80.0	12.0	3.67	4765	7	745R-2109
	21	C8	2.80	3	11	725-100C8-21H	80.0	123.4	80.0	12.0	3.49	4765	11	745R-2109

Spare parts
Insert screw 5513 020-80

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

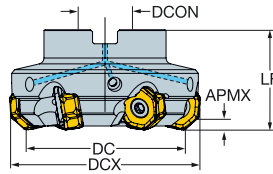


# CoroMill® 745 face milling cutter

Arbor - Internal coolant supply

STDNO  
KAPR

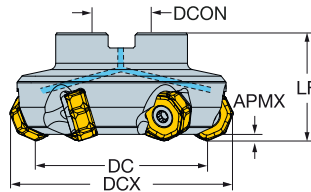
ISO 6462:2011  
42°



						Dimensions, mm											
DC		CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC		Ordering code	DCON	ISO	DBC	DCX	LF			RPMX	CICT	MIID	
63.0	21	22	5.20	3	5	745-063Q22-21M	22.0	A		78.2	50.0	12.0	0.80	5894	5	745R-2109	
	21	22	5.20	3	5	745-063Q22-21MD	22.0	A		78.2	46.0	12.0	0.83	5894	5	745R-2109	
	21	22	5.20	3	7	745-063Q22-21H	22.0	A		78.2	50.0	12.0	0.98	5894	7	745R-2109	
80.0	21	27	5.20	3	6	745-080Q27-21M	27.0	A		95.2	50.0	12.0	1.48	5324	6	745R-2109	
	21	27	5.20	3	6	745-080Q27-21MD	27.0	A		95.2	48.0	12.0	1.38	5324	6	745R-2109	
	21	27	5.20	3	9	745-080Q27-21H	27.0	A		95.2	50.0	12.0	1.37	5324	9	745R-2109	
100.0	21	32	5.20	3	7	745-100Q32-21M	32.0	A		115.2	50.0	12.0	2.19	4765	7	745R-2109	
	21	32	5.20	3	7	745-100Q32-21MD	32.0	A		115.2	50.0	12.0	2.12	4765	7	745R-2109	
	21	32	5.20	3	11	745-100Q32-21H	32.0	A		115.2	50.0	12.0	2.01	4765	11	745R-2109	
125.0	21	40	5.20	3	8	745-125Q40-21M	40.0	B		140.2	63.0	12.0	3.75	4216	8	745R-2109	
	21	40	5.20	3	8	745-125Q40-21MD	40.0	B		140.2	54.0	12.0	2.95	4216	8	745R-2109	
	21	40	5.20	3	14	745-125Q40-21H	40.0	B		140.2	63.0	12.0	3.53	4216	14	745R-2109	
160.0	21	40	5.20	3	10	745-160Q40-21M	40.0	B		175.2	63.0	12.0	5.26	3675	10	745R-2109	
	21	40	5.20	3	10	745-160Q40-21MD	40.0	B		175.2	60.0	12.0	4.70	3675	10	745R-2109	
	21	40	5.20	3	16	745-160Q40-21H	40.0	B		175.2	63.0	12.0	5.00	3675	16	745R-2109	
200.0	21	60	5.20	0	14	745-200Q60-21M	60.0	C	101.6	215.2	63.0	12.0	6.31	3292	14	745R-2109	
	21	60	5.20	0	21	745-200Q60-21H	60.0	C	101.6	215.2	63.0	12.0	6.61	3292	21	745R-2109	
250.0	21	60	5.20	0	16	745-250Q60-21M	60.0	C	101.6	264.4	63.0	12.0	9.40	2998	16	745R-2109	
	21	60	5.20	0	26	745-250Q60-21H	60.0	C	101.6	264.4	63.0	12.0	9.00	2998	26	745R-2109	

STDNO  
KAPR

ISO 6462:2011  
25°



## High feed cutter

						Dimensions, mm											
DC		CZC <sub>MS</sub>	APMX <sub>FFW</sub>	CNSC		Ordering code	DCON	ISO	DCX	LF			RPMX	CICT	MIID		
63.0	21	22	2.80	3	5	725-063Q22-21M	22.0	A	86.4	50.0	12.0	0.90	5894	5	745R-2109		
	21	22	2.80	3	7	725-063Q22-21H	22.0	A	86.4	50.0	12.0	0.81	5894	7	745R-2109		
80.0	21	27	2.80	3	6	725-080Q27-21M	27.0	A	103.4	50.0	12.0	1.36	5324	6	745R-2109		
	21	27	2.80	3	9	725-080Q27-21H	27.0	A	103.4	50.0	12.0	1.23	5324	9	745R-2109		
100.0	21	32	2.80	3	7	725-100Q32-21M	32.0	A	123.4	50.0	12.0	2.33	4765	7	745R-2109		
	21	32	2.80	3	11	725-100Q32-21H	32.0	A	123.4	50.0	12.0	2.18	4765	11	745R-2109		
125.0	21	40	2.80	3	8	725-125Q40-21M	40.0	B	148.4	63.0	12.0	3.97	4216	8	745R-2109		
	21	40	2.80	3	14	725-125Q40-21H	40.0	B	148.4	63.0	12.0	3.17	4216	14	745R-2109		
160.0	21	40	2.80	3	10	725-160Q40-21M	40.0	B	183.4	63.0	12.0	4.86	3675	10	745R-2109		
	21	40	2.80	3	16	725-160Q40-21H	40.0	B	183.4	63.0	12.0	5.31	3675	16	745R-2109		

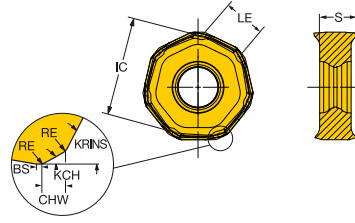
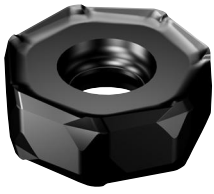
Spare parts		
DC	Shower screw	Insert screw
63.00	5512 073-01	5513 020-80
80.00	5512 073-02	5513 020-80
100.00	5512 073-05	5513 020-80
125.00-160.00	5512 098-03	5513 020-80
250.00	-	5513 020-80

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



# CoroMill® 745 insert for milling

KRINS 42°



		RE	KCH	CHW	Ordering code	P												M				K				S				Dimensions, mm									
						1040	1130	2030	2040	3040	4220	4230	4240	S40T	1040	2030	2040	4240	S30T	S40T	1020	3040	4220	4230	4240	K20D	K20W	2030	2040	S30T	S40T	IC	LE	S	BS	BSR			
Medium	M30	21	1.00	17°	1.3	745R-2109E-M30	★			☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	21.0	8.9	9.00	0.3	25.0	
	M31	21	1.00			745R-2109E-M31	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	21.0	7.1	9.00	1.9	150.0
Roughing	M50	21	1.00	17°	1.3	745R-2109E-M50	☆			☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	21.0	8.9	9.00	0.3	25.0
		21	1.00	17°	1.3	745L-2109E-M50														★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	21.0	8.5	9.00	0.3	25.0
Heavy	H50	21	1.00	17°	1.3	745R-2109E-H50				☆	☆	☆	☆	☆	☆	☆	☆	★	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	☆	21.0	8.9	9.00	0.3	25.0

745R-2109E-M31 not recommended for CoroMill 745 high feed cutter with 25° entering angle.

