Code key

for ISO inserts

Insert

Tolerances

Insert thickness

C	N	M	G	09	03	08	-	PF
1	2	3	4	5	6	7		8

1. INSERT SHAPE

2. INSERT CLEARANCE ANGLE

5. INSERT SIZE = CUTTING EDGE LENGTH

Toolholders

External

P	C	L	N	R	16	16	H	09
B	1	C	2	D	E	F	G	5

C3-
A

Internal

S	25	T	S	C	L	C	R	09
H	J	G	B	1	C	2	D	5

Bar diameter

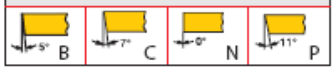
S = Solid steel bar
A = Steek bar with coolant supply

Coromant Capto®
Coupling size

Holder style

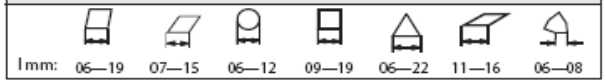
1. INSERT SHAPE

2. INSERT CLEARANCE ANGLE



4. INSERT TYPE

5. INSERT SIZE = CUTTING EDGE LENGTH



	06—19	07—15	06—12	09—19	06—22	11—16	06—08
l mm:							

7. NOSE RADIUS

04	$r_\varepsilon = 0{,}4$
08	$r_\varepsilon = 0{,}8$
12	$r_\varepsilon = 1{,}2$
16	$r_\varepsilon = 1{,}6$
24	$r_\varepsilon = 2{,}4$

First choice nose radius recommendations:

	T-MAX P	CoroTurn 107
FINISHING	08	04
MEDIUM	08	08
ROUGHING	12	08

8. GEOMETRY — MANUFACTURER'S OPTION

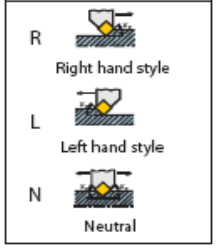
The manufacturer may add further two symbols to the code describing the insert geometry e. g.

-PF = ISO P Finishing

-MR = ISO M Roughing

B. CLAMPING SYSTEM

D. HAND OF TOOL

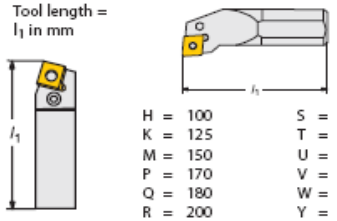


E. SHANK HEIGHT

F. SHANK WIDTH

G. TOOL LENGTH

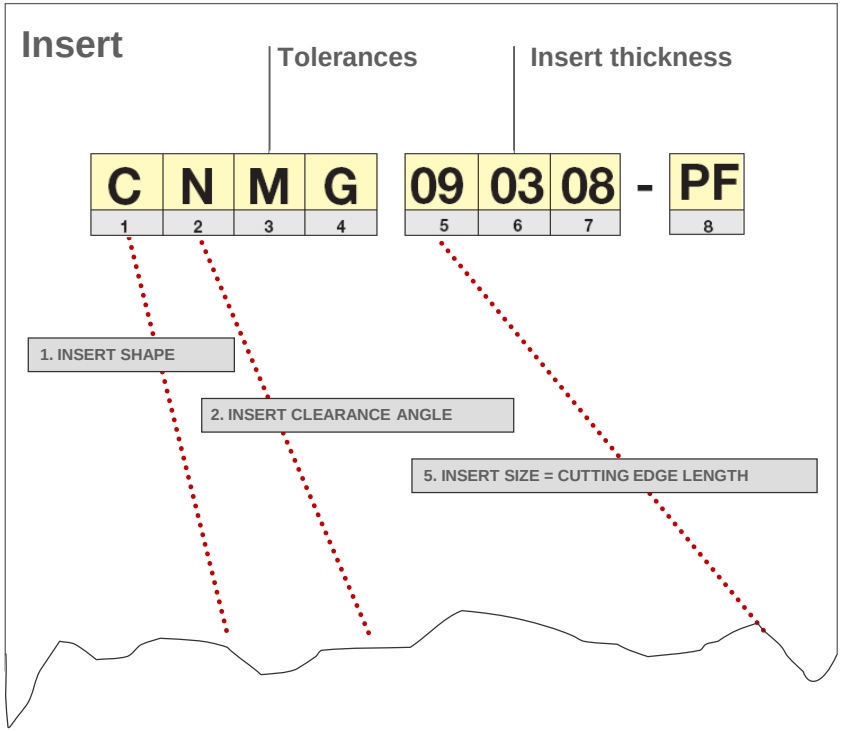
Tool length = l_1 in mm



H	= 100	S	= 250
K	= 125	T	= 300
M	= 150	U	= 350
P	= 170	V	= 400
Q	= 180	W	= 450
R	= 200	Y	= 500

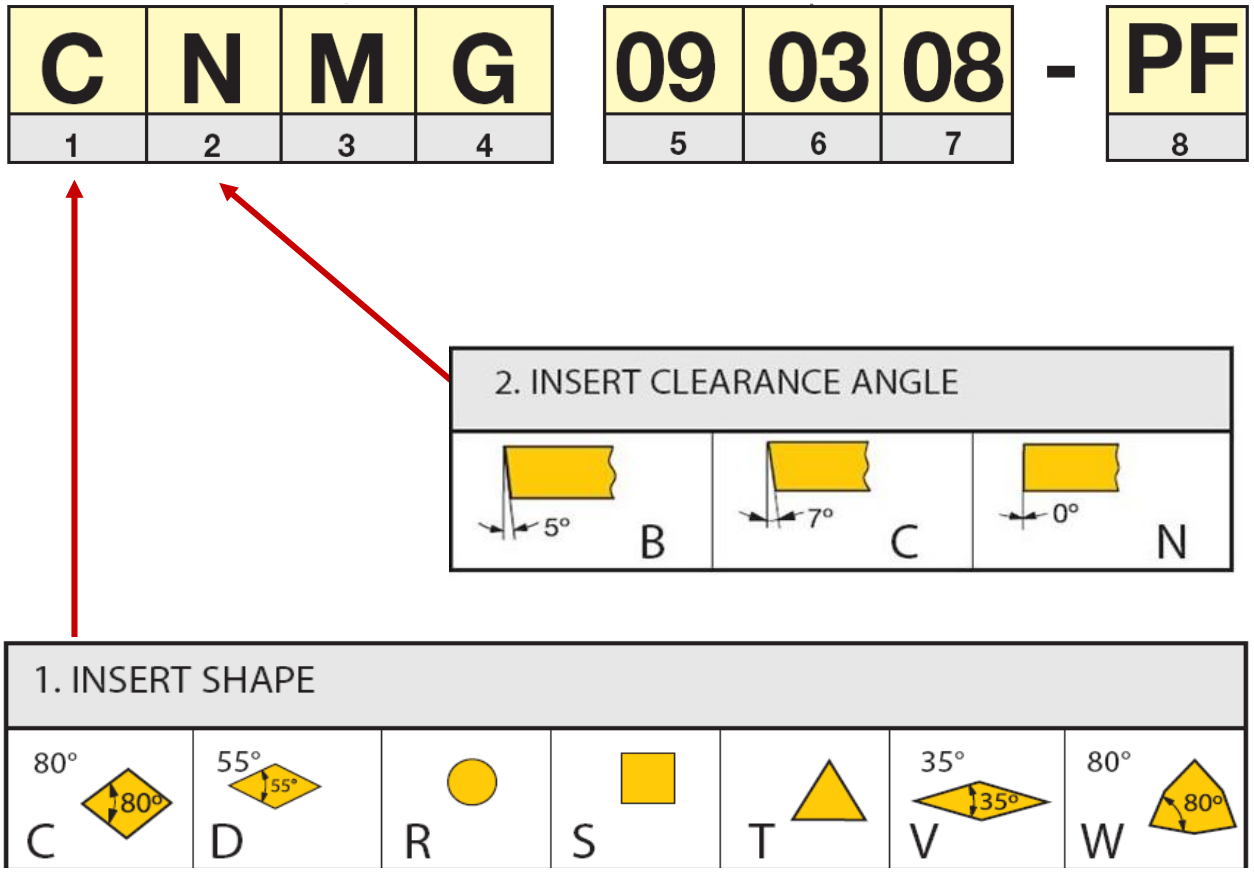
Code key

For inserts



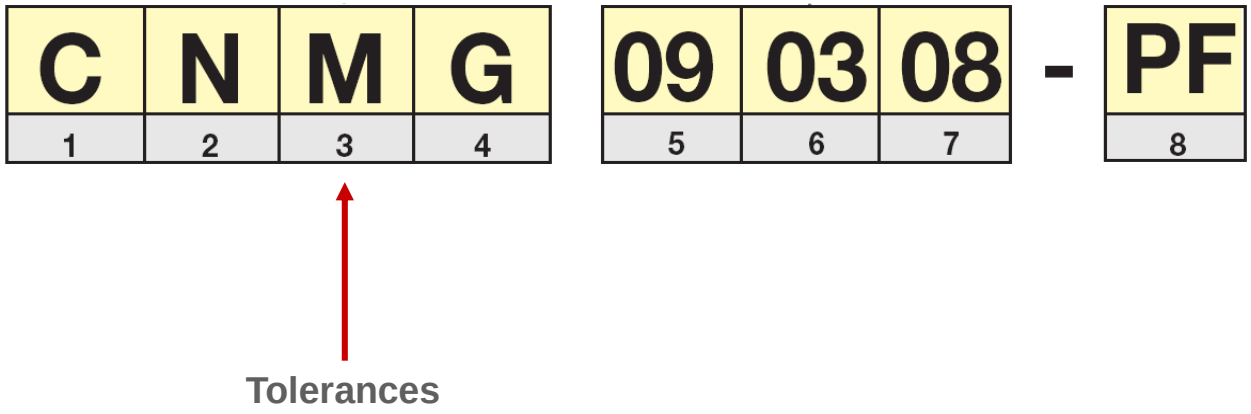
1. Insert shape
2. Insert clearance angle

Insert



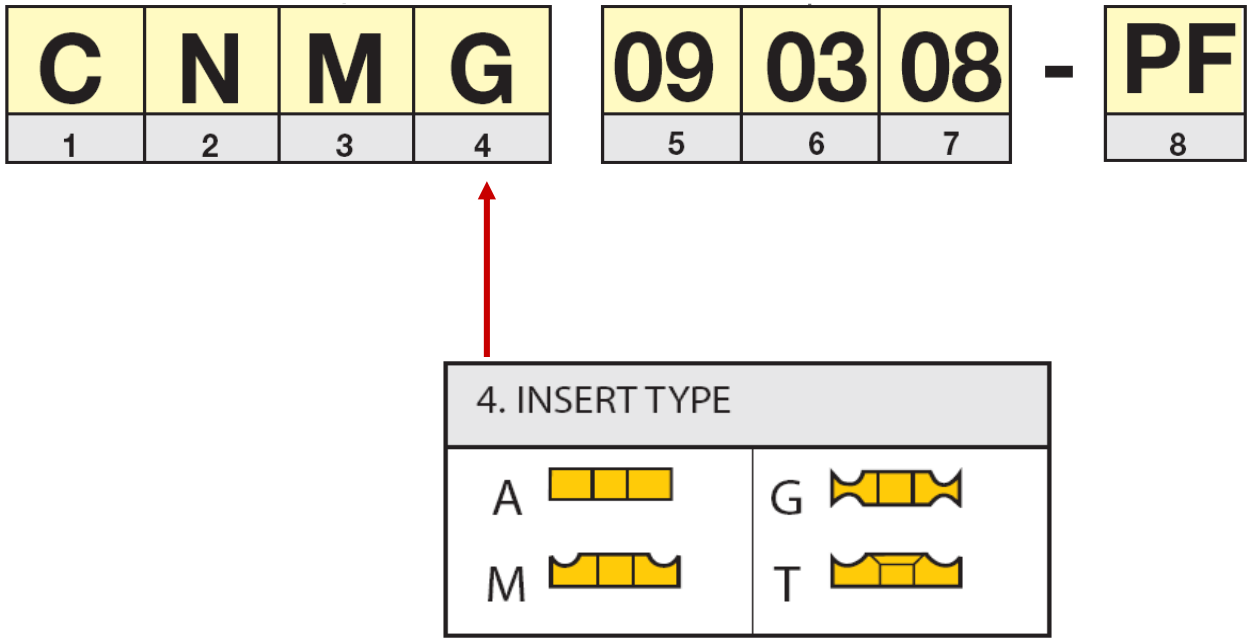
3. Tolerances

Insert



4. Insert type

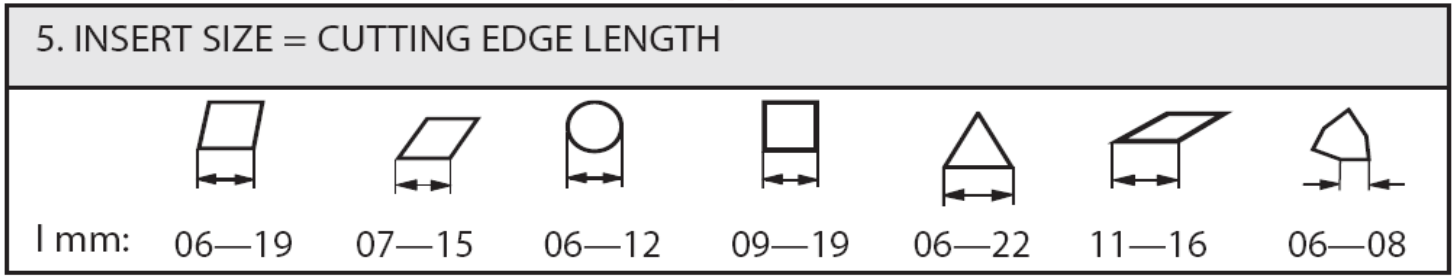
Insert



5. Insert size = cutting edge length

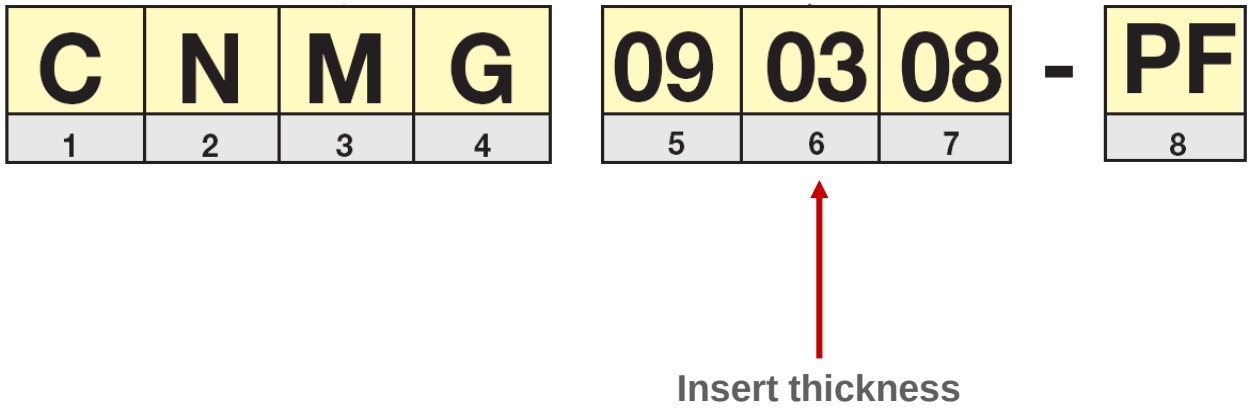
Insert

C	N	M	G	09	03	08	-	PF
1	2	3	4	5	6	7		8



6. Insert thickness

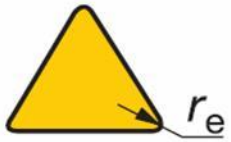
Insert



7. Nose radius

Insert

C	N	M	G	09	03	08	-	PF
1	2	3	4	5	6	7		8



7. NOSE RADIUS					
			First choice nose radius recommendations:		
				T-MAX P	CoroTurn 107
04	$r_\varepsilon = 0,4$		FINISHING	08	04
08	$r_\varepsilon = 0,8$		MEDIUM	08	08
12	$r_\varepsilon = 1,2$		ROUGHING	12	08
16	$r_\varepsilon = 1,6$				
24	$r_\varepsilon = 2,4$				

8. Geometry - manufacturer’s option

Insert

C	N	M	G	09	03	08	-	PF
1	2	3	4	5	6	7		8

8. GEOMETRY — MANUFACTURER'S OPTION
The manufacturer may add further two symbols to the code describing the insert geometry e. g. -PF = ISO P Finishing -MR = ISO M Roughing

Insert designation with geometry

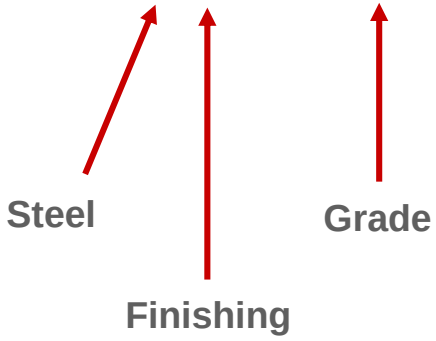
C	N	M	G	09	03	08	-	PF
1	2	3	4	5	6	7		8

CNMG 090308 - PF

Geometry

Insert designation with geometry and grade

CNMG 090308 - PF 4225

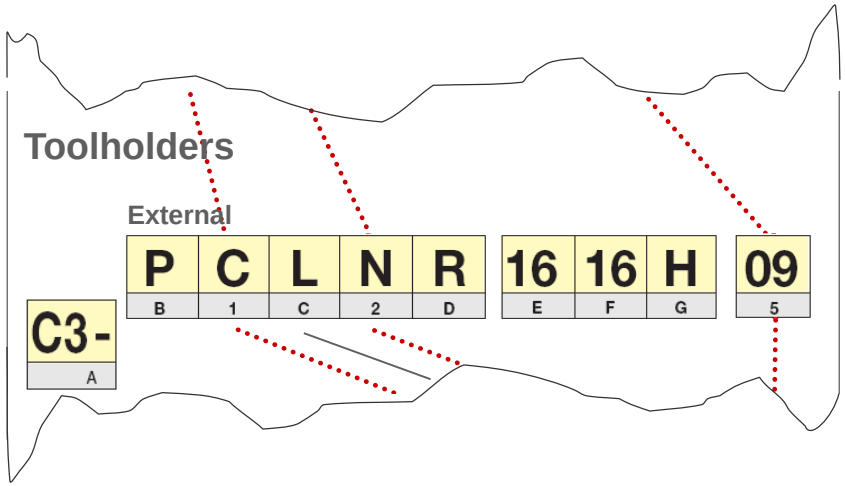


Code key

For ISO holders

Code key

For toolholders



B. Clamping system

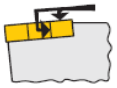
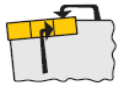
Toolholders

External

P	C	L	N	R	16	16	H	09
B	1	C	2	D	E	F	G	5

C3-
A

Coromant Capto® coupling size

B. CLAMPING SYSTEM	
 D Rigid clamping (RC)	 M Top and hole clamping
 P Hole clamping	 S Screw clamping

1. Insert shape

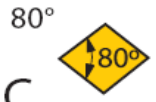
Toolholders

External

P	C	L	N	R	16	16	H	09
B	1	C	2	D	E	F	G	5

C3-
A

Coromant Capto® coupling size

1. INSERT SHAPE						
						
C	D	R	S	T	V	W

C. Holder style

Toolholders

External

P	C	L	N	R	16	16	H	09
B	1	C	2	D	E	F	G	5

C3 -
A

Coromant Capto® coupling size

Holder style

4 Holder style

A 90°	B 75°	D 45°	E 60°	F 90°	G 90°	H 107
J 93°	K 75°	L 95°	M 50°	N 63° 30'	Q 117° 30'	R 75°
S 45°	T 60°	U 93°	V 72° 30'	Y(X) 85°	Y(Z) 85°	

2. Insert clearance angle, D. Hand of tool

Toolholders

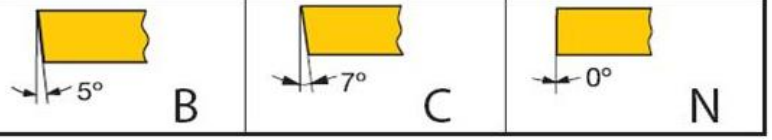
External

P	C	L	N	R	16	16	H	09
B	1	C	2	D	E	F	G	5

C3-
A

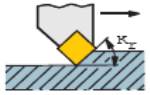
Coromant Capto® coupling size

2. INSERT CLEARANCE ANGLE



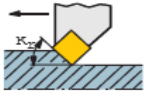
D. HAND OF TOOL

R



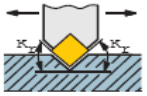
Right hand style

L



Left hand style

N



Neutral

E. Shank height, F. Shank width

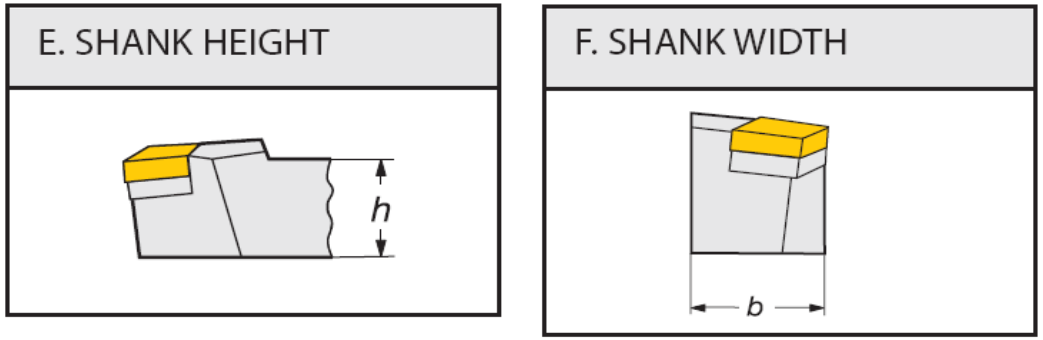
Toolholders

External

P	C	L	N	R	16	16	H	09
B	1	C	2	D	E	F	G	5

C3-
A

Coromant Capto® coupling size



G. Tool length

Toolholders

External

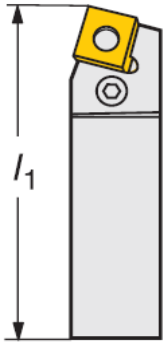
P	C	L	N	R	16	16	H	09
B	1	C	2	D	E	F	G	5

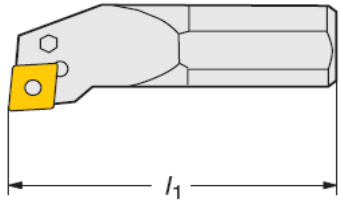
C3 -
A

Coromant Capto® coupling size

G. TOOL LENGTH

Tool length = l_1 in mm





H	=	100	S	=	250
K	=	125	T	=	300
M	=	150	U	=	350
P	=	170	V	=	400
Q	=	180	W	=	450
R	=	200	Y	=	500

5. Insert size = cutting edge length

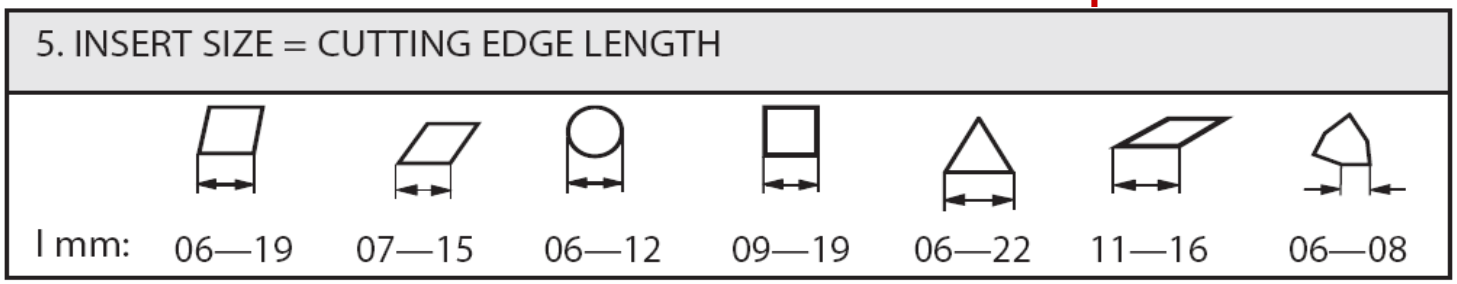
Toolholders

External

P	C	L	N	R	16	16	H	09
B	1	C	2	D	E	F	G	5

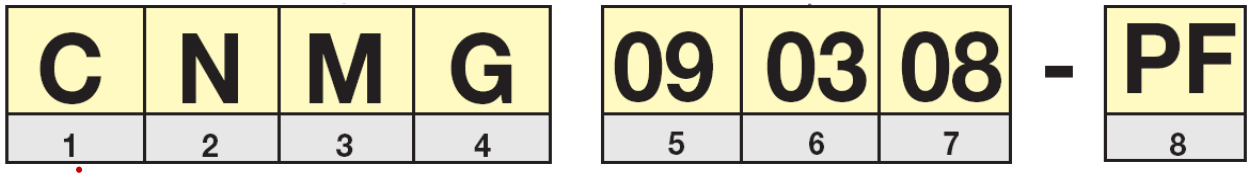
C3-
A

Coromant Capto® coupling size



1. Insert shape

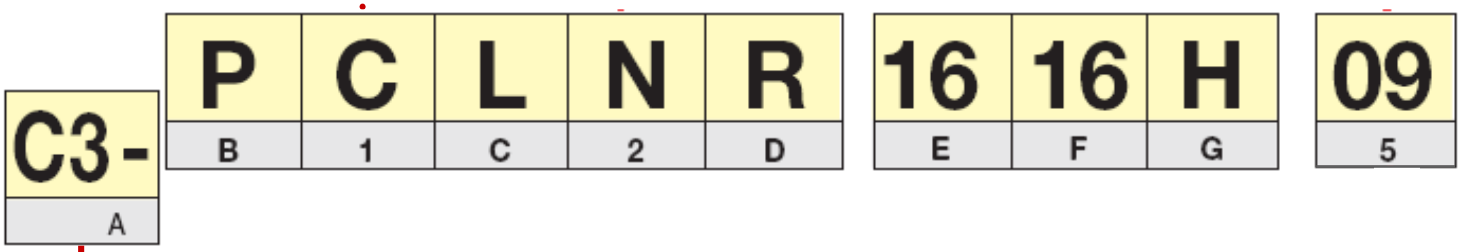
Insert



Insert shape should match in this case 80 degree.

Toolholders

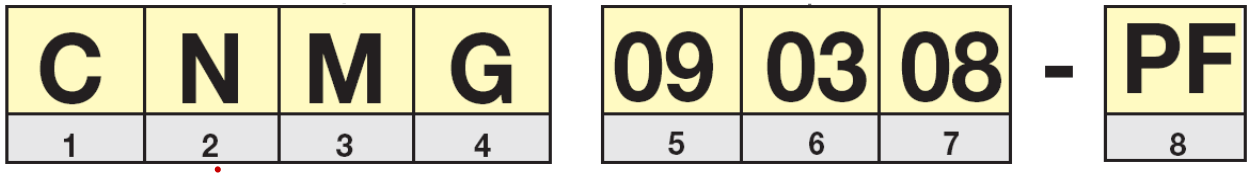
External



Coromant Capto® coupling size

2. Insert clerance angle

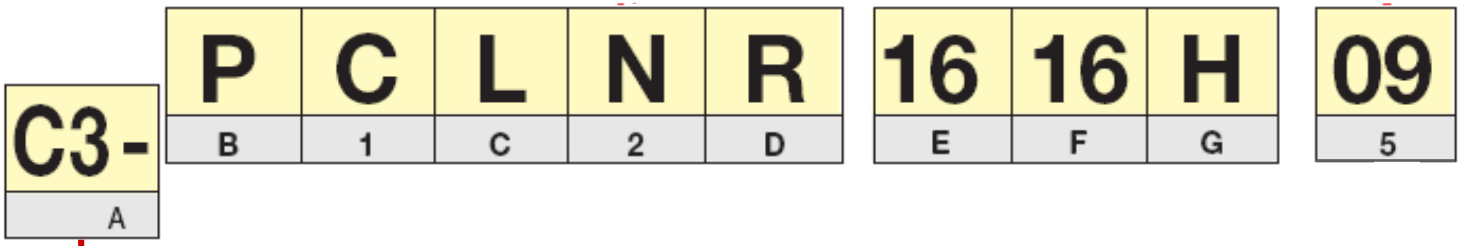
Insert



Insert clearance angle should match

Toolholders

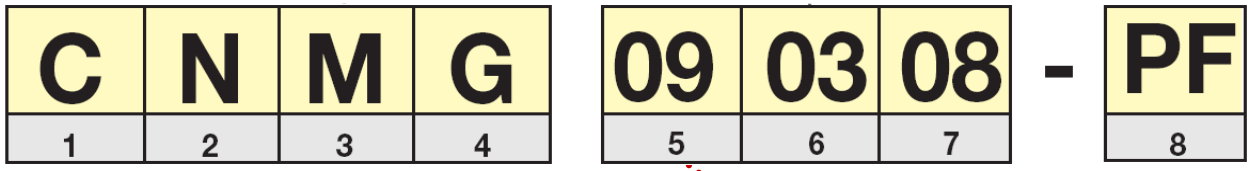
External



Coromant Capto® coupling size

5. Insert size = cutting edge length

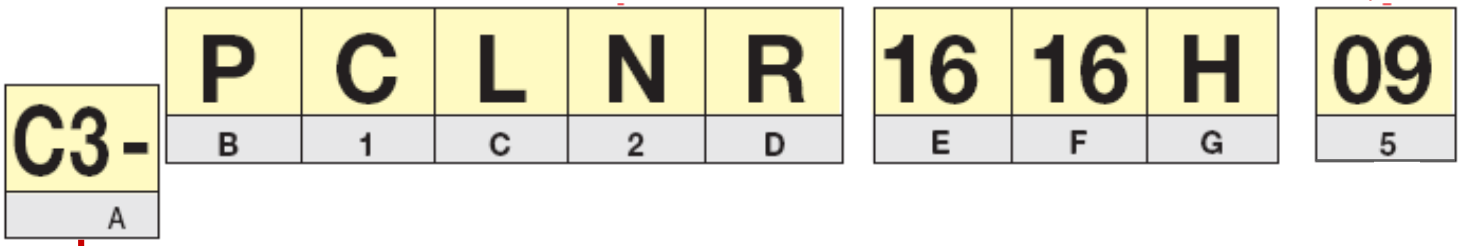
Insert



Insert I.C. should match

Toolholders

External



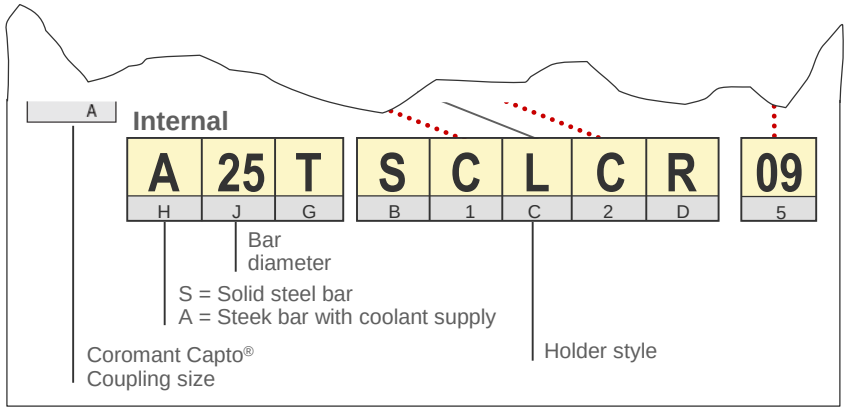
Coromant Capto® coupling size

Code key

Boring bars

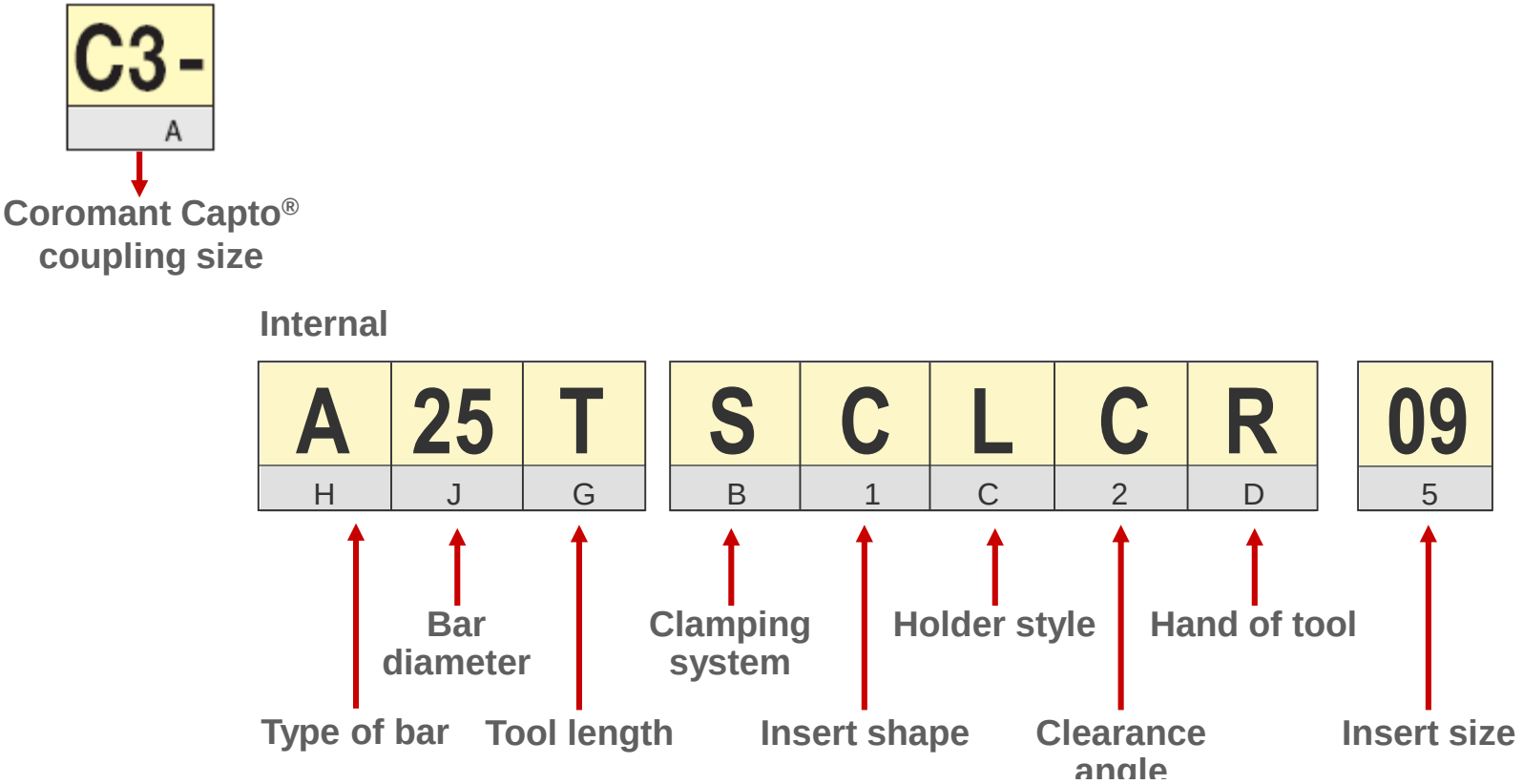
Code key

Boring bars



Internal holders - boring bars

Internal holders



External holder and corresponding boring bar

Toolholders