

CoroCut® MB

For internal machining with high precision

B

Application

- For internal machining of small holes
- Pre-parting
- Grooving
- Face grooving
- Profiling
- Turning
- Copying
- Back boring
- Threading

C

ISO application area:



D

Benefits and features

- Vibration free machining
- Fast set up for both tool and insert
- Stable high precision interface between interface and tool holder
- Front-mounted exchangeable cutting tool
- Sharp cutting edges
- Geometries and grades for all materials
- Carbide shanks for long overhangs
- Through coolant
- Easy fix clamping
- Grooving tools in a large variety of widths and corner radii – also for standardized grooves such as O-rings and circlip grooves.



E

www.sandvik.coromant.com/corocutmb

F

EasyFix

Cylindrical steel and carbide boring bars to be used with EasyFix sleeves for exact centre height.

CoroCut® MB boring bars

For stability and accessibility the bars are designed with an eccentric head with oval cross section.

Adaptors

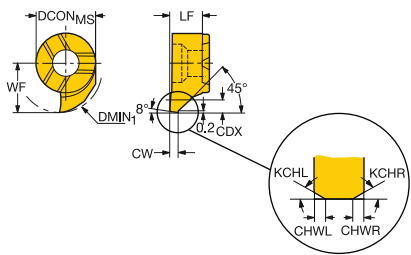
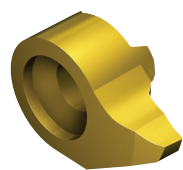
- Coromant Capto® to CoroTurn® XS adaptor
See page F22
- Rectangular shank to CoroTurn® XS adaptor
See page F33
- Cylindrical shank with flat to CoroTurn® XS adaptor
See page F42

G

Inserts

	Pre-parting	Grooving	Face grooving	Profiling	Turning	Copying	Back boring	Threading
								
	MB-..GX	MB-..G	MB-F	MB-..R	MB..T045	MB..TE93	MB..B	MB..TH
Insert width, mm	1.00	0.73-3.00	1.00-3.00					
Page	B123	B124	B127	Web	Web	Web	Web	C67

CoroCut® MB solid carbide head for pre-parting

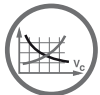


									P	M	N	S	O	Dimensions, mm		
	CZC _{MS}	CW	KCHL	KCHR	CHWL	CHWR	CDX	DMIN ₁	Ordering code					DCON _{MS}	LF	WF
	07	1.00	45°	45°	0.04	0.04	0.7	10.0	MB-07GX100-00-10R/L					7	3.9	5.8

CZC_{MS} to correspond with CZC_{WS} on adaptor. R = Right hand, L = Left hand

Tolerances:		
	CWTOLL	CWTOLU
MB..GX	0.000	0.050

 F2

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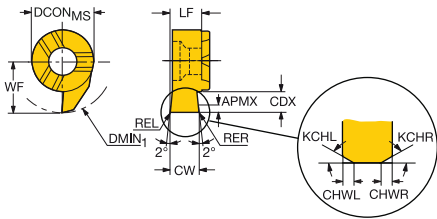
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CoroCut® MB solid carbide head for grooving

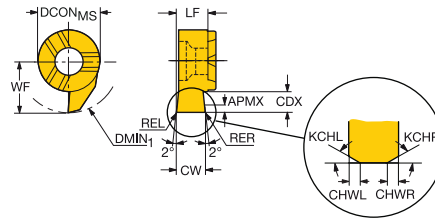


	CZC _{MS}	CW	REL	RER	KCHL	KCHR	CHWL	CHWR	CDX	DMIN ₁	Ordering code	P	M	N	S	H	O	Dimensions, mm		
												1025	1025	1025	1025	7015	1025	DCON _{MS}	LF	WF
	07	1.00			45°	45°	0.04	0.04	1.8	10.0	MB-07G100-00-10L	*	*	*	*	*	*	7	3.9	5.8
	07	1.00			45°	45°	0.04	0.04	1.8	10.0	MB-07G100-00-10R	*	*	*	*	*	*	7	3.9	5.8
	07	1.00			45°	45°	0.04	0.04	2.8	11.0	MB-07G100-00-11L	*	*	*	*	*	*	7	3.9	6.8
	07	1.00			45°	45°	0.04	0.04	2.8	11.0	MB-07G100-00-11R	*	*	*	*	*	*	7	3.9	6.8
	07	1.00			45°	45°	0.04	0.04	3.1	12.0	MB-07G100-00-12L	*	*	*	*	*	*	7	3.9	7.4
	07	1.00			45°	45°	0.04	0.04	3.1	12.0	MB-07G100-00-12R	*	*	*	*	*	*	7	3.9	7.4
	07	1.50			45°	45°	0.04	0.04	1.8	10.0	MB-07G150-00-10L	*	*	*	*	*	*	7	3.9	5.8
	07	1.50			45°	45°	0.04	0.04	1.8	10.0	MB-07G150-00-10R	*	*	*	*	*	*	7	3.9	5.8
	07	1.50			45°	45°	0.04	0.04	2.8	11.0	MB-07G150-00-11L	*	*	*	*	*	*	7	3.9	6.8
	07	1.50			45°	45°	0.04	0.04	2.8	11.0	MB-07G150-00-11R	*	*	*	*	*	*	7	3.9	6.8
	07	1.50			45°	45°	0.04	0.04	3.4	12.0	MB-07G150-00-12L	*	*	*	*	*	*	7	3.9	7.4
	07	1.50			45°	45°	0.04	0.04	3.4	12.0	MB-07G150-00-12R	*	*	*	*	*	*	7	3.9	7.4
	07	2.00			45°	45°	0.04	0.04	1.8	10.0	MB-07G200-00-10L	*	*	*	*	*	*	7	3.9	5.8
	07	2.00			45°	45°	0.04	0.04	1.8	10.0	MB-07G200-00-10R	*	*	*	*	*	*	7	3.9	5.8
	07	2.00			45°	45°	0.04	0.04	2.8	11.0	MB-07G200-00-11L	*	*	*	*	*	*	7	3.9	6.8
	07	2.00			45°	45°	0.04	0.04	2.8	11.0	MB-07G200-00-11R	*	*	*	*	*	*	7	3.9	6.8
	07	2.00			45°	45°	0.04	0.04	3.4	12.0	MB-07G200-00-12L	*	*	*	*	*	*	7	3.9	7.4
	07	2.00			45°	45°	0.04	0.04	3.4	12.0	MB-07G200-00-12R	*	*	*	*	*	*	7	3.9	7.4
	07	2.50			45°	45°	0.04	0.04	1.8	10.0	MB-07G250-00-10L	*	*	*	*	*	*	7	3.9	5.8
	07	2.50			45°	45°	0.04	0.04	1.8	10.0	MB-07G250-00-10R	*	*	*	*	*	*	7	3.9	5.8
	07	2.50			45°	45°	0.04	0.04	2.8	11.0	MB-07G250-00-11L	*	*	*	*	*	*	7	3.9	6.8
	07	2.50			45°	45°	0.04	0.04	2.8	11.0	MB-07G250-00-11R	*	*	*	*	*	*	7	3.9	6.8
	07	3.00			45°	45°	0.04	0.04	1.8	10.0	MB-07G300-00-10L	*	*	*	*	*	*	7	3.9	5.8
	07	3.00			45°	45°	0.04	0.04	1.8	10.0	MB-07G300-00-10R	*	*	*	*	*	*	7	3.9	5.8
	07	3.00			45°	45°	0.04	0.04	2.8	11.0	MB-07G300-00-11L	*	*	*	*	*	*	7	3.9	6.8
	07	3.00			45°	45°	0.04	0.04	2.8	11.0	MB-07G300-00-11R	*	*	*	*	*	*	7	3.9	6.8
	07	3.18			45°	45°	0.04	0.04	1.8	10.0	MB-07G318-00-10L	*	*	*	*	*	*	7	3.9	5.8
	07	3.18			45°	45°	0.04	0.04	1.8	10.0	MB-07G318-00-10R	*	*	*	*	*	*	7	3.9	5.8
	07	3.18			45°	45°	0.04	0.04	2.8	11.0	MB-07G318-00-11L	*	*	*	*	*	*	7	3.9	6.8
	07	3.18			45°	45°	0.04	0.04	2.8	11.0	MB-07G318-00-11R	*	*	*	*	*	*	7	3.9	6.8

CZC_{MS} to correspond with CZC_{WS} on adaptor. R = Right hand, L = Left hand

Tolerances:				
	CWTOLL	CWTOLU	RETOLL	RETOLU
MB..G	0.00	0.05	-0.02	0.02

CoroCut® MB solid carbide head for grooving



B

											P M N S H O						Dimensions, mm		
	CZC _{MS}	CW	REL	RER	KCHL	KCHR	CHWL	CHWR	CDX	DMIN ₁	Ordering code	1025	1025	1025	1025	7015	DCON _{MS}	LF	WF
	09	1.00			45°	45°	0.04	0.04	4.0	14.0	MB-09G100-00-14L	*	*	*	*	*	9	5.2	9.0
	09	1.00			45°	45°	0.04	0.04	4.0	14.0	MB-09G100-00-14R	*	*	*	*	*	9	5.2	9.0
	09	1.50			45°	45°	0.04	0.04	4.0	14.0	MB-09G150-00-14L	*	*	*	*	*	9	5.3	9.0
	09	1.50			45°	45°	0.04	0.04	4.0	14.0	MB-09G150-00-14R	*	*	*	*	*	9	5.3	9.0
	09	1.50			45°	45°	0.04	0.04	5.5	16.0	MB-09G150-00-16L	*	*	*	*	*	9	5.2	10.5
	09	1.50			45°	45°	0.04	0.04	5.5	16.0	MB-09G150-00-16R	*	*	*	*	*	9	5.2	10.5
	09	1.50			45°	45°	0.04	0.04	6.5	17.0	MB-09G150-00-17L	*	*	*	*	*	9	5.2	11.5
	09	1.50			45°	45°	0.04	0.04	6.5	17.0	MB-09G150-00-17R	*	*	*	*	*	9	5.2	11.5
	09	1.50	0.20	0.20					4.0	16.0	MB-09G150-02-16L	*	*	*	*	*	9	5.3	9.0
	09	1.50	0.20	0.20					4.0	16.0	MB-09G150-02-16R	*	*	*	*	*	9	5.3	9.0
	09	2.00			45°	45°	0.04	0.04	4.0	14.0	MB-09G200-00-14L	*	*	*	*	*	9	5.3	9.0
	09	2.00			45°	45°	0.04	0.04	4.0	14.0	MB-09G200-00-14R	*	*	*	*	*	9	5.3	9.0
	09	2.00			45°	45°	0.04	0.04	5.5	16.0	MB-09G200-00-16L	*	*	*	*	*	9	5.2	10.5
	09	2.00			45°	45°	0.04	0.04	5.5	16.0	MB-09G200-00-16R	*	*	*	*	*	9	5.2	10.5
	09	2.00			45°	45°	0.04	0.04	6.5	17.0	MB-09G200-00-17L	*	*	*	*	*	9	5.2	11.5
	09	2.00			45°	45°	0.04	0.04	6.5	17.0	MB-09G200-00-17R	*	*	*	*	*	9	5.2	11.5
	09	2.00	0.20	0.20					4.0	14.0	MB-09G200-02-14L	*	*	*	*	*	9	5.3	9.0
	09	2.00	0.20	0.20					4.0	14.0	MB-09G200-02-14R	*	*	*	*	*	9	5.3	9.0
	09	2.00	0.20	0.20					5.5	16.0	MB-09G200-02-16L	*	*	*	*	*	9	5.2	10.5
	09	2.00	0.20	0.20					5.5	16.0	MB-09G200-02-16R	*	*	*	*	*	9	5.2	10.5
	09	2.50			45°	45°	0.04	0.04	4.0	14.0	MB-09G250-00-14L	*	*	*	*	*	9	5.3	9.0
	09	2.50			45°	45°	0.04	0.04	4.0	14.0	MB-09G250-00-14R	*	*	*	*	*	9	5.3	9.0
	09	2.50			45°	45°	0.04	0.04	5.5	16.0	MB-09G250-00-16L	*	*	*	*	*	9	5.2	10.5
	09	2.50			45°	45°	0.04	0.04	5.5	16.0	MB-09G250-00-16R	*	*	*	*	*	9	5.2	10.5
	09	2.50			45°	45°	0.04	0.04	6.5	17.0	MB-09G250-00-17L	*	*	*	*	*	9	5.2	11.5
	09	2.50			45°	45°	0.04	0.04	6.5	17.0	MB-09G250-00-17R	*	*	*	*	*	9	5.2	11.5
	09	2.50	0.20	0.20					5.5	16.0	MB-09G250-02-16L	*	*	*	*	*	9	5.2	10.5
	09	2.50	0.20	0.20					5.5	16.0	MB-09G250-02-16R	*	*	*	*	*	9	5.2	10.5
	09	3.00			45°	45°	0.04	0.04	4.0	14.0	MB-09G300-00-14L	*	*	*	*	*	9	5.3	9.0
	09	3.00			45°	45°	0.04	0.04	4.0	14.0	MB-09G300-00-14R	*	*	*	*	*	9	5.3	9.0
	09	3.00			45°	45°	0.04	0.04	5.5	16.0	MB-09G300-00-16L	*	*	*	*	*	9	5.2	10.5
	09	3.00			45°	45°	0.04	0.04	5.5	16.0	MB-09G300-00-16R	*	*	*	*	*	9	5.2	10.5
	09	3.00			45°	45°	0.04	0.04	6.5	17.0	MB-09G300-00-17L	*	*	*	*	*	9	5.2	11.5
	09	3.00			45°	45°	0.04	0.04	6.5	17.0	MB-09G300-00-17R	*	*	*	*	*	9	5.2	11.5
	09	3.00	0.20	0.20					5.5	16.0	MB-09G300-02-16L	*	*	*	*	*	9	5.2	10.5
	09	3.00	0.20	0.20					5.5	16.0	MB-09G300-02-16R	*	*	*	*	*	9	5.2	10.5
	09	3.18			45°	45°	0.04	0.04	4.0	14.0	MB-09G318-00-14L	*	*	*	*	*	9	5.3	9.0
	09	3.18			45°	45°	0.04	0.04	4.0	14.0	MB-09G318-00-14R	*	*	*	*	*	9	5.3	9.0
	09	3.18	0.20	0.20					4.0	14.0	MB-09G318-02-14L	*	*	*	*	*	9	5.3	9.0
	09	3.18	0.20	0.20					4.0	14.0	MB-09G318-02-14R	*	*	*	*	*	9	5.3	9.0
	11	1.50	0.20	0.20					8.0	20.0	MB-11G150-02-20L	*	*	*	*	*	11	5.6	14.0
	11	1.50	0.20	0.20					8.0	20.0	MB-11G150-02-20R	*	*	*	*	*	11	5.6	14.0
	11	2.00	0.20	0.20					8.0	20.0	MB-11G200-02-20L	*	*	*	*	*	11	5.6	14.0
	11	2.00	0.20	0.20					8.0	20.0	MB-11G200-02-20R	*	*	*	*	*	11	5.6	14.0
	11	2.50	0.20	0.20					8.0	20.0	MB-11G250-02-20L	*	*	*	*	*	11	5.6	14.0
	11	2.50	0.20	0.20					8.0	20.0	MB-11G250-02-20R	*	*	*	*	*	11	5.6	14.0
	11	3.00	0.20	0.20					8.0	20.0	MB-11G300-02-20L	*	*	*	*	*	11	5.6	14.0
	11	3.00	0.20	0.20					8.0	20.0	MB-11G300-02-20R	*	*	*	*	*	11	5.6	14.0
	11	3.18	0.20	0.20					8.0	20.0	MB-11G318-02-20L	*	*	*	*	*	11	5.6	14.0
	11	3.18	0.20	0.20					8.0	20.0	MB-11G318-02-20R	*	*	*	*	*	11	5.6	14.0
	11	4.00	0.20	0.20					8.0	20.0	MB-11G400-02-20L	*	*	*	*	*	11	5.6	14.0
	11	4.00	0.20	0.20					8.0	20.0	MB-11G400-02-20R	*	*	*	*	*	11	5.6	14.0

D

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G

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand

Tolerances:

	CWTOLL	CWTOLU	RETOLL	RETOLU
MB..G	0.00	0.05	-0.02	0.02

H



F2



B134



B149



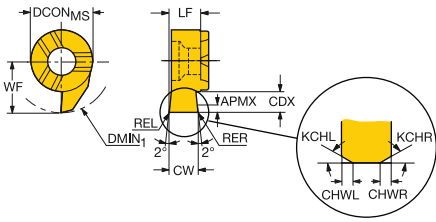
H36



H25

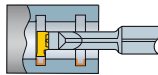
CoroCut® MB solid carbide head for grooving

For circlip grooves



B

C



D

										P	M	N	S	O	Dimensions, mm		
										1025	1025	1025	1025	1025	DCON _{MS}	LF	WF
CZC _{MS}	CW	KCHL	KCHR	CHWL	CHWR	CDX	DMIN ₁	Ordering code									
07	0.73	45°	45°	0.04	0.04	1.2	10.0	MB-07G070-00-10R/L	★	★	★	★	★	★	7	3.8	5.8
07	0.83	45°	45°	0.04	0.04	1.3	10.0	MB-07G080-00-10R/L	★	★	★	★	★	★	7	3.8	5.8
07	0.93	45°	45°	0.04	0.04	1.5	10.0	MB-07G090-00-10R/L	★	★	★	★	★	★	7	3.8	5.8
07	1.20	45°	45°	0.04	0.04	1.8	10.0	MB-07G120-00-10R/L	★	★	★	★	★	★	7	3.9	5.8
07	1.40	45°	45°	0.04	0.04	1.8	10.0	MB-07G140-00-10R/L	★	★	★	★	★	★	7	3.9	5.8
07	1.70	45°	45°	0.04	0.04	1.8	10.0	MB-07G170-00-10R/L	★	★	★	★	★	★	7	3.9	5.8
09	0.73	45°	45°	0.04	0.04	1.2	14.0	MB-09G070-00-14R/L	★	★	★	★	★	★	9	5.2	9.0
09	0.83	45°	45°	0.04	0.04	1.3	14.0	MB-09G080-00-14R/L	★	★	★	★	★	★	9	5.2	9.0
09	0.93	45°	45°	0.04	0.04	1.5	14.0	MB-09G090-00-14R/L	★	★	★	★	★	★	9	5.2	9.0
09	1.20	45°	45°	0.04	0.04	4.0	14.0	MB-09G120-00-14R/L	★	★	★	★	★	★	9	5.3	9.0
09	1.40	45°	45°	0.04	0.04	4.0	14.0	MB-09G140-00-14R/L	★	★	★	★	★	★	9	5.3	9.0
09	1.70	45°	45°	0.04	0.04	4.0	14.0	MB-09G170-00-14R/L	★	★	★	★	★	★	9	5.3	9.0

CZC_{MS} to correspond with CZC_{WS} on adaptor. R = Right hand, L = Left hand

Tolerances:		
	CWTOLL	CWTOLU
MB..G (CIRCLIP)	0.000	0.030

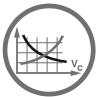
E

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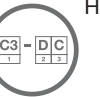
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F2

B134

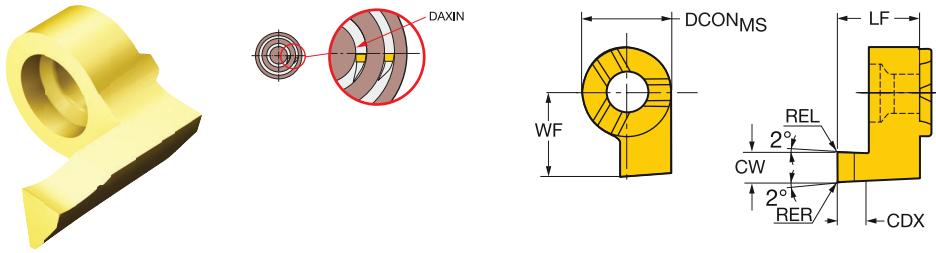
B149

H36

H25



CoroCut® MB solid carbide head for face grooving



A curve

												P	M	N	S	O	Dimensions, mm						
	CZC _{MS}	CW	REL	RER	KCHL	KCHR	CHWL	CDX	DAXIN	OHN	Ordering code	1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	CWTOLL	CWTOLU	RETOLL	RETOLU
	09	1.00			45°	45°	0.40	1.5	12.0		MB-09FA100-00-14R/L	★	★	★	★	★	9	8.3	9.0	0.000	0.050		
	09	1.50	0.20	0.20				2.5	11.0		MB-09FA150-02-14R/L	★	★	★	★	★	9	8.3	9.0	0.000	0.050	-0.02	0.02
	09	2.00	0.20	0.20				5.0	10.0		MB-09FA200-02-14R/L	★	★	★	★	★	9	10.3	9.0	0.000	0.050	-0.02	0.02
	09	2.50	0.20	0.20				5.0	9.0		MB-09FA250-02-14R/L	★	★	★	★	★	9	10.3	9.0	0.000	0.050	-0.02	0.02
	09	3.00	0.20	0.20				5.0	8.0		MB-09FA300-02-14R/L	★	★	★	★	★	9	10.3	9.0	0.000	0.050	-0.02	0.02
	09	3.18	0.20	0.20				5.0	7.6	10.3	MB-09FA318-02-14R/L	★	★	★	★	★	9	10.3	9.0	0.000	0.050	-0.02	0.02
	11	3.00	0.20	0.20				10.0	10.0		MB-11FA300-02-16R/L	★	★	★	★	★	11	15.8	11.0	0.000	0.050	-0.02	0.02
	11	4.00	0.20	0.20				10.0	8.0		MB-11FA400-02-16R/L	★	★	★	★	★	11	15.8	11.5	0.000	0.050	-0.02	0.02

B curve

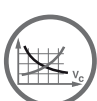
												P	M	N	S	O	Dimensions, mm						
	CZC _{MS}	CW	REL	RER	KCHL	KCHR	CHWL	CDX	DAXIN	OHN	Ordering code	1025	1025	1025	1025	1025	DCON _{MS}	LF	WF	CWTOLL	CWTOLU	RETOLL	RETOLU
	09	1.00			45°	45°	0.40	1.5	10.0		MB-09FB100-00-14R/L	★	★	★	★	★	9	8.3	7.0	0.000	0.050		
	09	1.50	0.20	0.20				2.5	9.0		MB-09FB150-02-14R/L	★	★	★	★	★	9	8.3	7.5	0.000	0.050	-0.02	0.02
	09	2.00	0.20	0.20				5.0	8.0		MB-09FB200-02-14R/L	★	★	★	★	★	9	10.3	8.0	0.000	0.050	-0.02	0.02
	09	2.50	0.20	0.20				5.0	7.0		MB-09FB250-02-14R/L	★	★	★	★	★	9	10.3	8.5	0.000	0.050	-0.02	0.02
	09	3.00	0.20	0.20				5.0	6.0		MB-09FB300-02-14R/L	★	★	★	★	★	9	10.3	9.0	0.000	0.050	-0.02	0.02
	09	3.18	0.20	0.20				5.0	5.6	10.3	MB-09FB318-02-12R/L	★	★	★	★	★	9	10.3	9.2	0.000	0.030	0.02	0.02
	11	3.00	0.20	0.20				10.0	10.0		MB-11FB300-02-16R/L	★	★	★	★	★	11	15.8	11.0	0.000	0.050	-0.02	0.02
	11	4.00	0.20	0.20				10.0	8.0		MB-11FB400-02-16R/L	★	★	★	★	★	11	15.8	12.0	0.000	0.050	-0.02	0.02

CZC_{MS} to correspond with CZC_{WS} on adaptor.

R = Right hand, L = Left hand



F2



B134



B149

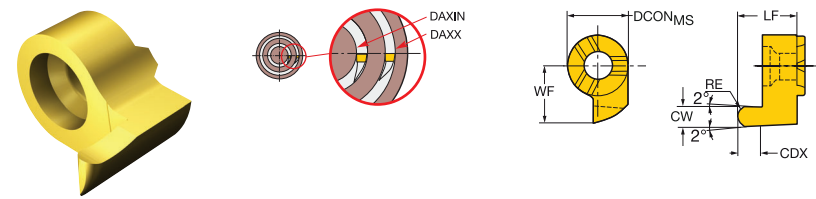


H36



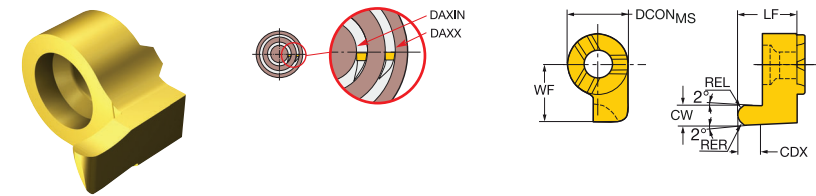
H25

CoroCut® MB solid carbide head for face grooving



A curve

	CZC _{MS}	CW	REL	RER	CDX	DAXIN	Ordering code	P	M	N	S	O	Dimensions, mm		
								1025	1025	1025	1025	1025			
								★	★	★	★	★	DCON _{MS}	LF	WF
	09	1.00	0.50	0.50	1.5	12.0	MB-09FAR100-05-14R/L	★	★	★	★	★	9	8.3	9.0
	09	1.50	0.75	0.75	2.5	11.0	MB-09FAR150-075-14R/L	★	★	★	★	★	9	8.3	9.0
	09	2.00	1.00	1.00	5.0	10.0	MB-09FAR200-10-14R/L	★	★	★	★	★	9	10.3	9.0
	09	2.50	1.25	1.25	5.0	9.0	MB-09FAR250-125-14R/L	★	★	★	★	★	9	10.3	9.0
	09	3.00	1.50	1.50	5.0	8.0	MB-09FAR300-15-14R/L	★	★	★	★	★	9	10.3	9.0



B curve

	CZC _{MS}	CW	REL	RER	CDX	DAXIN	Ordering code	P	M	N	S	O	Dimensions, mm		
								1025	1025	1025	1025	1025			
								★	★	★	★	★	DCON _{MS}	LF	WF
	09	1.00	0.50	0.50	1.5	10.0	MB-09FBR100-05-12R/L	★	★	★	★	★	9	8.3	7.0
	09	1.50	0.75	0.75	2.5	9.0	MB-09FBR150-075-14R/L	★	★	★	★	★	9	8.3	7.5
	09	2.00	1.00	1.00	5.0	8.0	MB-09FBR200-10-14R/L	★	★	★	★	★	9	10.3	8.0
	09	2.50	1.25	1.25	5.0	7.0	MB-09FBR250-125-14R/L	★	★	★	★	★	9	10.3	8.5
	09	3.00	1.50	1.50	5.0	6.0	MB-09FBR300-15-14R/L	★	★	★	★	★	9	10.3	9.0

CZC_{MS} to correspond with CZC_{WS} on adaptor. R = Right hand, L = Left hand

Tolerances:				
	CWTOLL	CWTOLU	RETOLL	RETOLU
MB..FAR	0.000	0.030	0.00	0.02
MB..FBR	0.000	0.030	0.00	0.02