

CoroMill® 690

The cutting edge for titanium milling

Application

- 2D profile milling of titanium
- Edging and full slotting

ISO application area:

S

Benefits and features

- High-productivity milling of titanium
- iLock™ interface gives a secure process, increased feed and longer tool life
- Cutting fluid supply, individual to each insert pocket
- Fully controlled flow and pressure through threaded holes - either for nozzles or plug screws
- Unique end- and side inserts for optimum performance



www.sandvik.coromant.com/coromill690

Couplings

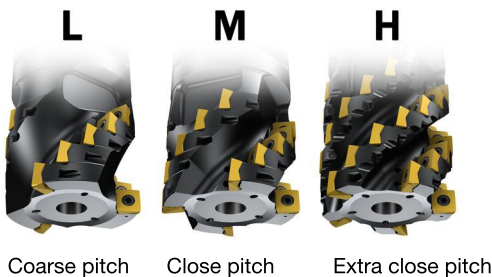
- Coromant Capto®
- Arbor
- HSK
- Oversized version available

Inserts

- Four cutting edges
- SL geometry optimized for titanium



P-SL = Side (or Periphery) insert
E-SL = End insert



Coarse pitch

Close pitch

Extra close pitch

Coolant supply

During cutting, the chips can be prone to sticking to the cutting edge. This means that the next cutter rotation is re-cutting the chip. By equipping every insert pocket with threaded coolant holes with nozzles for high pressure coolant delivery, you can apply maximum coolant where required. This effectively eliminates the problem for a constant cutting edge performance. Supplying cutting fluid to all the insert pockets in the long edge cutter requires high pump volumes and pressure capability.



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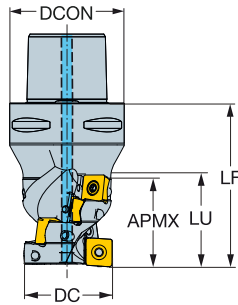


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CoroMill® 690 long edge square shoulder milling cutter

Coromant Capto® - Internal coolant supply

KAPR 90°



								Dimensions, mm							
DC	APMX _{FW}	CZC _{MS}	CNSC	Ordering code		DCON	DCX	LF	LU	RPMX	CICT _E	MID _E	CICT _P	MID _P	
40.0	46.0	10E 10P	C6 3	2	690-040C6-1046H	63.0	40.0	83.0	49.0	1.49	5000	2	690-100508M-E-SL	10	690-100510M-P-SL
53.0	46.0	10E 10P	C6 3	2	690-040C6-1053H	63.0	40.0	95.0	55.0	1.54	5000	2	690-100508M-E-SL	10	690-100510M-P-SL
44.0	46.0	10E 10P	C4 3	3	690-044C4-1046H	40.0	44.0	82.0		0.81	5000	3	690-100508M-E-SL	15	690-100510M-P-SL
50.0	53.0	10E 10P	C5 3	3	690-050C5-1053H	50.0	50.0	90.0	70.0	1.16	5000	3	690-100508M-E-SL	18	690-100510M-P-SL
54.0	53.0	10E 10P	C5 3	3	690-054C5-1053H	50.0	54.0	90.0		1.31	5000	3	690-100508M-E-SL	18	690-100510M-P-SL
61.0	14E 14P	C5 3	3		690-054C5-1461H	50.0	54.0	97.0		1.39	5000	3	690-140608M-E-SL	12	690-140610M-P-SL
63.0	60.0	10E 10P	C6 3	3	690-063C6-1060M	63.0	63.0	100.0	78.0	2.21	5000	3	690-100508M-E-SL	21	690-100510M-P-SL
	61.0	14E 14P	C6 3	3	690-063C6-1461H	63.0	63.0	103.0	79.0	2.13	5000	3	690-140608M-E-SL	12	690-140610M-P-SL
	112.0	10E 10P	C6 3	4	690-063C6-10112H	63.0	63.0	156.0	134.0	2.85	5000	4	690-100508M-E-SL	56	690-100510M-P-SL
66.0	49.0	14E 14P	C6 3	3	690-066C6-1449H	63.0	66.0	90.0		2.01	5000	3	690-140608M-E-SL	9	690-140610M-P-SL
	53.0	10E 10P	C6 3	3	690-066C6-1053M	63.0	66.0	95.0		2.28	5000	3	690-100508M-E-SL	18	690-100510M-P-SL
	53.0	10E 10P	C6 3	4	690-066C6-1053H	63.0	66.0	92.0		2.19	5000	4	690-100508M-E-SL	24	690-100510M-P-SL
	105.0	10E 10P	C6 3	4	690-066C6-10105H	63.0	66.0	150.0		2.88	5000	4	690-100508M-E-SL	52	690-100510M-P-SL
80.0	73.0	14E 14P	C8 3	3	690-080C8-1473M	80.0	80.0	128.0	98.0	4.27	5000	3	690-140608M-E-SL	15	690-140610M-P-SL
	73.0	14E 14P	C8 3	4	690-080C8-1473H	80.0	80.0	128.0	92.0	4.24	5000	4	690-140608M-E-SL	20	690-140610M-P-SL
	105.0	10E 10P	C8 3	5	690-080C8-10105H	80.0	80.0	153.0	120.0	4.79	5000	5	690-100508M-E-SL	65	690-100510M-P-SL
84.0	61.0	14E 14P	C8 3	3	690-084C8-1461L	80.0	84.0	112.0		3.99	5000	3	690-140608M-E-SL	12	690-140610M-P-SL
	61.0	14E 14P	C8 3	4	690-084C8-1461M	80.0	84.0	110.0		3.93	5000	4	690-140608M-E-SL	16	690-140610M-P-SL
	84.0	14E 14P	C8 3	5	690-084C8-1484H	80.0	84.0	132.0		4.57	5000	5	690-140608M-E-SL	30	690-140610M-P-SL
100.0	108.0	14E 14P	C8 3	4	690-100C8-14108M	80.0	100.0	160.0		7.12	5000	4	690-140608M-E-SL	32	690-140610M-P-SL

Spare parts			
DC	Insert screw	Plug screw	
40.00-44.00	10E 5513 020-68	3214 010-202	
50.00-80.00	10E 5513 020-68	3214 010-253	
54.00-100.00	14E 5513 020-55	3214 010-253	

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



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L4



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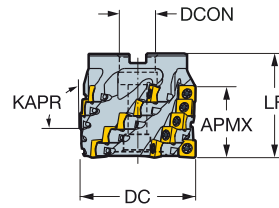
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CoroMill® 690 long edge square shoulder milling cutter

Arbor

STDNO
KAPRISO 6462:2011
90°

						Dimensions, mm										
DC	APMX _{FW}	10E	10P	CZC _{MS}	Ordering code	DCON	ISO	DCX	LF	KG	RPMX	CICT _E	MIID _E	CICT _P	MIID _P	
50.0	46.0	10E	10P	22	3	690-050Q22-1046H	22.0	A	50.0	75.0	0.98	5000	3	690-100508M-E-SL	15	690-100510M-P-SL
63.0	46.0	10E	10P	27	3	690-063Q27-1046M	27.0	A	63.0	80.0	1.48	5000	3	690-100508M-E-SL	15	690-100510M-P-SL
	49.0	14E	14P	27	3	690-063Q27-1449H	27.0	A	63.0	80.0	1.30	5000	3	690-140608M-E-SL	9	690-140610M-P-SL
80.0	61.0	14E	14P	32	3	690-080Q32-1461M	32.0	A	80.0	98.0	2.42	5000	3	690-140608M-E-SL	12	690-140610M-P-SL
100.0	61.0	14E	14P	32	5	690-100Q32-1461H	32.0	A	100.0	90.0	3.56	5000	5	690-140608M-E-SL	20	690-140610M-P-SL

Spare parts			
DC	Insert screw	Plug screw	
50.00-63.00	10E 5513 020-68	3214 010-253	
63.00-100.00	14E 5513 020-55	3214 010-253	

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

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L4



M2



N22

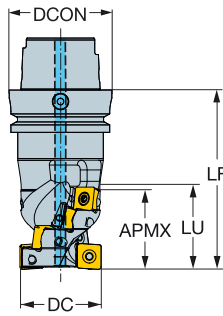


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CoroMill® 690 long edge square shoulder milling cutter

HSK - Internal coolant supply

KAPR 90°



								Dimensions, mm										
DC	APMX _{FW}	10E	10P	CZC _{MS}	CNSC	Ordering code		DCON	DCX	LF	LU	KG	RPMX	CICT _E	MID _E	CICT _P	MID _P	
40.0	46.0	10E	10P	63	1	2	690-040HA06-1046H	63.0	40.0	104.0	48.0	1.62	5000	2	690-100508M-E-SL	10	690-100510M-P-SL	
63.0	60.0	10E	10P	63	1	3	690-063HA06-1060M	63.0	63.0	120.0	94.0	2.30	5000	3	690-100508M-E-SL	21	690-100510M-P-SL	
	105.0	10E	10P	125	1	4	690-063HA12-10105H	125.0	63.0	180.0	110.0	7.51	5000	4	690-100508M-E-SL	52	690-100510M-P-SL	
80.0	84.0	14E	14P	125	1	4	690-080HA12-1484H	125.0	80.0	162.0	88.0	8.32	5000	4	690-140608M-E-SL	24	690-140610M-P-SL	
	105.0	10E	10P	100	1	4	690-080HA10-10105M	100.0	80.0	180.0	110.0	6.70	5000	4	690-100508M-E-SL	52	690-100510M-P-SL	
100.0	105.0	10E	10P	100	1	4	690-100HA10-10105M	100.0	100.0	180.0	151.0	8.85	5000	4	690-100508M-E-SL	52	690-100510M-P-SL	

Spare parts			
DC	Insert screw	Plug screw	
40.00	10E 5513 020-68	3214 010-202	
63.00-100.00	10E 5513 020-68	3214 010-253	
80.00	14E 5513 020-55	3214 010-253	

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



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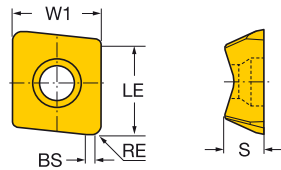
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CoroMill® 690 insert for milling

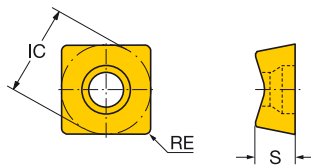
KRINS 90°



End insert

	RE	Ordering code	s			Dimensions, mm					
			T030	T040	S30T	S40T	W1	LE	S	BS	
Light	SL	10E 0.80	690-100508M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0
		1.20	690-100512M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0
		1.60	690-100516M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0
		2.00	690-100520M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0
		3.10	690-100531M-E-SL	☆	☆	★	☆	10.0	10.0	5.20	1.0
	SL	14E 0.80	690-140608M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
		1.20	690-140612M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
		1.60	690-140616M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
		2.00	690-140620M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
		2.40	690-140624M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
		3.10	690-140631M-E-SL	☆	☆	★	☆	14.5	14.7	6.35	1.0
		5.00	690-140650M-E-SL	☆	☆	★	☆	14.5	15.7	6.35	1.0
		6.00	690-140660M-E-SL	☆	☆	★	☆	14.5	16.5	6.35	1.0
		6.35	690-140664M-E-SL	☆	☆	★	☆	14.5	16.7	6.35	1.0

KRINS 90°



Peripheral insert

	RE	Ordering code	s			Dimensions, mm				
			T030	T040	S30T	S40T	IC	LE	S	
Light	SL	10P 1.00	690-100510M-P-SL	☆	☆	★	☆	10.0	9.0	5.20
		14P 1.00	690-140610M-P-SL	☆	☆	★	☆	14.5	13.5	6.35



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