

GENERAL INFORMATION

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Conversion table

Metric to imperial

Distance

1 meter = 39.370 inch

1 meter = 3.281 feet

1 millimeter = 0.039 inch

Weight

1 kilogram = 2.205 pounds

1 kilogram = 35.274 ounces

Torque

1 Newton meter (Nm) = 0.738 pound-force feet (ft-lbs)

1 Newton meter (Nm) = 8.851 pound-force inches (in-lbs)

Imperial to metric

Distance

1 inch = 25.4 millimeter

1 foot = 0.3 meter

1 foot = 304.8 millimeter

Weight

1 pound = 0.45 kilogram

1 ounce = 28.35 gram

Torque

1 pound-force foot (ft-lbf) = 1.4 Newton meter (Nm)

1 pound-force inch (in-lbf) = 0.1 Newton meter (Nm)

Formulas and definitions:

v_c = cutting speed

n = spindle speed

v_f = table feed

z_n = total number of cutting edges

z_c = number of effective cutting edges

f_z = feed per tooth

f_n = feed per revolution

h_{ex} = maximum thickness

a_p = cutting depth

l_a = insert width

a_e = cutting width

a_e/D_c % = Radial immersion

T = machining time

Q = metal removal rate

n_{ap} = number of passes

TPI = threads per inch

k_c = specific cutting force

R_a = surface roughness

Metric

m/min (meter/minute)

rpm (revolution per minute)

mm/min

mm/z

mm/rev

mm

mm

mm

mm

%

min

cm³/min

N/mm²

μm

Imperial

ft/min (feet/minute)

inch/min

inch/z

inch/rev

inch

inch

inch

inch

%

min

inch³/min

lbs/in²

μin

Insert size

IC = inscribed circle in inch

 = cutting edge length in mm



Additional tool options designed for your specific requirements.

Engineered solutions

When standard or Tailor Made solutions do not fulfill your needs you can depend on Sandvik Coromant's wide experience in engineered tool solutions to cope with particularly demanding criteria.

Apart from a comprehensive standard program we can offer tools to your dimensions on standard tool terms. In our Tailor Made offer you are free to specify your own dimensions without paying the price of a special tool.

- Drawing and quote within 24 hours
- Tools within 10 to 20 days

Download the Tailor Made Tool Selection Guide in PDF-format at www.sandvik.coromant.com

For further details, contact your nearest Coromant sales representative.

CoroMILL 490

Even more possibilities thanks to tailored design
If you do not find what you need in our comprehensive standard programme, choose the tool design you require and we will tailor it to you to your dimensions.

Options

Insert size: 16 (12)
 R₁: (12) Diameter: 12.00-16.00 mm
 R₂: (12) Diameter: 12.00-16.00 mm
 Flank type: Edge: 1 (1) Flank: 1 (1)
 R₁: (12) No. of inserts: 8 (8)
 R₂: (12) No. of inserts: 8 (8)
 Mounting type: Cylindrical, Rectangular, Coromant-Casts, HSK-A
 Mounting side: inner/outer

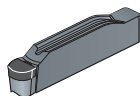
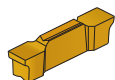
Standard tools:
 R₁: (12) Diameter: 12.00-16.00 mm
 R₂: (12) Diameter: 12.00-16.00 mm
 Flank type: Edge: 1 (1) Flank: 1 (1)
 R₁: (12) No. of inserts: 8 (8)
 R₂: (12) No. of inserts: 8 (8)
 Mounting type: Cylindrical, Rectangular, Coromant-Casts, HSK-A
 Mounting side: inner/outer



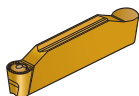
Overview of Tailor Made product families

Parting & grooving

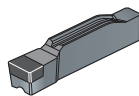
CoroCut 1-2 inserts



123-RS



123-RM

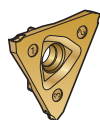


123-GE

Additional tool options

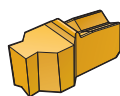
- Insert width
- Insert radius
- Insert shape
- Insert grade

CoroCut 3 inserts



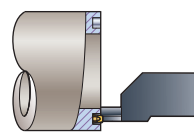
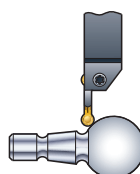
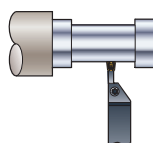
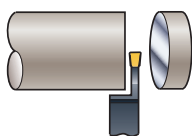
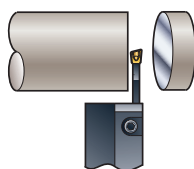
123-CM

T-Max Q-Cut inserts



- Insert width
- Insert radius
- Insert shape
- Insert grade

T-Max Q-Cut and CoroCut holders



- Coupling/shank size
- Cutting depths
- Insert system
- Holder style
- Diameters
- Machining limitations

Threading

CoroThread® 266 inserts



- External/internal
- Insert size
- Profiles
- Pitch
- Taper angles
- Crest form

T-Max U-Lock inserts



- External/internal
- Insert size
- Profiles
- Pitch
- Taper angles
- Crest form

Tailor Made

Milling

CoroMill 390 long edge milling cutters



Additional tool options

- Insert size
- No of inserts
- Diameter
- Pitch type
- Mounting type and size
- Tool length
- Coolant

CoroMill® 490 face and shoulder mill



- No of inserts
- Diameter
- Pitch type
- Mounting type and size
- Tool length
- Coolant ($D_c < 63$)

CoroMill Century face milling inserts



- Insert grade
- R/L hand
- Depth of cut
- Corner shape
- Wiper design

CoroMill 790 square shoulder face mill



- Insert size
- No of inserts
- Diameter
- Pitch type
- Mounting type and size
- Tool length
- Coolant

CoroMill 331 side and face milling cutter



- Cutter type
- R/L hand
- Insert size
- Diameter
- Pitch type
- Mounting type and size

CoroMill 331 inserts



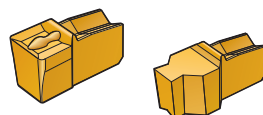
- Insert size
- Insert geometry
- Insert shape/radius
- Corner radius
- Insert grade

Slitting cutter 330



- Insert size
- No of inserts
- Diameter
- Pitch type
- Mounting type and size
- Tool length
- Coolant

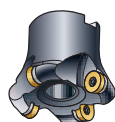
Q-Cut inserts for slitting cutter 330



- Insert size
- Insert grade
- Insert width
- Tolerance
- Chamfers

Milling

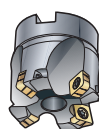
CoroMill 200 face milling and profiling cutter



Additional tool options

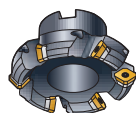
- Insert size
- No of inserts
- Diameter
- Shim
- Pitch type
- Mounting type and size
- Tool length

CoroMill 210 for face milling and plunging



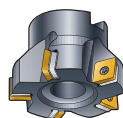
- Insert size
- No of inserts
- Diameter
- Mounting type and size
- Tool length
- Coolant

CoroMill 245 face milling cutter



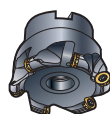
- No of inserts
- R/L, diameter
- Pitch type
- Mounting type and size
- Tool length

CoroMill 290 square shoulder face mill



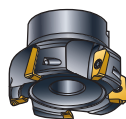
- Insert size
- No of inserts
- R/L, diameter
- Shim
- Pitch type
- Mounting type and size
- Tool length

CoroMill 300 face milling and profiling cutter



- Insert size
- No of inserts
- Diameter
- Pitch type
- Mounting type and size
- Tool length
- Coolant

CoroMill 390 square shoulder face mill



- Insert size
- Diameter
- Pitch type
- Mounting type and size
- Tool length
- Coolant

CoroMill 390 end mills



- Insert size
- No of inserts
- Diameter
- Pitch type
- Mounting type and size
- Tool length
- Coolant



Drilling

CoroDrill Delta-C solid carbide drills



Additional tool options

- Drill diameter/step
- Carbide grade
- Drill depth
- Chamfers/corner radius
- Tolerance
- Mounting type and size
- Coolant supply

Coromant Delta Brazed carbide drills



- Drill diameter
- Carbide grade
- Drill depth
- Chamfers/corner radius
- Tolerance
- Mounting type and size
- Coolant supply

CoroDrill® 854, 855, 856



- Drill diameter/step
- Carbide grade
- Drill depth
- Chamfers/corner radius
- Tolerance
- Mounting type and size
- Coolant supply

CoroDrill 880 indexable insert drill



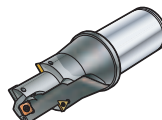
- Drill diameter
- Drill length
- Drill depth
- Mounting type and size
- Flute length

CoroDrill 881 indexable insert drill



- Drill diameter
- Drill length
- Drill depth
- Mounting type and size

CoroDrill® 880 step and chamfer



- Drill diameter
- Drill depth
- Chamfers/corner radius
- Mounting type and size
- Coolant supply
- Supporting insert

Coromant U indexable insert drill



- Drill diameter/step
- No of extra inserts
- Chamfer inserts
- Drill length
- Drill depth
- Mounting type and size
- Flute length

T-MAX adjustable drill heads

- Drill diameter

Drilling

High Feed CounterBore



Additional tool options

- Thread type
- Diameter

CoroDrill® 860



- Drill diameter
- Drill depth
- Tolerance
- Mounting type and size
- Coolant supply

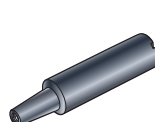
CoroDrill® 870



- Drill tip diameter
- Drill depth
- Mounting type and size
- Optimized drill body diameter

Tooling system

Shanks for exchangeable head system (EH)



- EH coupling size
- Diameter
- Cylindrical or Weldon
- Shank length
- Design, conical or straight

Safety information in connection with grinding of cemented carbide

Material composition

Most metal products contain tungsten carbide and cobalt. Other substances that may be constituents of hardmetal are titanium carbide, tantalum carbide, niobium carbide, chromium carbide, molybdenum carbide or vanadium carbide. Some grades contain titanium carbonitride and/or nickel.

Routes of exposure

Grinding or heating of hard metal blanks or hard metal products will produce dust or fumes with dangerous ingredients that can be inhaled, swallowed or come in contact with the skin or eyes.

Acute toxicity

The dust is toxic when inhaled. Inhalation may cause irritation and inflammation of the airways. Significantly higher acute inhalation toxicity has been reported during simultaneous inhalation of cobalt and tungsten carbide compared to inhalation of cobalt alone. Skin contact can cause irritation and rash. Sensitized persons may experience an allergic reaction.

Chronic toxicity

Repeated inhalation of aerosols containing cobalt may cause obstruction in the airways. Prolonged inhalation of increased concentrations may cause lung fibrosis or lung cancer. Epidemiological studies indicate that workers exposed in the past to high concentrations of tungsten carbide/cobalt carried an increased risk of developing lung cancer.

Cobalt and nickel are potent skin sensitizers. Repeated or prolonged contact can cause irritation and sensitization.

Risk phrases

Toxic: danger of serious damage to health by prolonged exposure through inhalation

Toxic when inhaled

Limited evidence of a carcinogenic effect.

May cause sensitization by inhalation and skin contact

Preventive measures

Avoid formation and inhalation of dust. Use adequate local exhaust ventilation to keep personal exposure well below the nationally authorised limits.

If ventilation is not available or adequate, use respirators nationally approved for the purpose.

Use safety goggles or glasses with side shields when necessary.

Avoid repeated skin contact. Wear suitable gloves. Wash skin thoroughly after handling.

Use suitable protective clothing. Launder clothing as needed.

Do not eat, drink or smoke in the working area. Wash skin thoroughly before eating, drinking or smoking.

Material cross reference list

ISO	Coromant Material Classification (CMC)	Country									
		USA	Great Britain		Sweden	Germany		France	Italy	Spain	Japan
		Standard									
		AISI/SAE	BS	EN	SS	W.-nr.	DIN	AFNOR	UNI	UNE	JIS
P Unalloyed steel											
Steel	01.1	A570.36	4360 40 C		1311	1.0038	RSt.37-2	E 24-2 Ne	-	-	STKM 12A;C
	01.1	1115	030A04	1A	1325	1.0038	GS-CK16	-	-	-	-
	01.1	A573-81 65	4360 40 B		1312	1.0116	St.37-3	E 24-U	Fe37-3	-	-
	01.1	1015	080M15	-	1350	1.0401	C15	CC12	C15C16	F.111	-
	01.1	1020	050A20	2C/2D	1450	1.0402	C22	CC20	C20C21	F.112	-
	01.1	1213	230M07	-	1912	1.0715	9SMn28	S250	CF9SMn28	11SMn28	SUM22
	01.1	12L13	-	-	1914	1.0718	9SMnPb28	S250Pb	CF9SMnPb28	11SMnPb28	SUM22L
	01.1	-	-	-	-	1.0722	10SPb20	10PbF2	CF10SPb20	10SPb20	-
	01.1	1215	240M07	1B	-	1.0736	9SMn36	S 300	CF9SMn36	12SMn35	-
	01.1	12L14	-	-	1926	1.0737	9SMnPb36	S300Pb	CF9SMnPb36	12SMnP35	-
	01.1	1015	080M15	32C	1370	1.1141	Ck15	XC12	C16	C15K	S15C
	01.1	1025	-	-	-	1.1158	Ck25	-	-	-	S25C
	01.1	A572-60	4360 55 E	-	2145	1.8900	StE 380	-	FeE390KG	-	-
	01.1	A572-60	4360 55 E	-	2142	-	17 MnV 6	NFA 35-501 E 36	-	-	-
	01.2	1035	060A35	-	1550	1.0501	C25	CC35	C35	F.113	-
	01.2	1045	080M46	-	1650	1.0503	C45	CC45	C45	F.114	-
	01.2	1140	212M36	8M	1957	1.0726	25Cr20	35MF4	-	F210G	-
	01.2	1039	150M36	15	-	1.1157	40Mn4	35M5	-	-	-
	01.2	1335	-	-	2120	1.1167	36Mn5	40M5	-	36Mn5	SMn438(H)
	01.2	1330	150M28	14A	-	1.1170	28Mn6	20M5	C28Mn	-	SCMn1
	01.2	1035	060A35	-	1572	1.1183	Cf35	XC38TS	C36	-	S35C
	01.2	1045	080M46	-	1672	1.1191	Ck45	XC42	C45	C45K	S45C
	01.2	1050	060A52	-	1674	1.1213	Cf53	XC48TS	C53	-	S50C
	01.3	1055	070M55	-	1655	1.0535	C55	-	C55	-	-
	01.3	1060	080A62	43D	-	1.0601	C60	CC55	C60	-	-
	01.3	1055	070M55	-	-	1.1203	Ck55	XC55	C50	C55K	S55C
	01.3	1060	080A62	43D	1678	1.1221	Ck60	XC60	C60	-	S58C
	01.4	1095	060 A 96	-	1870	1.1274	Ck 101	XC 100	-	F-5117	-
	01.4	W 1	BW 1A	-	1880	1.1545	C 105 W1	Y105	C36KU	F-5118	SK 3
	01.4	W210	BW2	-	2900	1.1545	C105W1	Y120	C120KU	F.515	SUP4
Low-alloy steel (02.1 = Non-hardened, 02.2 = Hardened and tempered)											
Steel	02.1	A573-81	4360 43C		1412	1.0144	St.44-2	E 28-3	-	-	SM 400A;B;C
	02.1	-	4360 50B		2132	1.0570	St.52-3	E36-3	Fe52BFN/Fe52CFN	-	SM490A;B;C;YA;YB
	02.1	5120	150 M 19		2172	1.0841	St.52-3	20 MC 5	Fe52	F-431	-
	02.1	9255	250A53	45	2085	1.0904	55Si7	55S7	55Si8	56Si7	-
	02.1	9262	-	-	-	1.0961	60SiCr7	60SC7	60SiCr8	60SiCr8	-
	02.1	52100	534A99	31	2258	1.3505	100Cr6	100C6	100Cr6	F.131	SUJ2
	02.1	ASTM A204Gr.A	1501-240	-	2912	1.5415	15Mo3	15D3	16Mo3KW	16Mo3	-
	02.1	4520	1503-245-420	-	-	1.5423	16Mo5	-	16Mo5	16Mo5	-
	02.1	ASTM A350LF5	-	-	-	1.5622	14Ni6	16N6	14Ni6	15Ni6	-
	02.1	8620	805M20	362	2506	1.6523	21NiCrMo2	20NCD2	20NiCrMo2	20NiCrMo2	SNM220(H)
	02.1	8740	311-Type 7	-	-	1.6546	40NiCrMo22	-	40NiCrMo2(KB)	40NiCrMo2	SNM240
	02.1	-	820A16	-	-	1.6587	17CrNiMo6	18NCD6	-	14NiCrMo13	-
	02.1	5015	523M15	-	-	1.7015	15Cr3	12C3	-	-	SCR415(H)
	02.1	5140	-	-	2245	1.7045	42Cr4	-	-	42Cr4	SCR440
	02.1	5155	527A60	48	-	1.7176	55Cr3	55C3	-	-	SUP9(A)
	02.1	-	-	-	2216	1.7262	15CrMo5	12CD4	-	12CrMo4	SCM415(H)
	02.1	ASTM A182	1501-620Gr27	-	-	1.7335	13CrMo4 4	15CD3.5	14CrMo4 5	14CrMo45	-
	02.1	F11;F12	-	-	-	-	-	15CD4.5	-	-	-
	02.1	ASTM A182	1501-622	-	2218	1.7380	10CrMo9 10	12CD9, 10	12CrMo9, 10	TU.H	-
	02.1	F.22	Gr.31;45	-	-	-	-	-	-	-	-
	02.1	-	1503-660-440	-	-	1.7715	14MoV6 3	-	-	13MoCrV6	-
	02.1	-	722 M 24		2240	1.8515	31 CeMo 12	30 CD 12	30CrMo12	F-1712	-
	02.1	-	897M39	40C	-	1.8523	39CrMoV13 9	-	36CrMoV12	-	-
	02.1	L1	524A14	-	2092	1.7039	34MoCrS4 G	-	105WCR 5	-	-
	02.1	8620	605A32	-	2108	1.5419	20MoCrS4	-	-	F520.S	-
	02.1	-	823M30	33	2512	1.7228	55NiCrMoV6G	-	653M31	-	-
	02.1	-	-	-	2127	1.7139	16MnCr5	-	-	-	-
	02.1	-	830 M 31	-	2534	-	31NiCrMo134	-	-	F-1270	-
	02.1	L6	-	-	2550	1.2721	50NiCr13	55NCV6	-	F-528	-
	02.2	3135	640A35	111A	-	1.5710	36NiCr6	35NC6	-	-	SNC236
	02.2	3415	-	-	-	1.5732	14NiCr10	14NC11	16NiCr11	15NiCr11	SNC415(H)
	02.2	3415;3310	655M13; A12	36A	-	1.5752	14NiCr14	12NC15	-	-	SNC815(H)
	02.2	9255	-	-	2090	1.0904	55Si7	55S7	-	-	-

GENERAL INFORMATION

Material cross reference list

ISO	Coromant Material Classification (CMC)	Country									
		USA	Great Britain		Sweden	Germany		France	Italy	Spain	Japan
		Standard									
		AISI/SAE	BS	EN	SS	W.-nr.	DIN	AFNOR	UNI	UNE	JIS
P	02.1/02.2	9840	816M40	110	-	1.6511	36CrNiMo4	40NCD3	38NiCrMo4(KB)	35NiCrMo4	-
	02.1/02.2	4340	817M40	24	2541	1.6582	35CrNiMo6	35NCD6	35NiCrMo6(KB)	-	-
	02.1/02.2	5132	530A32	18B	-	1.7033	34Cr4	32C4	34Cr4(KB)	35Cr4	SCr430(H)
	02.1/02.2	5140	530A40	18	-	1.7035	41Cr4	42C4	41Cr4	42Cr4	SCr440(H)
	02.1/02.2	5115	(527M20)	-	2511	1.7131	16MnCr5	16MC5	16MnCr5	16MnCr5	-
	02.1/02.2	4130	1717CDS110	-	2225	1.7218	25CrMo4	25CD4	25CrMo4(KB)	55Cr3	SCM420;SCM430
										AM26CrMo4	
	02.1/02.2	4137;4135	708A37	19B	2234	1.7220	34CrMo4	35CD4	35CrMo4	34CrMo4	SCM432;SCCRM3
	02.1/02.2	4140;4142	708M40	19A	2244	1.7223	41CrMo4	42CD4TS	41CrMo4	42CrMo4	SCM 440
	02.1/02.2	4140	708M40	19A	2244	1.7225	42CrMo4	42CD4	42CrMo4	42CrMo4	SCM440(H)
	02.1/02.2	-	722M24	40B	2240	1.7361	32CrMo12	30CD12	32CrMo12	F.124.A	-
	02.1/02.2	6150	735A50	47	2230	1.8159	50CrV4	50CV4	50CrV4	51CrV4	SUP10
	02.1/02.2	-	905M39	41B	2940	1.8509	41CrAlMo7	40CAD6, 12	41CrAlMo7	41CrAlMo7	-
	02.1/02.2	L3	BL3	-	-	1.2067	100Cr6	Y100C6	-	100Cr6	-
	02.1/02.2	-	-	-	2140	1.2419	105WCr6	105WC13	10WCr6	105WCr5	SKS31
								107WCr5KU		SKS2, SKS3	
02.1/02.2	L6	-	-	-	-	1.2713	55NiCrMoV6	55NCDV7	-	F.520.S	SKT4
High-alloy steel											
Steel	03.11	ASTM A353	1501-509;510	-	-	1.5662	X8Ni9	-	X10Ni9	XBNI09	-
	03.11	2515	-	-	-	1.5680	12Ni19	-	-	-	-
	03.11	-	832M13	36C	-	1.6657	14NiCrMo134	Z18N5	15NiCrMo13	14NiCrMo131	-
	03.11	D3	BD3	-	-	1.2080	X210Cr12	Z200C12	X210Cr13KU X250Cr12KU	X210Cr12	SKD1
	03.11					2314					
	03.11	H13	BH13	-	2242	1.2344	X40CrMoV5 1	Z40CDV5	X35CrMoV05KU X40CrMoV511KU	X40CrMoV5	SKD61
	03.11	A2	BA2	-	2260	1.2363	X100CrMoV5 1	Z100CDV5	X100CrMoV51KU	X100CrMoV5	SKD12
	03.11	-	-	-	2312	1.2436	X210CrW12	-	X215CrW12 1KU	X210CrW12	SKD2
	03.11	S1	BS1	-	2710	1.2542	45WCrV7	-	45WCrV8KU	45WCrSi8	-
	03.11	H21	BH21	-	-	1.2581	X30WCrV9 3 X30WCrV9 3KU	Z30WCV9	X28W09KU X30WCrV9 3KU	X30WCrV9	SKD5
	03.11	-	-	-	2310	1.2601	X165CrMoV 12	-	X165CrMoW12KU	X160CrMoV12	-
	03.11	HW3	401S45	52	-	1.4718	X45GrSi93	Z45CS9	X45GrSi8	F322	SUH1
	03.11	D3	4959BA2	-	2715	1.3343	S6-5-2	Z40CSD10	15NiCrMo13	-	SUH3
	03.13	M 2	BM 2	-	2722	1.3343	S6/5/2	Z 85 WDCV	HS 6-5-2-2	F-5603.	SKH 51
	03.13	M 35	BM 35	-	2723	1.3243	S6/5/2/5	6-5-2-5	HS 6-5-2-5	F-5613	SKH 55
	03.13	M 7	-	-	2782	1.3348	S2/9/2	-	HS 2-9-2	F-5607	-
	03.21	HNV3	-	-	2736	1.2379	X210Cr12 G	-	-	-	-
	Steel castings										
06.2	-	-	-	2223	-	-	-	-	-	-	-
06.33	-	Z120M12	-	-	1.3401	G-X120Mn12	Z120M12	XG120Mn12	X120Mn12	SCMnH/1	
06.33		BW 10		2183	1.3401		2120 M12	GX120 Mn12	F-8251	SEMn H1	
		Trade names									
02.1		OVAKO 520M (Ovako Steel)									
02.1		FORMAX (Uddeholm Tooling)									
02.1		IMACRO NIT (Imatra Steel)									
02.2		INEXA 482 (XM) (Inexa Profil)									
		S355J2G3(XM)									
		C45(XM)									
		16MnCrS5(XM)									
		INEXA280(XM)									
		070M20(XM)									
02.2		HARDOX 500 (SSAB – Swedish Steel Corp.)									
02.2		WELDOX 700 (SSAB – Swedish Steel Corp.)									

ISO	Coromant Material Classification (CMC)	Country									
		USA	Great Britain		Sweden	Germany		France	Italy	Spain	Japan
		Standard									
		AISI/SAE	BS	EN	SS	W.-nr.	DIN	AFNOR	UNI	UNE	JIS
M	Stainless steels										
	Ferritic/martensitic materials (05.11, 12 = Forged, 15.11, 12 = Cast)										
	05.11/15.11	403	403S17	-	2301	1.4000	X7Cr13	Z6C13	X6Cr13	F3110	SUS403
						1.4001	X7Cr14	-	-	F.8401	-
	05.11/15.11	416	416 S 21		2380	1.4005	X12CrS13	Z11CF13	X12 CrS 13	F-3411	SUS 416
	05.11/15.11	430	430S15	960	2320	1.4016	X8Cr17	Z8C17	X8Cr17	F3113	SUS430
	05.11/15.11	410	410S21	56A	2302	1.4006	X10Cr13	Z10C14	X12Cr13	F.3401	SUS410
	05.11/15.11	430	430S17	60	2320	-	X8Cr17	Z8C17	X8Cr17	F.3113	SUS430
	05.11/15.11	-	420S45	56D	2304	1.4034	X46Cr13	Z40CM	X40Cr14	F.3405	SUS420J2
								Z38C13M			
	05.11/15.11	405	405S17	-	-	1.4002	-	Z8CA12	X6CrAl13	-	-
	05.11/15.11	420	420S37	-	2303	1.4021	-	Z20C13	X20Cr13	-	-
	05.11/15.11	431	431S29	57	2321	1.4057	X22CrNi17	Z15CNi6.02	X16CrNi16	F.3427	SUS431
	05.11/15.11	430F	-	-	2383	1.4104	X12CrMoS17	Z10CF17	X10CrS17	F.3117	SUS430F
	05.11/15.11	434	434S17	-	2325	1.4113	X6CrMo17	Z8CD17.01	X8CrMo17	-	SUS434
	05.11/15.11	CA6-NM	425C11	-	2385	1.4313	X5CrNi13-4	Z4CND13.4M	(G)X6CrNi304	-	SCS5
	05.11/15.11	405	403S17	-	-	1.4724	X10CrA113	Z10C13	X10CrA112	F.311	SUS405
	05.11/15.11	430	430S15	60	-	1.4742	X10CrA118	Z10CAS18	X8Cr17	F.3113	SUS430
	05.11/15.11	HNV6	443S65	59	-	1.4747	X80CrNiSi20	Z80CSN20.02	X80CrSiNi20	F.320B	SUH4
	05.11/15.11	446	-	-	2322	1.4762	X10CrA124	Z10CAS24	X16Cr26	-	SUH446
	05.11/15.11	EV8	349S54	-	-	1.4871	X53CrMnNiN21-9	Z52CMN21.09	X53CrMnNiN21 9	-	SUH35, SUH36
	05.11/15.11	S44400	-	-	2326	1.4521	X1CrMoTi18-2	-	-	-	-
	05.11/15.11	-	-	-	2317	1.4922	X20CrMoV12-1	-	X20CrMoNi 12 01	-	-
	05.12/15.12	630	-	-	-	1.4542/ 1.4548	-	Z7CNU17-04	-	-	-
	Austenitic materials (05.21, 22, 23 = Forged, 15.21, 22, 23 = Cast)										
	05.21/15.21	304L	304S11	-	2352	1.4306	-	Z2CN18-10	X2CrNi18 11	-	-
	05.21/15.21	304	304S31	58E	2332/2333	1.4350	X5CrNi189	Z6CN18.09	X5CrNi18 10	F.3551 F.3541 F.3504	SUS304
	05.21/15.21	303	303S21	58M	2346	1.4305	X12CrNiS18-8	Z10CNF 18.09	X10CrNiS 18.09	F.3508	SUS303
	05.21/15.21	304	304S15	58E	2332	1.4301	X5CrNi18-9	Z6CN18.09	X5CrNi18 10	F.3551	SUS304
			304C12		2333			Z3CN19.10	-	-	SUS304L
	05.21/15.21	304L	304S12	-	2352	1.4306	X2CrNi18-9	Z2CrNi18 10	X2CrNi18 11	F.3503	SCS19
	05.21/15.21	301	-	-	2331	1.4310	X12CrNi17-7	Z12CN17.07	X12CrNi17 07	F.3517	SUS301
	05.21/15.21	304LN	304S62	-	2371	1.4311	X2CrNiN18-10	Z2CN18.10	-	-	SUS304LN
	05.21/15.21	316	316S16	58J	2347	1.4401	X5CrNiMo18-10	Z6CND17.11	X5CrNiMo17 12	F.3543	SUS316
	05.21/15.21	316LN	-	-	2375	1.4429	X2CrNiMoN18-13	Z2CND17.13	-	-	SUS316LN
	05.21/15.21	316L	316S13	-	2348	1.4404	-	Z2CND17-12	X2CrNiMo1712	-	-
	05.21/15.21	316L	316S13	-	2353	1.4435	X2CrNiMo18-12	Z2CND17.12	X2CrNiMo17 12	-	SCS16
								-	-	-	SUS316L
	05.21/15.21	316	316S33	-	2343	1.4436	-	Z6CND18-12-03	X8CrNiMo1713	-	-
					2347						
	05.21/15.21	317L	317S12	-	2367	1.4438	X2CrNiMo18-16	Z2CND19.15	X2CrNiMo18 16	-	SUS317L
	05.21/15.21	UNS	-	-	2562	1.4539	X1NiCrMo	Z2 NCDU25-20	-	-	-
	05.21/15.21	V 0890A									
	05.21/15.21	321	321S12	58B	2337	1.4541	X10CrNiTi18-9	Z6CNT18.10	X6CrNiTi18 11	F.3553 F.3523 F.3552 F.3524	SUS321
	05.21/15.21	347	347S17	58F	2338	1.4550	X10CrNiNb18-9	Z6CNNb18.10	X6CrNiNb18 11	-	SUS347
	05.21/15.21	316Ti	320S17	58J	2350	1.4571	X6CrNiMoTi-12-2	Z6NDT17.12	X6CrNiMoTi17 12	F.3535	-
	05.21/15.21	318	-	-	-	1.4583	X10CrNiMoNb 18-12	Z6CNDNb17 13B	X6CrNiMoNb17 13	-	-
	05.21/15.21	309	309S24	-	-	1.4828	X15CrNiSi20-12	Z15CNS20.12	-	-	SUH309
	05.21/15.21	310S	310S24	-	2361	1.4845	X12CrNi25-21	Z12CN25 20	X6CrNi25 20	F.331	SUH310
	05.21/15.21	308	301S21	58C	2370	1.4406	X10CrNi18.08	Z1NCDU25.20	-	F.8414	SCS17
	15.21	-	-	-	2387	1.4418	X4 CrNiMo16-5	Z6CND16-04-01	-	-	-
	05.22/15.22	17-7PH	316S111	-	-	1.4568/ 1.4504	-	Z8CNA17-07	X2CrNiMo1712	-	-
	05.23/15.23	NO8028	-	-	2584	1.4563	-	Z1NCDU31-27-03	-	-	-
	05.23/15.23	S31254	-	-	2378	-	-	Z1CNDU20-18-06AZ	-	-	-
	Austenitic / ferritic materials (Duplex) (05.51, 52 = Forged, 15.51, 52 = Cast)										
	05.51/15.51	S31500	-	-	2376	1.4417	X2CrNiMoSi19-5	-	-	-	-
	05.51/15.51	S32900	-	-	2324	-	X8CrNiMo27-5	-	-	-	-
	05.52/15.52	S32304	-	-	2327	-	X2CrNiN23-4	Z2CN23-04AZ	-	-	-
	05.52/15.52	-	-	-	2328	-	-	-	-	-	-
	05.52/15.52	S31803	-	-	2377	-	X2CrNiMoN22-53	Z2CND22-05-03	-	-	-

GENERAL INFORMATION

Material cross reference list

ISO	Coromant Material Classification (CMC)	Country										
		USA	Great Britain		Sweden	Germany		France	Italy	Spain	Japan	
		Standard										
		AISI/SAE	BS	EN	SS	W.-nr.	DIN	AFNOR	UNI	UNE	JIS	
M		Trade names										
		Stainless steels										
	05.21/15.21	SANMAC 304 (Sandvik Steel)										
	05.21/15.21	SANMAC 304L (Sandvik Steel)										
	05.21/15.21	SANMAC 316 (Sandvik Steel)										
	05.21/15.21	SANMAC 316L (Sandvik Steel)										
	05.23/15.23	254 SMO										
	05.23/15.23	654 SMO										
	05.23/15.23	SANMAC SANICRO (Sandvik Steel)										
05.52/15.52	SANMAC SAF 2205 (Sandvik Steel)											
05.52/15.52	SANMAC SAF 2507 (Sandvik Steel)											
K	Malleable cast iron											
	07.1			8 290/6		0814		-	MN 32-8		FCMB310	
	07.1	32510		B 340/12		0815		GTS-35	MN 35-10		FCMW330	
	07.2	40010		P 440/7		0852	0.8145	GTS-45	Mn 450	GMN 45	FCMW370	
	07.2	50005		P 510/4		0854	0.8155	GTS-55	MP 50-5	GMN 55	FCMP490	
		70003		P 570/3		0858		GTS-65	MP 60-3		FCMP540	
	07.2	A220-70003		P570/3		0856	0.8165	GTS-65-02	Mn 650-3	GMN 65	FCMP590	
	07.3	A220-80002		P690/2		0862	0.8170	GTS-70-02	Mn700-2	GMN 70	FCMP690	
	Grey cast iron											
	08.1					0100						
	08.1	No 20 B				0110		GG 10	Ft 10 D		FC100	
	08.1	No 25 B	Grade 150			0115	0.6015	GG 15	Ft 15 D	G 15	FC150	
	08.1	No 30 B	Grade 220			0120	0.6020	GG 20	Ft 20 D	G 20	FC200	
	08.2	No 35 B	Grade 260			0125	0.6025	GG 25	Ft 25 D	G 25	FC250	
		No 40 B										
	08.2	No 45 B	Grade 300			0130	0.6030	GG 30	Ft 30 D	G 30	FC300	
	08.2	No 50 B	Grade 350			0135	0.6035	GG 35	Ft 35 D	G 35	FC350	
	08.2	No 55 B	Grade 400			0140	0.6040	GG 40	Ft 40 D			
	08.3	A436 Type 2	L-NiCuCr202			0523	0.6660	GGL-NiCr202	L-NC 202	-	-	
	Nodular cast iron											
	09.1	60-40-18	SNG 420/12			0717-02	0.7040	GGG 40	FCS 400-12	GS 370-17	FGE 38-17	FCD400
	09.1	-	SNG 370/17			0717-12		GGG 40.3	FGS 370-17			
	09.1	-	-			0717-15	0.7033	GGG 35.3	-			
	09.1	80-55-06	SNG 500/7			0727-02	0.7050	GGG 50	FGS 500-7	GS 500	FGE 50-7	FCD500
	09.1	A43D2	Grade S6			0776	0.7660	GGG-NiCr202	S-NC 202	-	-	
	09.2	-	SNG 600/3			0732-03		GGG 60	FGS 600-3			FCD600
	09.2	100-70-03	SNG 700/2			0737-01	0.7070	GGG 70	FGS 700-2	GS 700-2	FGS 70-2	FCD700

ISO	Coromant Material Classification (CMC)	Country USA	Great Britain		Sweden	Germany		France	Italy	Spain	Japan	
		Standard										
		AISI/SAE	BS	EN	SS	W.-nr.	DIN	AFNOR	UNI	UNE	JIS	
N	Non-ferrous metals											
		30.21	SC64D	-	-	4251	3.2373	G-AISI9MGWA	A-S7G	-	-	C4BS
		30.21	GD-AISI12	LM5	-	4252	-	G-ALMG5	A-SU12	-	-	AC4A
		30.21/30.22	356.1	LM25		4244						A5052
			A413.0			4247		GD-AISi12				A6061
			A380.1	LM24		4250		GD-AISI8Cu3				A7075
			A413.1	LM20		4260		G-AISI12(Cu)				ADC12
	A413.2	LM6		4261		G-AISi12						
	A360.2	LM9		4253		G-AISI10Mg(Cu)						
S	Heat resistant super alloys											
		20.11	330	-	-	-	1.4864	X12NiCrSi36 16	Z12NCS35.16	F-3313	-	SUH330
		20.11	-	330C11	-	-	1.4865	G-X40NiCrSi38 18	-	XG50NiCr39 19	-	SCH15
		20.21	5390A	-	-	-	2.4603	-	NC22FeD	-	-	
		20.21	5666	-	-	-	2.4856	NiCr22Mo9Nb	NC22FeDNB	-	-	
		20.21	-	HR5.203-4	-	-	2.4630	NiCr20Ti	NC20T	-	-	
		20.22	5660	-	-	-	LW2.4662	NiFe35Cr14MoTi	ZSNCDT42	-	-	
		20.22	5391	3146-3	-	-	LW2 4670	S-NiCr13A16MoNb	NC12AD	-	-	
		20.22	5383	HR8	-	-	LW2.4668	NiCr19Fe19NbMo	NC19eNB	-	-	
		20.22	4676	3072-76	-	-	2.4375	NiCu30Al	-	-	-	
		20.22	-	Hr401.601	-	-	2.4631	NiCr20TiAk	NC20TA	-	-	
		20.22	AMS 5399	-	-	-	2.4973	NiCr19Co11MoTi	NC19KDT	-	-	
		20.22	AMS 5544	-	-	-	LW2.4668	NiCr19Fe19NbMo	NC20K14	-	-	
		20.24	AMS 5397	-	-	-	LW2 4674	NiCo15Cr10MoAlTi	-	-	-	
		20.32	5537C	-	-	-	LW2.4964	CoCr20W15Ni	KC20WN	-	-	
			AMS 5772	-	-	-	-	CoCr22W14Ni	KC22WN	-	-	
		Titanium alloys										
		23.22	AMS R54520	TA14/17	-	-	-	TiAl5Sn2.5	T-A5E	-	-	
		23.22	AMS R56400	TA10-13/TA28	-	-	-	TiAl6V4	T-A6V	-	-	
		23.22	AMS R56401	TA11	-	-	-	TiAl6V4ELI	-	-	-	
		23.22	-	-	-	-	-	TiAl4Mo4Sn4Si0.5	-	-	-	
		Trade names										
		20.11	Iron base									
			Incoloy 800									
		20.2	Nickel base									
		20.2	Haynes 600									
		20.2	Nimocast PD16									
		20.2	Nimonic PE 13									
		20.2	Rene 95									
		20.21	Hastelloy C									
		20.21	Incoloy 825									
		20.21	Inconel 600									
20.21	Monet 400											
20.22	Inconel 700											
20.22	Inconel 718											
20.22	Mar – M 432											
20.22	Nimonic 901											
20.22	Waspaloy											
20.24	Jessop G 64											
	Cobalt base											
20.3	Air Resist 213											
20.3	Jetalloy 209											
H	Hardened materials											
		04.1		-	-	2258-08	1.4108	X100CrMo13	-	-	-	C4BS
		04.1		-	-	2534-05	1.4111	X110CrMoV15	-	-	-	AC4A
		04.1		-	-	2541-06	-	X65CrMo14	-	-	-	AC4A

For the sake of the environment

Get into the Sandvik Coromant Recycling Concept (CRC) now!

The Sandvik Coromant Recycling Concept (CRC) is a comprehensive service for used carbide inserts and solid carbide tools offered by Sandvik Coromant to all its customers.

In the light of increasing consumption of non-renewable raw materials, the economic management of dwindling resources is a duty owed by all manufacturers.

Sandvik Coromant is playing its part by offering to collect used carbide inserts and solid carbide tools and recycle them in the most environmentally friendly way.

All used carbide inserts are collected in the collection box at the workplace.

When the collection box is sufficiently full, its contents are transferred to the transport box. The full transport box is then sent to the nearest Sandvik Coromant office or to your Sandvik Coromant dealer who can also give you more information.



The benefits of the CRC speak for themselves

- A worldwide ISO and OHAS certified recycling system.
- Open to all Sandvik Coromant customers.
- Simple procedure with collection and transport boxes.
- Less waste, easing the burden on the environment.
- Better utilisation of resources.
- Other manufacturers' carbide inserts are also accepted.



Order collection boxes for each lathe, milling machine, drill or for your machining centre. We recommend one collection box for inserts and one separate box for solid carbide tools for each cutting workplace.

For detailed instructions on how to sell your used cemented carbide, please visit www.sandvik.coromant.com and select your market.

Collection box (yellow):	Order numbers
Transport box for solid carbide tools (plywood):	91617
Transport box inserts (plywood):	92994
	92995

Code	Page	Code	Page	Code	Page
170-PFHN	D202	391.01T	G122	393.2063	G110
170-PFLN	D202	391.200	G128	393.277	E131
170-PFMN	D202	391.510	G127	393.37A	F50
170-PRHN	D202	391.530	G127	393.39A	F126
170-PRMN	D202	391.540	G127	393.45	G134
176M-PM	D208	391.60A	G118	393.45C	G134
260	D101	391.68A	F20,F24,F26	393.55	G134
316-BM	D221,D222	391.68B	F20,F24,F26	393.55C	G134
316-CM	D223,D224	391.68D	F20	393.69A	F26
316-FM	D220	391.68F	F20,F24,F26	393.CG	G136
316-HM	D218	391.68X	F22	393.CGA	G96
316-SM	D214,D215,D217,D219	392.14019Y	D294	393.CGP	G96
316-UM	D225	392.140EH	G102	393.CGS	G135
325	D189	392.140T	G122	393.T	G123
325R16	D190	392.272CG	G89	41005CG	G95
325R-BG	D191	392.272CGB	G90	416.2	E112
325R-HA	D190	392.272CGD	G88	420.5	E239-E297
325R-HB	D190	392.410 37A	F50	420.6	E238,E240,E242
326R-CH	D193	392.410 37B	F51	420.9S	E266,E267,E270,E271
326R-TH	D193	392.41005	G72	424.10	E210,E252
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