

Turning tools

GENERAL TURNING | PARTING & GROOVING | THREADING | TOOLING SYSTEMS

2012



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TURN - ENG

GENERAL TURNING External machining - Holders for negative basic-shape inserts

Coromant Capto® cutting units

T-Max P wedge clamp design

TNMM, TNMX
TNMG
TNMA, TNGA

Entering angle:
Lead angle:

MTJNR/L
 $\kappa_r 93^\circ$
 -3°

Coolant inlet: Radial through the taper

Right hand style shown unless otherwise stated

Main application	Δ	iC	Ordering code	Dimensions, mm, inch					Gauge inserts	
				D_{5m}	f_1	l_1	γ^1	λ_s^2	ISO	ANSI
	16	3/8	C3-MTJNR/L-22040-16	32	22	40	-6°	-6°	TNMG 16 04 08	TNMG 332
			C4-MTJNR/L-27050-16	40	.866	1.575	-6°	-6°	TNMG 16 04 08	TNMG 332
			C5-MTJNR/L-35060-16	50	1.063	1.968	-6°	-6°	TNMG 16 04 08	TNMG 332
	22	1/2	C4-MTJNR/L-27050-22	40	27	50	-6°	-6°	TNMG 22 04 08	TNMG 432
			C5-MTJNR/L-35060-22	50	1.063	1.968	-6°	-6°	TNMG 22 04 08	TNMG 432
			C6-MTJNR/L-45065-22	63	1.378	2.362	-6°	-6°	TNMG 22 04 08	TNMG 432
27	5/8	C6-MTJNR/L-45065-27	63	45	65	-6°	-6°	TNMG 27 06 12	TNMG 543	
				63	1.772	2.559	-6°	-6°	TNMG 27 06 12	TNMG 543

1) γ = Rake angle (valid with flat insert).
2) λ_s = Angle of inclination.

R = Right hand, L = Left hand

Main spare parts

Insert size		Main spare parts					
Δ	iC	Wedge clamp set	Key (mm)	Shim	Pin	Screw	Key (mm)
16	3/8	170.38-820-1	174.1-863 (2.5)	170.3-852	5313 021-02	3212 010-206	174.1-863 (2.5)
22	1/2	170.38-821-1	174.1-864 (3.0)	170.3-855	181.38-840	3212 010-255	174.1-864 (3.0)
27	5/8	170.38-822-1	174.1-864 (3.0)	170.3-854	5313 021-04	3212 100-307	3021 010-040 (4.0)

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