

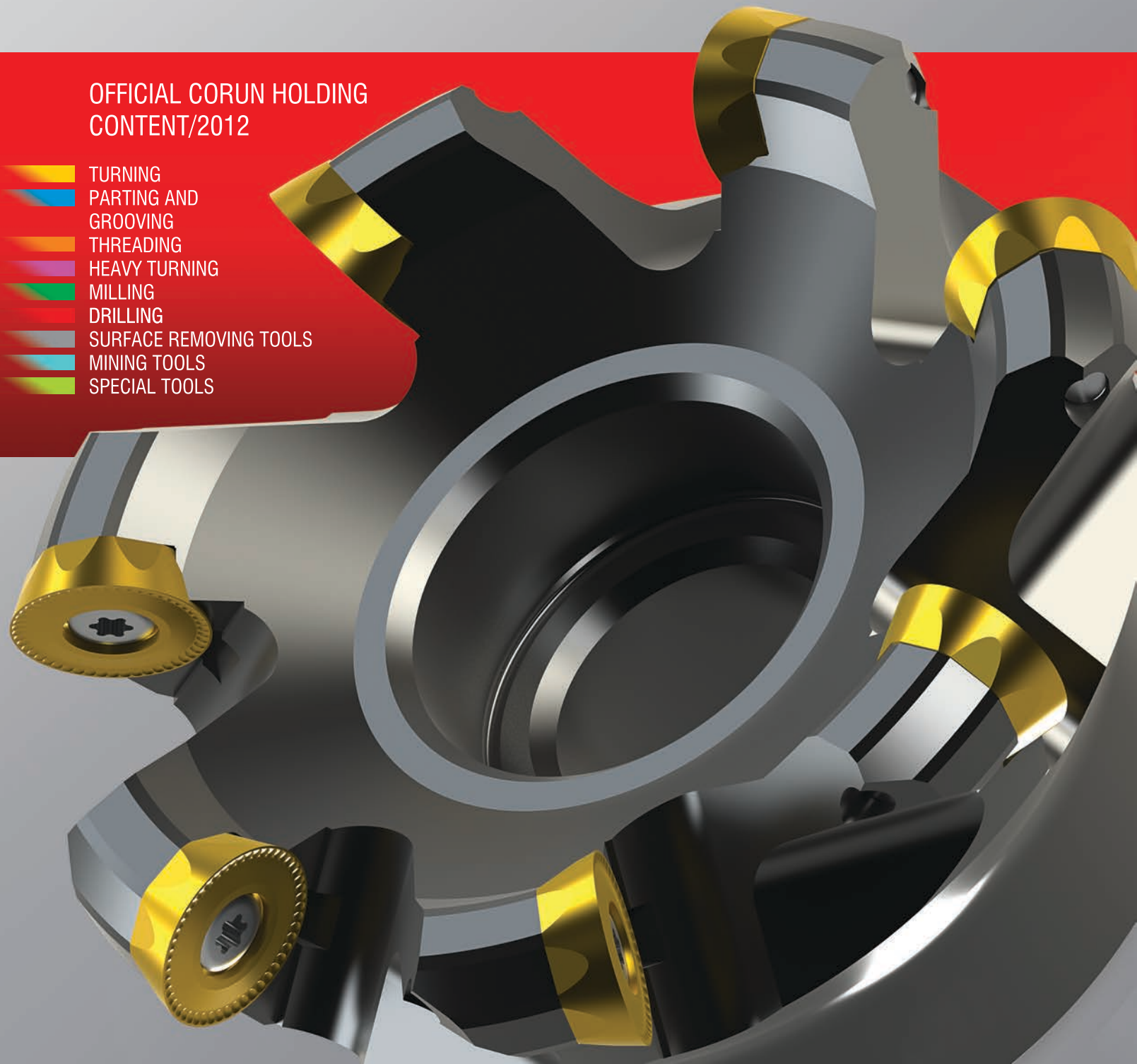


CATALOGUE/2012

THE COMPLETE RANGE OF PRODUCTS

OFFICIAL CORUN HOLDING
CONTENT/2012

-  TURNING
-  PARTING AND GROOVING
-  THREADING
-  HEAVY TURNING
-  MILLING
-  DRILLING
-  SURFACE REMOVING TOOLS
-  MINING TOOLS
-  SPECIAL TOOLS



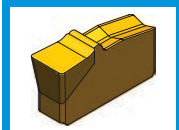
PARTING AND GROOVING

B.a Parting and grooving - inserts



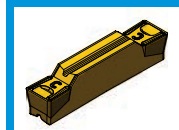
N-C51.2-...-4E

B.a2



N-C51.2-...-3B

B.a2



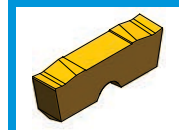
NC23J2-...

B.a3



R/L154.91-...

B.a4



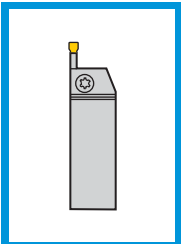
BG-154.91-...

B.a4

B

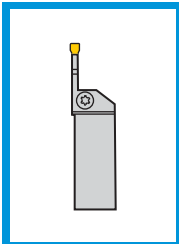
PARTING AND GROOVING

B.b Parting and grooving - toolholders



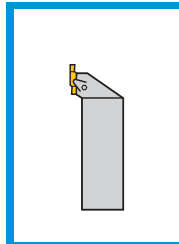
R/LFC51.22

B.b2



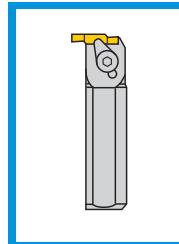
R/LFC51.23

B.b3



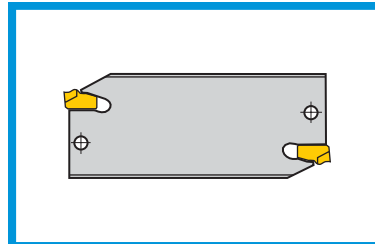
R/L 154.91

B.b4



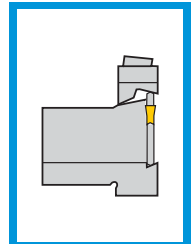
R/L 154.91

B.b4



C51.2-...-...

B.b5



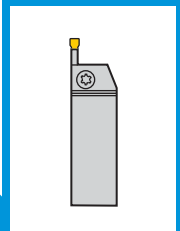
C51.2-...-...

B.b6

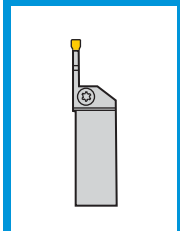
**B
a1**

PARTING AND GROOVING

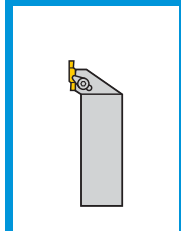
B.b Toolholders



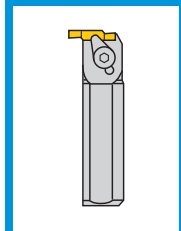
R/LFC51.22
B.b2



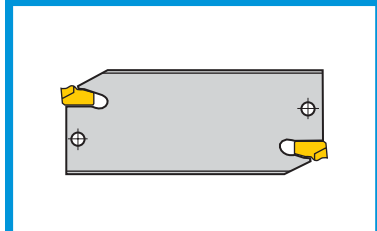
R/LFC51.23
B.b3



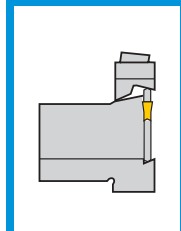
R/L 154.91
B.b4



R/L 154.91
B.b4



C51.2-...-
B.b5



C51.2-...-
B.b6

B

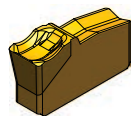
B
b1

PARTING AND GROOVING

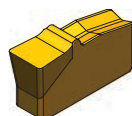
B.b S-MAX Q for grooving, profiling and turning

S-MAX Q

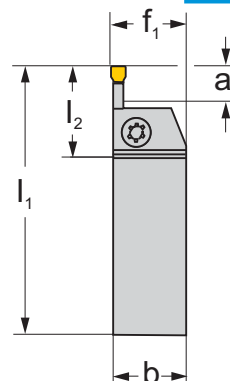
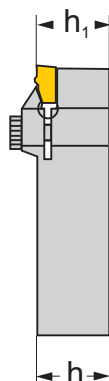
S-MAX Q
Screw clamp



N-C51.2-...



NC51.2-...



Inserts angle	Ordering code	Dimensions (mm)						Inserts seat size	Spare parts		Inserts to use
		a _r	b	f ₁	h=h ₁	l ₁	l ₂		Screw	Key	
	R/LFC51.22-1616-25	10.1	16	16.7	16	100	39	25	3312 012-259	5680 043-03	N-C51.2-250...
	R/LFC51.22-2020-25	10.1	20	20.7	20	125	39				N-C51.2-300...
	R/LFC51.22-2525-25	10.1	25	25.4	25	150	27				N-C51.2-300...
	R/LFC51.22-1616-30	10.1	16	16.7	16	100	39	30	3312 012-259	5680 043-03	N-C51.2-300...
R/LFC51.22-2020-30	10.1	20	20.7	20	125	39					
R/LFC51.22-2525-30	10.1	25	25.7	25	150	39					
R/LFC51.22-3225-30	10.1	25	25.7	32	170	39					
	R/LFC51.22-2020-40	13.1	20	20.7	20	125	41	40	3312 012-360	5680 043-07	N-C51.2-400...
	R/LFC51.22-2525-40	13.1	25	25.7	25	150	41				N-C51.2-500...
	R/LFC51.22-3225-40	13.1	25	25.7	32	170	41				N-C51.2-500...
	R/LFC51.22-2020-50	13.1	20	20.7	20	125	41	50	3312 012-360	5680 043-07	N-C51.2-500...
R/LFC51.22-2525-50	13.1	25	25.7	25	150	41					
R/LFC51.22-3225-50	13.1	25	25.7	32	170	41					

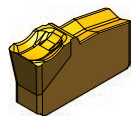
Features and benefits	Application area
<p>Screw clamp integrated in the holder</p> <ul style="list-style-type: none"> - few spare parts - easy installation and removal of inserts <p>Designed for maximum stability</p> <ul style="list-style-type: none"> - small depths of penetration 	<ul style="list-style-type: none"> - First choice for grooving, turning and profiling - Recommended for parting off thin walled tubes and slender bars

PARTING AND GROOVING

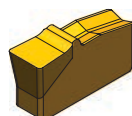
B.b S-MAX Q for parting and deep grooving

S-MAX Q

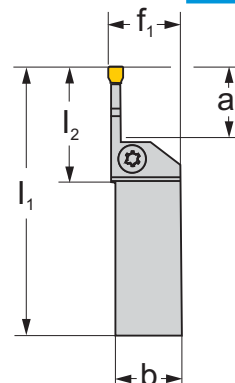
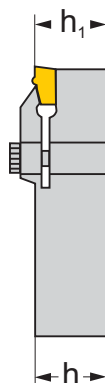
S-MAX Q Screw clamp



N-C51.2-...



NC51.2-...



B

Inserts angle	Ordering code	Dimensions (mm)						Inserts seat size	Spare parts		Inserts to use
		a _r	b	f ₁	h=h ₁	l ₁	l ₂		Screw	Key	
	R/LFC51.23-1616-25	20	16	16.7	16	100	39	25	3312 012-259	5860 043-03	N-C51.2-250...
	R/LFC51.23-2020-25	20	20	20.7	20	125	39				N-C51.2-300...
	R/LFC51.23-2525-25	20	25	26	25	150	40				N-C51.2-300...
	R/LFC51.23-1616-30	20	16	16.7	16	100	39	30	3312 012-310	5860 043-04	N-C51.2-300...
	R/LFC51.23-2020-30	20	20	20.7	20	125	39				
	R/LFC51.23-2525-30	20	25	25.7	25	150	39				
	R/LFC51.23-3225-30	20	25	25.7	32	170	39				
	R/LFC51.23-2020-40	25	20	20.7	20	125	41	40	3312 012-360	5860 043-07	N-C51.2-400...
	R/LFC51.23-2525-40	25	25	25.7	25	150	41				N-C51.2-500...
	R/LFC51.23-3225-40	25	25	25.7	32	170	41				N-C51.2-500...
	R/LFC51.23-2020-50	25	20	20.7	20	125	41	50	3312 012-360	5860 043-07	N-C51.2-500...
	R/LFC51.23-2525-50	25	25	25.7	25	150	41				
	R/LFC51.23-3225-50	25	25	25.7	32	170	41				

Features and benefits

- Screw clamp integrated in the holder
 - few spare parts
 - easy installation and removal of inserts
- Designed for large depths of penetration

Application area

- To be used when C.51.22 holders not able to provide required accessibility.
- When finish turning and profiling cutting data should be reduced somewhat.

B
b3

PARTING AND GROOVING

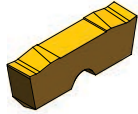
B.b Tools for turning of grooves and reliefs

S-MAX

S-MAX S
Top clamp



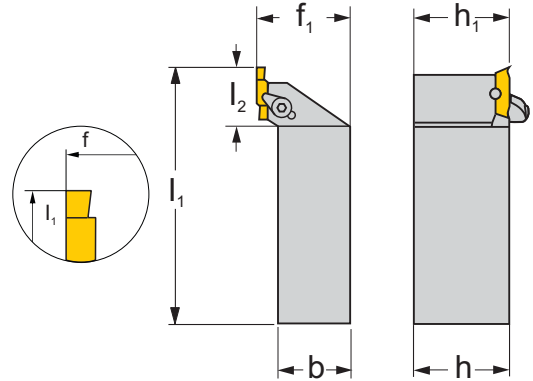
R154.91-...



BG-154.91-...

Toolholders and inserts for turning and internal grooves and reliefs are designed for use in the most modern machine tools. Accurate location satisfies the demands for precision in NC machines. When grinding the insert the toolholder can be used as a fixture.

Standard inserts for circlip grooves, from 1.10 to 5.0 mm and blanks for grinding to special profiles make this range of tools universally applicable in grooving profiling operations.

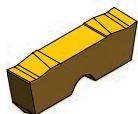


Inserts angle	Ordering code	Dimensions (mm)					Spare parts	
		h=h ₁	b	l ₁	l ₂	f	Clamp set	Pin
	R/L 154.91-1616-3	16	16	100	20.2	20	174.9-830-2	Ø3
	R/L 154.91-2020-3	20	20	125	20.2	25		
	R/L 154.91-1616-5	16	16	100	25.2	25.2	174.9-832-2	Ø3
	R/L 154.91-2020-5	20	20	125	25.2	25.2		
	R/L 154.91-2525-3 Q	25	25	150	20.2	20.2	174.9-832-2	Ø3
	R/L 154.91-2525-5 Q	25	25	150	25.2	25.2	174.9-832-2	Ø3
R/L 154.91-2525-8 Q	25	25	150	25.2	25.2	174.9-832-2	Ø3	

S-MAX S
Top clamp

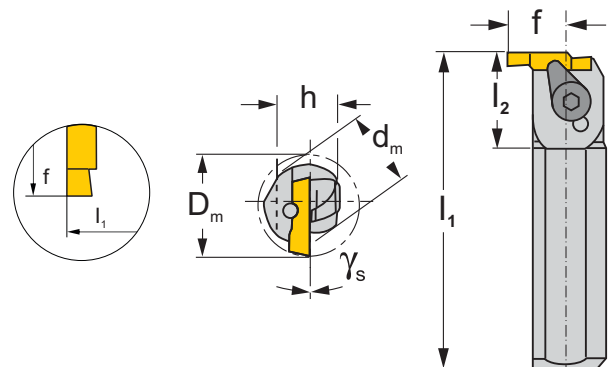


R154.91-...



BG-154.91-...

Right hand (R) tools must be used with left hand (L) inserts, and left hand (L) tools with right hand (R) inserts



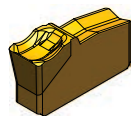
Inserts angle	Ordering code	Dimensions (mm)							Spare parts	
		d	h	l ₁	l ₂	f	D	λ	Clamp set	Pin
	R/L 154.91-16-3	16	15	150	16.9	11	20	-6	174.9-830-2	Ø3
	R/L 154.91-25-3	25	23	200	21.9	17	32	-5		
	R/L 154.91-40-3	40	37	300	31.8	27	50	0		
	R/L 154.91-25-5	25	23	200	24.1	17	32	-5	174.9-832-1	Ø3
	R/L 154.91-40-5	40	37	300	33.9	27	50	0		

PARTING AND GROOVING

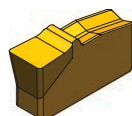
B.b S-MAX Q blades for parting

S-MAX Q

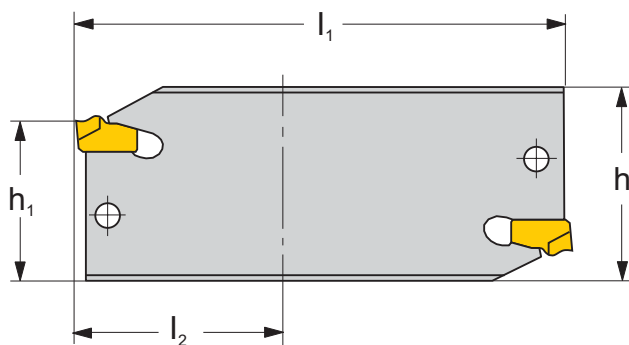
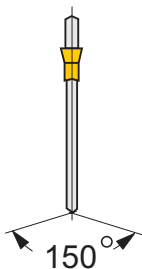
S-MAX Q
Spring clamp



N-C51.2-...



NC51.2-...



B

Inserts angle	Ordering code	Dimensions (mm) of - Blade				Inserts seat size	Spare parts	
		h	h ₁	l ₁	l _{2max}		Key	Inserts to use
	C51.2-21-25	25.9	21.4	110	45	25	5680 054-02	N-C51.2-250...
	C51.2-21-30	25.9	21.4	110	45	30		N-C51.2-300...
	C51.2-25-25	31.9	25.0	150	80	25		N-C51.2-250...
	C51.2-25-30	31.9	25.0	150	80	30		N-C51.2-300...
	C51.2-21-40	25.9	21.4	110	45	40	5680 054-01	N-C51.2-400...
	C51.2-21-50	25.9	21.4	110	45	50		N-C51.2-500...
	C51.2-25-40	31.9	25.0	150	80	40		N-C51.2-400...
	C51.2-25-50	31.9	25.0	150	80	50		N-C51.2-500...

Features and benefits

- Double ended blades**
 - two insert seats reduce tool costs
- Adjustable blade**
 - the overhang can be adjusted according to the parting depth
- Spring effect clamping**
 - secure, easy insert mounting with robust key system
- Versatility**
 - fully interchangeable with other parting system
- Coolant adaptor**
 - can be mounted and should be orderd as on optional extra

Application area

- First choice for general parting and grooving at varying parting depths
- Deep grooving
- For use in multi-spindle automatics and CNC turning centres and lathes

B
b5

PARTING AND GROOVING

B.c Cutting speed recommendations for parting and grooving


ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				2C20	2C35	2C40
				h_{ex} , mm \approx feed f_n , mm/r		
				0.05-0.5	0.05-0.5	0.05-0.5
				Cutting speed (V_c), m/min		
Steel	Unalloyed steel					
	C = 0.1 - 0.25%	2000	125	320-160	300-150	290-140
	C = 0.25 - 0.55%	2100	150	300-130	280-120	270-110
	C = 0.55 - 0.80%	2200	170	270-100	260-90	250-90
	Low - alloyed steel (alloying elements < 5%)					
	Non - hardened	2150	180	240-100	220-90	220-90
	Ball bearing steel	2300	210	230-95	210-85	210-85
	Hardened and tempered	2550	275	200-80	180-70	180-70
	Hardened and tempered	2850	350	160-60	160-50	160-50
	High - alloy steel (alloying elements < 5%)					
	Annealed	2500	200	220-80	180-60	180-60
	Hardened tool steel	3900	325	160-60	150-50	150-50
Steel casting						
Unalloyed	200	180	130-60	120-55	120-55	
Low - alloy (alloying elements \leq 5%)	2100	200	110-50	100-45	100-45	
High - alloy (alloying elements > 5%)	2650	225	90-40	80-30	80-30	


ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				2C15	2C35	7515
				h_{ex} , mm \approx feed f_n , mm/r		
				0.05-0.5	0.05-0.5	0.05-0.5
				Cutting speed (V_c), m/min		
Stainless steel	Ferritic / martensitic Bars / forged					
	Non - hardened	2300	200	130-100	110-80	130-60
	PH - hardened	3550	330	90-70	70-50	100-50
	Hardened	2850	330	90-70	70-50	100-50
	Austenitic Bars / forged					
	Austenitic	2300	180	120-90	100-70	150-70
	PH - hardened	3550	330	70-50	60-40	90-40
	Super austenitic	2950	200	80-60	70-50	100-50
	Austenitic - ferritic (Duplex) Bars / forged					
	Non - veldable \geq 0.05%C	2550	230	100-70	90-60	110-60
	Weldable < 0.05%C	3050	260	60-45	50-90	80-40
	Ferritic / martensitic Cast					
	Non - hardened	2100	200	90-60	80-50	120-60
	PH - hardened	3150	330	60-40	50-30	80-40
	Hardened	2650	330	60-40	50-30	80-40
	Austenitic Cast					
	Austenitic	2200	180	80-40	70-45	100-50
	PH - hardened	3150	330	50-30	45-25	80-40
Super austenitic	2700	200	80-40	70-45	100-50	
Austenitic - ferritic (Duplex) Cast						
Non - veldable \geq 0.05%C	2250	230	100-70	90-60	100-50	
Weldable < 0.05%C	2750	260	60-45	50-30	70-30	


ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				2C15	4C25	715
				h_{ex} , mm \approx feed f_n , mm/r		
				0.05-0.5	0.05-0.5	0.05-0.5
				Cutting speed (V_c), m/min		
Cast iron	Malleable cast iron					
	Ferritic (short chipping)	940	130	240-140	240-140	180-90
	Pearlitic (long chipping)	1100	230	180-80	180-80	120-60
	Grey cast iron					
	Low tensile strenght	1100	180	200-100	200-100	140-60
	High tensile strenght	1150	220	160-80	160-80	110-40
	Nodular SG iron					
	Ferritic	1050	160	180-90	180-90	120-50
	Pearlitic	1750	250	160-70	160-70	90-40
	Martensitic	2700	380	110-50	110-50	70-30

PARTING AND GROOVING

B.c Cutting speed recommendations for parting and grooving

					TOUGHNESS 			
4C25	720	735	7520	7535				
0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5				
320-160	200-100	170-80	200-100	170-80				
300-130	180-80	150-70	180-80	150-70				
270-100	160-70	130-60	160-70	130-60				
240-100	150-70	130-60	150-70	130-60				
230-95	140-65	120-55	140-65	120-55				
200-80	130-60	110-50	130-60	110-50				
160-60	110-50	90-40	110-50	90-40				
220-80	140-60	120-50	140-60	120-50				
160-60	100-40	80-35	100-40	80-35				
130-60	90-50	80-40	90-50	80-40				
110-50	80-45	70-35	80-45	70-35				
90-40	60-30	50-30	60-30	50-30				

					TOUGHNESS 			
7520	7535	K13A	P6					
0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5					
130-60	110-60	80-60	80-40					
100-50	90-40	50-35	50-30					
100-50	90-40	60-35	50-30					
150-70	120-70	80-50	80-50					
90-40	90-40	45-30	45-30					
100-50	100-50	50-30	50-30					
110-60	90-50	-	-					
80-40	60-30	-	-					
120-60	90-50	60-40	50-35					
80-40	60-30	40-30	35-20					
80-40	60-30	40-30	35-20					
100-50	80-40	60-30	50-30					
80-40	60-30	40-20	35-15					
100-50	80-40	60-30	50-30					
100-50	80-40	-	-					
70-30	50-25	-	-					

					TOUGHNESS 			
720	7515	7520	K13A	K10F				
0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5	0.05-0.5				
180-90	180-90	180-95	80-60	80-60				
120-60	120-60	120-60	60-40	60-40				
140-60	140-60	140-60	70-50	70-50				
110-40	110-40	110-40	70-50	70-50				
120-50	120-50	120-50	60-40	60-40				
90-40	90-40	90-40	50-30	50-30				
70-30	70-30	70-30	40-20	40-20				

PARTING AND GROOVING

B.c Cutting speed recommendations for parting and grooving

ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				715	720	7515
				h_{ex} , mm \approx feed f_n , mm/r		
				0.05-0.8	0.05-0.8	0.05-0.8
Cutting speed (V_c), m/min						
Non - ferrous metals	Aluminium alloys					
	Wrought or wrought and coldworked, non - aging	500	60	1200(1500-150)	1200(1500-150)	1200(1500-150)
	Wrought or wrought and aged	800	100	1200(1500-150)	1200(1500-150)	1200(1500-150)
	Aluminium alloys					
Cast, non - aging	750	75	1200(1500-150)	1200(1500-150)	1200(1500-150)	
Cast or cast and aged	900	90	1200(1500-150)	1200(1500-150)	1200(1500-150)	
N	Aluminium alloys					
	Cast, 13 - 15% Si	950	130	300(400-50)	300(400-50)	300(400-50)
	Cast, 16 - 22% Si	950	130	200(250-30)	200(250-30)	200(250-30)
	Copper and copper alloys					
	Free cutting alloys, \leq 1% Pb	700	110	300(400-50)	300(400-50)	300(400-50)
	Brass, leaded bronzes, \leq 1% Pb	700	90	350(450-55)	350(450-55)	350(450-55)
Bronze and non - leadad copper, included electrolytic copper	1750	100	200(250-30)	200(250-30)	200(250-30)	

ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				715	720	7515
				h_{ex} , mm \approx feed f_n , mm/r		
				0.05-0.3	0.05-0.3	0.05-0.3
Cutting speed (V_c), m/min						
Heat resistant material	Heat resistant super alloy					
	Iron base					
	Annealed or solution treated	3000	200	55-30	55-30	55-30
	Aged or solution treated and aged	3050	280	40-25	40-25	40-25
	Nickel base					
	Annealed or solution treated	3300	250	40-25	40-25	40-25
	Aged or solution treated and aged	3600	350	35-15	35-15	35-15
	Cast or cast and aged	3700	320	30-10	30-10	30-10
	Cobalt base					
	Annealed or solution treated	3300	200	40-25	40-25	40-25
	Aged or solution treated and aged	3700	300	30-15	30-15	30-15
	Cast or cast and aged	3800	320	25-10	25-10	25-10
S	Titanium alloys		Rm			
	Commercial pure (99.5% Ti)	1550	400	160-80	160-80	160-80
	α , near α and $\alpha+\beta$ alloys, annealed	1700	950	50-30	50-30	50-30
	$\alpha+\beta$ alloys in aged conditions, β alloys, annealed or aged	1700	1050	45-25	45-25	45-25

ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				h_{ex} , mm \approx feed f_n , mm/r		
				Cutting speed (V_c), m/min		
Hardened material	Hard steel					
	Hardened and tempered	3250	45HRC			
		3950	50HRC			
		4700	55HRC			
	Extra hard steel					
	Hardened and tempered	5550	60HRC			
	6450	65HRC				
H	Chilled cast iron					
	Cast or cast and aged	2800	400			

PARTING AND GROOVING

B.c First choice grade recommendations

ISO	Material	TYPES OF MACHINING											
		FINISHING				MEDIUM				ROUGHING			
		a _p	f _n	V _c	GRADE	a _p	f _n	V _c	GRADE	a _p	f _n	V _c	GRADE
mm	mm/r	m/min	-	mm	mm/r	m/min	-	mm	mm/r	m/min	-		
Steel	Unalloyed steel C = 0.1 - 0.25% C = 0.25 - 0.55% C = 0.55 - 0.80%												
			0.05	180	7520		0.10	200	2C35		0.15	150	2C35
			0.05	160	7520		0.10	160	2C35		0.15	100	2C35
		0.05	140	7520		0.10	130	2C35		0.15	80	2C35	
	Low - alloyed steel (alloying elements < 5%) Non - hardened Ball bearing steel Hardened and tempered Hardened and tempered												
			0.05	130	7520		0.10	160	2C35		0.15	80	2C35
			0.05	120	7520		0.10	150	2C35		0.15	70	2C35
			0.05	110	7520		0.10	130	2C35		0.15	60	2C35
			0.05	90	7520		0.10	100	2C35		0.15	40	2C35
	High - alloy steel (alloying elements < 5%) Annealed Hardened tool steel												
			0.05	120	7520		0.10	130	2C35		0.15	60	2C35
			0.05	80	7520		0.10	100	2C35		0.15	40	2C35
Steel casting Unalloyed Low - alloy (alloying elements ≤ 5%) High - alloy (alloying elements > 5%)													
		0.05	80	7520		0.10	100	2C35		0.15	50	2C35	
		0.05	70	7520		0.10	80	2C35		0.15	40	2C35	
	0.05	50	7520		0.10	70	2C35		0.15	30	2C35		

ISO	Material	TYPES OF MACHINING											
		FINISHING				MEDIUM				ROUGHING			
		a _p	f _n	V _c	GRADE	a _p	f _n	V _c	GRADE	a _p	f _n	V _c	GRADE
mm	mm/r	m/min	-	mm	mm/r	m/min	-	mm	mm/r	m/min	-		
Stainless steel	Ferritic / martensitic Bars / forged Non - hardened PH - hardened Hardened												
			0.05	100	7520		0.10	70	7535		0.15	50	7535
			0.05	80	7520		0.10	60	7535		0.15	40	7535
		0.05	80	7520		0.10	60	7535		0.15	40	7535	
	Austenitic Bars / forged Austenitic PH - hardened Super austenitic												
			0.05	110	7520		0.10	80	7535		0.15	60	7535
			0.05	80	7520		0.10	60	7535		0.15	40	7535
		0.05	90	7520		0.10	70	7535		0.15	40	7535	
	Austenitic - ferritic (Duplex) Bars / forged Non - veldable ≥ 0.05%C Weldable < 0.05%C												
			0.05	100	7520		0.10	80	7535		0.15	50	7535
		0.05	70	7520		0.10	50	7535		0.15	30	7535	
	Ferritic / martensitic Cast Non - hardened PH - hardened Hardened												
		0.05	110	7520		0.10	90	7535		0.15	60	7535	
		0.05	70	7520		0.10	50	7535		0.15	30	7535	
	0.05	60	7520		0.10	50	7535		0.15	30	7535		
Austenitic Cast Austenitic PH - hardened Super austenitic													
		0.05	90	7520		0.10	70	7535		0.15	50	7535	
		0.05	70	7520		0.10	50	7535		0.15	30	7535	
	0.05	90	7520		0.10	70	7535		0.15	30	7535		
Austenitic - ferritic (Duplex) Cast Non - veldable ≥ 0.05%C Weldable < 0.05%C													
		0.05	80	7520		0.10	60	7535		0.15	40	7535	
	0.05	60	7520		0.10	40	7535		0.15	30	7535		

ISO	Material	TYPES OF MACHINING											
		FINISHING				MEDIUM				ROUGHING			
		a _p	f _n	V _c	GRADE	a _p	f _n	V _c	GRADE	a _p	f _n	V _c	GRADE
mm	mm/r	m/min	-	mm	mm/r	m/min	-	mm	mm/r	m/min	-		
Cast iron	Malleable cast iron Ferritic (short chipping) Pearlitic (long chipping)												
			0.05	200	2C15		0.10	180	4C25		0.15	120	4C25
		0.05	160	2C15		0.10	140	4C25		0.15	70	4C25	
Grey cast iron Low tensile strenght High tensile strenght													
		0.05	160	2C15		0.10	140	4C25		0.15	140	4C25	
		0.05	130	2C15		0.10	110	4C25		0.15	60	4C25	
Nodular SG iron Ferritic Pearlitic Martensitic													
		0.05	150	2C15		0.10	130	4C25		0.15	70	4C25	
		0.05	120	2C15		0.10	110	4C25		0.15	50	4C25	
	0.05	70	2C15		0.10	70	4C25		0.15	30	4C25		

PARTING AND GROOVING

B.c First choice grade recommendations

ISO	Material	TYPES OF MACHINING											
		FINISHING				MEDIUM				ROUGHING			
		a _p mm	f _n mm/r	V _c m/min	GRADE	a _p mm	f _n mm/r	V _c m/min	GRADE	a _p mm	f _n mm/r	V _c m/min	GRADE
Non - ferrous metals	Aluminium alloys Wrought or wrought and coldworked, non - aging												
			0.10	500	7520		0.20	500	7520		0.20	500	7520
	Wrought or wrought and aged		0.10	500	7520		0.20	500	7520		0.20	500	7520
			0.10	500	7520		0.20	500	7520		0.20	500	7520
	Aluminium alloys Cast, non - aging		0.10	500	7520		0.20	500	7520		0.20	500	7520
		Cast or cast and aged		0.10	500	7520		0.20	500	7520		0.20	500
N	Aluminium alloys Cast, 13 - 15% Si		0.10	200	7520		0.20	200	7520		0.20	200	7520
			0.10	150	7520		0.20	150	7520		0.20	150	7520
	Cast, 16 - 22% Si												
Copper and copper alloys Free cutting alloys, ≤ 1% Pb		0.10	200	7520		0.20	200	7520		0.20	200	7520	
	Brass, leaded bronzes, ≤ 1% Pb		0.10	200	7520		0.20	200	7520		0.20	200	7520
	Bronze and non - leaded copper, included electrolytic copper		0.10	150	7520		0.20	150	7520		0.20	150	7520

ISO	Material	TYPES OF MACHINING												
		FINISHING				MEDIUM				ROUGHING				
		a _p mm	f _n mm/r	V _c m/min	GRADE	a _p mm	f _n mm/r	V _c m/min	GRADE	a _p mm	f _n mm/r	V _c m/min	GRADE	
Heat resistant material	Heat resistant super alloy Iron base Annealed or solution treated		0.05	40	7520		0.10	35	7520		0.15	30	7520	
		Aged or solution treated and aged		0.05	30	7520		0.10	30	7520		0.15	25	7520
	Nickel base Annealed or solution treated		0.05	30	7520		0.10	25	7520		0.15	20	7520	
		Aged or solution treated and aged		0.05	30	7520		0.10	25	7520		0.15	20	7520
		Cast or cast and aged		0.05	25	7520		0.10	20	7520		0.15	15	7520
	Cobalt base Annealed or solution treated		0.05	30	7520		0.10	25	7520		0.15	20	7520	
		Aged or solution treated and aged		0.05	30	7520		0.10	25	7520		0.15	20	7520
		Cast or cast and aged		0.05	25	7520		0.10	20	7520		0.15	15	7520
	Titanium alloys Commercial pure (99.5% Ti)		0.05	100	7520		0.10	90	7520		0.15	80	7520	
		α, near α and α+β alloys, annealed		0.05	40	7520		0.10	35	7520		0.15	30	7520
α+β alloys in aged conditions, β alloys, annealed or aged			0.05	30	7520		0.10	25	7520		0.15	20	7520	

ISO	Material	TYPES OF MACHINING											
		FINISHING				MEDIUM				ROUGHING			
		a _p mm	f _n mm/r	V _c m/min	GRADE	a _p mm	f _n mm/r	V _c m/min	GRADE	a _p mm	f _n mm/r	V _c m/min	GRADE
Hardened material	Hard steel Hardened and tempered												
	Extra hard steel Hardened and tempered												
H	Chilled cast iron Cast or cast and aged												

PARTING AND GROOVING

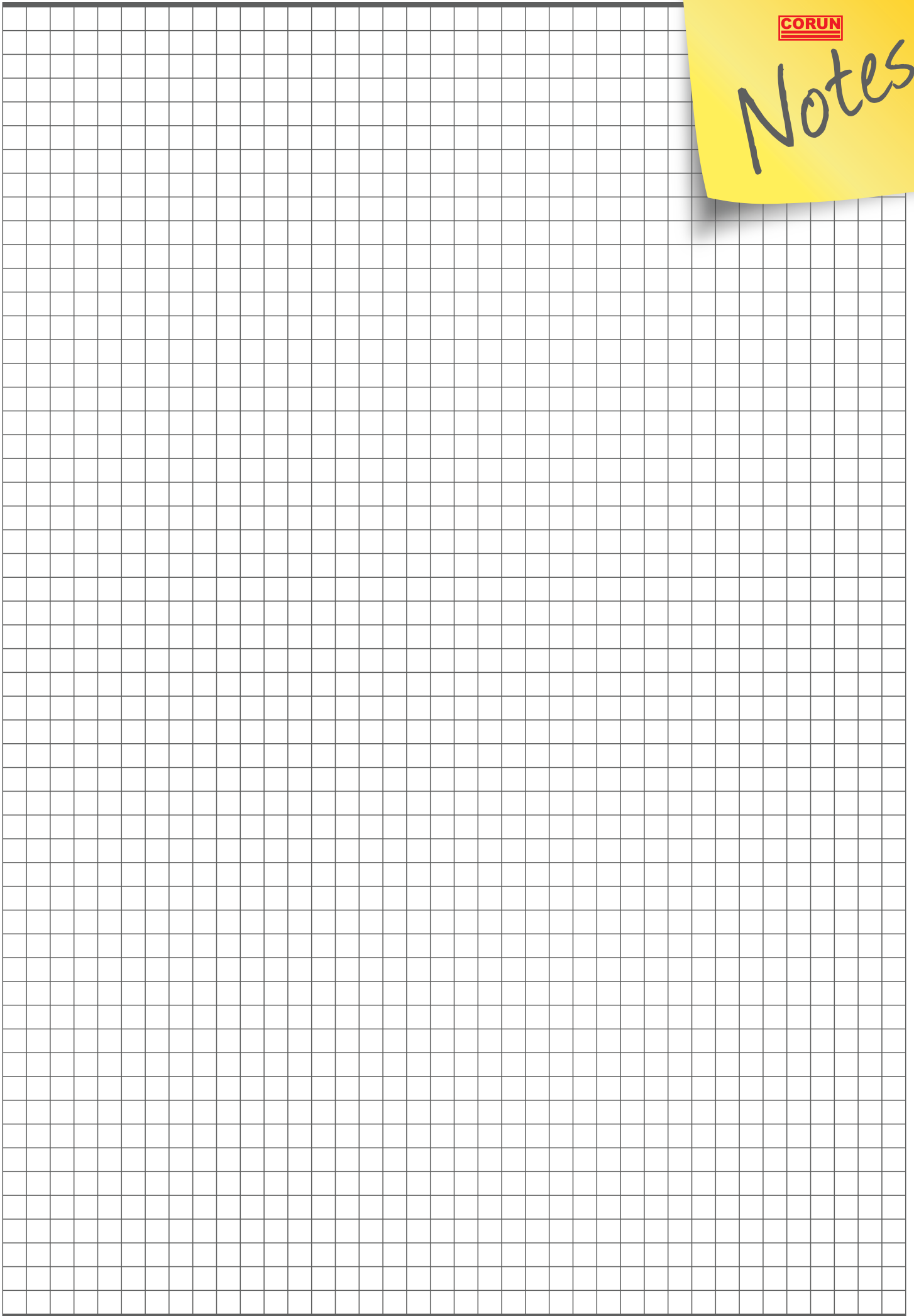
B.c Technical information - grades for parting and grooving inserts

ISO

P	ISO	ANSI	BASIC GRADES				SUPPLEMENTARY GRADES				TOUGHNES	WEAR RESISTANCE	
			2C	4C	7C	7S	7	K	P				
steel, cast steel, long chipping, malleable, iron.	01	C8											
	05												
	10												
	15												
	20												
	25												
	30												
	35												
	40												
	45												
50													
steel, cast steel, manganese steel, alloy cast iron, austenitic steels, malleable iron, free cutting steel.	01												
	05												
	10												
	15												
	20												
	25												
	30												
	35												
	40												
	cast iron, chilled cast iron, short chipping malleable iron, hardened steel, non ferrous metals, plastics, wood.	01	C4										
05													
10													
15													
20													
25													
30													
35													
40													
non ferrous metals.		01		C3									
	05												
	10												
	15												
	20												
	25												
	30												
	35												
	40												
	heat resistans super alloys.	01	C2										
05													
10													
15													
20													
25													
30													
35													
40													
hardened materials.		01		C1									
	05												
	10												
	15												
	20												
	25												
	30												
	35												
	40												

CORUN

Notes



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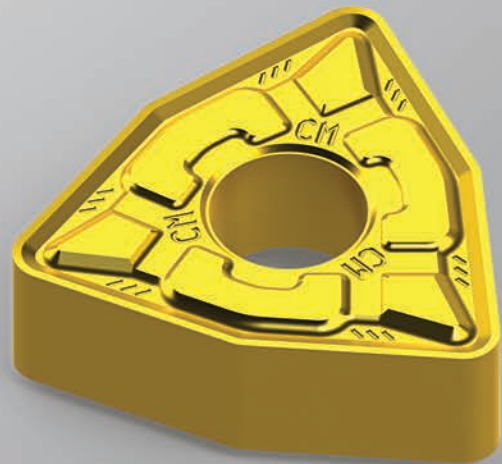
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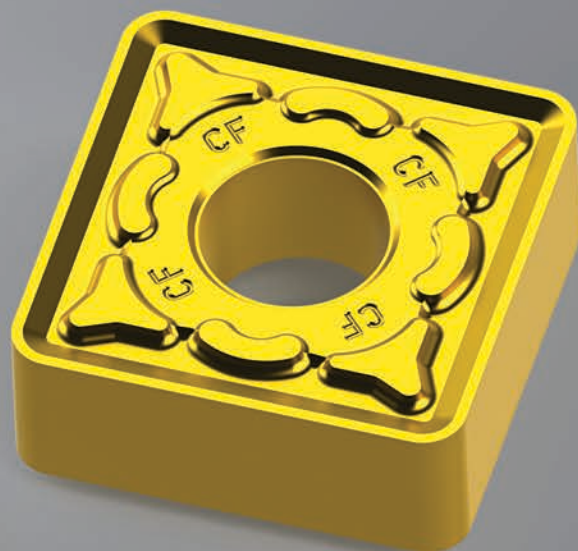
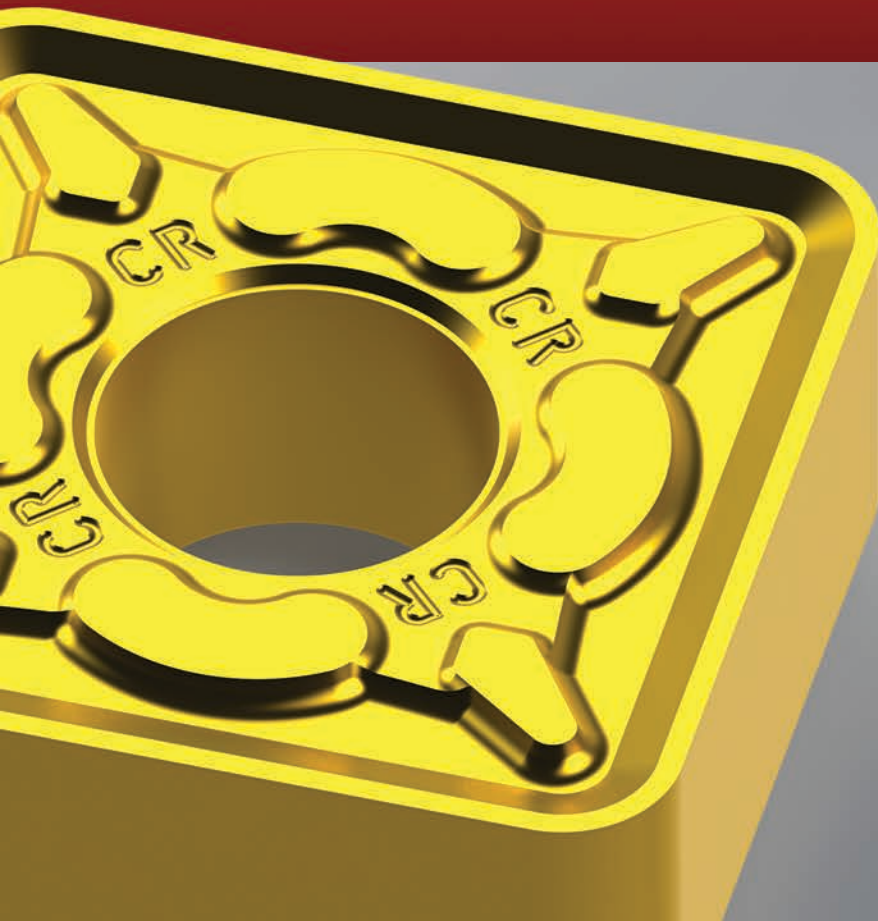
ABOUT COMPANY

CORUN HOLDING d.o.o. Užice, Serbia is factory for production of cemented carbide indexable inserts, toolholders, milling cutters and other special cutting tools based on cemented carbide.

Also, we produce tools for road and mining industry (picks for asphalt removing, cutters for canal digging, mining drill for deep hole drilling), as well as tools for cold heading and forming (cemented carbide dies for forging, pulling, squeamishing - all with corresponding pins).

CORUN HOLDING d.o.o has their own development and construction bureau, so we have a opportunity to give our customers complete technological answers for all problems in cutting industry.

One of the main target of **CORUN HOLDING** d.o.o. company is to be available all the time for our customers worldwide and to respond on all of Yours requests as soon as possible in order to make the best solutions together.



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