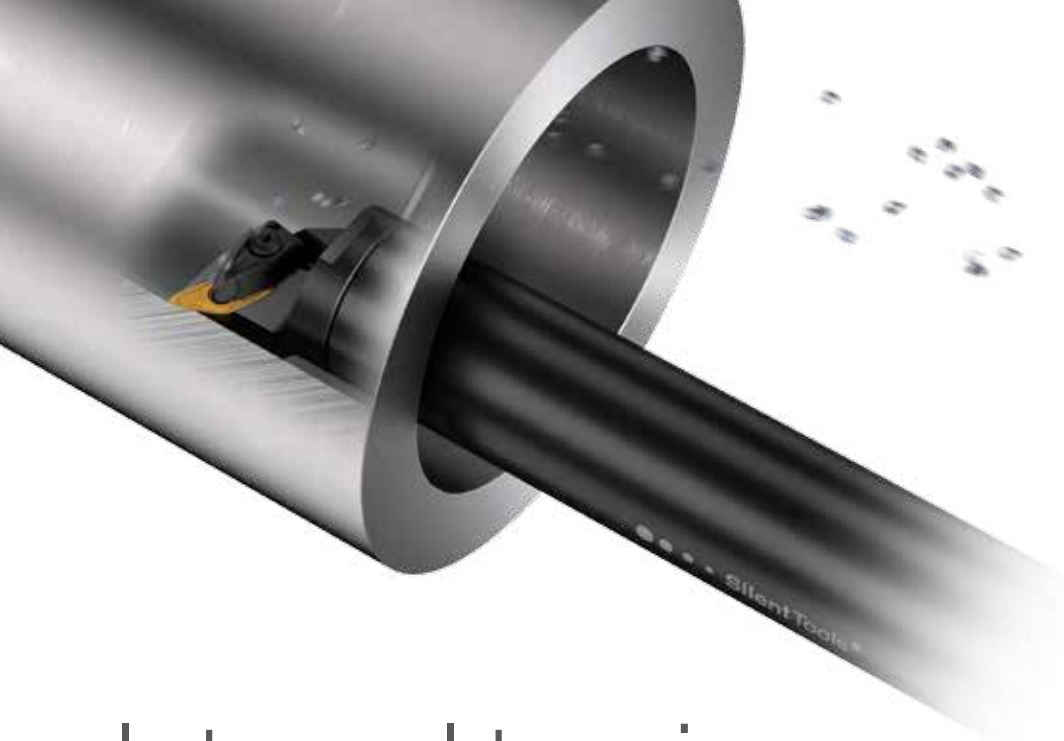


CoroTurn® Prime SL head for internal turning



Extraordinary productivity
for internal turning applications



Internal turning with excellent chip evacuation

It is now possible to use our PrimeTurning™ methodology for internal turning applications. The inside-out machining capability allows for excellent chip evacuation and chip control.

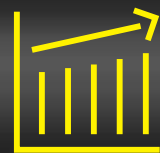
In addition, this CoroTurn® Prime SL head solution produces an excellent surface finish and offers high productivity, longer tool life and high machine utilization.



Saves tool change
and set-up time



Reduces inventory



Increases
productivity

Flexible tooling

With CoroTurn® Prime SL heads you can create a wide range of tool combinations from a small inventory of adaptors and cutting heads.

SL heads are available in diameter 40 mm (1.575 inch). They fit with solid steel bars and carbide bars, as well as with Silent Tools™ damped boring bars for vibration-free internal machining.



A-type

- Designed for light roughing, finishing and profiling
- Inside-out direction



B-type

- Designed for roughing
- Inside-out direction



B-type

- Designed for roughing
- Outside-in direction

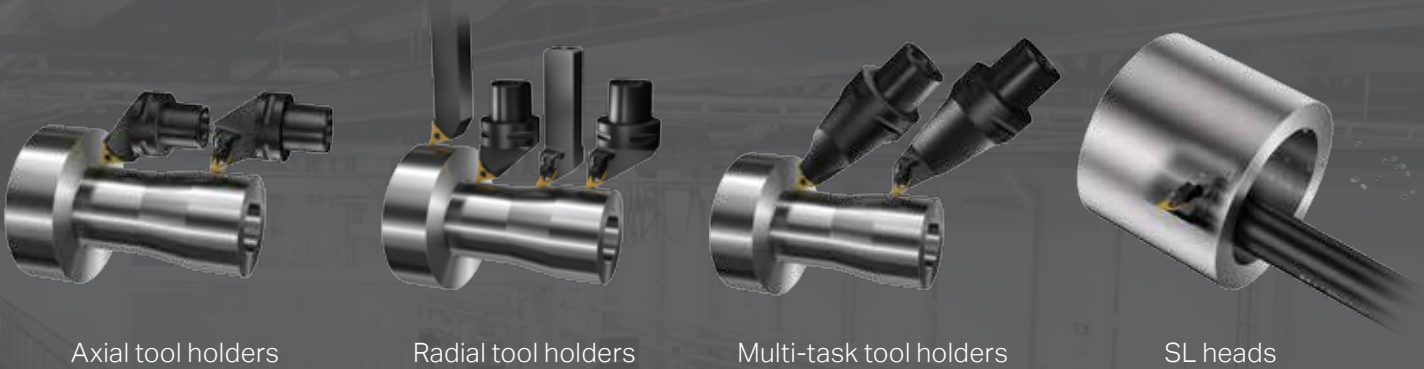
Application

- For internal turning of large diameters above 90 mm (3.5 inch) and overhangs up to 8–10×D
- For oil and gas, aerospace, and other industries where there is a need of internal machining of large diameter holes
- ISO P, M, K and S



CoroTurn® Prime tool holders

Our total offer for PrimeTurning™ now includes even more productive machining possibilities. Achieve increased productivity and profitability through fewer machine stoppages with new tool holders for turning centres, vertical lathes and multi-task machines.



Axial tool holders

Radial tool holders

Multi-task tool holders

SL heads

Customer case

Component: Ball bearing ring, internal diameter 300 mm (11.8 inch)

Material: CMC 02.2

Operation: Internal turning

Machine: EMAG vertical lathe



Roughing



Finishing

Increased chip control and superior surface finish

	Roughing	Finishing
Tool	SL-CP-25BR-40C	SL-CP-30AR-11C
Insert	CP-B1108-M5 4325	CP-A1108-L5W 4325
a_p mm (inch)	2 (0.079)	1 (0.039)
f_r mm/rev (in/rev)	0.8 (0.031)	0.4 (0.016)
v_c m/min (ft/min)	250 (820)	250 (820)

Results:

The chips were easily evacuated from the hole resulting in increased chip control and better surface finish. Seeing the result, the customer directly decided to implement CoroTurn® Prime SL heads to the complete production line.

For more information, please contact your local Sandvik Coromant representative.

Head office:
 AB Sandvik Coromant
 SE-811 81 Sandviken, Sweden
 E-mail: info.coromant@sandvik.com
www.sandvik.coromant.com

