



CoroTurn® 300

Effective and high-quality turning

With its eight-edged insert, CoroTurn® 300 has better chip control and more stable performance. With fewer inserts needed, setup times are shortened especially when changing tool holders and inserts. This can ultimately save your time and money.



Insert grade:

- GC4315
- GC4325

Application area:

- Longitudinal and face turning
- Finishing to medium

Machine type:

- Turning centres
- Multi-task machines

Recommendations:

Insert geometries and grades

Operations	Geometry	Machining Condition	P
Finishing	-L4	Good	GC4315
Medium	-M5	Average	GC4325
Extra fine surface / High feed	-M5W	Difficult	GC4325

- -L4, nose radii 04: Excels in a_p 0.25–3 mm (.010–.118 inch) and f_n between 0.1–0.3 mm/r (.004–.012 inch/rev)
- -L4, nose radii 08: Excels in a_p 0.5–3 mm (.020–.118 inch) and f_n between 0.12–0.32 mm/r (.005–.013 inch/rev)
- -L4, nose radii 12: Excels in a_p 0.65–3 mm (.026–.118 inch) and f_n between 0.15–0.35 mm/r (.006–.014 inch/rev)
- -M5, nose radii 08: Excels in a_p 0.8–3.8 mm (.031–.150 inch) and f_n between 0.2–0.45 mm/r (.008–.018 inch/rev)
- -M5, nose radii 12: Excels in a_p 1.2–3.8 mm (.047–.150 inch) and f_n between 0.25–0.55 mm/r (.010–.022 inch/rev)
- -M5W, nose radii 08: Excels in a_p 0.5–3.8 mm (.020–.150 inch) and f_n between 0.2–0.6 mm/r (.008–.024 inch/rev)
- -M5W, nose radii 12: Excels in a_p 0.8–3.8 mm (.031–.150 inch) and f_n between 0.25–0.7 mm/r (.010–.028 inch/rev)

Insert change



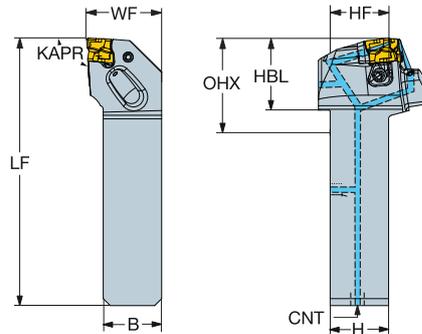
Use a torque of 4.5 Nm to change the insert in 5 easy steps where a clamping solution with lever makes the insert self-locking into the tip seat and fixed location points (iLock™). This ensures rigidity and accuracy.

Assortment:

Tool



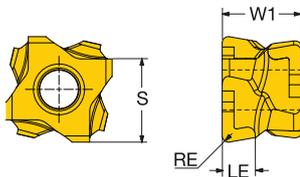
KAPR
PSIR 94.7°
-4.7°



Metric version

					Dimensions													MIID
SSC	CZC _{MS}	OHX	CNSC	Ordering code	B	H	HBL	LF	WF	HF	CNT	CP Bar	Nm	Kg				
10	20 x 20	54.0	3	QS-3-80LR/L202034-10C	20.0	20.0	34.0	103.0	25.0	20.0	G1/8	150	4.5	0.32	3-80-101108			
	25 x 25	56.0	3	QS-3-80LR/L252531-10C	25.0	25.0	31.0	115.0	32.0	25.0	G1/8	150	4.5	0.55	3-80-101108			

Insert



							P		
		SSC	LE	S	RE	W1	ISO CODE	4315	4325
Finishing		10	4.0	11.00	0.40	10.0	3-80-101104-8-L4	☆	☆
			.157	.433	.016	.394			
			4.0	11.00	0.79	10.0	3-80-101108-8-L4	☆	☆
			.157	.433	.031	.394			
			4.0	11.00	1.19	10.0	3-80-101112-8-L4	☆	☆
		.157	.433	.047	.394				
Medium		10	4.0	11.00	0.79	10.0	3-80-101108-8-M5	☆	☆
			.157	.433	.031	.394			
			4.0	11.00	1.19	10.0	3-80-101112-8-M5	☆	☆
			.157	.433	.047	.394			