

CoroThread® 266

Ultra-rigid thread turning for all types of threads

B

Application

- External threads
- Internal threads

ISO application area:



C

Benefits and features

- Reduced machine- and downtime
- Excellent surface finish due to the exceptional stability
- Three sharp cutting edges for high-quality threads
- Multi-point inserts available, require fewer passes resulting in increased productivity
- Large standard product range of tools and thread profile inserts
- Unique guide rail interface between the insert and tip seat
- Good edge indexing
- Easy to mount the insert correctly

D

High precision coolant from above controls the chip breaking for secure machining, while under coolant controls the temperature for long and predictable tool life.



E

www.sandvik.coromant.com/corothread266

Inserts

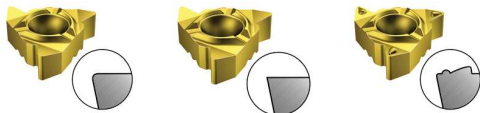
- Insert geometries and grades for all materials
- Tailor Made inserts for almost any thread form or pitch

Tools

- Coromant Capto® cutting units
- Shank tools
- Boring bars
- CoroTurn® SL heads



F



Standard A-geometry Sharp F-geometry Chip-breaking C-geometry

Three different threading insert types

G

Full profile

High productivity

V-profile

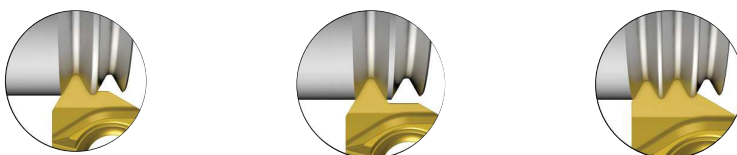
Minimum tool inventory

Multi-point

Economical mass production

Secure iLock™ clamping

The slotted insert sits rigidly on the T-rails in the pocket eliminating any insert movement caused by cutting force variations.

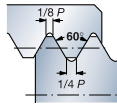


H

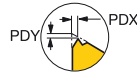


CoroThread® 266 insert for thread turning

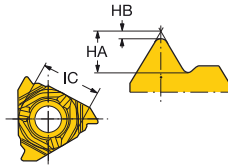
Metric 60° Full form



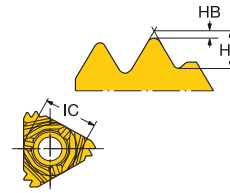
STDNO
TCTR



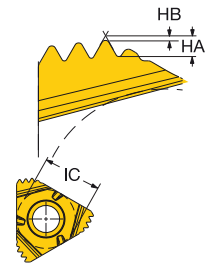
ISO 965-1998
IT 6



ISO 965-1998
IT 6



ISO 965-1998
IT 6



Internal right-hand threads

| TP | NT | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | | |
|----|------|---------------|-------------------|------|------|------|------|------|------|------|------|------|------|------|----|----|------|------|------|------|
| | | | P | | M | | K | | N | | S | | H | | HA | HB | PDX | PDY | | |
| | | | 1020 | 1125 | 1135 | 1020 | 1125 | 1135 | 1020 | 1125 | 1135 | 1020 | 1125 | 1135 | | | | | 1020 | 1125 |
| 16 | 0.50 | 1 | 266RL-16MM01A050M | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.32 | 0.03 | 0.50 | 1.30 |
| | 0.75 | 1 | 266RL-16MM01A075M | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.47 | 0.04 | 0.50 | 1.30 |
| | 1.00 | 1 | 266RL-16MM01A100M | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.64 | 0.06 | 0.80 | 1.30 |
| | 1.00 | 1 | 266RL-16MM01C100M | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.64 | 0.06 | 0.80 | 1.30 |
| | 1.00 | 1 | 266RL-16MM01F100E | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.64 | 0.06 | 0.80 | 1.30 |
| | 1.25 | 1 | 266RL-16MM01A125M | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.79 | 0.07 | 0.80 | 1.30 |
| | 1.25 | 1 | 266RL-16MM01C125M | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.79 | 0.07 | 0.80 | 1.30 |
| | 1.25 | 1 | 266RL-16MM01F125E | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.79 | 0.07 | 0.80 | 1.30 |
| | 1.50 | 1 | 266RL-16MM01A150M | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.96 | 0.09 | 1.00 | 1.30 |
| | 1.50 | 1 | 266RL-16MM01C150M | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.96 | 0.09 | 1.50 | 1.43 |
| | 1.50 | 1 | 266RL-16MM01F150E | * | * | * | * | * | * | * | * | * | * | * | * | * | 0.96 | 0.09 | 1.00 | 1.30 |
| | 1.75 | 1 | 266RL-16MM01A175M | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.11 | 0.11 | 1.20 | 1.30 |
| | 1.75 | 1 | 266RL-16MM01C175M | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.11 | 0.11 | 1.20 | 1.30 |
| | 1.75 | 1 | 266RL-16MM01F175E | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.11 | 0.11 | 1.20 | 1.30 |
| | 2.00 | 1 | 266RL-16MM01A200M | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.27 | 0.12 | 1.40 | 1.30 |
| | 2.00 | 1 | 266RL-16MM01C200M | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.27 | 0.12 | 1.40 | 1.30 |
| | 2.00 | 1 | 266RL-16MM01F200E | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.27 | 0.12 | 1.40 | 1.30 |
| | 2.50 | 1 | 266RL-16MM01A250M | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.59 | 0.16 | 1.40 | 1.30 |
| | 2.50 | 1 | 266RL-16MM01C250M | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.59 | 0.16 | 1.40 | 1.30 |
| | 2.50 | 1 | 266RL-16MM01F250E | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.59 | 0.16 | 1.40 | 1.30 |
| | 3.00 | 1 | 266RL-16MM01A300M | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.92 | 0.19 | 1.80 | 1.30 |
| | 3.00 | 1 | 266RL-16MM01C300M | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.92 | 0.19 | 1.80 | 1.30 |
| | 3.00 | 1 | 266RL-16MM01F300E | * | * | * | * | * | * | * | * | * | * | * | * | * | 1.92 | 0.19 | 1.80 | 1.30 |
| 22 | 3.50 | 1 | 266RL-22MM01A350M | * | * | * | * | * | * | * | * | * | * | * | * | * | 2.24 | 0.26 | 2.50 | 1.64 |
| | 4.00 | 1 | 266RL-22MM01A400M | * | * | * | * | * | * | * | * | * | * | * | * | * | 2.56 | 0.30 | 2.50 | 1.64 |
| | 4.50 | 1 | 266RL-22MM01A450M | * | * | * | * | * | * | * | * | * | * | * | * | * | 2.89 | 0.33 | 2.50 | 1.64 |
| | 5.00 | 1 | 266RL-22MM01A500M | * | * | * | * | * | * | * | * | * | * | * | * | * | 3.21 | 0.38 | 2.50 | 1.35 |
| | 5.50 | 1 | 266RL-22MM01A550M | * | * | * | * | * | * | * | * | * | * | * | * | * | 3.54 | 0.40 | 2.50 | 1.06 |
| | 6.00 | 1 | 266RL-22MM01A600M | * | * | * | * | * | * | * | * | * | * | * | * | * | 3.86 | 0.47 | 2.40 | 0.87 |

Internal right-hand threads - multipoint insert

| TP | NT | Ordering code | Dimensions, mm | | | | | | | | | | | | | | | | |
|----|------|---------------|-------------------|------|------|------|------|------|------|------|------|------|----|----|-----|------|------|------|------|
| | | | P | | M | | K | | N | | S | | HA | HB | PDX | PDY | | | |
| | | | 1020 | 1125 | 1135 | 1020 | 1125 | 1135 | 1020 | 1125 | 1135 | 1020 | | | | | 1125 | 1135 | |
| 16 | 1.00 | 3 | 266RL-16MM03A100M | * | * | * | * | * | * | * | * | * | * | * | * | 0.64 | 0.06 | 2.40 | 1.59 |
| | 1.50 | 2 | 266RL-16MM02A150M | * | * | * | * | * | * | * | * | * | * | * | * | 0.96 | 0.14 | 2.25 | 1.41 |
| | 2.00 | 2 | 266RL-16MM02A200M | * | * | * | * | * | * | * | * | * | * | * | * | 1.27 | 0.12 | 2.85 | 1.79 |
| 22 | 2.50 | 2 | 266RL-22MM02A250E | * | * | * | * | * | * | * | * | * | * | * | * | 1.59 | 0.16 | 3.50 | 1.93 |
| | 3.00 | 2 | 266RL-22MM02A300E | * | * | * | * | * | * | * | * | * | * | * | * | 1.98 | 0.19 | 4.40 | 2.70 |

R = Right hand



C30



C39



C73



C83



H36



H35



H26