

CoroTurn® XS

For internal small part machining

For internal turning, grooving and threading of small bores, down to 0,3 mm



CoroTurn® XS tooling

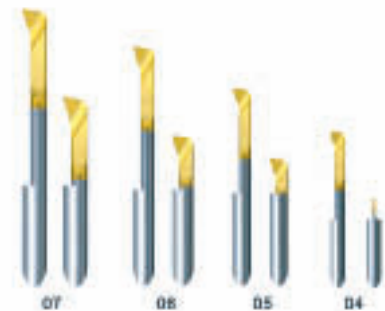
The system consists of inserts in the well proven grade GC1025 for:

- Turning
- Turning copying
- Grooving
- Face grooving
- Profiling full radius
- Pre-parting
- Threading

Boring bars in different outer diameters adapted for different machine types

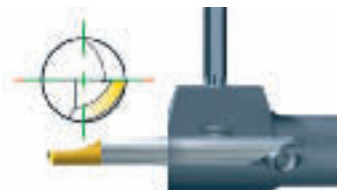
CoroTurn® XS assortment

The programme consists of four different insert sizes



CoroTurn® XS precision

The insert locates precisely into the boring bar thanks to a locating pin which locks the insert into the correct orientation



CoroTurn® XS grooving

All grooving inserts produce grooves with flat bottom and sharp corner radii

For further information about our different tooling solutions for Small Part Machining, see page 2

CoroTurn® XS coolant supply

The boring bars are designed with internal cutting fluid supply



Code key for CoroTurn® XS

Insert for turning

CXS	04	T	098	-	10	-	22	06	R
1	2	3	4		5		9	10	12

Insert for grooving

CXS	06	F	100	-	62	15	A	R
1	2	3	6		9	10	11	12

Insert for threading

CXS	04	TH	050	VM	-	42	15	R
1	2	3	7	8		9	10	12

Boring bars

CXS	A	10	-	04
1	13	14		2

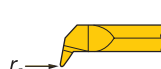
1 Main code

CXS = CoroTurn® XS

4 Entering angle (Turning)

E.g.: 098 = 98°

5 Nose radius, r_ϵ mm (Turning)



E.g.: 10 = 0.1 mm

8 Thread profile (Threading)

V profile 60°
 WH = Whitworth 55°
 NT = NPT 60°


11 Type of curve (Face grooving)

A = A-curved

12 Hand of insert


R = Right hand style
 L = Left hand style

2 Insert size mm



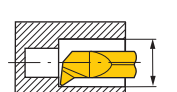
04 = 4 mm 05 = 5 mm 06 = 6 mm 07 = 7 mm

6 Insert width, l_a mm (Grooving)



E.g.: 100 = 1.00 mm

9 Min hole diameter, D_m min. mm



E.g.: 22 = 2.2 mm

13 Type of bar

A = Steel bar with internal coolant supply

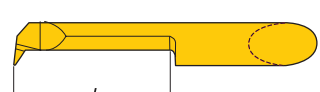
3 Type of operation

T = Turning
 TE = Turning copying, extended f_1 -dimension
 F = Face grooving
 G = Grooving
 GX = Pre-parting
 R = Profiling full radius
 TH = Threading

7 Pitch, mm (Threading)

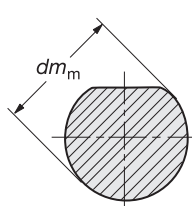
mm: pitch x 100
 inch: No. of threads per inch x 10

10 Penetration depth, l_3 mm



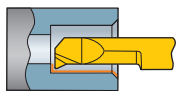
E.g.: 06 = 6 mm

14 Bar dia, dm_m mm



CoroTurn® XS inserts

Turning



Entering angle:
90°

Tolerances, mm:

$l_a +0.05/-0$

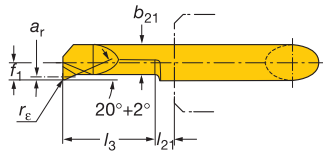
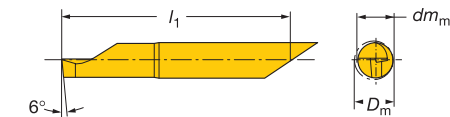
$r_e \pm 0.02$

$l_1 \pm 0.02$

Centre height:

+0.05/-0

CXS-..T090



Insert size	Ordering code	Dimensions, mm										P		M		N		S	
		a_r max	b_{21}	D_m min	f_1	l_{21}	l_1	l_3	r_e	z	GC	-	GC	-	GC	-	GC	-	
		dm_m																	
04	CXS-04T090-15-3212R	0.2	2.55	3.2	1.45	3	29.26	12	0.1	-	★	★	★	★	★	★	★	★	
	CXS-04T090-15-4215R/L	0.3	3.45	4.2	1.95	3	39.26	15	0.1	-	★	★	★	★	★	★	★	★	
	05	CXS-05T090-20-5210R/L	0.5	4.2	5.2	2.45	3	32.25	10	0.2	-	★	★	★	★	★	★	★	
	CXS-05T090-20-5215R/L	0.5	4.2	5.2	2.45	3	37.25	15	0.2	-	★	★	★	★	★	★	★	★	
	CXS-05T090-20-5220R/L	0.5	4.2	5.2	2.45	3	42.25	20	0.2	-	★	★	★	★	★	★	★	★	
											P25	P15	M15	M20	N15	N15	S15	S15	

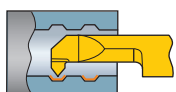
Ordering example: 2 pieces CXS-04T090-15-3212R

CXS-04T090-15-4215L

R = Right hand, L = Left hand

★ = First choice

Turning/profiling



Entering angle:
45°

Tolerances, mm:

$l_a = +0.05/-0$

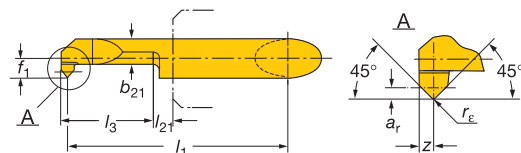
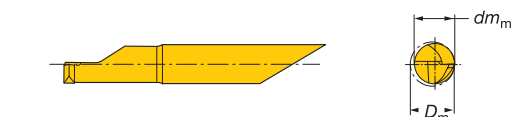
$r_e = \pm 0.02$

$l_1 = \pm 0.02$

Centre height:

+0.05/-0

CXS-..T045



Insert size	Ordering code	Dimensions, mm										P		M		N		S	
		a_r max	b_{21}	D_m min	f_1	l_{21}	l_1	l_3	r_e	z	GC	-	GC	-	GC	-	GC	-	
		dm_m																	
05	CXS-05T045-20-5215R	0.7	3.75	5.2	2.45	3	37.25	15	0.2	1.0	★	★	★	★	★	★	★	★	
	CXS-05T045-20-5220R/L	0.7	3.75	5.2	2.45	3	42.25	20	0.2	1.0	★	★	★	★	★	★	★	★	
06	CXS-06T045-20-6220R	0.7	3.95	6.2	2.95	3	42.25	20	0.2	1.0	★	★	★	★	★	★	★	★	
	CXS-06T045-20-6225R/L	0.7	3.95	6.2	2.95	3	47.25	25	0.2	1.0	★	★	★	★	★	★	★	★	
07	CXS-07T045-20-7220R/L	0.7	4.25	7.2	3.45	3	62.25	20	0.2	1.0	★	★	★	★	★	★	★	★	
	CXS-07T045-20-7240R/L	0.7	4.25	7.2	3.45	3	62.25	40	0.2	1.0	★	★	★	★	★	★	★	★	
											P25	P15	M15	M20	N15	N15	S15	S15	

Ordering example: 2 pieces CXS-05T045-20-5215R

CXS-05T045-20-5220L

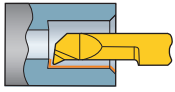
R = Right hand, L = Left hand

★ = First choice



CoroTurn® XS inserts

Turning



Entering angle:
98°

Tolerances, mm:

$l_a = +0.05/-0$

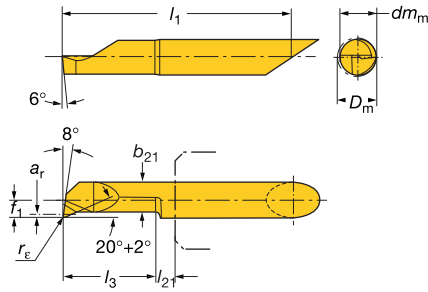
$r_\epsilon = \pm 0.02$

$l_1 = \pm 0.02$

Centre height:

$+0.05/-0$

CXS-..T098



Insert size	dm _m	Ordering code	Dimensions, mm							P		M		N		S		
			a _r max	b ₂₁	D _m min	f ₁	l ₂₁	l ₁	l ₃	r _ε	GC	-	GC	-	GC	-	GC	-
			1025	H10F	1025	H10F	1025	H10F	1025	H10F	1025	H10F	1025	H10F	1025	H10F	1025	H10F
04	CXS-04T098-00-0301R	0.06	0.19	0.3	0.1	8.8	27.25	1.2	0.00	★	★	★	★	★	★	★	★	
	CXS-04T098-00-0401R	0.07	0.28	0.4	0.15	8.4	27.25	1.6	0.00	★	★	★	★	★	★	★	★	
	CXS-04T098-00-0502R	0.08	0.37	0.5	0.2	8	27.25	2	0.00	★	★	★	★	★	★	★	★	
	CXS-04T098-00-0602R	0.09	0.46	0.6	0.25	7.5	27.25	2.5	0.00	★	★	★	★	★	★	★	★	
	CXS-04T098-00-0703R	0.1	0.55	0.7	0.3	6.5	27.25	3.5	0.00	★	★	★	★	★	★	★	★	
	CXS-04T098-00-0804R	0.1	0.64	0.8	0.35	6	27.25	4	0.00	★	★	★	★	★	★	★	★	
	CXS-04T098-00-0905R	0.1	0.73	0.9	0.4	5	27.25	5	0.00	★	★	★	★	★	★	★	★	
	CXS-04T098-05-1004R	0.1	0.65	1	0.45	8	26.25	4	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-1006R	0.1	0.65	1	0.45	6	26.25	6	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-1706R	0.2	1.05	1.7	0.7	6	26.25	6	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-1709R	0.2	1.05	1.7	0.7	3	26.25	9	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-2206R	0.2	1.55	2.2	0.95	6	26.25	6	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-2209R	0.2	1.55	2.2	0.95	3	26.25	9	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-2710R	0.2	2.05	2.7	1.2	3	27.25	10	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-2715R	0.2	2.05	2.7	1.2	3	32.25	15	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-3215R	0.2	2.55	3.2	1.45	3	32.25	15	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-3220R	0.2	2.55	3.2	1.45	3	37.25	20	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-4215R	0.3	3.45	4.2	1.95	3	32.25	15	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-4220R	0.3	3.45	4.2	1.95	3	37.25	20	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-05-4225R	0.3	3.45	4.2	1.95	3	42.25	25	0.05	★	★	★	★	★	★	★	★	
	CXS-04T098-10-1004R/L	0.1	0.65	1	0.45	3	21.26	4	0.10	★	☆	★	★	☆	★	★	☆	
	CXS-04T098-10-1006R	0.1	0.65	1	0.45	3	23.26	6	0.10	★	☆	★	★	☆	★	★	☆	
	CXS-04T098-10-1706R/L	0.2	1.05	1.7	0.7	3	23.26	6	0.10	★	☆	★	★	☆	★	★	☆	
	CXS-04T098-10-1709R/L	0.2	1.05	1.7	0.7	3	26.26	9	0.10	★	★	★	★	★	★	★	★	
	CXS-04T098-10-2206R/L	0.2	1.55	2.2	0.95	3	23.26	6	0.10	★	★	★	★	★	★	★	★	
	CXS-04T098-10-2209R/L	0.2	1.55	2.2	0.95	3	26.26	9	0.10	★	☆	★	★	☆	★	★	☆	
	CXS-04T098-10-2213R/L	0.2	1.55	2.2	0.95	3	30.26	13	0.10	★	★	★	★	★	★	★	★	
	CXS-04T098-15-2710R/L	0.2	2.05	2.7	1.2	3	27.26	10	0.15	★	☆	★	★	☆	★	★	☆	
	CXS-04T098-15-2715R/L	0.2	2.05	2.7	1.2	3	32.26	15	0.15	★	★	★	★	★	★	★	★	
	CXS-04T098-15-3210R/L	0.2	2.55	3.2	1.45	3	27.26	10	0.15	★	☆	★	★	☆	★	★	☆	
CXS-04T098-15-3215R/L	0.2	2.55	3.2	1.45	3	32.26	15	0.15	★	★	★	★	★	★	★	★		
CXS-04T098-15-3220R/L	0.2	2.55	3.2	1.45	3	37.26	20	0.15	★	★	★	★	★	★	★	★		
CXS-04T098-15-4210R/L	0.3	3.45	4.2	1.95	3	27.26	10	0.15	★	★	★	★	★	★	★	★		
CXS-04T098-15-4215R/L	0.3	3.45	4.2	1.95	3	32.26	15	0.15	★	☆	★	★	☆	★	★	☆		
CXS-04T098-15-4220R/L	0.3	3.45	4.2	1.95	3	37.26	20	0.15	★	★	★	★	★	★	★	★		
CXS-04T098-15-4225R/L	0.3	3.45	4.2	1.95	3	43.26	25	0.15	★	★	★	★	★	★	★	★		

Ordering example: 2 pieces CXS-04T098-00-0301R

CXS-04T098-10-1004L

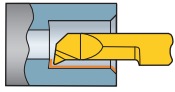
R = Right hand, L = Left hand

★ = First choice



CoroTurn® XS inserts

Turning



Entering angle:

98°

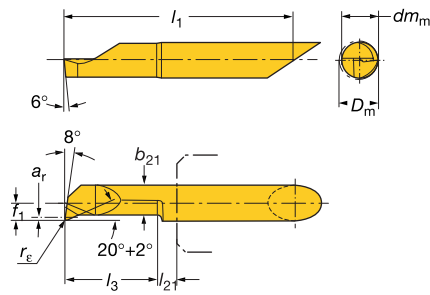
Tolerances, mm:

 $l_a = +0.05/-0$ $r_\epsilon = \pm 0.02$ $l_1 = \pm 0.02$

Centre height:

+0.05/-0

CXS-..T098



Insert size	Dimensions, mm	Ordering code	Dimensions, mm								P		M		N		S		
			a_r	b_{21}	D_m	f_1	l_{21}	l_1	l_3	r_ϵ	GC	-	GC	-	GC	-	GC	-	
			max		min						1025	H10F	1025	H10F	1025	H10F	1025	H10F	
05		CXS-05T098-05-5220R	0.5	4.25	5.2	2.45	3	42.25	20	0.05	★	★	★	★	★	★	★	★	
		CXS-05T098-05-5230R	0.5	4.25	5.2	2.45	3	57.25	30	0.05	★	★	★	★	★	★	★	★	
		CXS-05T098-20-5210R/L	0.5	4.25	5.2	2.45	3	32.25	10	0.20	★	★	★	★	★	★	★	★	
		CXS-05T098-20-5220R/L	0.5	4.25	5.2	2.45	3	42.25	20	0.20	★	★	★	★	★	★	★	★	
		CXS-05T098-20-5225R/L	0.5	4.25	5.2	2.45	3	47.25	25	0.20	★	☆	★	★	☆	★	☆	★	
		CXS-05T098-20-5230R/L	0.5	4.25	5.2	2.45	3	57.25	30	0.20	★	★	★	★	★	★	★	★	
	06		CXS-06T098-20-6215R/L	0.5	5.25	6.2	2.95	3	37.25	15	0.20	★	★	★	★	★	★	★	★
			CXS-06T098-20-6220R/L	0.5	5.25	6.2	2.95	3	42.25	20	0.20	★	☆	★	★	☆	★	☆	★
			CXS-06T098-20-6225R/L	0.5	5.25	6.2	2.95	3	47.25	25	0.20	★	★	★	★	★	★	★	★
			CXS-06T098-20-6230R/L	0.5	5.25	6.2	2.95	3	52.25	30	0.20	★	★	★	★	★	★	★	★
		CXS-06T098-20-6235R/L	0.5	5.25	6.2	2.95	3	57.25	35	0.20	★	★	★	★	★	★	★	★	
		CXS-06T098-20-6240R	0.5	5.25	6.2	2.95	3	62.25	40	0.20	★	★	★	★	★	★	★	★	
07		CXS-07T098-20-7225R/L	0.5	6.25	7.2	3.45	3	47.25	25	0.20	★	☆	★	★	☆	★	☆	★	
		CXS-07T098-20-7230R	0.5	6.25	7.2	3.45	3	57.25	30	0.20	★	★	★	★	★	★	★	★	
		CXS-07T098-20-7240R/L	0.5	6.25	7.2	3.45	3	62.25	40	0.20	★	★	★	★	★	★	★	★	
		CXS-07T098-20-7245R/L	0.5	6.25	7.2	3.45	3	67.25	45	0.20	★	★	★	★	★	★	★	★	
		CXS-07T098-20-7250R	0.5	6.25	7.2	3.45	3	72.25	50	0.20	★	★	★	★	★	★	★	★	
											P25	P15	M15	M20	N15	N15	S15	S15	

Ordering example: 2 pieces CXS-05T098-05-5220R

CXS-05T098-20-5210L

R = Right hand, L = Left hand

★ = First choice

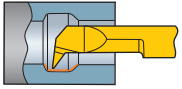


CoroTurn® XS inserts

Copying

Insert with extended f_1 dimension

CXS-..TE98 Copying



Entering angle:
98°

Tolerances, mm:

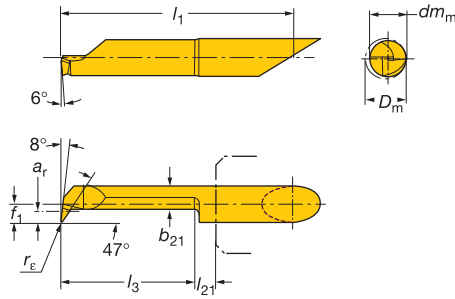
$l_a = +0.05/-0$

$r_\epsilon = \pm 0.02$

$l_1 = \pm 0.02$

Centre height:

+0.05/-0



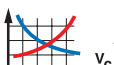
	Insert size	Ordering code	Dimensions, mm								P		M		N		S		
			dm_m	a_r max	b_{21}	D_m min	f_1	l_{21}	l_1	l_3	r_ϵ	GC	-	GC	-	GC	-	GC	-
												1025	H10F	1025	H10F	1025	H10F	1025	H10F
	04	CXS-04TE98-15-422OR/L	0.8	2.95	4.2	1.95	3	37.26	20	0.15	★	★	★	★	★	★	★	★	
	05	CXS-05TE98-15-5225R/L	1	3.75	5.2	2.45	3	47.25	25	0.15	★	★	★	★	★	★	★	★	
	06	CXS-06TE98-15-6230R/L	1.8	3.95	6.2	2.95	3	52.25	30	0.15	★	★	★	★	★	★	★	★	
											P25	P15	M15	M20	N15	N15	S15	S15	

Ordering example: 2 pieces CXS-04TE98-15-422OR

CXS-04TE98-15-422OL

R = Right hand, L = Left hand

★ = First choice



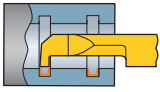
A350



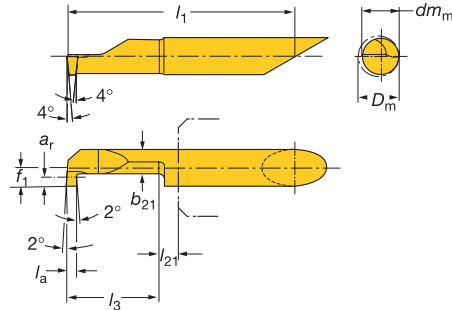
A2

CoroTurn® XS inserts

Grooving



CXS-..G



Tolerances, mm:

- $l_a = +0.05/-0$
- $r_{\epsilon} = \pm 0.02$
- $l_1 = \pm 0.02$
- Centre height: $+0.05/-0$

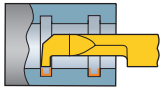
	Selection criteria, mm				Insert size	Dimensions, mm	Material								
	a_r max	D_m min	l_a	l_3			P	M	N	S					
	0.8	4.2	0.78	10	04	CXS-04G078-4210R	2.95	1.95	3	27.4	★	★	★	★	
	0.8	4.2	0.78	15			CXS-04G078-4215R/L	2.95	1.95	3	32.5	★	★	★	★
	0.8	4.2	0.78	20			CXS-04G078-4220R	2.95	1.95	3	37.6	★	★	★	★
	0.8	4.2	1.00	10			CXS-04G100-4210R/L	2.95	1.95	3	27.3	★	★	★	★
	0.8	4.2	1.00	15			CXS-04G100-4215R/L	2.95	1.95	3	32.3	★	★	★	★
	0.8	4.2	1.00	20			CXS-04G100-4220R/L	2.95	1.95	3	37.3	★	★	★	★
	1.0	5.2	0.78	10	05	CXS-05G078-5210R	3.75	2.45	3	32.4	★	★	★	★	
	1.0	5.2	0.78	20			CXS-05G078-5220R/L	3.75	2.45	3	42.5	★	★	★	★
	1.0	5.2	0.78	30			CXS-05G078-5230R	3.75	2.45	3	52.7	★	★	★	★
	1.0	5.2	1.00	10			CXS-05G100-5210R	3.75	2.45	3	32.3	★	★	★	★
	1.0	5.2	1.00	20			CXS-05G100-5220R/L	3.75	2.45	3	42.3	★	★	★	★
	1.0	5.2	1.00	30			CXS-05G100-5230R	3.75	2.45	3	52.3	★	★	★	★
	1.0	5.2	1.17	10			CXS-05G117-5210R	3.75	2.45	3	32.4	★	★	★	★
	1.0	5.2	1.17	20			CXS-05G117-5220R/L	3.75	2.45	3	42.5	★	★	★	★
	1.0	5.2	1.17	30			CXS-05G117-5230R	3.75	2.45	3	52.7	★	★	★	★
	1.0	5.2	1.50	10			CXS-05G150-5210R	3.75	2.45	3	32.3	★	★	★	★
	1.0	5.2	1.50	15			CXS-05G150-5215R/L	3.75	2.45	3	37.3	★	★	★	★
	1.0	5.2	1.50	20			CXS-05G150-5220R/L	3.75	2.45	3	42.3	★	★	★	★
	1.0	5.2	1.50	30			CXS-05G150-5230R	3.75	2.45	3	52.3	★	★	★	★
	1.0	5.2	1.57	10			CXS-05G157-5210R	3.75	2.45	3	32.4	★	★	★	★
1.0	5.2	1.57	20	CXS-05G157-5220R/L	3.75	2.45	3	42.5	★	★	★	★			
1.0	5.2	1.57	30	CXS-05G157-5230R	3.75	2.45	3	52.7	★	★	★	★			
1.0	5.2	1.98	10	CXS-05G198-5210R	3.75	2.45	3	32.4	★	★	★	★			
1.0	5.2	1.98	20	CXS-05G198-5220R/L	3.75	2.45	3	42.5	★	★	★	★			
1.0	5.2	1.98	30	CXS-05G198-5230R	3.75	2.45	3	52.7	★	★	★	★			
1.0	5.2	2.00	10	CXS-05G200-5210R	3.75	2.45	3	32.3	★	★	★	★			
1.0	5.2	2.00	20	CXS-05G200-5220R/L	3.75	2.45	3	42.3	★	★	★	★			
1.0	5.2	2.00	30	CXS-05G200-5230R	3.75	2.45	3	52.3	★	★	★	★			
1.8	6.2	0.78	10	06	CXS-06G078-6210R	3.95	2.95	3	32.4	★	★	★	★		
1.8	6.2	0.78	15			CXS-06G078-6215R/L	3.95	2.95	3	37.5	★	★	★	★	
1.8	6.2	0.78	25			CXS-06G078-6225R	3.95	2.95	3	47.6	★	★	★	★	
1.8	6.2	0.78	35			CXS-06G078-6235R/L	3.95	2.95	3	57.8	★	★	★	★	
1.8	6.2	1.00	10			CXS-06G100-6210R	3.95	2.95	3	32.3	★	★	★	★	
1.8	6.2	1.00	15			CXS-06G100-6215R/L	3.95	2.95	3	37.3	★	★	★	★	
1.8	6.2	1.00	25			CXS-06G100-6225R/L	3.95	2.95	3	47.3	★	★	★	★	
1.8	6.2	1.00	35			CXS-06G100-6235R	3.95	2.95	3	57.3	★	★	★	★	
1.8	6.2	1.17	10			CXS-06G117-6210R	3.95	2.95	3	32.4	★	★	★	★	
1.8	6.2	1.17	15			CXS-06G117-6215R/L	3.95	2.95	3	37.5	★	★	★	★	
1.8	6.2	1.17	25			CXS-06G117-6225R	3.95	2.95	3	47.6	★	★	★	★	
1.8	6.2	1.17	35			CXS-06G117-6235R/L	3.95	2.95	3	57.8	★	★	★	★	
1.8	6.2	1.50	10			CXS-06G150-6210R	3.95	2.95	3	32.3	★	★	★	★	
1.8	6.2	1.50	15			CXS-06G150-6215R/L	3.95	2.95	3	37.3	★	★	★	★	
1.8	6.2	1.50	25	CXS-06G150-6225R/L	3.95	2.95	3	47.3	★	★	★	★			
1.8	6.2	1.50	35	CXS-06G150-6235R	3.95	2.95	3	57.3	★	★	★	★			

Ordering example: 2 pieces CXS-04G078-4210R
 CXS-04G078-4215L
 R = Right hand, L = Left hand
 ★ = First choice

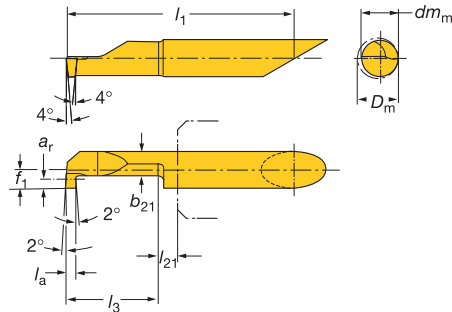


CoroTurn® XS inserts

Grooving



CXS-..G



Tolerances, mm:

- $l_a = +0.05/-0$
- $r_c = \pm 0.02$
- $l_1 = \pm 0.02$
- Centre height: $+0.05/-0$

	Selection criteria, mm				Insert size	Dimensions, mm	P				M				N				S				
	a_r max	D_m min	l_a	l_3			dm_m	Ordering code	b_{21}	f_1	l_{21}	l_1	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
	1.8	6.2	1.57	10	06	CXS-06G157-6210R	3.95	2.95	3	32.4	★	★	★	★	★	★	★	★	★	★	★	★	
	1.8	6.2	1.57	15		CXS-06G157-6215R/L	3.95	2.95	3	37.5	★	★	★	★	★	★	★	★	★	★	★	★	★
	1.8	6.2	1.57	25		CXS-06G157-6225R	3.95	2.95	3	47.6	★	★	★	★	★	★	★	★	★	★	★	★	★
	1.8	6.2	1.57	35		CXS-06G157-6235R/L	3.95	2.95	3	57.8	★	★	★	★	★	★	★	★	★	★	★	★	★
	1.8	6.2	1.98	10		CXS-06G198-6210R	3.95	2.95	3	32.4	★	★	★	★	★	★	★	★	★	★	★	★	★
	1.8	6.2	1.98	15		CXS-06G198-6215R/L	3.95	2.95	3	37.5	★	★	★	★	★	★	★	★	★	★	★	★	★
	1.8	6.2	1.98	25		CXS-06G198-6225R	3.95	2.95	3	47.6	★	★	★	★	★	★	★	★	★	★	★	★	★
	1.8	6.2	1.98	35		CXS-06G198-6235R/L	3.95	2.95	3	57.8	★	★	★	★	★	★	★	★	★	★	★	★	★
	1.8	6.2	2.00	10		CXS-06G200-6210R	3.95	2.95	3	32.3	★	★	★	★	★	★	★	★	★	★	★	★	★
	1.8	6.2	2.00	15		CXS-06G200-6215R/L	3.95	2.95	3	37.3	★	★	★	★	★	★	★	★	★	★	★	★	★
	1.8	6.2	2.00	25	CXS-06G200-6225R/L	3.95	2.95	3	47.3	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	0.78	10	07	CXS-07G078-7210R	4.25	3.45	3	32.4	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	0.78	15		CXS-07G078-7215R/L	4.25	3.45	3	37.5	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	0.78	25		CXS-07G078-7225R	4.25	3.45	3	47.6	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	0.78	35		CXS-07G078-7235R/L	4.25	3.45	3	57.8	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	1.00	10		CXS-07G100-7210R/L	4.25	3.45	3	32.3	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	1.00	15		CXS-07G100-7215R/L	4.25	3.45	3	37.3	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	1.00	25		CXS-07G100-7225R/L	4.25	3.45	3	47.3	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	1.00	35		CXS-07G100-7235R	4.25	3.45	3	57.3	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	1.17	10		CXS-07G117-7210R	4.25	3.45	3	32.4	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	1.17	15		CXS-07G117-7215R/L	4.25	3.45	3	37.5	★	★	★	★	★	★	★	★	★	★	★	★	★
	2.5	7.2	1.17	25	CXS-07G117-7225R	4.25	3.45	3	47.6	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.17	35	CXS-07G117-7235R/L	4.25	3.45	3	57.8	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.50	10	CXS-07G150-7210R	4.25	3.45	3	32.3	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.50	15	CXS-07G150-7215R/L	4.25	3.45	3	37.3	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.50	25	CXS-07G150-7225R/L	4.25	3.45	3	47.3	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.50	35	CXS-07G150-7235R	4.25	3.45	3	57.3	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.57	10	CXS-07G157-7210R	4.25	3.45	3	32.4	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.57	15	CXS-07G157-7215R/L	4.25	3.45	3	37.5	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.57	25	CXS-07G157-7225R	4.25	3.45	3	47.6	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.57	35	CXS-07G157-7235R/L	4.25	3.45	3	57.8	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.98	10	CXS-07G198-7210R	4.25	3.45	3	32.4	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.98	15	CXS-07G198-7215R/L	4.25	3.45	3	37.5	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.98	25	CXS-07G198-7225R	4.25	3.45	3	47.6	★	★	★	★	★	★	★	★	★	★	★	★	★	
	2.5	7.2	1.98	35	CXS-07G198-7235R/L	4.25	3.45	3	57.8	★	★	★	★	★	★	★	★	★	★	★	★	★	
2.5	7.2	2.00	10	CXS-07G200-7210R	4.25	3.45	3	32.3	★	★	★	★	★	★	★	★	★	★	★	★	★		
2.5	7.2	2.00	15	CXS-07G200-7215R/L	4.25	3.45	3	37.3	★	★	★	★	★	★	★	★	★	★	★	★	★		
2.5	7.2	2.00	25	CXS-07G200-7225R/L	4.25	3.45	3	47.3	★	★	★	★	★	★	★	★	★	★	★	★	★		
2.5	7.2	2.00	35	CXS-07G200-7235R	4.25	3.45	3	57.3	★	★	★	★	★	★	★	★	★	★	★	★	★		

Ordering example: 2 pieces CXS-06G157-6210R

CXS-06G157-6215L

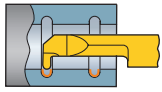
R = Right hand, L = Left hand

★ = First choice

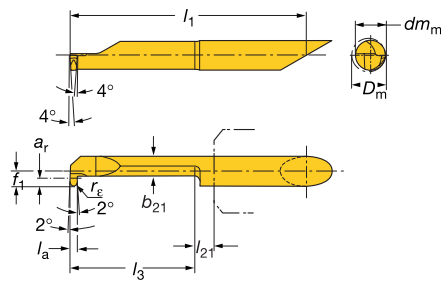


CoroTurn® XS inserts

Profiling



CXS-..R



Tolerances, mm:

 $l_a = +0.05/-0$ $r_\epsilon = \pm 0.02$ $l_1 = \pm 0.02$

Centre height:

 $+0.05/-0$

	Selection criteria, mm				Insert size	Ordering code	Dimensions, mm											
	a_r max	D_m min	l_a	l_3			dm_m	b_{21}	f_1	l_{21}	l_1	r_ϵ	P	M	N	S		
											GC	GC	GC	GC				
											1025	1025	1025	1025				
	0.8	4.2	1.00	15	04	CXS-04R100-4215R/L	2.95	1.95	3	32.3	0.50	★	★	★	★			
	0.8	4.2	1.17	15		CXS-04R058-4215R	2.95	2.45	3	32.5	0.58	★	★	★	★			
	1.0	5.2	1.00	20	05	CXS-05R100-5220R/L	3.75	2.45	3	42.3	0.50	★	★	★	★			
	1.0	5.2	1.17	20		CXS-05R058-5220R/L	3.75	2.45	3	42.5	0.58	★	★	★	★			
	1.0	5.2	1.50	20		CXS-05R150-5220R	3.75	2.45	3	42.3	0.75	★	★	★	★			
	1.0	5.2	1.63	20		CXS-05R081-5220R/L	3.75	2.45	3	42.5	0.81	★	★	★	★			
	1.0	5.2	1.98	20		CXS-05R099-5220R/L	3.75	2.45	3	42.5	0.99	★	★	★	★			
	1.0	5.2	2.00	20		CXS-05R200-5220R	3.75	2.45	3	42.3	1.00	★	★	★	★			
	1.8	6.2	1.00	25	06	CXS-06R100-6225R/L	3.95	2.95	3	47.3	0.50	★	★	★	★			
	1.8	6.2	1.17	25		CXS-06R058-6225R/L	3.95	2.95	3	47.6	0.58	★	★	★	★			
	1.8	6.2	1.50	25		CXS-06R150-6225R/L	3.95	2.95	3	47.3	0.75	★	★	★	★			
	1.8	6.2	1.63	25		CXS-06R081-6225R/L	3.95	2.95	3	47.6	0.81	★	★	★	★			
	1.8	6.2	1.98	25		CXS-06R099-6225R/L	3.95	2.95	3	47.6	0.99	★	★	★	★			
	1.8	6.2	2.00	25		CXS-06R200-6225R/L	3.95	2.95	3	47.3	1.00	★	★	★	★			
2.5	7.2	1.00	30	07	CXS-07R100-7230R/L	4.25	3.45	3	52.3	0.50	★	★	★	★				
2.5	7.2	1.17	30		CXS-07R058-7230R/L	4.25	3.45	3	52.7	0.58	★	★	★	★				
2.5	7.2	1.50	30		CXS-07R150-7230R/L	4.25	3.45	3	52.3	0.75	★	★	★	★				
2.5	7.2	1.63	30		CXS-07R081-7230R/L	4.25	3.45	3	52.7	0.81	★	★	★	★				
2.5	7.2	1.98	30		CXS-07R099-7230R/L	4.25	3.45	3	52.7	0.99	★	★	★	★				
2.5	7.2	2.00	30		CXS-07R200-7230R/L	4.25	3.45	3	52.3	1.00	★	★	★	★				
											P25	P15	M15	M20	N15	N15	S15	S15

Ordering example: 2 pieces CXS-04R100-4215R 1025

2 pieces CXS-04R100-4215L 1025

R = Right hand, L = Left hand

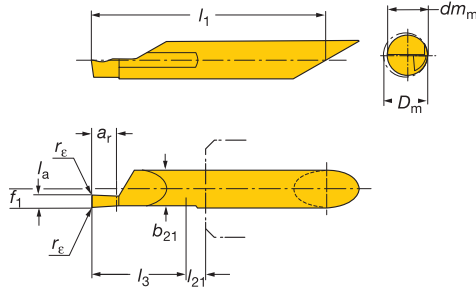
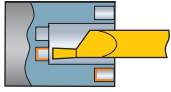
★ = First choice



CoroTurn® XS inserts

Face grooving

CXS-..F



Tolerances, mm:

- $l_a = +0.05/-0$
- $r_e = \pm 0.02$
- $l_1 = \pm 0.02$
- Centre height: $+0.05/-0$

	Selection criteria, mm					Insert size	Dimensions, mm	Material									
	a_r max	D_m min	l_a	l_3	dm_m			Ordering code	b_{21}	f_1	l_{21}	l_1	r_e	P	M	N	S
														GC	GC	GC	GC
	2.0	6.2	1.00	15	06	CXS-06F100-6215AR	6	2.95	3	37.3	0.15	★	★	★	★		
	3.0	6.2	1.50	15		CXS-06F150-6215AR	6	2.95	3	37.3	0.15	★	★	★	★		
	4.0	6.2	2.00	15		CXS-06F200-6215AR	6	2.95	3	37.3	0.15	★	★	★	★		
	5.0	6.2	2.50	15		CXS-06F250-6215AR	6	2.95	3	37.3	0.15	★	★	★	★		
	6.0	6.2	3.00	15		CXS-06F300-6215AR	6	2.95	3	37.3	0.15	★	★	★	★		

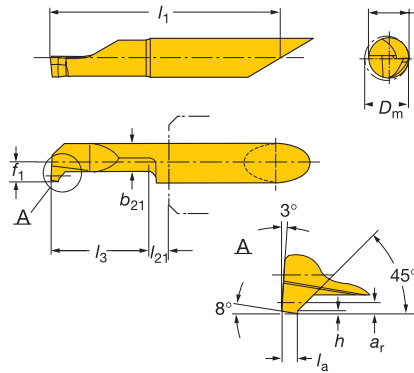
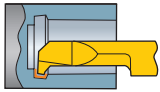
Ordering example: 2 pieces CXS-06F100-6215AR 1025

R = Right hand

★ = First choice

Pre-parting

CXS-..GX



Tolerances, mm:

- $l_a = +0.05/-0$
- $r_e = \pm 0.02$
- $l_1 = \pm 0.02$
- Centre height: $+0.05/-0$

	Selection criteria, mm					Insert size	Dimensions, mm	Material										
	a_r max	D_m min	l_a	l_3	dm_m			Ordering code	b_{21}	f_1	h	l_{21}	l_1	r_e	P	M	N	S
															GC	GC	GC	GC
	0.7	5.2	1.00	15	05	CXS-05GX100-5215R/L	3.75	2.45	0.2	3	37.3	0.50	★	★	★	★		
	0.7	5.2	1.00	20		CXS-05GX100-5220R	3.75	2.45	0.2	3	42.3	0.75	★	★	★	★		
	0.7	5.2	1.00	25		CXS-05GX100-5225R/L	3.75	2.45	0.2	3	47.3	1.00	★	★	★	★		
	0.7	5.2	1.00	30		CXS-05GX100-5230R	3.75	2.45	0.2	3	52.3	1.00	★	★	★	★		

Ordering example: 2 pieces CXS-05GX100-5215R 1025

2 pieces CXS-05GX100-5215L 1025

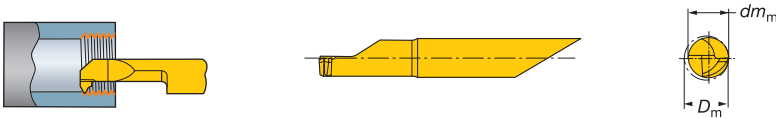
R = Right hand, L = Left hand

★ = First choice



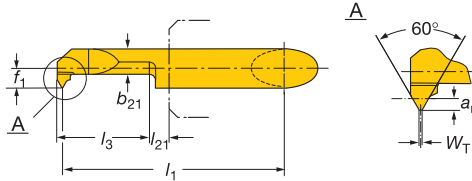
CoroTurn® XS inserts

Threading



Tolerances, mm:

$l_a = +0.05/-0$
 $r_{\epsilon} = \pm 0.02$
 $l_1 = \pm 0.02$
 Centre height:
 $+0.05/-0$



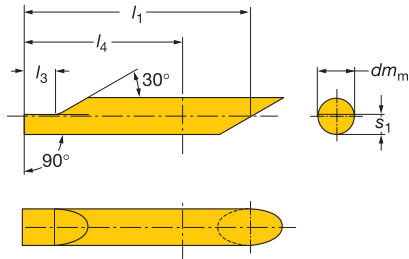
Insert size	Pitch	Dimensions, mm	Ordering code	P				M				N				S				
				GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC		
dm_m	mm t.p.i.	a_r max	b_{21}	D_m min	f_1	l_{21}	l_1	l_3	W_T	1025	1025	1025	1025	1025	1025	1025	1025	1025	1025	
 V-profile 60°	04	0.5	CXS-04TH050VM-4215R/L	0.27	2.95	4.2	1.95	3	32.3	15	0.06	★	★	★	★	★	★	★	★	★
	05	0.5	CXS-05TH050VM-5215R	0.27	3.75	5.2	2.45	3	37.3	15	0.06	★	★	★	★	★	★	★	★	★
		0.7	CXS-05TH070VM-5115R	0.40	3.65	5.1	2.35	3	37.3	15	0.09	★	★	★	★	★	★	★	★	★
		1.0	CXS-05TH100VM-4815R/L	0.55	3.55	4.8	2.25	3	37.3	15	0.12	★	★	★	★	★	★	★	★	★
	06	1.0	CXS-06TH100VM-6215R/L	0.55	3.55	6.2	2.95	3	37.3	15	0.12	★	★	★	★	★	★	★	★	★
1.2		CXS-06TH125VM-6215R/L	0.68	3.55	6.2	2.95	3	37.3	15	0.12	★	★	★	★	★	★	★	★	★	
05	28	28	CXS-05TH28WH-5215R	3.75	5.2	2.45	3	37.3	15			★	★	★	★	★	★	★	★	
		26	CXS-05TH26WH-5215R	3.75	5.2	2.45	3	37.3	15			★	★	★	★	★	★	★	★	
 Withworth 55°	06	24	CXS-05TH24WH-5215R	3.75	5.2	2.45	3	37.3	15			★	★	★	★	★	★	★	★	
		28	CXS-06TH28WH-6215R	3.95	6.2	2.95	3	37.3	15			★	★	★	★	★	★	★	★	
	26	CXS-06TH26WH-6215R	3.95	6.2	2.95	3	37.3	15			★	★	★	★	★	★	★	★	★	
		24	CXS-06TH24WH-6215R	3.95	6.2	2.95	3	37.3	15			★	★	★	★	★	★	★	★	
		22	CXS-06TH22WH-6215R	3.95	6.2	2.95	3	37.3	15			★	★	★	★	★	★	★	★	
		20	CXS-06TH20WH-6215R	3.95	6.2	2.95	3	37.3	15			★	★	★	★	★	★	★	★	
06	19	CXS-06TH19WH-6215R/L	3.95	6.2	2.95	3	37.3	15			★	★	★	★	★	★	★	★		
	27	CXS-06TH27NT-6215R	3.95	6.2	2.95	3	37.3	15			★	★	★	★	★	★	★	★		
06	18	27	CXS-06TH27NT-6215R	3.95	6.2	2.95	3	37.3	15			★	★	★	★	★	★	★	★	
		18	CXS-06TH18NT-6215R/L	3.95	6.2	2.95	3	37.3	15			★	★	★	★	★	★	★	★	
 NPT 60°												P25	P15	M15	M20	N15	N15	S15	S15	

Ordering example: 2 pieces CXS-04TH050VM-4215R
 2 pieces CXS-04TH050VM-4215L
 R = Right hand, L = Left hand
 ★ = First choice



CoroTurn® XS inserts

Blanks



Tolerances, mm:
 $l_1 = +0.25/+0.05$

Insert size	Ordering code	Dimensions, mm				Grades				
		dm_m	l_1	l_4	s_1	H10F				
04	CXS-04B-50	4.00	50.00	35.75	2.25	★				
05	CXS-04B-65	5.00	65.00	45.75	2.75	★				
06	CXS-06B-70	6.00	70.00	50.75	3.25	★				
07	CXS-07B-70	7.00	70.00	50.75	3.75	★				

Ordering example: 2 pieces CXS-04B-50 H10F

★= First choice



This catalogue has been split into smaller parts
to enhance downloading speeds.

If you want to view the next page
please click [HERE!](#)