

# CoroCut® XS

For external machining of small and slender components

## Application

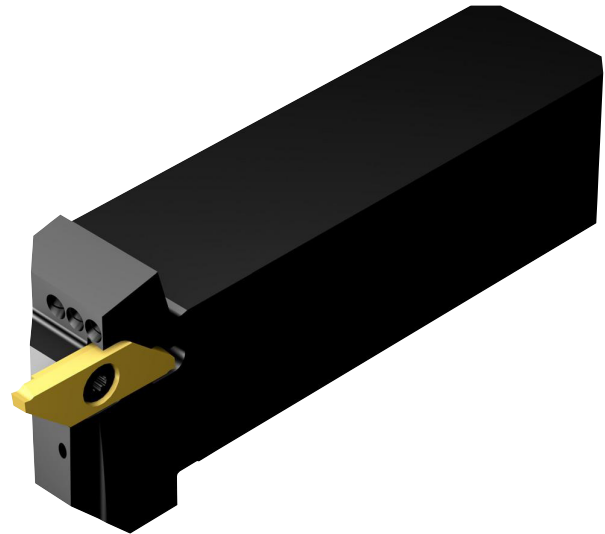
- Parting off
- External threading
- External grooving
- Turning

## ISO application area:



## Benefits and features

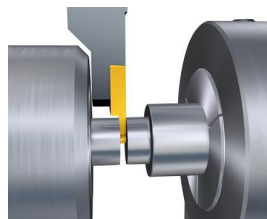
- High precision
- Close tolerances
- Good accessibility when changing inserts
- Wide variety of insert widths
- Sharp cutting edges
- All inserts fit into the same tool holder
- High quality ground inserts and holders
- Full profile inserts for high quality threads in one operation
- Designed to maintain the tool holder intact in case of insert breakage.
- Available with precision coolant



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

## HOLDERS

Dedicated holders for parting off close to sub spindle are available in high precision square shank style.



## Inserts

Turning	Back turning	Parting off	Grooving	Profiling	Threading
A261	A261	B81	B101	B105	C56

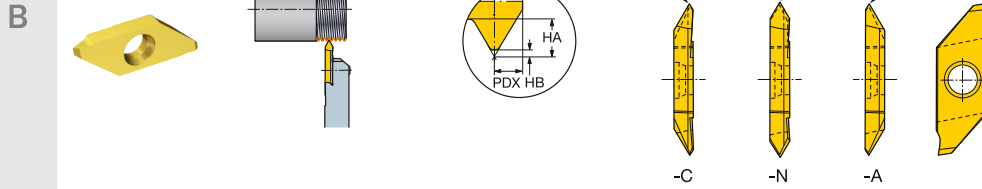
## Tools

QS™ shank tools	CoroTurn® SL cutting heads
B83	B84

Right hand style shown unless otherwise stated

# CoroCut® XS insert for thread turning

V-profile 60° Non-topping



C External right-hand threads

							P	M	K	N	S	O	Dimensions, mm											
SSC	TPN	TPX	TPIN	TPIX	NT	Ordering code	1025	1105	1025	1105	1025	1105	1025	1105	1025	1105	1025	1105	1025	1105	RE	HA	HB	PDX
3	0.4	1.0	24.0	72.0	1	MATR 3 60-A	★	☆	★	★	★	★	★	★	★	★	★	★	★	★	0.05	0.75	0.05	0.60
	0.4	1.0	24.0	72.0	1	MATR 3 60-C	★	☆	★	★	★	★	★	★	★	★	★	★	★	★	0.05	0.75	0.05	0.60
	0.4	2.0	12.0	72.0	1	MATR 3 60-N	★	☆	★	★	★	★	★	★	★	★	★	★	★	★	0.05	1.50	0.05	1.59

D External left-hand threads

							P	M	K	N	S	O	Dimensions, mm											
SSC	TPN	TPX	TPIN	TPIX	NT	Ordering code	1025	1105	1025	1105	1025	1105	1025	1105	1025	1105	1025	1105	1025	1105	RE	HA	HB	PDX
3	0.4	1.0	24.0	72.0	1	MATL 3 60-A	★	☆	★	★	★	★	★	★	★	★	★	★	★	★	0.05	0.75	0.05	0.60
	0.4	1.0	24.0	72.0	1	MATL 3 60-C	★	☆	★	★	★	★	★	★	★	★	★	★	★	★	0.05	0.75	0.05	0.60
	0.4	2.0	12.0	72.0	1	MATL 3 60-N	★	☆	★	★	★	★	★	★	★	★	★	★	★	★	0.05	1.50	0.05	1.59

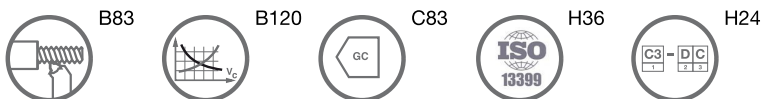
E SSC = To correspond with SSC on tool.

R = Right hand, L = Left hand

F

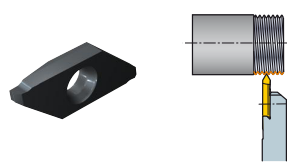
G

H

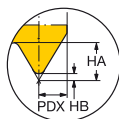


# CoroCut® XS insert for thread turning

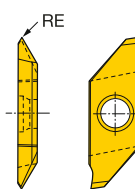
Metric 60° fullform



STDNO  
TCTR



ISO 965-1998  
6



## External right-hand threads

SSC	TP	NT	Ordering code	P	M	K	N	S	O	Dimensions, mm			
				1105	1105	1105	1105	1105	RE	HA	HB	PDX	
3	0.20	1	MATR 3-MM01F-020-A	*	*	*	*	*	*	0.03	0.14	0.02	0.23
	0.25	1	MATR 3-MM01F-025-A	*	*	*	*	*	*	0.04	0.18	0.03	0.28
	0.30	1	MATR 3-MM01F-030-A	*	*	*	*	*	*	0.04	0.22	0.03	0.28
	0.35	1	MATR 3-MM01F-035-A	*	*	*	*	*	*	0.05	0.25	0.04	0.32
	0.40	1	MATR 3-MM01F-040-A	*	*	*	*	*	*	0.06	0.29	0.04	0.38
	0.45	1	MATR 3-MM01F-045-A	*	*	*	*	*	*	0.06	0.32	0.05	0.38
	0.50	1	MATR 3-MM01F-050-A	*	*	*	*	*	*	0.07	0.36	0.05	0.48
	0.70	1	MATR 3-MM01F-070-A	*	*	*	*	*	*	0.10	0.51	0.08	0.38
	0.75	1	MATR 3-MM01F-075-A	*	*	*	*	*	*	0.11	0.54	0.08	0.38
	0.80	1	MATR 3-MM01F-080-A	*	*	*	*	*	*	0.11	0.58	0.09	0.38
	1.00	1	MATR 3-MM01F-100-A	*	*	*	*	*	*	0.12	0.72	0.11	0.38
	1.25	1	MATR 3-MM01F-125-A	*	*	*	*	*	*	0.15	0.90	0.14	0.38
	1.50	1	MATR 3-MM01F-150-A	*	*	*	*	*	*	0.22	1.08	0.16	0.38

## External left-hand threads

SSC	TP	NT	Ordering code	P	M	K	N	S	O	Dimensions, mm			
				1105	1105	1105	1105	1105	RE	HA	HB	PDX	
3	0.40	1	MATL 3-MM01F-040-A	*	*	*	*	*	*	0.06	0.29	0.04	0.38
	0.50	1	MATL 3-MM01F-050-A	*	*	*	*	*	*	0.07	0.36	0.05	0.38
	0.70	1	MATL 3-MM01F-070-A	*	*	*	*	*	*	0.10	0.51	0.08	0.38
	0.75	1	MATL 3-MM01F-075-A	*	*	*	*	*	*	0.11	0.54	0.08	0.38
	0.80	1	MATL 3-MM01F-080-A	*	*	*	*	*	*	0.11	0.58	0.09	0.38
	1.00	1	MATL 3-MM01F-100-A	*	*	*	*	*	*	0.12	0.72	0.11	0.38
	1.25	1	MATL 3-MM01F-125-A	*	*	*	*	*	*	0.15	0.90	0.14	0.38
	1.50	1	MATL 3-MM01F-150-A	*	*	*	*	*	*	0.22	1.08	0.16	0.38

SSC = To correspond with SSC on tool.

R = Right hand, L = Left hand



B83



B120



C83



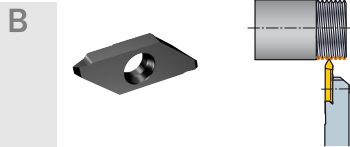
H36



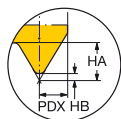
H24

# CoroCut® XS insert for thread turning

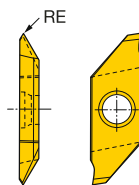
UN 60° Full form



STDNO  
TCTR



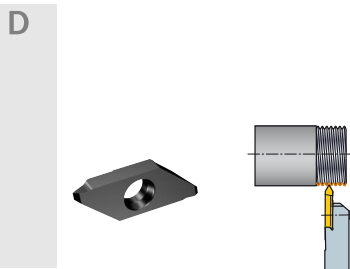
ISO 5864-1978  
2A



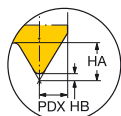
External right-hand threads

SSC	TPI	NT	Ordering code	P M K N S O					Dimensions, mm				
				1105	1105	1105	1105	1105	RE	HA	HB	PDX	
3	80.0	1	MATR 3-UN01F-800-A	*	*	*	*	*	*	0.04	0.22	0.04	0.38
	72.0	1	MATR 3-UN01F-720-A	*	*	*	*	*	*	0.05	0.27	0.05	0.38
	64.0	1	MATR 3-UN01F-640-A	*	*	*	*	*	*	0.06	0.31	0.06	0.38
	56.0	1	MATR 3-UN01F-560-A	*	*	*	*	*	*	0.06	0.35	0.06	0.38
	48.0	1	MATR 3-UN01F-480-A	*	*	*	*	*	*	0.07	0.38	0.07	0.38
	40.0	1	MATR 3-UN01F-400-A	*	*	*	*	*	*	0.09	0.51	0.09	0.38
	32.0	1	MATR 3-UN01F-320-A	*	*	*	*	*	*	0.10	0.59	0.10	0.38

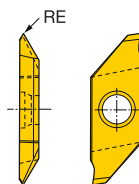
Whitworth 55° (BSW, BSF, BSP) Full form



STDNO  
STDNO  
STDNO  
TCTR



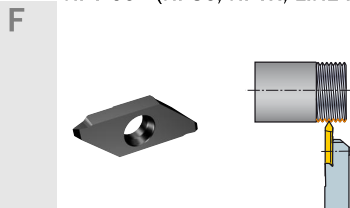
ISO 228-1982  
BS-2779-1973  
BS 84-1955  
A



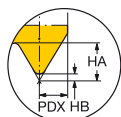
External right-hand threads

SSC	TPI	NT	Ordering code	P M K N S O					Dimensions, mm				
				1105	1105	1105	1105	1105	RE	HA	HB	PDX	
3	28.0	1	MATR 3-WH01F-280-A	*	*	*	*	*	*	0.13	0.72	0.13	0.38
	19.0	1	MATR 3-WH01F-190-A	*	*	*	*	*	*	0.19	1.06	0.19	0.38

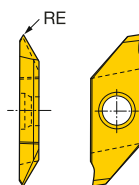
NPT 60° (NPSC, NPTR, LINE PIPE) Full form



STDNO



ANSI B.1.20.1-1983



External right-hand threads

SSC	TPI	NT	Ordering code	P M K N S O					Dimensions, mm				
				1105	1105	1105	1105	1105	RE	HA	HB	PDX	
3	27.0	1	MATR 3-NT01F-270-A	*	*	*	*	*	*	0.05	0.76	0.05	0.38
	18.0	1	MATR 3-NT01F-180-A	*	*	*	*	*	*	0.08	1.14	0.08	0.38
	14.0	1	MATR 3-NT01F-140-A	*	*	*	*	*	*	0.09	1.46	0.09	0.38

SSC = To correspond with SSC on tool.

R = Right hand

