

CoroCut® MB

For internal machining with high precision

B

Application

- For internal machining of small holes
- Pre-parting
- Grooving
- Face grooving
- Profiling
- Turning
- Copying
- Back boring
- Threading

C

ISO application area:



D

Benefits and features

- Vibration free machining
- Fast set up for both tool and insert
- Stable high precision interface between interface and tool holder
- Front-mounted exchangeable cutting tool
- Sharp cutting edges
- Geometries and grades for all materials
- Carbide shanks for long overhangs
- Through coolant
- Easy fix clamping
- Grooving tools in a large variety of widths and corner radii – also for standardized grooves such as O-rings and circlip grooves.

E



www.sandvik.coromant.com/corocutmb

EasyFix

Cylindrical steel and carbide boring bars to be used with EasyFix sleeves for exact centre height.

Adaptors









- Coromant Capto® to CoroTurn® XS adaptor
See page F21
- Rectangular shank to CoroTurn® XS adaptor
See page F30
- Cylindrical shank with flat to CoroTurn® XS adaptor
See page F37

F

CoroCut® MB boring bars

For stability and accessibility the bars are designed with an eccentric head with oval cross section.

Inserts

	Pre-parting	Grooving	Face grooving	Profiling	Turning	Copying	Back boring	Threading
								
	MB-..GX	MB-..G	MB-F	MB-..R	MB-..T045	MB-..TE93	MB-..B	MB-..TH
Insert width, mm	1.00	0.73-3.00	1.00-3.00					
Page	B107	B108	B111	Web	Web	Web	Web	C67

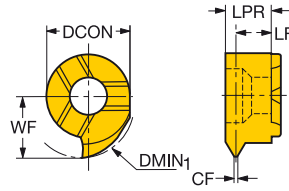
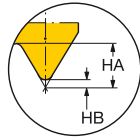
Right hand style shown unless otherwise stated

G

H

CoroCut® MB solid carbide head for thread turning

V-profile 60° Non-topping



Internal right-hand threads

CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	Ordering code	Dimensions, mm				WF	HA	HB				
							P	M	N	S							
07	0.50	0.75	34.0	51.0	10.0	MB-07TH050VM-10R	1025	1025	1025	1025	7	0.1	3.8	3.4	5.8	0.5	0.1
07	1.00	1.25	20.0	25.0	10.0	MB-07TH100VM-10R	1025	1025	1025	1025	7	0.1	3.8	3.2	5.8	0.8	0.1
07	1.50	1.75	15.0	17.0	10.0	MB-07TH150VM-10R	1025	1025	1025	1025	7	0.2	3.8	3.0	5.8	1.1	0.2
07	2.00	2.50	10.0	13.0	10.0	MB-07TH200VM-10R	1025	1025	1025	1025	7	0.3	3.8	2.8	5.8	1.6	0.2
07	2.50	3.00	8.0	10.0	10.0	MB-07TH250VM-10R	1025	1025	1025	1025	7	0.3	3.8	2.6	5.8	2.0	0.3

Internal left-hand threads

CZC _{MS}	TPN	TPX	TPIN	TPIX	DMIN ₁	Ordering code	Dimensions, mm				WF	HA	HB				
							P	M	N	S							
07	0.50	0.75	34.0	51.0	10.0	MB-07TH050VM-10L	1025	1025	1025	1025	7	0.1	3.8	3.4	5.8	0.5	0.1
07	1.00	1.25	20.0	25.0	10.0	MB-07TH100VM-10L	1025	1025	1025	1025	7	0.1	3.8	3.2	5.8	0.8	0.1
07	1.50	1.75	15.0	17.0	10.0	MB-07TH150VM-10L	1025	1025	1025	1025	7	0.2	3.8	3.0	5.8	1.1	0.2
07	2.00	2.50	10.0	13.0	10.0	MB-07TH200VM-10L	1025	1025	1025	1025	7	0.3	3.8	2.8	5.8	1.6	0.2
07	2.50	3.00	8.0	10.0	10.0	MB-07TH250VM-10L	1025	1025	1025	1025	7	0.3	3.8	2.6	5.8	2.0	0.3

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



F2



B118



C83



H36

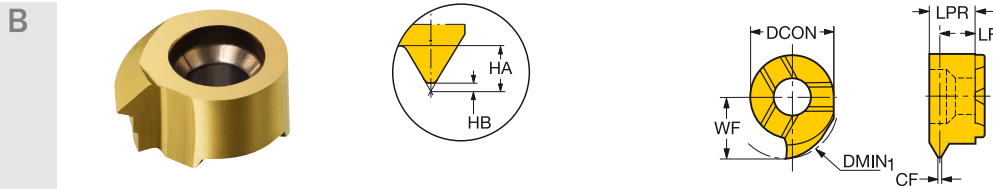


H25

CoroCut® MB solid carbide head for thread turning

Metric 60° Full form

TCTR 6
STDNO ISO 956-1998



C Internal right-hand threads

CZC _{MS}	DMIN ₁	Ordering code	P	M	N	S	Dimensions, mm			
			1025	1025	1025	1025	7015	DCON	LPR	LF
07	10.0	MB-07TH050MM-10R	*	*	*	*	7	3.8	3.4	5.8
07	10.0	MB-07TH100MM-10R	*	*	*	*	7	3.8	3.2	5.8
07	10.0	MB-07TH150MM-10R	*	*	*	*	7	3.8	3.0	5.8
07	10.0	MB-07TH175MM-10R	*	*	*	*	7	3.8	2.9	5.8
07	10.0	MB-07TH200MM-10R	*	*	*	*	7	3.8	2.8	5.8
07	10.0	MB-07TH250MM-10R	*	*	*	*	7	3.8	2.6	5.8

Internal left-hand threads

CZC _{MS}	TP	DMIN ₁	Ordering code	P	M	N	S	Dimensions, mm						
				1025	1025	1025	1025	DCON	CF	LPR	LF	WF	HA	HB
07	0.5	10.0	MB-07TH050MM-10L	*	*	*	*	7	0.1	3.8	3.4	5.8	0.5	0.1
07	1.0	10.0	MB-07TH100MM-10L	*	*	*	*	7	0.1	3.8	3.2	5.8	0.9	0.1
07	1.5	10.0	MB-07TH150MM-10L	*	*	*	*	7	0.2	3.8	3.0	5.8	1.4	0.2
07	1.8	10.0	MB-07TH175MM-10L	*	*	*	*	7	0.2	3.8	2.9	5.8	1.1	0.2
07	2.0	10.0	MB-07TH200MM-10L	*	*	*	*	7	0.3	3.8	2.8	5.8	1.3	0.2
07	2.5	10.0	MB-07TH250MM-10L	*	*	*	*	7	0.3	3.8	2.6	5.8	1.6	0.3

F CZC_{MS} to correspond with CZC_{WS} on adaptor. R = Right hand, L = Left hand

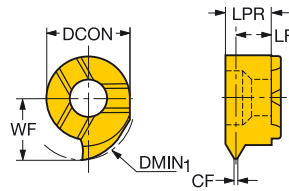
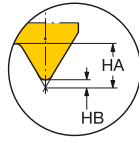
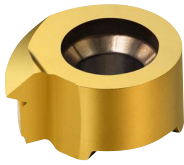
G



CoroCut® MB solid carbide head for thread turning

UN 60° Full form

TCTR 2B
STDNO ISO 5864-1978



Internal right-hand threads

	CZC _{MS}	TPI	DMIN ₁	Ordering code	P	M	N	S	Dimensions, mm						
					1025	1025	1025	1025	DCON	CF	LPR	LF	WF	HA	HB
	07	32.0	10.0	MB-07TH320UN-10R	*	*	*	*	7	0.1	3.8	3.4	5.8	0.9	0.1
	07	28.0	10.0	MB-07TH280UN-10R	*	*	*	*	7	0.1	3.8	3.4	5.8	0.9	0.1
	07	24.0	10.0	MB-07TH240UN-10R	*	*	*	*	7	0.1	3.8	3.3	5.8	1.0	0.1
	07	20.0	10.0	MB-07TH200UN-10R	*	*	*	*	7	0.2	3.8	3.2	5.8	1.1	0.1
	07	18.0	10.0	MB-07TH180UN-10R	*	*	*	*	7	0.2	3.8	3.2	5.8	1.3	0.2
	07	16.0	10.0	MB-07TH160UN-10R	*	*	*	*	7	0.2	3.8	3.1	5.8	1.4	0.2
	07	14.0	10.0	MB-07TH140UN-10R	*	*	*	*	7	0.2	3.8	3.2	5.8	1.6	0.2

Internal left-hand threads

	CZC _{MS}	TPI	DMIN ₁	Ordering code	P	M	N	S	Dimensions, mm						
					1025	1025	1025	1025	DCON	CF	LPR	LF	WF	HA	HB
	07	32.0	10.0	MB-07TH320UN-10L	*	*	*	*	7	0.1	3.8	3.4	5.8	0.9	0.1
	07	28.0	10.0	MB-07TH280UN-10L	*	*	*	*	7	0.1	3.8	3.4	5.8	0.9	0.1
	07	24.0	10.0	MB-07TH240UN-10L	*	*	*	*	7	0.1	3.8	3.3	5.8	1.0	0.1
	07	20.0	10.0	MB-07TH200UN-10L	*	*	*	*	7	0.2	3.7	3.2	5.8	1.1	0.1
	07	18.0	10.0	MB-07TH180UN-10L	*	*	*	*	7	0.2	3.8	3.2	5.8	1.3	0.2
	07	16.0	10.0	MB-07TH160UN-10L	*	*	*	*	7	0.2	3.8	3.1	5.8	1.4	0.2
	07	14.0	10.0	MB-07TH140UN-10L	*	*	*	*	7	0.2	3.8	3.2	5.8	1.6	0.2

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



F2



B118



C83



H36

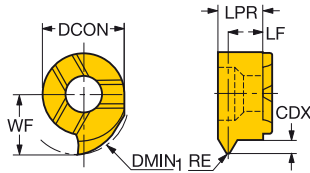
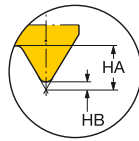


H25

CoroCut® MB solid carbide head for thread turning

Whitworth 55° (BSW, BSF, BSP) Full form

TCTR A
 STDNO ISO 228-1982
 STDNO BS 2779-1973
 STDNO BS 84-1956

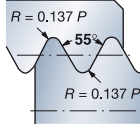


B

C

Internal right-hand threads

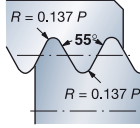
CZC _{MS}	TPI	DMIN ₁	RE	Ordering code	Dimensions, mm				DCON	LPR	LF	WF	HA	HB
					P	M	N	S						
07	19.0	10.0	0.180	MB-07TH190WH-10R	★	★	★	★	7	3.8	2.8	5.8	1.1	0.2
07	14.0	10.0	0.240	MB-07TH140WH-10R	★	★	★	★	7	3.8	2.6	5.8	1.4	0.3
07	11.0	10.0	0.310	MB-07TH110WH-10R	★	★	★	★	7	3.8	2.3	5.8	1.8	0.4



D

Internal left-hand threads

CZC _{MS}	TPI	DMIN ₁	RE	Ordering code	Dimensions, mm				DCON	LPR	LF	WF	HA	HB
					P	M	N	S						
07	19.0	10.0	0.180	MB-07TH190WH-10L	★	★	★	★	7	3.8	2.8	5.8	1.1	0.2
07	14.0	10.0	0.240	MB-07TH140WH-10L	★	★	★	★	7	3.8	2.6	5.8	1.4	0.3
07	11.0	10.0	0.310	MB-07TH110WH-10L	★	★	★	★	7	3.8	2.3	5.8	1.8	0.4



F

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand

G

H



F2



B118



C83



H36

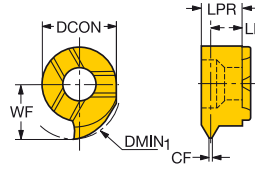
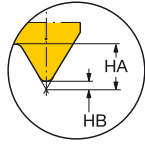


H25

CoroCut® MB solid carbide head for thread turning

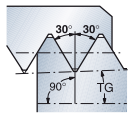
NPT 60° (NPSC, NPTR, LINE PIPE) Full form

STDNO ANSI B.1.20.1-1983



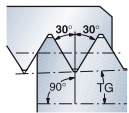
Internal right-hand threads

				P	M	N	S	Dimensions, mm						
CZC _{MS}	TPI	DMIN ₁	RE	Ordering code	1025	1025	1025	1025	DCON	LPR	LF	WF	HA	HB
07	18.0	10.0	0.050	MB-07TH180NT-10R	*	*	*	*	7	3.8	2.9	5.8	1.4	0.0
07	14.0	10.0	0.070	MB-07TH140NT-10R	*	*	*	*	7	3.8	2.7	5.8	1.5	0.1



Internal left-hand threads

				P	M	N	S	Dimensions, mm						
CZC _{MS}	TPI	DMIN ₁	RE	Ordering code	1025	1025	1025	1025	DCON	LPR	LF	WF	HA	HB
07	18.0	10.0	0.050	MB-07TH180NT-10L	*	*	*	*	7	3.8	2.9	5.8	1.4	0.0
07	14.0	10.0	0.070	MB-07TH140NT-10L	*	*	*	*	7	3.8	2.7	5.8	1.5	0.1



CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



F2



B118



C83



H36



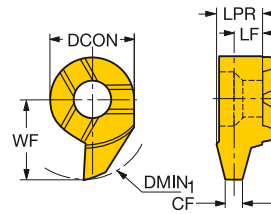
H25



CoroCut® MB solid carbide head for thread turning

ACME 29° partial profile

TCTR 2G
STDNO ANSI B1.5-1988

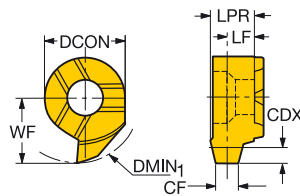


Internal right-hand threads

CZC _{MS}	TPI	DMIN ₁	Ordering code	P	M	N	S	Dimensions, mm						
				1025	1025	1025	1025	DCON	CF	LPR	LF	WF	HA	HB
07	8.0	11.0	MB-07TH080AC-11R	*	*	*	*	7	1.0	3.9	2.8	6.8	4.1	2.0
07	16.0	11.0	MB-07TH160AC-11R	*	*	*	*	7	0.5	3.9	3.3	6.8	2.1	1.0
07	14.0	11.0	MB-07TH140AC-11R	*	*	*	*	7	0.6	3.9	3.2	6.8	2.3	1.2
07	12.0	11.0	MB-07TH120AC-11R	*	*	*	*	7	0.7	3.9	3.1	6.8	2.7	1.4
07	10.0	11.0	MB-07TH100AC-11R	*	*	*	*	7	0.8	3.9	3.0	6.8	3.3	1.6

STUB-ACME 29° partial profile

TCTR 2G
STDNO ANSI B1.8-1988



Internal right-hand threads

CZC _{MS}	TPI	DMIN ₁	Ordering code	P	M	N	S	Dimensions, mm						
				1025	1025	1025	1025	DCON	CF	LPR	LF	WF	HA	HB
07	8.0	10.0	MB-07TH080SA-10R	*	*	*	*	7	1.2	3.7	2.5	5.8	3.7	2.3
07	16.0	10.0	MB-07TH160SA-10R	*	*	*	*	7	0.6	4.0	3.4	5.8	1.9	1.1
07	14.0	10.0	MB-07TH140SA-10R	*	*	*	*	7	0.7	4.0	3.3	5.8	2.2	1.3
07	12.0	10.0	MB-07TH120SA-10R	*	*	*	*	7	0.8	4.0	3.2	5.8	2.5	1.6
07	10.0	10.0	MB-07TH100SA-10R	*	*	*	*	7	0.9	3.9	3.1	5.8	3.0	1.8

G CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand

