

# CoroMill® 328

Grooving, threading and circlip grooving

## Application

- Thread milling
- Grooving
- Circlip grooving

## ISO application area:



## Benefits and features

- Inserts mounted in pockets for safe and stable mounting
- Large programme of inserts covering circlips, slots, threads, etc.
- Sharp precision-ground insert
- Different thread pitches possible with one tool
- Excellent for both internal and external machining
- Comes in four tool holder sizes with the same insert size
- Sharp cutting edges for high quality grooves without burr
- One grade; PVD coated GC1025 for all materials
- Multiple edges for economic machining



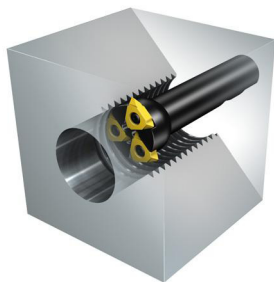
[www.sandvik.coromant.com/coromill328](http://www.sandvik.coromant.com/coromill328)

## Couplings

- Arbor
- Weldon
- Bore with keyway

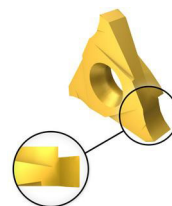
## Inserts

- Three cutting edges

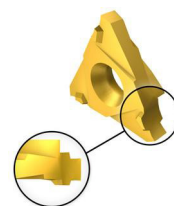


Thread forms: V-profile 60°, M 60° and UN 60°

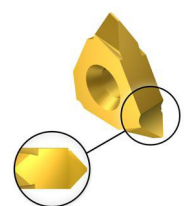
Circlip grooving



Circlip grooving with chamfer



Thread milling



I134

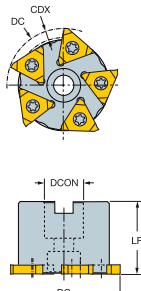


I135

# CoroMill® 328 groove milling cutter

Arbor

STDNO ISO 6462:2011  
KAPR 90°

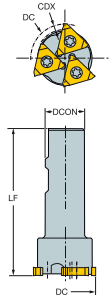


Dimensions, mm

CW	DC	CDX		CZC <sub>MS</sub>		Ordering code	DCON	ISO	LF	DHUB			RPMX	CICT	MIID
1.30	63	5.0	13	22	5	328-063Q22-13M	22.0	A	40.00	51.0	6.5	0.84	11900	5	328R13-130 00-GM

Weldon

KAPR 90°

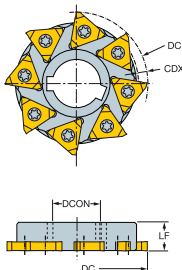


Dimensions, mm

CW	DC	CDX		CZC <sub>MS</sub>		Ordering code	DCON	LF			RPMX	CICT	MIID
1.30	39	3.0	13	25	2	328-039B25-13M	25.0	125.00	6.5	0.67	19300	2	328R13-130 00-GM
	44	4.0	13	25	3	328-044B25-13M	25.0	125.00	6.5	0.61	17100	3	328R13-130 00-GM

Bore with keyway

KAPR 90°



Dimensions, mm

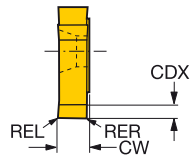
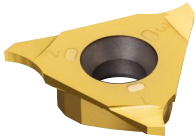
CW	DC	CDX		CZC <sub>MS</sub>		Ordering code	DCON	LF	DRVCT	DHUB			RPMX	CICT	MIID
1.30	63	5.0	13	22	5	328-063S22-13M	22.0	14.00	1	51.0	6.5	0.50	11900	5	328R13-130 00-GM
	80	5.0	13	27	8	328-080S27-13M	27.0	16.00	1	68.0	6.5	0.64	9400	8	328R13-130 00-GM

Spare parts
Insert screw 5513 039-05

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

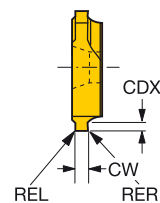
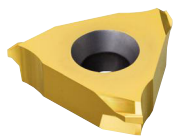


## CoroMill® 328 insert for groove milling



## For circlip grooves

						P	M	K	N	S	H	Dimensions, mm				
						1025	1025	1025	1025	1025	1025	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
SSC	CW	REL	RER	CDX	Ordering code	☆	☆	☆	☆	☆	☆					
Medium	13	1.30	0.10	0.10	5.00	328R13-130 00-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		1.60	0.15	0.15	5.00	328R13-160 00-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		1.85	0.15	0.15	5.00	328R13-185 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.15	0.15	0.15	5.00	328R13-215 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.65	0.15	0.15	5.00	328R13-265 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		3.15	0.15	0.15	5.00	328R13-315 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		4.15	0.15	0.15	5.00	328R13-415 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
	5.15	0.15	0.15	5.00	328R13-515 02-GM	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050	



## For circlip grooves and chamfering

						P	M	K	N	S	H	Dimensions, mm				
						1025	1025	1025	1025	1025	1025	AN	CWTOLL	CWTOLU	RETOLL	RETOLU
SSC	CW	REL	RER	CDX	Ordering code	☆	☆	☆	☆	☆	☆					
Medium	13	1.85	0.15	0.15	1.25	328R13-185 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.15	0.15	0.15	1.50	328R13-215 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.65	0.15	0.15	1.50	328R13-265 4515-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		2.65	0.15	0.15	1.75	328R13-265 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		3.15	0.15	0.15	1.75	328R13-315 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		4.15	0.15	0.15	2.00	328R13-415 4520-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		4.15	0.15	0.15	2.50	328R13-415 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050
		5.15	0.15	0.15	3.00	328R13-515 45-GC	☆	☆	☆	☆	☆	6°	0.090	0.110	-0.050	0.050



1134



1146



1168



N22



N12