





Tightening torque values for boring tools



Coromant Capto®

Size		
C3	40-50	30-37
C4	50-60	37-44
C5	90-100	67-74
C6-C8	160-180	118-133
C10	380	283



CoroBore® 820

Slide Diameter					
mm	inch	ISO	ANSI		
35-45	1.378-1.772	CC06	CC2(1.5)	4.8	3.5
44-56	1.732-2.205	CC06	CC2(1.5)	9.0	6.6
55-87	2.165-3.425	CC09	CC3(2.5)	16.0	11.8
86-107	3.386-4.213	SC09	SC3(2.5)		
		CC12	CC43	38.0	28.0
106-167	4.173-6.575	SC12	CC43		
		CC12	CC43	75.0	55.3
166-191	6.535-7.520	SC12	CC43		
		CC12	CC43	75.0	55.3
166-191	6.535-7.520	SC12	CC43		
		CN16	CN54	120.0	88.5
189-214	7.441-8.425	SN15	SN54		
		CC12	CC43	75.0	55.3
189-214	7.441-8.425	SC12	CC43		
		CN16	CN54	120.0	88.5
212-237	8.346-9.331	SN15	SN54		
		CC12	CC43	75.0	55.3
212-237	8.346-9.331	SC12	CC43		
		CN16	CN54	120.0	88.5
235-260	9.252-10.236	SN15	SN54		
		CC12	CC43	75.0	55.3
235-260	9.252-10.236	SC12	CC43		
		CN16	CN54	120.0	88.5
258-283	10.157-11.142	SN15	SN54		
		CC12	CC43	75.0	55.3
258-283	10.157-11.142	SC12	CC43		
		CN16	CN54	120.0	88.5
281-306	11.063-12.047	SN15	SN54		
		CC12	CC43	75.0	55.3
281-306	11.063-12.047	SC12	CC43		
		CN16	CN54	120.0	88.5
		SN15	SN54		

DuoBore™ 821 and DuoBore™ 821D

Diameter				Slide	
mm	inch	ISO	ANSI		
25-47	.984-1.850	CC06	CC2(1.5)	4.8	3.5
		TC11	TC2(1.5)		
46-56	1.811-2.205	TC16	TC3(2.5)	9.0	6.6
		SC09	SC3(2.5)		
55-70	2.165-2.756	TC16	TC3(2.5)	16.0	11.8
		SC09	SC3(2.5)		
69-84	2.717-3.307	TC16	TC3(2.5)	16.0	11.8
		SC12	CC43		
69-84	2.717-3.307	CN12	CN43	75.0	55.0
		SN12	SN43		
83-101	3.268-3.976	TC16	TC3(2.5)	16.0	11.8
		TC22	TC43		
83-101	3.268-3.976	SC12	CC43		
		CN12	CN43	75.0	55.0
99-125	3.898-4.921	SN12	SN43		
		TC16	TC3(2.5)	38.0	28.0
99-125	3.898-4.921	TC22	TC43		
		SC12	CC43		
99-125	3.898-4.921	CN12	CN43	120.0	88.5
		CN16	CN54		
123-150	4.843-5.906	SN12	SN43		
		SN15	SN54		
123-150	4.843-5.906	TC16	TC3(2.5)	38.0	28.0
		TC22	TC43		
123-150	4.843-5.906	SC12	CC43		
		CN12	CN43	120.0	88.5
123-150	4.843-5.906	CN16	CN54		
		SN12	SN43		
		SN15	SN54		

CoroBore® 820 XL

		
Bridge	200	148
Slide	60	44
Cartridge	60	44
Insert screw (CoroTurn 107)	3	2.2
Insert clamping (CoroTurn RC)	6.4	4.7

Tightening torque values for boring tools

CoroBore® 825 and 825D

Diameter		Cartridge screw and Locking screw		Insert screw			
mm	inch			ISO	ANSI	Nm	Ft/lbs
19-36	.748-1.417	Cylindrical shank		TC06	TC1.2(1.2)	0.6	0.4
19-36	.748-1.417	Coromant Capto®		TC09	TC1.8(1.5)	0.8	0.6
35-56	1.378-2.205			TC11	TC22	0.9	0.7
55-167	2.165-6.575			CC09	CC3(2.5)	3.0	2.2

CoroBore® 825/826 XL - Diameter 315-1275 mm (12.402-50.197 inch)

	ISO	ANSI	Nm	Ft/lbs
Bridge			200	148
Slide			60	44
Cartridge			60	44
Fine boring head			16	12
Cartridge screw			6.0	4.4
Insert screw	TC/TP11	TC/TP22	0.9	0.7
Insert screw	CC09	CC3(2.5)	3.0	2.2

CoroBore® 825 SL XL (Large diameter face grooving)

	Nm	Ft/lbs
Face grooving head (A34)	16	12
Locking screw	8	6
Blade	9	6.6

CoroBore 825/826XL and 825D/826D XL - Diameter 150-315 mm (5.906-12.402 inch)

	Nm	Ft/lbs
Slide	60	44
Counterweight	60	44
Fine boring head 825/826	16	12
Cartridge screw	6.0	4.4
Locking screw	6.0	4.4
Insert screw (TC/TP)	0.9	0.7
Insert screw (CC09)	3.0	2.2

Coromant EH coupling

Size	Nm	Ft/lbs
16	30	22
20	50	37
25	65	48

CoroBore® 825/826 XL - Diameter 298-1275 mm (11.732-50.197 inch)

	Nm	Ft/lbs
Bridge		
Slide	60	44
Cartridge	60	44
Insert screw (CoroTurn 107)	0.9	0.7
Insert screw (CoroTurn RC)	3.0	2.2

CoroBore® 825 SL (Small diameter face grooving)

	Nm	Ft/lbs
Face grooving head (S20)	16	12
Locking screw	8	6
Counterweight	8	6
Blade	9	6.6