

CoroCut® QD

For secure parting off and deep grooving

B

Application

- Parting off
- Deep grooving
- When machining with long overhang

C

ISO application area:



D

Benefits and features

- Insert geometries optimize coolant access
- Insert grades with high edge-line security
- Chip breaking geometries
- Material alloy with high fatigue resistance
- No torque wrench needed, correct clamping force ensured with quick-release key
- Rail insert seat ensures stable, precise insert position

E

www.sandvik.coromant.com/corocutqd

Tools

- Coromant Capto® cutting units
- Parting blades
- Shank tools
- QST™ shank tools
- CoroTurn® SL heads

Inserts

- Insert grades and geometries dedicated for parting off
- Wiper inserts for excellent surface finish

F

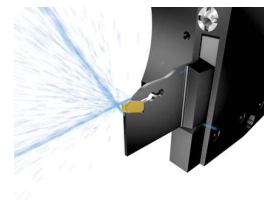
Key for insert indexing

Quick-release key for insert indexing with one hand.



Precision coolant

All tools have internal over- and under-coolant supply for chip control and tool life. The adaptors have plug and play function for easy connection in the machine.



G

H



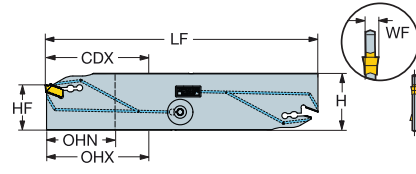
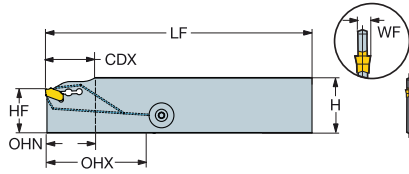
B 50



CoroCut® QD blade for parting

Spring lock design

Neutral coupling - Precision coolant supply



Single ended parting blade

SSC	CZC _{MS}	CDX	OHX	OHN	CNSC	Ordering code	Dimensions, mm					BAR	KG	MIID
							H	LF	WF	HF				
E	25	26.0	26.0	17.0	2	QD-NR1E26C25A	31.9	150.0	1.8	25.0	70	0.12	QD-NE-0200-0002-CM	
F	25	33.0	33.0	17.0	2	QD-NR1F33C25A	31.9	150.0	2.3	25.0	70	1.22	QD-NF-0250-0002-CM	
G	25	60.0	60.0	17.0	2	QD-NN1G60C25A	31.9	150.0	2.7	25.0	70	0.13	QD-NG-0300-0002-CM	
H	21	36.0	36.0	17.0	2	QD-NN1H36C21A	25.9	110.0	3.7	21.4	70	0.11	QD-NH-0400-0002-CM	
	25	60.0	60.0	17.0	2	QD-NN1H60C25A	31.9	150.0	3.7	25.0	70	0.16	QD-NH-0400-0002-CM	

Double ended parting blade

SSC	CZC _{MS}	CDX	OHX	OHN	CNSC	Ordering code	Dimensions, mm					BAR	KG	MIID
							H	LF	WF	HF				
D	25	16.0	50.0	18.0	2	QD-NR2D16C25A	31.9	150.0	2.5	25.0	70	0.10	QD-ND-0150-0001-CM	
E	25	26.0	60.0	26.0	2	QD-NR2E26C25A	31.9	150.0	2.6	25.0	70	0.12	QD-NE-0200-0002-CM	
F	25	33.0	60.0	33.0	2	QD-NR2F33C25A	31.9	150.0	2.6	25.0	70	0.11	QD-NF-0250-0002-CM	
G	21	36.0	36.0	19.0	2	QD-NN2G36C21A	25.9	110.0	2.7	21.4	70	0.09	QD-NG-0300-0002-CM	
	25	60.0	60.0	20.0	2	QD-NN2G60C25A	31.9	150.0	2.7	25.0	70	0.12	QD-NG-0300-0002-CM	
H	45	80.0	80.0	30.0	2	QD-NN2G80C45A	52.5	225.0	2.7	45.0	70	0.30	QD-NG-0300-0002-CM	
	25	60.0	60.0	20.0	2	QD-NN2H60C25A	31.9	150.0	3.7	25.0	70	0.15	QD-NH-0400-0002-CM	
J	45	80.0	80.0	30.0	2	QD-NN2H80C45A	52.5	225.0	3.7	45.0	70	0.38	QD-NH-0400-0002-CM	
	25	60.0	60.0	25.0	2	QD-NN2J60C25A	31.9	150.0	4.7	25.0	70	0.17	QD-NJ-0500-0002-CM	
K	45	80.0	80.0	30.0	2	QD-NN2J80C45A	52.5	225.0	4.7	45.0	70	0.45	QD-NJ-0500-0002-CM	
	25	60.0	60.0	24.0	2	QD-NN2K60C25A	31.9	150.0	5.7	25.0	70	0.20	QD-NK-0600-0003-CM	
L	45	80.0	80.0	30.0	2	QD-NN2K80C45A	52.5	225.0	5.7	45.0	70	0.53	QD-NK-0600-0003-CM	
	45	80.0	80.0	25.0	2	QD-NN2L80C45A	52.5	225.0	7.7	45.0	70	0.67	QD-NL-0800-0004-CM	

SSC = To correspond with SSC on insert.

N = Neutral, R = Right hand

		Spare parts	
SSC	CZC _{MS}	Coolant plug	Plug
D,E,F	25	5643 028-01	5645 040-01
G	21	5643 028-01	5645 040-02
G	25-45	5643 028-01	5645 040-01
H,J,K,L	21-45	5643 028-01	5645 040-01

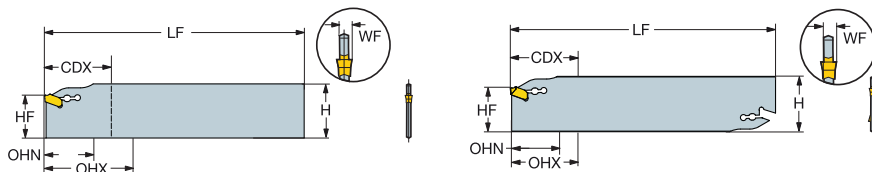
For complete list of spare parts, see www.sandvik.coromant.com



CoroCut® QD blade for parting

Spring lock design

Neutral coupling

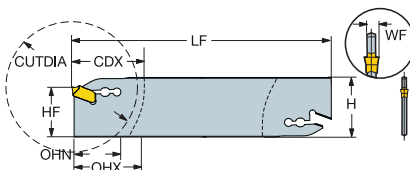


Single ended parting blade

SSC	CZC _{MS}	CDX	OHX	OHN	Ordering code	Dimensions, mm					MIID
						H	LF	WF	HF	KG	
E	25	26.0	26.0	17.0	QD-NR1E26-25A	31.9	150.0	1.8	25.0	0.11	QD-NE-0200-0002-CM
F	25	33.0	33.0	17.0	QD-NN1F33-25A	31.9	150.0	2.3	25.0	0.11	QD-NF-0250-0002-CM
G	25	60.0	60.0	17.0	QD-NN1G60-25A	31.9	150.0	2.7	25.0	0.12	QD-NG-0300-0002-CM
H	21	36.0	36.0	17.0	QD-NN1H36-21A	25.9	110.0	3.7	21.4	0.10	QD-NH-0400-0002-CM
	25	60.0	60.0	17.0	QD-NN1H60-25A	31.9	150.0	3.7	25.0	0.15	QD-NH-0400-0002-CM

Double ended parting blade

SSC	CZC _{MS}	CDX	OHX	OHN	Ordering code	Dimensions, mm					MIID
						H	LF	WF	HF	KG	
E	25	26.0	50.0	26.0	QD-NR2E26-25A	31.9	150.0	2.6	25.0	0.11	QD-NE-0200-0002-CM
F	21	33.0	35.0	17.0	QD-NN2F33-21A	25.9	110.0	2.3	21.4	0.01	QD-NF-0250-0002-CM
	25	33.0	50.0	17.0	QD-NN2F33-25A	31.9	150.0	2.3	25.0	0.10	QD-NF-0250-0002-CM
G	21	36.0	36.0	17.0	QD-NN2G36-21A	25.9	110.0	2.7	21.4	0.08	QD-NG-0300-0002-CM
	25	60.0	60.0	17.0	QD-NN2G60-25A	31.9	150.0	2.7	25.0	0.12	QD-NG-0300-0002-CM
	45	80.0	80.0	30.0	QD-NN2G80-45A	52.5	225.0	2.7	45.0	0.30	QD-NG-0300-0002-CM
H	25	60.0	60.0	17.0	QD-NN2H60-25A	31.9	150.0	3.7	25.0	0.15	QD-NH-0400-0002-CM
	45	80.0	80.0	30.0	QD-NN2H80-45A	52.5	225.0	3.7	45.0	0.38	QD-NH-0400-0002-CM
L	45	80.0	80.0	25.0	QD-NN2L80-45A	52.5	225.0	7.7	45.0	0.70	QD-NL-0800-0004-CM



Double ended parting blade with curved reinforcement

SSC	CZC _{MS}	CDX	OHX	OHN	Ordering code	Dimensions, mm					MIID	
						H	LF	WF	HF	CUTDIA		KG
E	21	26.0	50.0	26.0	QD-NR2E26-21D	25.9	110.0	2.6	21.4	52	0.08	QD-NE-0200-0002-CM

SSC = To correspond with SSC on insert.

N = Neutral, R = Right hand

For spare parts, visit www.sandvik.coromant.com



B51



F2



E1



ISO 13399



H36



H35



H20