

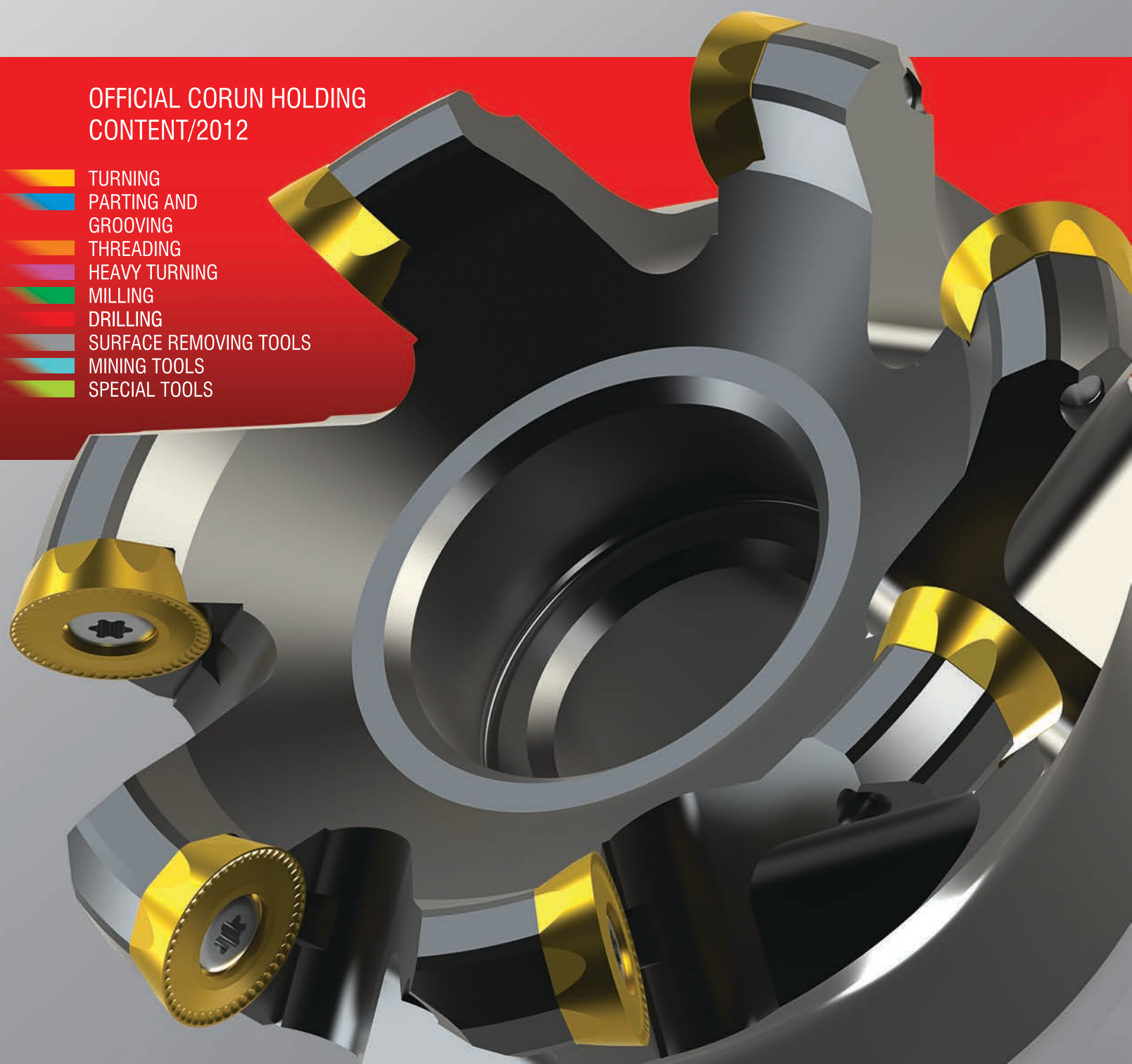


CATALOGUE/2012

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

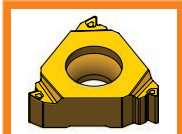


THREADING

C.a S-MAX U and S-MAX inserts for threading

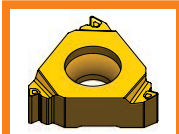
S-MAX U

S-MAX



RS66.OS...

C.a2



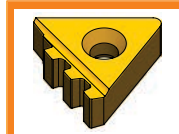
RS66.OU...

C.a2



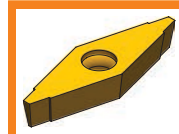
TI-15.1NR-2.

C.a3



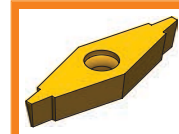
TI-22.1ER-5.

C.a3



RP-013..-00

C.a4



RP-013..-00

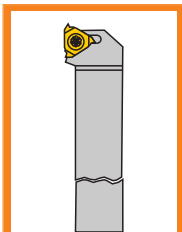
C.a5

C

THREADING

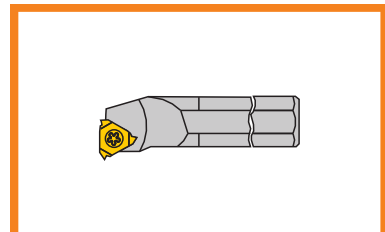
C.b Toolholders for threading

S-MAX



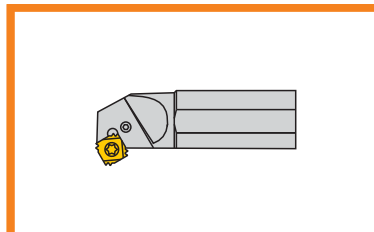
RS66.OFG-

C.b1



RS66.OKF-

C.b1



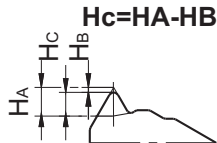
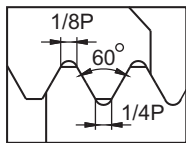
S40S-PSWNR

C.b2

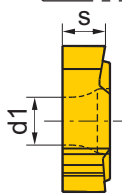
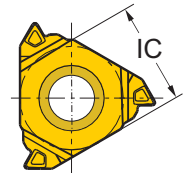
C
a1

C.a S-MAX inserts

S-MAX

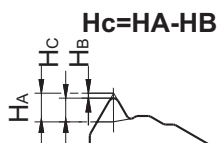
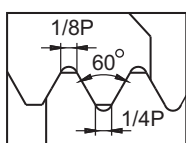


Dimensions	IC	d1	s			
16	9.525	4.4	3.97			

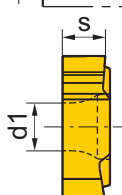
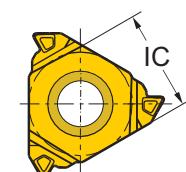


Insert for external metric thread

S-MAX	Ordering code	Dimensions (mm)			P		M		K		N		S		H											
		HA	HB	Pitch	CVD	PVD	CVD	PVD	CVD	PVD	CVD	PVD	CVD	PVD	CVD	PVD										
16	RS66.OS-16MM01-100	0.75	0.15	1.0	2C25 P25	2C35 P35	7515 P15	7520 P20	2C15 M25	2C35 M35	7515 M15	7520 M20	-	2C15 K15	2C25 K25	7515 K15	7520 K20	K13A K20	7520 N20	K13A N20	7515 S15	7520 S20	K13A S15	K10F S20	715 H15	7520 H20
	RS66.OS-16MM01-150	1.12	0.22	1.5	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	RS66.OS-16MM01-200	1.50	0.29	2.0	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●



Dimensions	IC	d1	s			
16	9.525	4.4	3.97			



Insert for internal thread

S-MAX	Ordering code	Dimensions (mm)			P		M		K		N		S		H												
		HA	HB	Pitch	CVD	PVD	CVD	PVD	CVD	PVD	CVD	PVD	CVD	PVD	CVD	PVD											
16	RS66.OU-16MM01-100	0.75	0.15	1.0	2C25 P25	2C35 P35	7515 P15	7520 P20	2C15 M25	2C35 M35	7515 M15	7520 M20	-	2C15 K15	2C25 K25	7515 K15	7520 K20	K13A K20	7520 N20	K13A N20	7515 S15	7520 S20	K13A S15	K10F S20	715 H15	7520 H20	
	RS66.OU-16MM01-150	1.12	0.22	1.5	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●
	RS66.OU-16MM01-200	1.50	0.29	2.0	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●	●



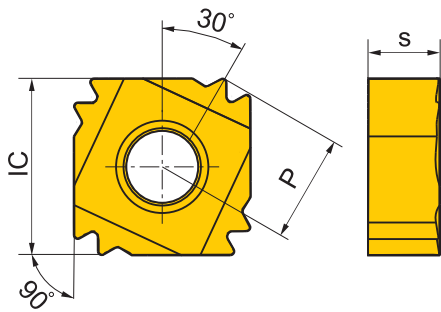
C

C
a2

THREADING

C.a S-MAX inserts

S-MAX



Dimensions	IC	d1	s	P		
16	12.700	4.2	5.92	5.08		

C

S-MAX

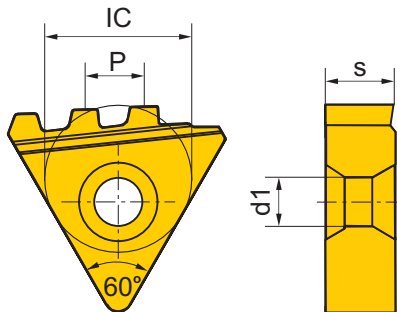


Ordering code

16 TI-15.1NR-2.54WMO



P		M		K		N		S		H											
CVD	PVD	CVD	PVD	-	CVD	PVD	-	PVD	-	PVD	H20										
2C25 P25	2C35 P35	7515 P15	7520 P20	2C15 M25	2C35 M35	7515 M15	7520 M20	K13A M20	2C15 K15	2C25 K25	7515 K15	7520 K20	K13A K20	7520 N20	K13A N20	7515 S15	7520 S20	K13A S15	K10F S20	715 H15	7520 H20



Dimensions	IC	d1	s	P		
16	12.700	4.2	5.92	5.08		

S-MAX



Ordering code

16 TI-22.1ER-5.08TRO



P		M		K		N		S		H											
CVD	PVD	CVD	PVD	-	CVD	PVD	-	PVD	-	PVD	H20										
2C25 P25	2C35 P35	7515 P15	7520 P20	2C15 M25	2C35 M35	7515 M15	7520 M20	K13A M20	2C15 K15	2C25 K25	7515 K15	7520 K20	K13A K20	7520 N20	K13A N20	7515 S15	7520 S20	K13A S15	K10F S20	715 H15	7520 H20

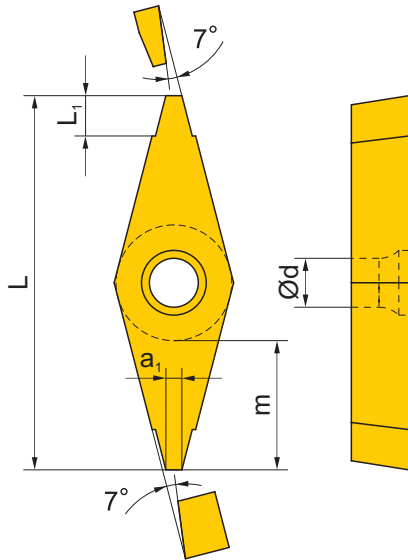
C
a3

● First choice ● Second choice



C.a Inserts for cutting of trapezoidal threading - finishing

S-MAX U



Dimensions	L	L ₁	m	a ₁	Ød
RP-01375-00	26.00	2.80	8.98	1.11	4.50
RP-01377-00	25.30	3.40	8.63	1.46	4.50
RP-01379-00	21.00	4.39	6.48	2.22	4.50
RP-01381-00	24.00	4.25	7.98	1.87	4.50
RP-01385-00	26.00	3.40	8.98	1.24	4.50
RP-01387-00	21.18	4.70	6.57	2.56	4.50

	P		M		K		N		S		H	
	CVD	PVD	CVD	PVD	CVD	PVD	CVD	PVD	CVD	PVD	CVD	PVD
2C25	P25											
2C35	P35											
7515	P15											
7520	P20											
2C15	M25											
2C35	M35											
7515	M15											
7520	M20											
K13A	M20											
2C15	K15											
2C25	K25											
7515	K15											
7520	K20											
K13A	K20											
7520	N20											
K13A	N20											
7515	S15											
7520	S20											
K13A	S15											
K10F	S20											
715	H15											
7520	H20											

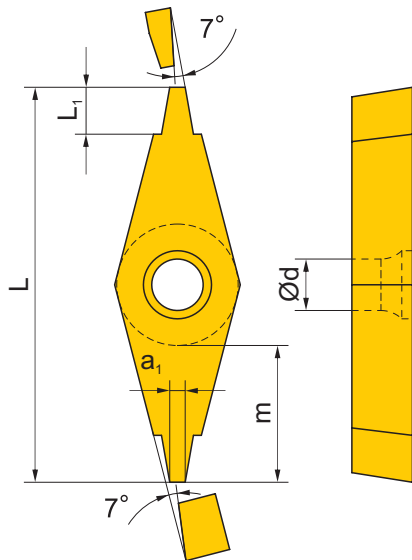
S-MAX U	Ordering code
	RP-01375-00
	RP-01377-00
	RP-01379-00
	RP-01381-00
	RP-01385-00
	RP-01387-00

C

C
a4

C.a Inserts for cutting of trapezoidal threading - roughing

S-MAX U

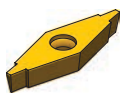


Dimensions	L	L ₁	m	a ₁	Ød
RP-01361-00	26.10	3.10	9.030	1.02	4.50
RP-01363-00	25.4	3.32	8.680	1.38	4.50
RP-01365-00	21.00	4.42	6.480	2.15	4.50
RP-01367-00	24.23	4.30	8.095	1.75	4.50
RP-01371-00	26.10	3.10	9.030	1.18	4.50
RP-01373-00	21.34	4.70	6.65	2.50	4.50

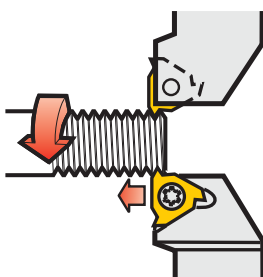
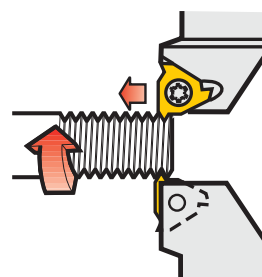
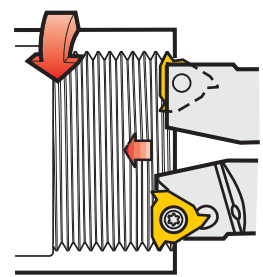
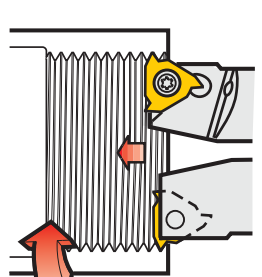
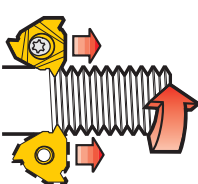
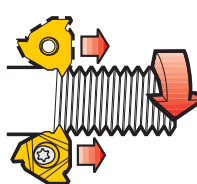


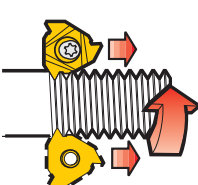
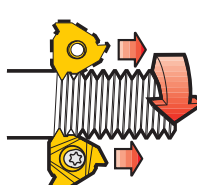
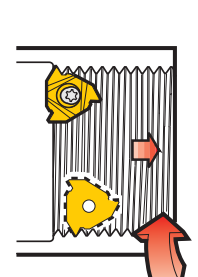
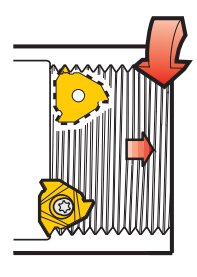
C

	P		M		K		N		S		H		
	CVD	PVD	CVD	PVD	-	CVD	PVD	-	PVD	-	CVD	PVD	
2C25	P25		2C15	M25		2C25	K25		2C15	N20		2C15	H20
2C35	P35		2C35	M35		2C25	K25		2C15	N20		2C15	H20
7515	P15		7520	P20		7515	K15		7520	S20		7515	H15
7520	P20		7515	M15		7515	K15		7515	S15		7515	H15
7520	M20		7520	M20		7520	K20		7520	S20		7520	H20
K13A	M20		K13A	M20		K13A	K20		K13A	S15		K13A	S15
2C15	K15		2C15	K15		2C25	K25		2C15	N20		2C15	H20
7515	K15		7515	K15		7515	K15		7515	S15		7515	H15
7520	K20		7520	K20		7520	K20		7520	S20		7520	H20
K13A	K20		K13A	K20		K13A	K20		K13A	S15		K13A	S15
7520	N20		7520	N20		7520	N20		7520	S20		7520	H20
K13A	N20		K13A	N20		K13A	N20		K13A	S15		K13A	S15
7515	S15		7515	S15		7515	S15		7515	S15		7515	H15
7520	S20		7520	S20		7520	S20		7520	S20		7520	H20
K13A	S15		K13A	S15		K13A	S15		K13A	S15		K13A	S15
K10F	S20		K10F	S20		K10F	S20		K10F	S20		K10F	S20
715	H15		715	H15		715	H15		715	H15		715	H15
7520	H20		7520	H20		7520	H20		7520	H20		7520	H20

S-MAX U	Ordering code
RP-01361-00	
RP-01363-00	
RP-01365-00	
RP-01367-00	
RP-01371-00	
RP-01373-00	



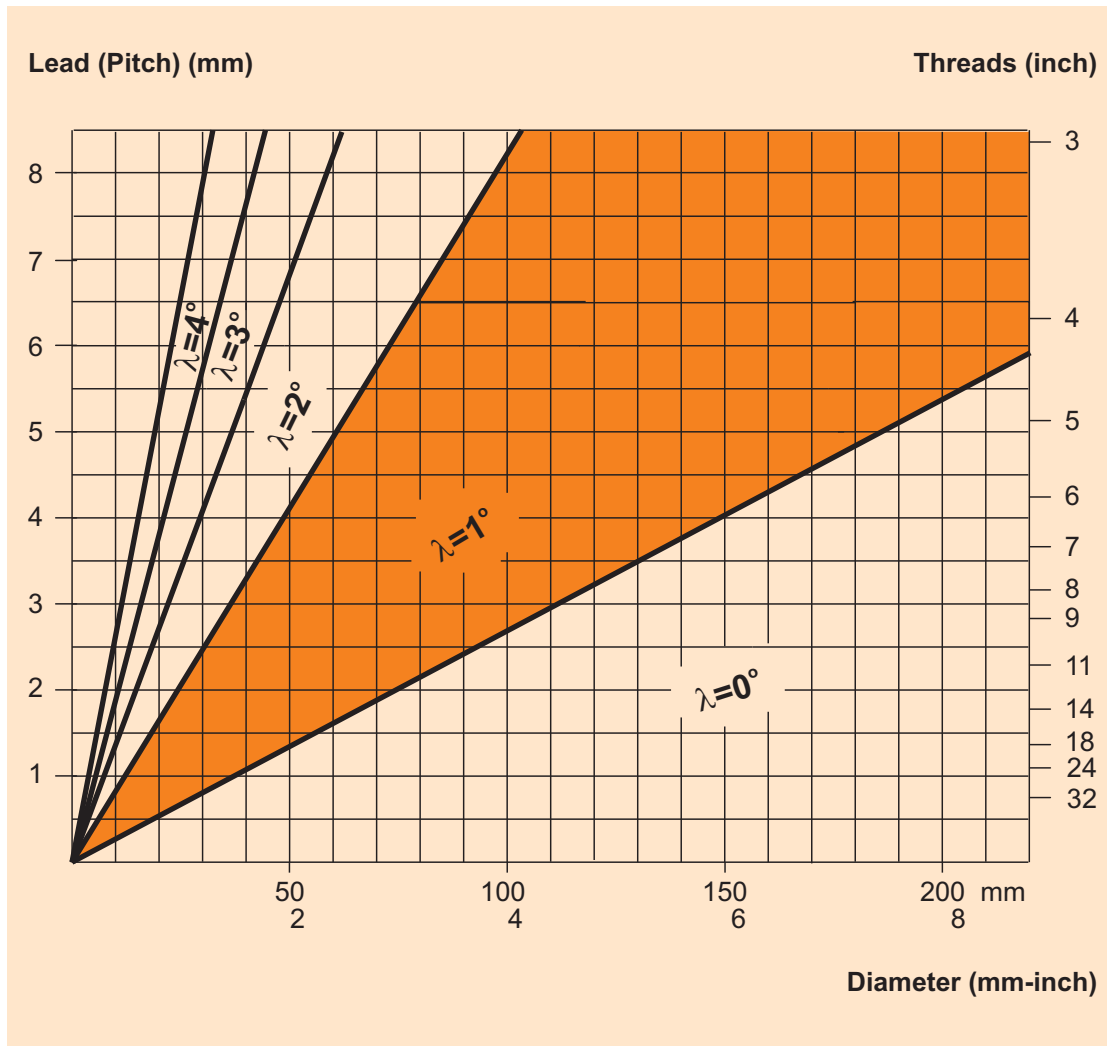
C.c Technical information

1. Methods for external threading		2. Methods for internal threading	
<p>Right hand threads</p>  <p>Left hand threads</p> 	<p>Right hand threads</p>  <p>Left hand threads</p> 		
Right hand tools/inserts	Left hand tools/inserts	Right hand tools/inserts	Left hand tools/inserts
			
Right hand tools/inserts	Left hand tools/inserts	Right hand tools/inserts	Left hand tools/inserts
			
Right hand tools/inserts	Left hand tools/inserts	Right hand tools/inserts	Left hand tools/inserts
<p>Note: negative helix angle</p>		<p>Note: negative helix angle</p>	

C

C.c Technical information

3. Choosing an angle of inclination



Formula for calculating the angle of inclination

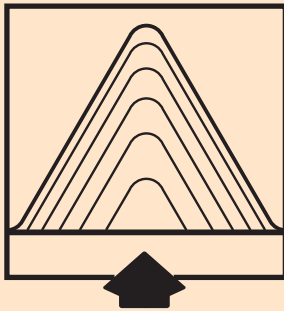
$$\operatorname{tg} \lambda = \frac{P}{D \times \pi}$$

P=Pitch
 D=Effective diameter of thread
 λ=Angle of inclination

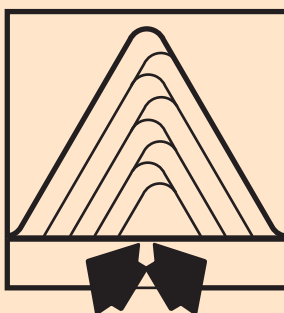
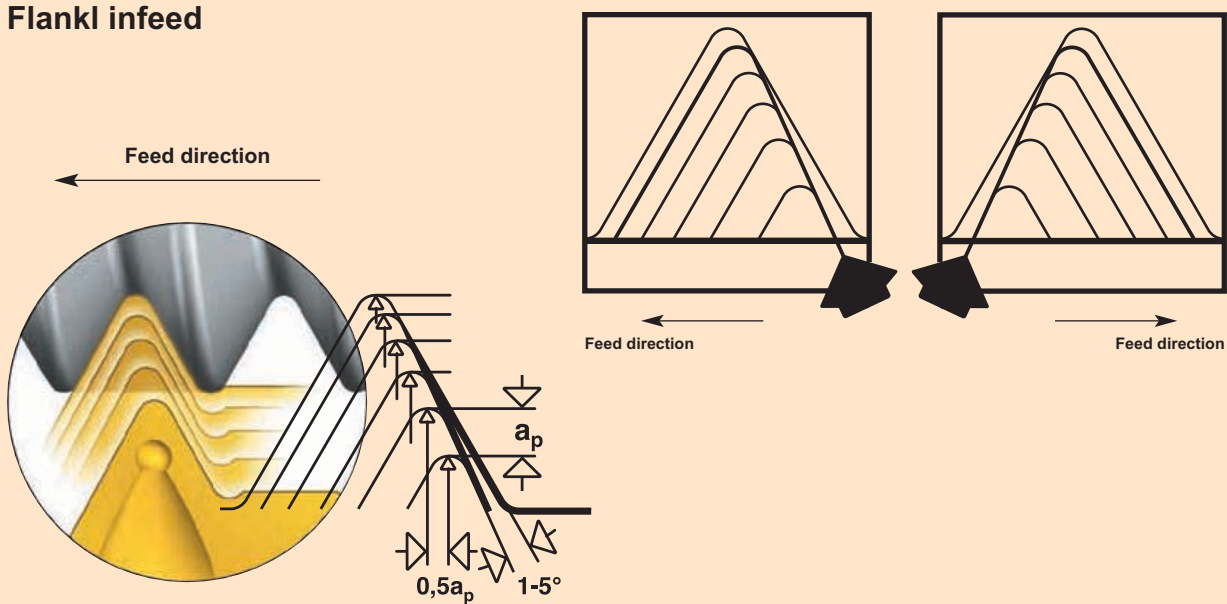
C.c Technical information

4. Choosing type of infeed for threading operations

Radial infeed

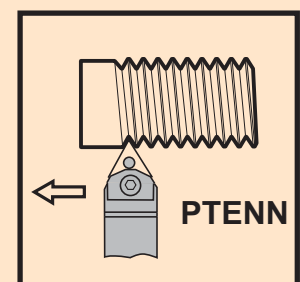


Flank infeed



Incremental infeed

Machining larger profiles



C.c Technical information

5. ISO metric, internal

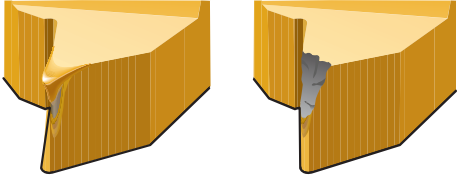
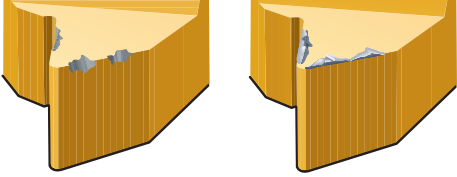
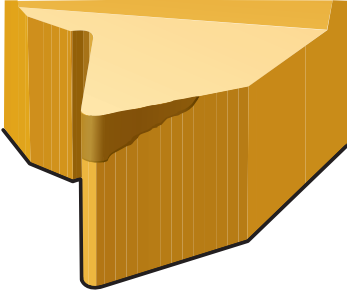
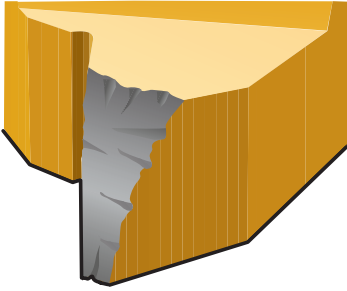
No. of infeeds	Pitch	Reduce cutting speed														
		0.50	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00
Radial infeed per pass, mm																
1		0.11	0.17	0.19	0.20	0.22	0.22	0.25	0.27	0.28	0.32	0.33	0.36	0.41	0.41	0.44
2		0.09	0.14	0.16	0.17	0.21	0.21	0.23	0.25	0.26	0.30	0.31	0.33	0.38	0.38	0.41
3		0.07	0.10	0.11	0.13	0.15	0.15	0.17	0.18	0.20	0.23	0.24	0.27	0.30	0.32	0.35
4		0.07	0.07	0.09	0.10	0.13	0.13	0.14	0.15	0.16	0.19	0.21	0.23	0.25	0.26	0.28
5		0.34	0.48	0.08	0.09	0.11	0.10	0.12	0.13	0.14	0.17	0.18	0.21	0.22	0.22	0.24
6				0.63	0.08	0.08	0.09	0.11	0.12	0.13	0.15	0.15	0.19	0.20	0.20	0.22
7					0.77	0.90	0.09	0.10	0.11	0.12	0.14	0.14	0.16	0.17	0.18	0.20
8							0.08	0.08	0.10	0.11	0.13	0.13	0.15	0.16	0.17	0.19
9							1.07	1.20	0.10	0.10	0.12	0.12	0.14	0.15	0.16	0.18
10									0.08	0.10	0.11	0.12	0.13	0.15	0.15	0.16
11									1.49	0.09	0.10	0.11	0.12	0.14	0.14	0.15
12										0.08	0.08	0.10	0.12	0.14	0.14	0.15
13										1.77	2.04	0.10	0.11	0.12	0.13	0.14
14												0.08	0.10	0.10	0.12	0.13
15												2.32	2.26	2.89	0.12	0.12
16															0.10	0.10
															3.20	3.46

6. ISO metric, external

No. of infeeds	Pitch	Reduce cutting speed														
		0.50	0.75	1.00	1.25	1.50	1.75	2.00	2.50	3.00	3.50	4.00	4.50	5.00	5.50	6.00
Radial infeed per pass, mm																
1		0.11	0.17	0.19	0.20	0.22	0.22	0.25	0.27	0.28	0.34	0.34	0.37	0.41	0.43	0.46
2		0.09	0.15	0.16	0.17	0.21	0.21	0.24	0.24	0.26	0.31	0.32	0.34	0.39	0.40	0.43
3		0.07	0.11	0.13	0.14	0.17	0.17	0.18	0.20	0.21	0.25	0.25	0.28	0.32	0.32	0.35
4		0.07	0.07	0.11	0.11	0.14	0.14	0.16	0.17	0.18	0.21	0.22	0.24	0.27	0.27	0.30
5		0.34	0.50	0.08	0.10	0.12	0.12	0.14	0.15	0.16	0.18	0.19	0.22	0.24	0.24	0.27
6				0.67	0.08	0.08	0.10	0.12	0.13	0.14	0.17	0.17	0.20	0.22	0.22	0.24
7					0.80	0.94	0.10	0.11	0.12	0.13	0.15	0.16	0.18	0.20	0.20	0.22
8							0.08	0.08	0.11	0.12	0.14	0.15	0.17	0.19	0.19	0.21
9							1.14	1.28	0.11	0.12	0.14	0.14	0.16	0.18	0.18	0.20
10									0.08	0.11	0.12	0.13	0.15	0.17	0.17	0.19
11									1.58	0.10	0.11	0.12	0.14	0.16	0.16	0.18
12										0.08	0.08	0.12	0.13	0.15	0.15	0.16
13										1.89	2.20	0.11	0.12	0.12	0.13	0.15
14												0.08	0.10	0.10	0.13	0.14
15												2.50	2.80	3.12	0.12	0.12
16															0.10	0.10
															3.41	3.72

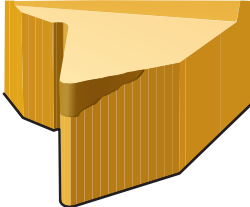
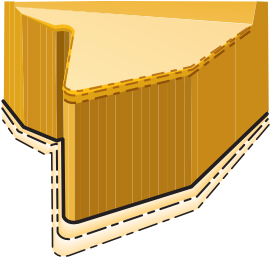
C.c Technical information

C

Problem	Cause	Remedy
<p>Rapid flank wear</p> 	<p>A too high cutting speed. Lack of coolant. Infeed per pass too small-too many passes Incorrect grade.</p>	<p>Reduce the cutting speed. Increase coolant supply. Increase the depth of infeed for the smallest infeed depths - reduce the number of passes. Select a more wear resistant grade.</p>
<p>Edge spalling</p> 	<p>Intermittent coolant supply.</p>	<p>Position coolant flow and/or increase coolant supply.</p>
<p>Uneven flank wear</p> 	<p>Incorrect method of infeed. Incorrect angle inclination.</p>	<p>In case of flank infeed, use modified flank infeed. Decrease infeed angle 3-5° Correct the angle of inclination according to diagram.</p>
<p>Insert breakage</p> 	<p>Instabiliti. Lack of chip control. Excessive plastic deformation. Intermittent or inadequate coolant supply. Incorrect preparatory.</p>	<p>Check rigidity of operation. Select a tougher grade. Select modified flank infeed. Machine with same infeed per pass. Position coolant flow and/or increase coolant supply. Check dimension of blank.</p>

C.c Technical information

C

Problem	Cause	Remedy
<p>Edge frittering</p> 	<p>Instability of workholding and/or tool set-up</p>	<p>Check rigidity of operation. Select a tougher grade.</p>
<p>Excessive plastic deformation</p> 	<p>Infeed per pass too large-too few passes. Lack of coolant. Cutting speed too high. Incorrect grade. Excessive stock removal from crest.</p>	<p>Decrease the depth of infeed for the biggest depths-increase the number of passes. Increase coolant supply. Reduce the cutting speed. Select a more wear resistant grade. Check material stock above the crest.</p>
<p>Shallow thread profile</p>	<p>Wrong centre height. Insert not cresting. Excessive tool setting.</p>	<p>Adjust cutting edge height. Check dimension of blank. Change insert earlier.</p>
<p>Incorrect thread profile</p>	<p>Incorrect tool setting.</p>	<p>Correct tool setting.</p>
<p>Bad surface finish</p>	<p>Cutting speed too low. Incorrect angle of inclination. Flank infeed.</p>	<p>Increase the cutting speed. Correct the angle og inclination according to diagram. Use modified flank infeed or radial infeed.</p>

C.c Technical information - grades for threading inserts

ISO

	ISO	ANSI	BASIC GRADES	SUPPLEMENTARY GRADES	TOUGHNES	WEAR RESISTANCE
P steel, cast steel, long chipping, malleable, iron.	01 05 10 15 20 25 30 35 40 45 50	C8 C7 C6 C5	7520	7515 2C25 2C35	TOUGHNES	WEAR RESISTANCE
M steel, cast steel, manganese steel, alloy cast iron, austenitic steels, malleable iron, free cutting steel.	01 05 10 15 20 25 30 35 40		7520 K13A	7515 2C25 2C35	TOUGHNES	WEAR RESISTANCE
K cast iron, chilled cast iron, short chipping melleable iron, hardened steel, non ferrous metals, plastics, wood.	01 05 10 15 20 25 30 35 40	C4 C3 C2 C1	7520 K13A	2C15 2C25 7515	TOUGHNES	WEAR RESISTANCE
N non ferrous metals.			K13A 7520		TOUGHNES	WEAR RESISTANCE
S heat resistans super alloys.			7520 K13A	7515 K10F	TOUGHNES	WEAR RESISTANCE
H hardened materials.			7520	715	TOUGHNES	WEAR RESISTANCE

C

27

C.c Cutting speed recommendations for threading

ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				2C25	2C35	7515
				Cutting speed (V_c), m/min		
Steel	Unalloyed steel					
	C = 0.1 - 0.25%	2000	125	220	200	180
	C = 0.25 - 0.55%	2100	150	180	160	150
	C = 0.55 - 0.80%	2200	170	140	120	120
	Low - alloyed steel (alloying elements < 5%)					
	Non - hardened	2150	180	160	140	100
	Ball bearing steel	2300	210	125	110	80
	Hardened and tempered	2550	275	110	95	70
	Hardened and tempered	2850	350	90	85	60
	High - alloy steel (alloying elements < 5%)					
Annealed	2500	200	130	120	90	
Hardened tool steel	3900	325	100	90	70	
Steel casting						
Unalloyed	200	180	200	180	180	
Low - alloy (alloying elements ≤ 5%)	2100	200	160	140	140	
High - alloy (alloying elements > 5%)	2650	225	120	100	100	


ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				2C25	2C35	7515
				Cutting speed (V_c), m/min		
Stainless steel	Ferritic / martensitic Bars / forged					
	Non - hardened	2300	200	130	110	110
	PH - hardened	3550	330	110	90	90
	Hardened	2850	330	70	70	60
	Austenitic Bars / forged					
	Austenitic	2300	180	130	110	110
	PH - hardened	3550	330	110	90	90
	Super austenitic	2950	200	70	70	60
	Austenitic - ferritic (Duplex) Bars / forged					
	Non - veldable ≥ 0.05%C	2550	230	110	100	90
Weldable < 0.05%C	3050	260	70	70	60	
Ferritic / martensitic Cast						
Non - hardened	2100	200	100	90	90	
PH - hardened	3150	330	70	60	60	
Hardened	2650	330	50	50	50	
Austenitic Cast						
Austenitic	2200	180	100	90	90	
PH - hardened	3150	330	70	60	60	
Super austenitic	2700	200	50	40	40	
Austenitic - ferritic (Duplex) Cast						
Non - veldable ≥ 0.05%C	2250	230	100	90	80	
Weldable < 0.05%C	2750	260	60	55	55	

ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				2C15	2C25	7515
				Cutting speed (V_c), m/min		
Cast iron	Malleable cast iron					
	Ferritic (short chipping)	940	130	160	150	100
	Pearlitic (long chipping)	1100	230	120	110	160
K	Grey cast iron					
	Low tensile strenght	1100	180	170	160	110
	High tensile strenght	1150	220	120	110	70
	Nodular SG iron					
Ferritic	1050	160	140	130	100	
Pearlitic	1750	250	100	90	70	
Martensitic	2700	380	80	70	50	

C.c Cutting speed recommendations for threading

TOUGHNESS 

7520									
170									
140									
110									
90									
70									
60									
50									
80									
60									
160									
120									
80									

TOUGHNESS 

7520									
100									
80									
60									
100									
80									
60									
80									
50									
85									
55									
45									
85									
55									
40									
70									
40									

TOUGHNESS 

7520	K13A								
90	60								
50	40								
100	50								
60	35								
90	50								
60	35								
40	30								

C.c Cutting speed recommendations for threading

ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				7520	K13A	
				Cutting speed (V_c), m/min		
Non - ferrous metals	Aluminium alloys Wrought or wrought and coldworked, non - aging	500	60	1000	400	
	Wrought or wrought and aged	800	100	300	300	
	Aluminium alloys Cast, non - aging	750	75	400	350	
	Cast or cast and aged	900	90	250	200	
N	Aluminium alloys Cast, 13 - 15% Si	950	130	220	180	
	Cast, 16 - 22% Si	950	130	220	180	
	Copper and copper alloys Free cutting alloys, \leq 1% Pb	700	110	350	300	
	Brass, leaded bronzes, \leq 1% Pb Bronze and non - leadad copper, included electrolytic copper	700 1750	90 100	200 150	170 120	

ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				7515	7520	K13A
				Cutting speed (V_c), m/min		
Heat resistant material	Heat resistant super alloy Iron base Annealed or solution treated	3000	200	45	45	45
	Aged or solution treated and aged	3050	280	25	25	25
	Nickel base Annealed or solution treated	3300	250	15	15	15
	Aged or solution treated and aged Cast or cast and aged	3600 3700	350 320	12 10	12 10	12 10
S	Cobalt base Annealed or solution treated	3300	200	23	23	23
	Aged or solution treated and aged	3700	300	13	13	13
	Cast or cast and aged	3800	320	10	10	10
	Titanium alloys Commercial pure (99.5% Ti)	1550	Rm 400	140	140	110
α , near α and $\alpha+\beta$ alloys, annealed	1700	950	55	55	45	
$\alpha+\beta$ alloys in aged conditions, β alloys, annealed or aged	1700	1050	40	40	30	

ISO	Material	Specific cutting force k_c 0.4 N/mm ²	Hardness Brinell HB	WEAR RESISTANCE		
				7515	7520	
				Cutting speed (V_c), m/min		
Hardened material	Hard steel Hardened and tempered	3250	45HRC	50	50	
		3950	50HRC	45	45	
		4700	55HRC	40	40	
H	Extra hard steel Hardened and tempered	5550	60HRC	30	30	
		6450	65HRC			
	Chilled cast iron Cast or cast and aged	2800	400	30	30	

C.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 N	Aluminium alloys Wrought or wrought and coldworked, non - aging Wrought or wrought and aged			500	7520								
				200	7520								
	Aluminium alloys Cast, non - aging Cast or cast and aged			300	7520								
				150	7520								
	Aluminium alloys Cast, 13 - 15% Si Cast, 16 - 22% Si			150	7520								
				150	7520								
	Copper and copper alloys Free cutting alloys, ≤ 1% Pb Brass, leaded bronzes, ≤ 1% Pb Bronze and non - leadad copper, included electrolytic copper			200	7520								
				120	7520								
				80	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 S	Heat resistant super alloy Iron base Annealed or solution treated Aged or solution treated and aged			30	7520								
				20	7520								
	Nickel base Annealed or solution treated Aged or solution treated and aged Cast or cast and aged			12	7520								
				10	7520								
				8	7520								
	Cobalt base Annealed or solution treated Aged or solution treated and aged Cast or cast and aged			20	7520								
				10	7520								
				8	7520								
	Titanium alloys Commercial pure (99.5% Ti) α, near α and α+β alloys, annealed α+β alloys in aged conditions, β alloys, annealed or aged			120	7520								
				40	7520								
				25	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 H	Hard steel Hardened and tempered			30	7520								
	Extra hard steel Hardened and tempered			20	7520								
Chilled cast iron Cast or cast and aged			20	7520									

CORUN HOLDING d.o.o.

Miloša Obrenovića, Suite 2
Užice, Serbia 31000

phone: +381 31 / 563 344
fax: +381 31 / 563 461
e-mail: corunad@yahoo.com

SALES DEPARTMENT

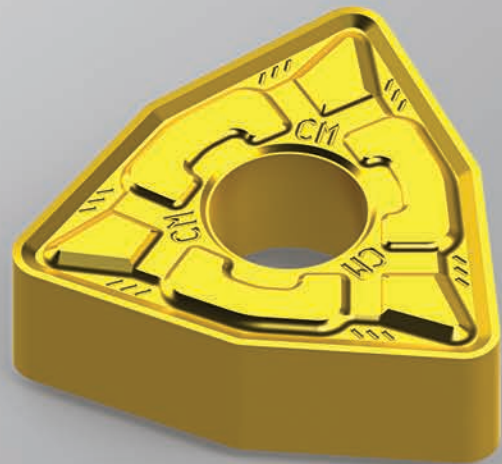
phone: +381 31 / 563 391
fax: +381 31 / 563 391
e-mail: sales@corun.rs

MARKETING

phone: +381 31 / 563 391
fax: +381 31 / 563 391
e-mail: marketing@corun.rs

DEVELOPMENT

phone: +381 31 / 563 400
e-mail: development@corun.rs



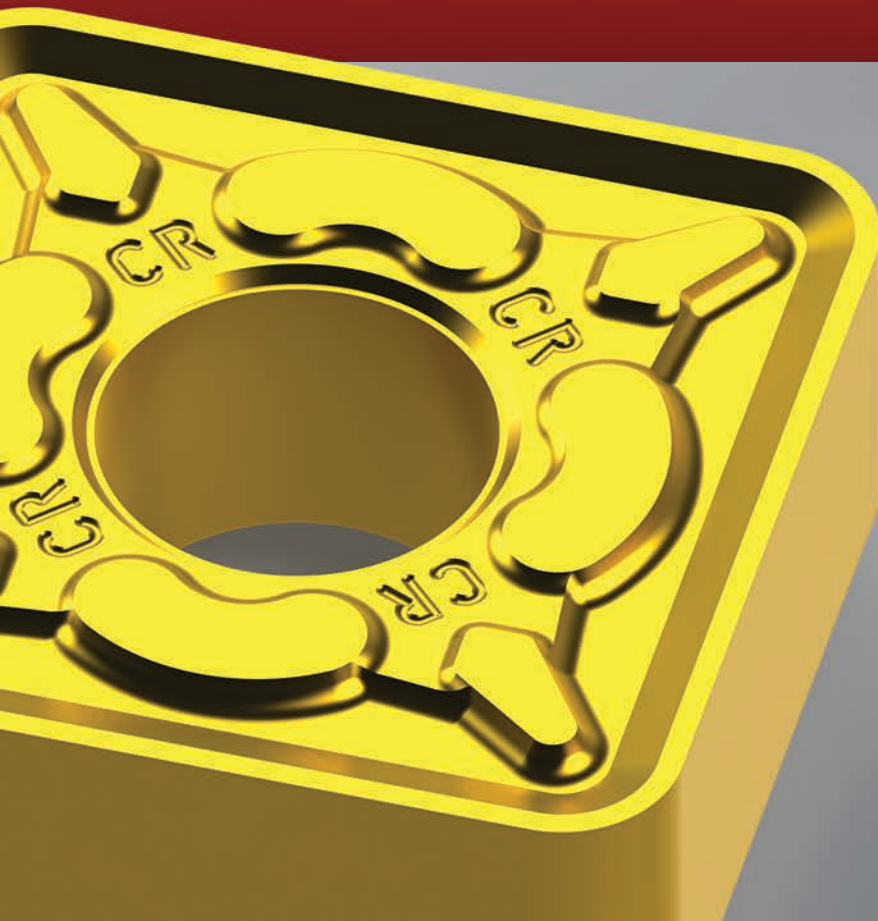
ABOUT COMPANY

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.



CORUN

WWW.CORUN.RS