

# CoroTurn® XS

Internal turning, face grooving and threading of small components

## Application

- Internal turning
- Copying
- Backboring
- Profiling
- Grooving
- Face grooving
- Pre-parting
- Threading

## ISO application area:



## Benefits and features

- Optimized for machining of small high quality features
- High precision and repeatability
- Reliable and easy-to-use clamping system
- Precision ground tools for high repeatability
- Longer tool life by minimized micro vibrations with cylindrical carbide shank adaptors
- Clamping nut ensures easy change of cutting tool with cylindrical carbide shank adaptors



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

## Internal coolant

- The adaptors are designed with internal precision coolant supply.
- Selectable coolant direction for better chip evacuation and safe machining



## Locking precision

Precise location into the boring bar due to a locating pin.



## Inserts

Turning	Back boring	Pre-parting	Grooving	Face grooving	Profiling	Threading
A254	A259	B100	B101	B104	B105	C60

## Adaptors

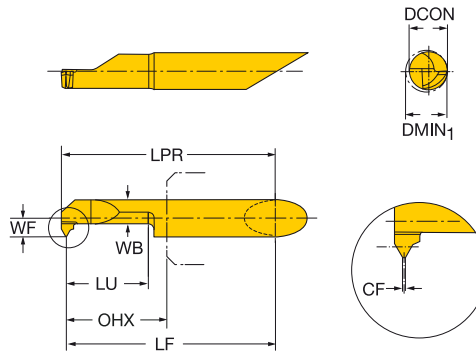
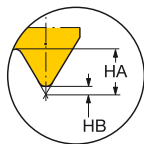
Coromant Capto®	Rectangular shank	Cylindrical shank with flat
F21	F30	F37

Right hand style shown unless otherwise stated

# CoroTurn® XS solid carbide tool for thread turning

V-profile 60° Non-topping

B



C

## Internal right-hand threads

CZC <sub>MS</sub>	TPN	TPX	TPIN	TPIX	DMIN <sub>1</sub>	LU	OHX	Ordering code	P	M	N	S	H	Dimensions, mm								
									1025	1025	1025	1025	7015	DCON	WB	CF	LPR	LF	WF	HA	HB	
	4	0.50	0.70	48.0	56.0	4.2	15.0	17.6	CXS-04TH050VM-4215R	*	*	*	*		4	3.0	0.1	32.7	32.3	2.0	0.5	0.1
	5	0.50	0.75	48.0	56.0	5.2	15.0	17.6	CXS-05TH050VM-5215R	*	*	*	*		5	3.8	0.1	37.7	37.3	2.5	0.5	0.1
	5	0.70	1.00	48.0	56.0	5.1	15.0	17.6	CXS-05TH070VM-5115R	*	*	*	*		5	3.7	0.1	37.8	37.3	2.4	0.7	0.1
	5	1.00	1.25	36.0	40.0	4.8	15.0	17.5	CXS-05TH100VM-4815R	*	*	*	*		5	3.6	0.1	37.9	37.3	2.3	0.8	0.1
	6	1.00	1.25	36.0	40.0	6.2	15.0	17.5	CXS-06TH100VM-6215R	*	*	*	*	*	6	3.6	0.1	37.9	37.3	3.0	0.8	0.1
	6	1.25	1.50	20.0	20.0	6.2	15.0	17.2	CXS-06TH125VM-6215R	*	*	*	*	*	6	3.6	0.2	38.1	37.3	3.0	1.0	0.1
6	1.50	1.75	16.0	18.0	6.2	15.0	17.2	CXS-06TH150VM-6215R	*	*	*	*	*	6	3.6	0.2	38.3	37.3	3.0	1.1	0.2	

D

## Internal left-hand threads

CZC <sub>MS</sub>	TPN	TPX	TPIN	TPIX	DMIN <sub>1</sub>	LU	OHX	Ordering code	P	M	N	S	H	Dimensions, mm								
									1025	1025	1025	1025	7015	DCON	WB	CF	LPR	LF	WF	HA	HB	
	4	0.50	0.70	48.0	56.0	4.2	15.0	17.6	CXS-04TH050VM-4215L	*	*	*	*		4	3.0	0.1	32.7	32.3	2.0	0.5	0.1
	5	1.00	1.25	36.0	40.0	4.8	15.0	17.5	CXS-05TH100VM-4815L	*	*	*	*		5	3.6	0.1	37.9	37.3	2.3	0.8	0.1
	6	1.00	1.25	36.0	40.0	6.2	15.0	17.5	CXS-06TH100VM-6215L	*	*	*	*	*	6	3.6	0.1	37.9	37.3	3.0	0.8	0.1
	6	1.25	1.50	20.0	20.0	6.2	15.0	17.2	CXS-06TH125VM-6215L	*	*	*	*	*	6	3.6	0.2	38.1	37.3	3.0	1.0	0.1
	6	1.50	1.75	16.0	18.0	6.2	15.0	17.2	CXS-06TH150VM-6215L	*	*	*	*	*	6	3.6	0.2	38.3	37.3	3.0	1.1	0.2

E

CZC<sub>MS</sub> to correspond with CZC<sub>WS</sub> on adaptor.

R = Right hand, L = Left hand

F

G

H



F2



B119



C83



H36

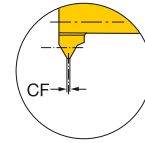
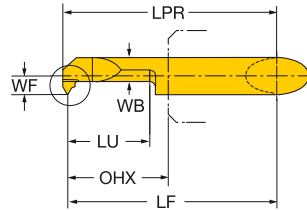
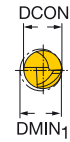
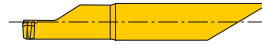
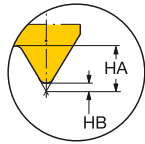


H22

# CoroTurn® XS solid carbide tool for thread turning

Metric 60° Full form

TCTR 6  
STDNO ISO 956-1998



## Internal right-hand threads

CZC <sub>MS</sub>	TP	DMIN <sub>1</sub>	LU	OHX	Ordering code	P	M	N	S	Dimensions, mm								
						1025	1025	1025	1025	DCON	WB	CF	LPR	LF	WF	HA	HB	
						*	*	*	*	*	*	*	*	*	*	*	*	*
	4	0.5	4.2	15.0	17.6	CXS-04TH050MM-4215R	*	*	*	*	4	3.5	0.1	32.7	32.3	2.0	0.5	0.1
	4	0.7	4.2	15.0	17.5	CXS-04TH070MM-4215R	*	*	*	*	4	3.3	0.1	32.8	32.3	1.9	0.8	0.1
	4	0.8	4.0	15.0	17.5	CXS-04TH080MM-4015R	*	*	*	*	4	3.0	0.1	32.8	32.3	1.9	0.8	0.1
	5	0.5	5.2	15.0	17.6	CXS-05TH050MM-5215R	*	*	*	*	5	4.5	0.1	37.7	37.3	2.5	0.5	0.1
	5	0.8	5.1	15.0	17.5	CXS-05TH075MM-5115R	*	*	*	*	5	4.2	0.1	37.8	37.3	2.4	0.8	0.1
	5	1.0	4.8	15.0	17.4	CXS-05TH100MM-4815R	*	*	*	*	5	3.6	0.1	37.9	37.3	2.3	1.0	0.1
	6	1.0	6.2	15.0	17.4	CXS-06TH100MM-6215R	*	*	*	*	6	5.1	0.1	37.9	37.3	3.0	1.0	0.1
	6	1.3	6.2	15.0	17.3	CXS-06TH125MM-6215R	*	*	*	*	6	4.8	0.2	38.0	37.3	3.0	1.3	0.1
	6	1.5	6.2	15.0	17.2	CXS-06TH150MM-6215R	*	*	*	*	6	4.5	0.2	38.1	37.3	3.0	1.6	0.2
	6	1.8	6.2	15.0	17.1	CXS-06TH175MM-6215R	*	*	*	*	6	4.3	0.2	38.2	37.3	3.0	1.8	0.2
	6	2.0	6.2	15.0	17.0	CXS-06TH200MM-6215R	*	*	*	*	6	4.1	0.3	38.3	37.3	3.0	2.1	0.2

CZC<sub>MS</sub> to correspond with CZC<sub>WS</sub> on adaptor.

R = Right hand



F2



B119



C83



H36

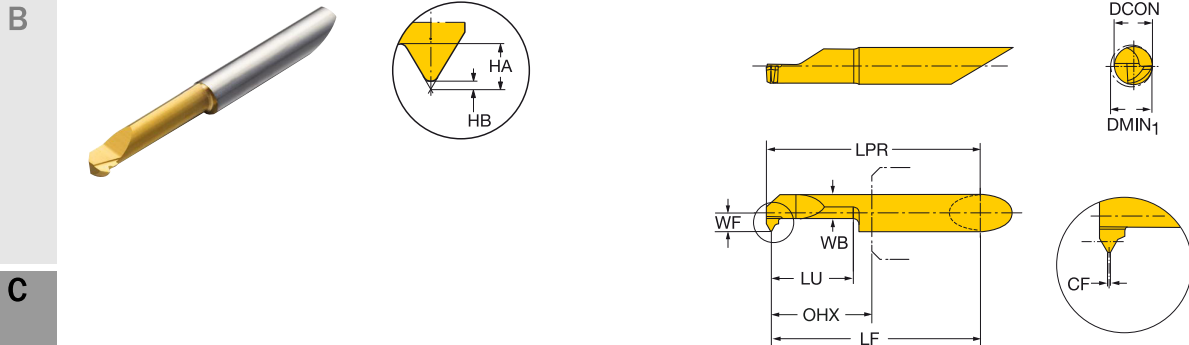


H22

# CoroTurn® XS solid carbide tool for thread turning

UN 60° Full form

TCTR 2B  
STDNO ISO 5864-1978

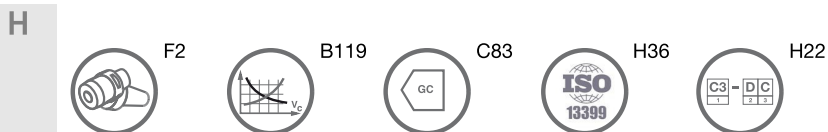


C Internal right-hand threads

CZC <sub>MS</sub>	TPI	DMIN <sub>1</sub>	LU	OHX	Ordering code	P	M	N	S	Dimensions, mm							
						1025	1025	1025	1025	DCON	WB	CF	LPR	LF	WF	HA	HB
4	32.0	4.0	15.0	17.5	CXS-04TH320UN-4015R	*	*	*	*	4	3.0	0.1	32.9	32.3	1.9	0.9	0.1
4	28.0	4.0	15.0	17.4	CXS-04TH280UN-4015R	*	*	*	*	4	3.0	0.1	32.9	32.3	1.9	0.9	0.1
4	24.0	4.2	15.0	17.4	CXS-04TH240UN-4215R	*	*	*	*	4	3.1	0.1	33.0	32.3	2.0	1.0	0.1
5	20.0	5.2	15.0	17.3	CXS-05TH200UN-5215R	*	*	*	*	5	4.0	0.2	38.0	37.3	2.5	1.1	0.1
6	18.0	6.2	15.0	17.3	CXS-06TH180UN-6215R	*	*	*	*	6	4.9	0.2	38.1	37.3	3.0	1.3	0.2
6	16.0	6.2	15.0	15.2	CXS-06TH160UN-6215R	*	*	*	*	6	4.8	0.2	38.2	37.3	3.0	1.4	0.2

CZC<sub>MS</sub> to correspond with CZC<sub>WS</sub> on adaptor.

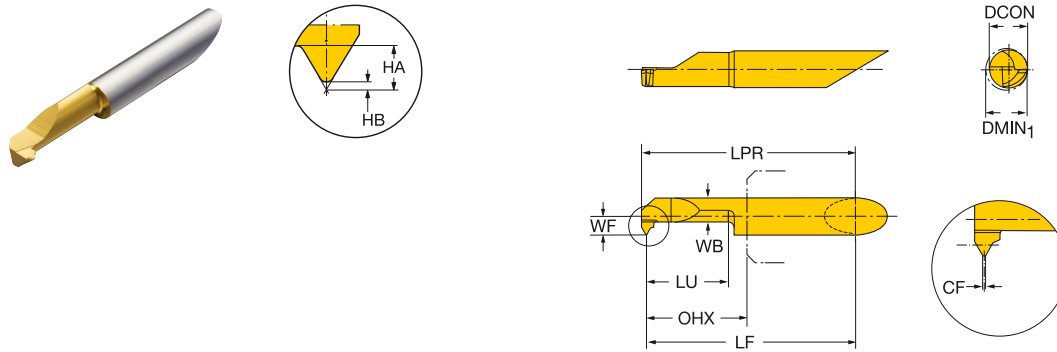
R = Right hand



# CoroTurn® XS solid carbide tool for thread turning

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

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



## Internal right-hand threads

CZC <sub>MS</sub>	TPI	DMIN <sub>1</sub>	LU	RE	OHX	Ordering code	P	M	N	S	Dimensions, mm							
							1025	1025	1025	1025	DCON	WB	LPR	LF	WF	HA	HB	
							*	*	*	*								
	5	28.0	5.2	15.0	0.120	17.2	CXS-05TH28WH-5215R	*	*	*	*	5	3.8	38.1	37.3	2.5	0.7	0.1
	5	26.0	5.2	15.0	0.150	17.2	CXS-05TH26WH-5215R	*	*	*	*	5	3.8	38.1	37.3	2.5	0.8	0.2
	5	24.0	5.2	15.0	0.150	17.2	CXS-05TH24WH-5215R	*	*	*	*	5	3.8	38.1	37.3	2.5	0.9	0.2
	6	28.0	6.2	15.0	0.120	17.2	CXS-06TH28WH-6215R	*	*	*	*	6	4.0	38.1	37.3	3.0	0.7	0.1
	6	22.0	6.2	15.0	0.160	17.0	CXS-06TH22WH-6215R	*	*	*	*	6	4.0	38.3	37.3	3.0	0.9	0.2
	6	20.0	6.2	15.0	0.170	17.0	CXS-06TH20WH-6215R	*	*	*	*	6	4.0	38.3	37.3	3.0	1.0	0.2
	6	19.0	6.2	15.0	0.180	17.0	CXS-06TH19WH-6215R	*	*	*	*	6	4.0	38.3	37.3	3.0	1.1	0.2

## Internal left-hand threads

CZC <sub>MS</sub>	TPI	DMIN <sub>1</sub>	LU	RE	OHX	Ordering code	P	M	N	S	Dimensions, mm							
							1025	1025	1025	1025	DCON	WB	LPR	LF	WF	HA	HB	
							*	*	*	*								
	6	19.0	6.2	15.0	0.180	17.0	CXS-06TH19WH-6215L	*	*	*	*	6	4.0	38.3	37.3	3.0	1.1	0.2

CZC<sub>MS</sub> to correspond with CZC<sub>WS</sub> on adaptor.

R = Right hand, L = Left hand



F2



B119



C83



H36

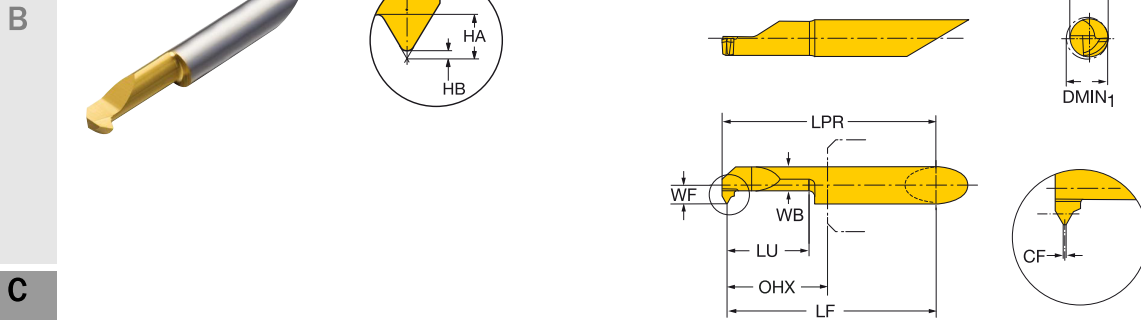


H22

# CoroTurn® XS solid carbide tool for thread turning

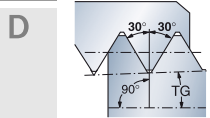
NPT 60° (NPSC, NPTR, LINE PIPE) Full form

STDNO ANSI B.1.20.1-1983



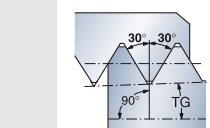
## C Internal right-hand threads

CZC <sub>MS</sub>	TPI	DMIN <sub>1</sub>	LU	RE	OHX	Ordering code	P	M	N	S	Dimensions, mm						
							1025	1025	1025	1025	DCON	WB	LPR	LF	WF	HA	HB
6	27.0	6.2	15.0	0.070	17.2	CXS-06TH27NT-6215R	*	*	*	*	6	4.0	38.1	37.3	3.0	1.6	0.0
6	18.0	6.2	15.0	0.100	17.2	CXS-06TH18NT-6215R	*	*	*	*	6	4.0	38.3	37.3	3.0	1.6	0.0



## D Internal left-hand threads

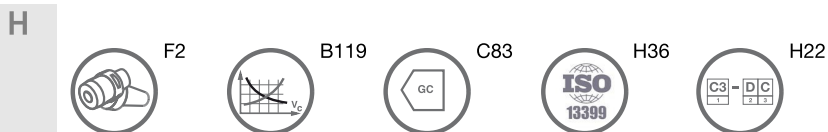
CZC <sub>MS</sub>	TPI	DMIN <sub>1</sub>	LU	RE	OHX	Ordering code	P	M	N	S	Dimensions, mm						
							1025	1025	1025	1025	DCON	WB	LPR	LF	WF	HA	HB
6	18.0	6.2	15.0	0.100	17.0	CXS-06TH18NT-6215L	*	*	*	*	6	4.0	38.3	37.3	3.0	1.6	0.0



F CZC<sub>MS</sub> to correspond with CZC<sub>WS</sub> on adaptor.

R = Right hand, L = Left hand

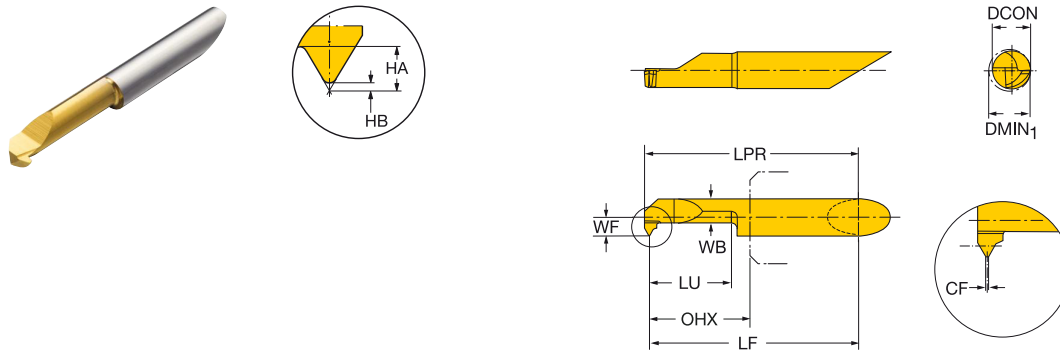
G



# CoroTurn® XS solid carbide tool for thread turning

ISO Trapezoidal 30° Chamfered crest form

TCTR 7  
 STDNO ISO 2901-2904  
 STDNO DIN 103-1977



## Internal right-hand threads

CZC <sub>MS</sub>	TP	DMIN <sub>1</sub>	LU	OHX	Ordering code	Dimensions, mm				DCON	WB	CF	LPR	LF	WF	HA	HB
						P	M	N	S								
						1025	1025	1025	1025								
6	1.5	6.2	20.0	17.4	CXS-06TH150TR-6220R	*	*	*	*	6	4.9	0.5	38.2	37.6	3.0	1.8	0.9
6	2.0	6.2	20.0	17.3	CXS-06TH200TR-6220R	*	*	*	*	6	4.6	0.6	38.4	37.6	3.0	2.4	1.2
7	3.0	7.2	30.0	16.9	CXS-07TH300TR-7230R	*	*	*	*	7	4.6	1.0	53.4	52.3	3.5	3.5	1.8

CZC<sub>MS</sub> to correspond with CZC<sub>WS</sub> on adaptor.

R = Right hand

