

CoroTurn® 107 screw clamping

Internal tools for positive basic-shape inserts with 7° clearance angle

Min. bore diameter from 8.5 mm

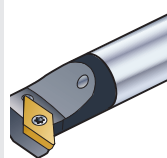
For light roughing to finishing of small, long and slender components, ideal for copy machining

The CoroTurn 107 tool holder programme includes boring bars with cylindrical steel and carbide shanks. It even offers damped boring bars, Silent Tools, down to 13 mm bores.



Accuracy

The inserts and holders are designed to reduce cutting forces to minimise the risk of vibration, thus enabling you to produce the highest component quality possible.



Correct clamping with EasyFix

Fast, simple and correct setting of centre height due to spring loaded plunger. Available for all cylindrical boring bars. For more information see page C29

A screw clamping system, giving:

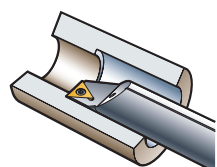
- Secure insert clamping
- Excellent repeatability
- Unhampered chip flow
- Few spare parts

Different types of bars

- Solid steel for overhang up to 4 x bar dia
- Carbide bar for overhang up to 6 x bar dia
- Damped carbide bar for overhang up to 10 x bar dia
-

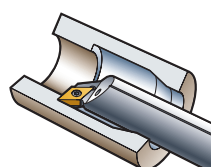
First choice recommendation

Turning



Bore: 8.5 mm
 Insert: TCMT 06 T1 02-PF 5015
 Holder: A06F-STFCR 06-R
 Material: low alloy steel
 v_c m/min: 480
 a_p mm: 0.30
 f_n mm/rev: 0.06

Turning/copying



Bore: 15 mm
 Insert: DCGT 07 02 02-UM 5015
 Holder: A10K-SDUCR 07-ER
 Material: low alloy steel
 v_c m/min: 375
 a_p mm: 0.50
 f_n mm/rev: 0.07

For more specific cutting data, see pages F1, F2, F3

Boring bars

General turning

CoroTurn® 107 screw clamp design

Cylindrical with flats

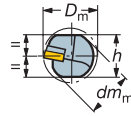
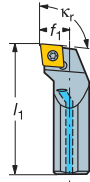
Steel shank A...-SCLCR/L

Entering angle:

$\kappa_r 95^\circ$



- CCMT, CCGT
CCGX
- CCMW



Max overhang 4 x dm_m With internal coolant supply

Right hand style shown when nothing else is stated

κ_r	Main application	Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	D_m min	f_1	h	l_1	$\gamma^1)$	$\lambda_s^2)$		
95°		A08H-SCLCR/L 06	8	10.0	5.0	7.0	100.0	0°	-13.5°	CCMT 06 02 04	0.9
		A10K-SCLCR/L 06	10	12.0	6.0	9.0	125.0	0°	-10.5°	CCMT 06 02 04	0.9
		A12M-SCLCR/L 06	12	16.0	9.0	11.0	150.0	0°	-7°	CCMT 06 02 04	0.9

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

R = Right hand, L = Left hand

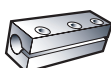
For coolant connector, see page C31

Main spare parts

Insert size			
Bar dia.	Insert screw	Key (Torx Plus)	
06 8-12	5513 020-03	5680 051-02 (71P)	



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INTERNAL MACHINING CoroTurn® 107

Boring bars

General turning

CoroTurn® 107 screw clamp design

Cylindrical

Entering angle:

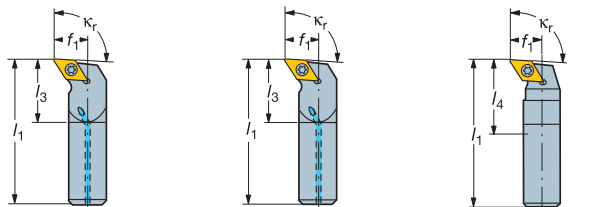
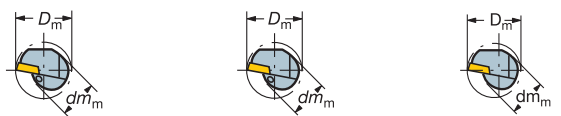
Steel shank
A...-SDUCR/L...ER
 $\kappa_r 93^\circ$

Carbide shank
E...-SDUCR/L
 $\kappa_r 93^\circ$

Damped carbide shank
F...-SDUCR/L
 $\kappa_r 93^\circ$



DCMT, DCMX
DCGT, DCGX
DCMW

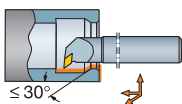



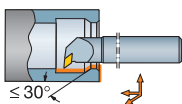

Max overhang
4 x dm_m
With internal coolant supply

6 x dm_m
With internal coolant supply

10 x dm_m

Right hand style shown



κ_r	Main application	Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾	
			dm_m	D_m min	f_1	l_1	l_3	l_4 ⁴⁾	γ^1			λ_s ²⁾
93°		07 A10K-SDUCR/L 07-ER	10	15.0	9.0	125.0	16.4	0°	-7°	DCMT 07 02 04	0.9	
		A12M-SDUCR/L 07-ER	12	18.0	11.0	150.0	18.2	0°	-5°	DCMT 07 02 04	0.9	
		07 E10M-SDUCR/L 07-ER	10	15.0	9.0	150.0	21.3	0°	-5°	DCMT 07 02 04	0.9	
		E12Q-SDUCR/L 07-ER	12	18.0	11.0	180.0	25.3	0°	-5°	DCMT 07 02 04	0.9	
		07 F10M-SDUCR/L 07-ER	10	15.0	9.0	150.0		60	0°	-7°	DCMT 07 02 04	0.9
		F12Q-SDUCR/L 07-ER	12	18.0	11.0	180.0		72	0°	-9°	DCMT 07 02 04	0.9

¹⁾ γ = Rake angle (valid with flat insert).
²⁾ λ_s = Angle of inclination.
³⁾ Insert tightening torque Nm.
⁴⁾ Do not clamp in this area.

R = Right hand, L = Left hand

For coolant connector, see page C31

Main spare parts

Insert size	Bar dia.	Insert screw	Key (Torx Plus)
07	10-12	5513 020-03	5680 051-02 (7IP)



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C 4



Boring bars

General turning

CoroTurn® 107 screw clamp design

Cylindrical with flats

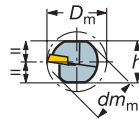
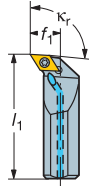
Steel shank
A...-SDUCR/L

Entering angle:

$\kappa_r 93^\circ$



- DCMT, DCMX
- DCGT, DCGX
- DCMW



Max overhang 4 x dm_m

With internal coolant

Right hand style shown

κ_r	Main application	Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	D_m min	f_1	h	l_1	l_r	$\gamma^1)$		
93°		A10K-SDUCR/L 07	10	13.0	7.0	9.0	125.0	0°	-9°	DCMT 07 02 04	0.9
		A12M-SDUCR/L 07	12	16.0	9.0	11.0	150.0	0°	-6.5°	DCMT 07 02 04	0.9

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

R = Right hand, L = Left hand

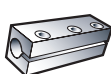
For coolant connector, see page C31

Main spare parts

Insert size			
Bar dia.	Insert screw	Key (Torx Plus)	
07 10-12	5513 020-03	5680 051-02 (7IP)	



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INTERNAL MACHINING CoroTurn® 107

Boring bars

General turning
CoroTurn® 107 screw clamp design

Cylindrical

Entering angle:

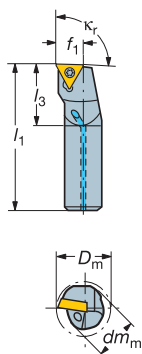
Steel shank
A...-STFCR/L...R
 $\kappa_r 91^\circ$

Carbide shank
E...-STFCR/L
 $\kappa_r 91^\circ$

Damped carbide shank
F...-STFCR/L
 $\kappa_r 91^\circ$



TCMT, TCMX
TCGT, TCGX
TCMW



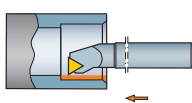

Max overhang

4 x dm_m With internal coolant supply

6 x dm_m With internal coolant supply

10 x dm_m

Right hand style shown when nothing else is stated

κ_r	Main application	Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾	
			dm_m	D_m min	f_1	l_1	l_3	l_4 ⁴⁾	γ ¹⁾			λ_s ²⁾
91°		06 A06F-STFCR/L 06-R	6	8.5	4.5	80.0	11.0		0°	-10°	TCMT 06 T1 02	0.6
		A08H-STFCR/L 06-R	8	11.0	5.9	100.0	12.6		0°	-6°	TCMT 06 T1 02	0.6
		09 A10K-STFCR/L 09-R	10	13.0	7.0	125.0	16.7		0°	-8°	TCMT 09 02 04	0.9
		A12M-STFCR/L 09-R	12	16.0	9.0	150.0	19.0		0°	-6°	TCMT 09 02 04	0.9
		06 E06H-STFCR/L 06-R	6	8.5	4.5	100.0	13.3		0°	-10°	TCMT 06 T1 02	0.6
		E08K-STFCR/L 06-R	8	10.5	5.9	125.0	17.3		0°	-6°	TCMT 06 T1 02	0.6
		09 E10M-STFCR/L 09-R	10	13.0	7.0	150.0	21.3		0°	-8°	TCMT 09 02 04	0.9
		E12Q-STFCR/L 09-R	12	16.0	9.0	180.0	25.3		0°	-6°	TCMT 09 02 04	0.9
		09 F10M-STFCR/L 09-R	10	13.0	7.0	150.0		60	0°	-8°	TCMT 09 02 04	0.9
		F12Q-STFCR/L 09-R	12	16.0	9.0	180.0		72	0°	-10°	TCMT 09 02 04	0.9

¹⁾ γ = Rake angle (valid with flat insert).
²⁾ λ_s = Angle of inclination.
³⁾ Insert tightening torque Nm.
⁴⁾ Do not clamp in this area.

R = Right hand, L = Left hand

For coolant connector, see page C31

Main spare parts

Insert size	Bar dia.	Insert screw	Key (Torx Plus)
06	6	5513 020-28	5680 051-01 (6IP)
06	8	5513 020-27	5680 051-01 (6IP)
09	10-12	5513 020-05	5680 051-02 (7IP)



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Boring bars

General turning

CoroTurn® 107 screw clamp design

Cylindrical with flats

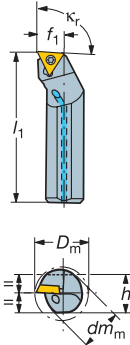
Steel shank
A...-STFCR/L

Entering angle:

$\kappa_r 91^\circ$



- TCMT, TCMX
- TCGT, TCGX
- TCMW



Max overhang 4 x dm_m With internal coolant supply

Right hand style shown when nothing else is stated

κ_r	Main application	Ordering code	Dimensions, mm							Gauge inserts	Nm ³⁾
			dm_m	D_m min	f_1	h	l_1	$\gamma^{1)}$	$\lambda_s^{2)}$		
91°		06 A06F-STFCR/L 06	6	8.5	4.5	5.0	80.0	0°	-12°	TCMT 06 T1 02	0.6
		A08H-STFCR/L 06	8	11.0	5.9	7.0	100.0	0°	-10°	TCMT 06 T1 02	0.6
		09 A10K-STFCR/L 09	10	13.0	7.0	9.0	125.0	0°	-9°	TCMT 09 02 04	0.9
		A12M-STFCR/L 09	12	16.0	9.0	11.0	150.0	0°	-6.5°	TCMT 09 02 04	0.9
		11 A12M-STFCR/L 11-B1 ⁴⁾	12	16.0	9.0	11.0	150.0	0°	-8°	TCMT 11 03 04	0.9

¹⁾ γ = Rake angle (valid with flat insert).

²⁾ λ_s = Angle of inclination.

³⁾ Insert tightening torque Nm.

⁴⁾ B1 = For insert with thickness 03 = 3.18 mm.

R = Right hand, L = Left hand

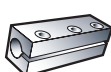
For coolant connector, see page C31

Main spare parts

Insert size			
\triangle	Bar dia.	Insert screw	Key (Torx Plus)
06	6	5513 020-28	5680 051-01 (6IP)
06	8	5513 020-27	5680 051-02 (7IP)
09	10-12	5513 020-05	5680 051-02 (7IP)
11	12	5513 020-03	5680 051-02 (7IP)



B12



B13