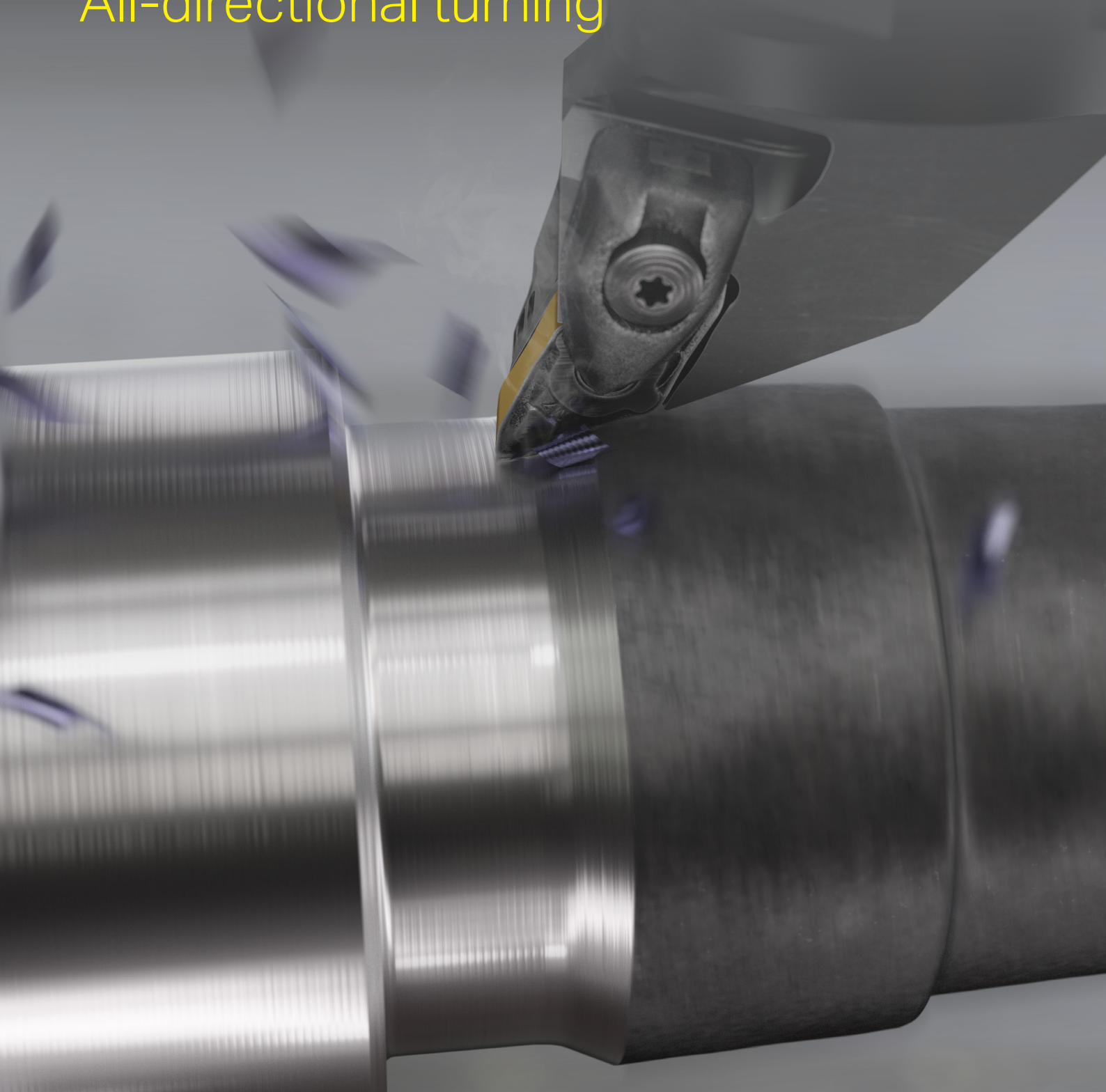


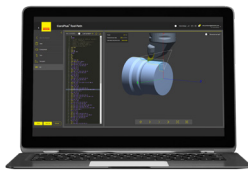
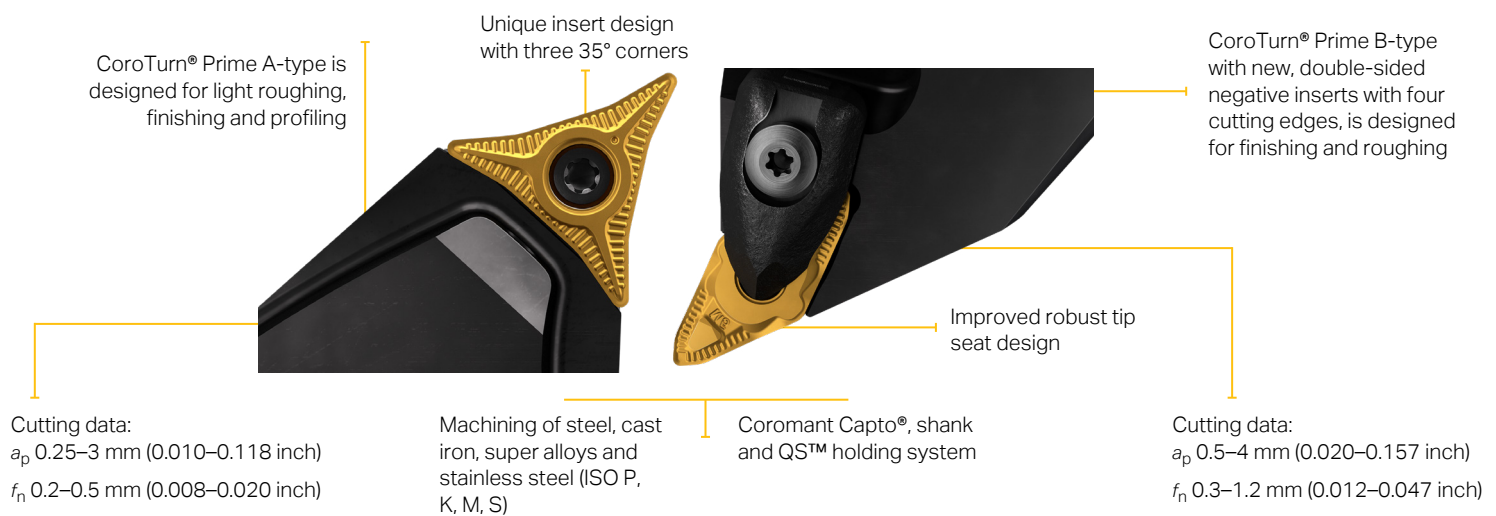
PrimeTurning™

All-directional turning



The biggest innovation in turning... since turning

PrimeTurning™ enables you to do turning in all directions in a much more efficient and productive way compared to conventional turning. This concept is comprised of the PrimeTurning™ method, CoroTurn® Prime turning tools and the CoroPlus® Tool Path for PrimeTurning™ software.

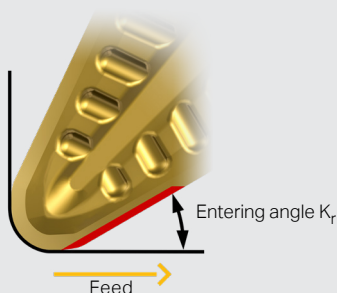


Secure maximum output by using the CoroPlus® Tool Path for PrimeTurning™ software. The software supplies programming codes and techniques to set up proper parameters and variables for your application.

Success factors

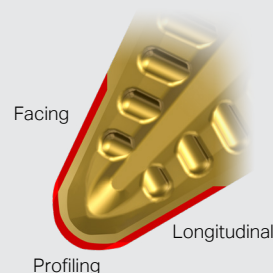
The key attributes of PrimeTurning™ that result in increased productivity and long-lasting tool life:

Small entering angle



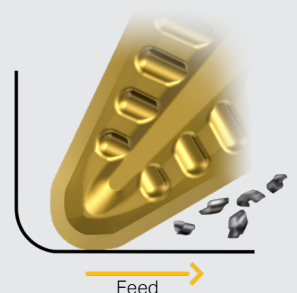
Thin and wide chips spread the load and heat away from the nose radius.

Efficient edge utilization



Three edges distribute wear over a longer edge and move heat away from the cutting zone.

No chip jamming



By turning away from the shoulder, the risk of chip jamming is eliminated.

Why should you switch to PrimeTurning™?



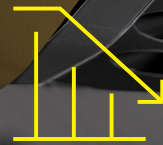
Reliable, secure
and cost-efficient
machining

>50%

Productivity
increase



Longer lasting
inserts



Optimized tool
inventory



Higher machine
utilization

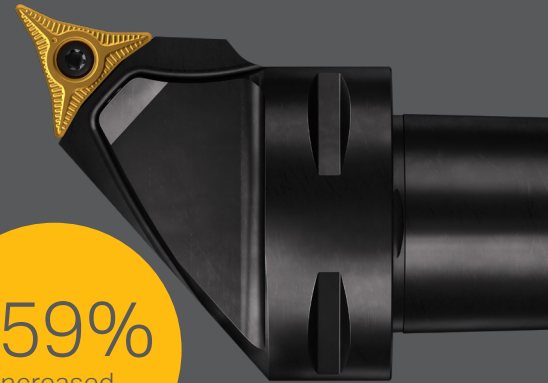


Faster metal
removal rates

Productivity gains with PrimeTurning™ and CoroTurn® Prime

CoroTurn® Prime A-type

Material:	Cast, SAE 1045, CMC 02.1, 207 HB	
Coolant:	Emulsion	
	Competitor insert	CoroTurn® Prime A-type (CP-A1108-L5 4325)
v_c , m/min (ft/min)	300 (984)	300 (984)
f_n , mm/rev (in/rev)	0.25 (0.010)	0.4 (0.016)
a_p , mm (inch)	1.5 (0.059)	3 (0.118)
Result:		
Total cycle time	70 sec	44 sec
Total life/edge	360 pcs	558 pcs



+59%
Increased
productivity

CoroTurn® Prime B-type

Material:	Stainless steel, M1.0.Z.AQ (1.4435)	
Operation:	Roughing, external PrimeTurning™	
	Existing insert (CNMG 190612-QM 4335)	CoroTurn® Prime B-type gen 2 (CP-B1208D-L4 4425)
v_c , m/min (ft/min)	80 (262)	180 (591)
f_n , mm/rev (in/rev)	0.4 (0.016)	0.9 (0.035)
a_p , mm (inch)	4.5 (0.177)	3 (0.118)
MRR, cm³/min (in³/min)	144 (8.79)	486 (29.7)
Time in cut, min	180	120
Result:		
Tool life, pcs	0.19	0.30



+93%
Increased
productivity

Visit our website to see PrimeTurning™ in action: www.sandvik.coromant.com/primeturning

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

C-1040:302 en-GB © AB Sandvik Coromant 2022

SANDVIK
Coromant