

Drehen *Turning*

1

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

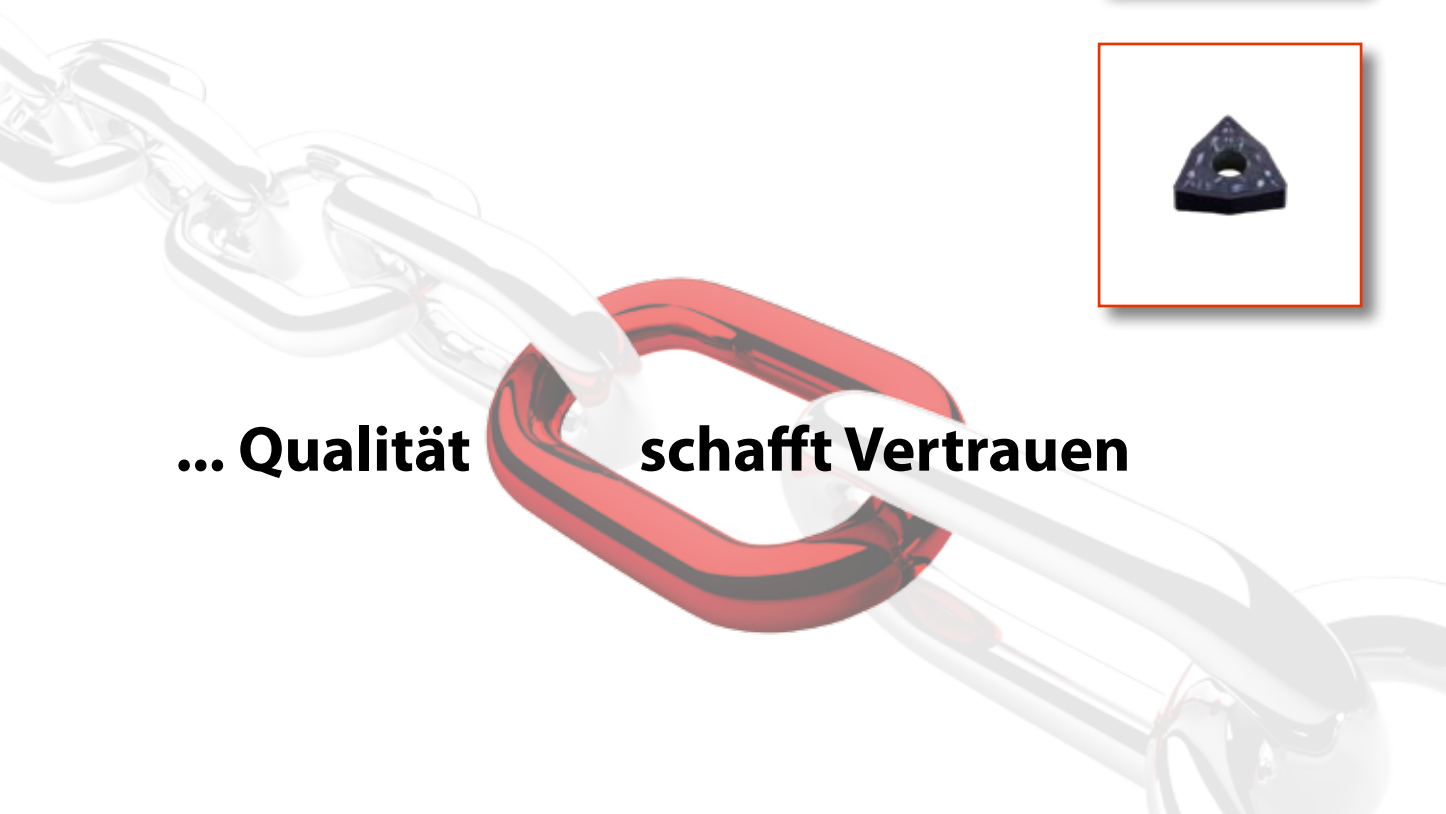
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills



... Qualität schafft Vertrauen





Drehen
Turning

Fräswerkzeuge
Milling Tools

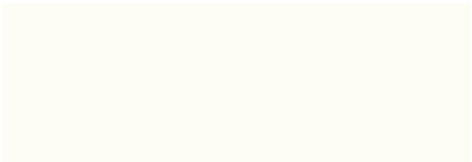
HDS-/VHM- Fräser
HDS-/ Solid Carbide
Endmills

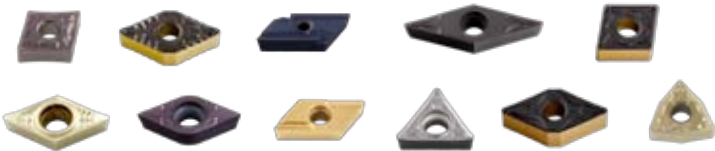
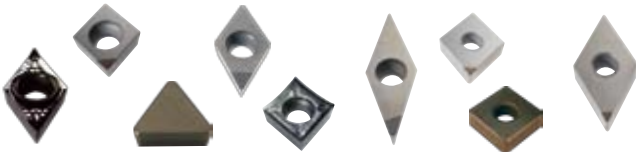
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Solid Carbide Drills



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ISO - Bezeichnungssystem für Klemmhalter / ISO Designation System for Toolholders

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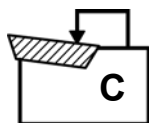
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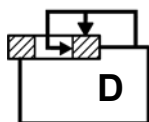
Mini/ Micro
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Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

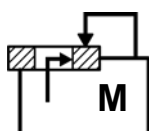
Wendepaltenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills



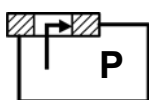
Von oben geklemmt
Top clamping



Von oben und über
Bohrung geklemmt
Top and hole clamping



Von oben und über
Bohrung geklemmt
Top and hole clamping



Über Bohrung geklemmt
Hole clamping



Durch Bohrung
aufgeschraubt
With screw through hole



80° C

55° D

75° E

86° M

35° V



85° A

82° B

55° K



H



L



O



P



R



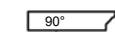
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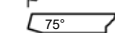
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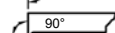
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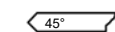
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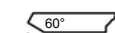
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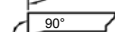
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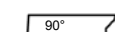
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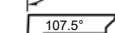
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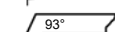
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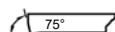
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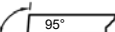
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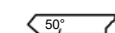
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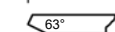
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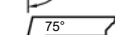
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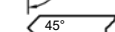
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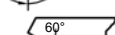
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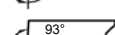
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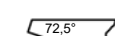
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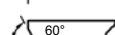
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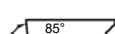
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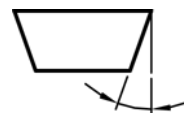
V



W



Y



3° A

5° B

7° C

15° D

20° E

25° F

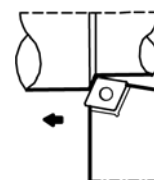
30° G

0° N

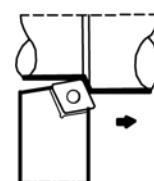
11° P

Sonstige
Others O

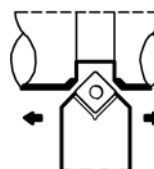
R



L



N



S

C

L

C

R

Klemmsystem
Clamping Method

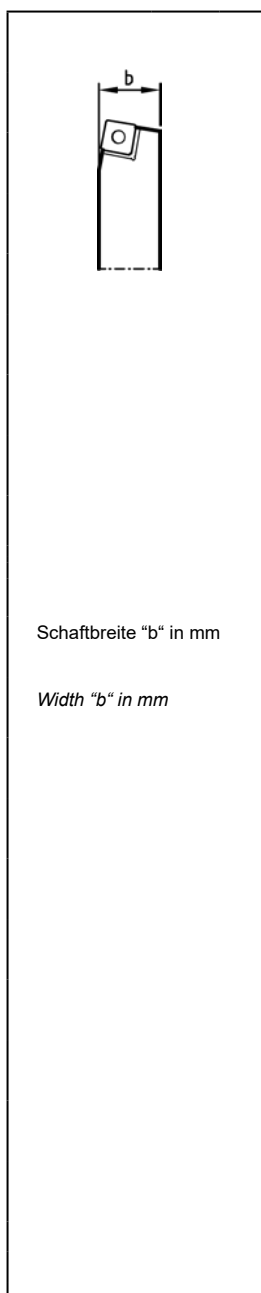
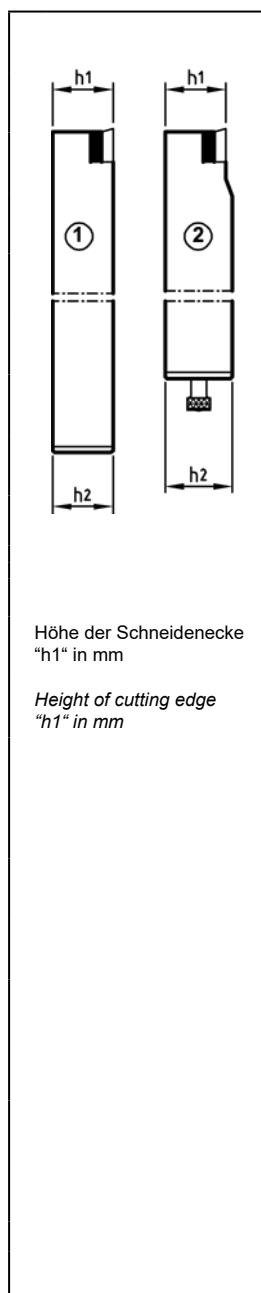
Plattenform
Shape

Halterform
Style

Freiwinkel
Clearance Angle

Halterausführung
Holder Execution

ISO - Bezeichnungssystem für Klemmhalter / ISO Designation System for Toolholders



L1 (mm)		L1 (mm)	
32	A	150	M
40	B	160	N
50	C	170	P
60	D	180	Q
70	E	200	R
80	F	250	S
90	G	300	T
100	H	350	U
110	J	400	V
125	K	450	W
140	L	500	Y
Sonderlänge Special Length		X	

d (mm)			
06			
08			
10			
12			
16			
20			
25			
32			
(mm)		d (inch) (mm)	
06	5/32	3.96	03
09	7/32	5.55	05
11	1/4	6.35	06
16	3/8	9.52	09
22	1/2	12.7	12
27	5/8	15.8	15
33	3/4	19.0	19
44	1	25.4	25

25

25

M

12

Schafthöhe
Height of Shank

Schaftbreite
Width of Shank

Halterlänge
Length of Holder

Schneidenlänge
Length of Cutting Edge

Übersicht - Außendrehen Overview - External Turning

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MTJNR/L 93° Seite / page: 1.08	PCBNR/L 75° Seite / page: 1.08	PCLNR/L 95° Seite / page: 1.09	PCLNR/L-IK 95° Seite / page: 1.09
PDJNR/L 93° Seite / page: 1.10	PDJNR/L-IK 93° Seite / page: 1.10	PSBNR/L 75° Seite / page: 1.11	PSKNR/L 75° Seite / page: 1.11
PSSNR/L 45° Seite / page: 1.12	PTFNR/L 90° Seite / page: 1.12	PTGNR/L 95° Seite / page: 1.13	PWLR/L 95° Seite / page: 1.13
PWLR/L-IK 95° Seite / page: 1.14	SCLCR/L 95° Seite / page: 1.14	SCLCR/L-IK 95° Seite / page: 1.15	SDACR/L 90° Seite / page: 1.15

Übersicht - Außendrehen Overview - External Turning

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/Solid Carbide
Endmills

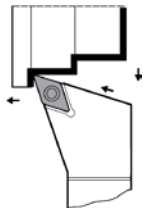
Stech- und
Abstechwerkzeuge
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Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

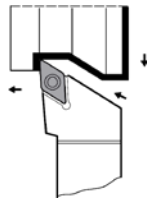
Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

SDHCR/L 107,5°



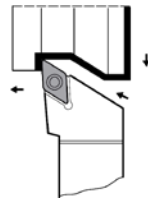
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SDJCR/L 93°



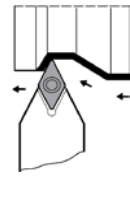
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SDJCR/L - IK 93°



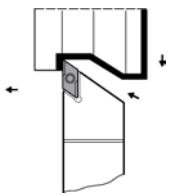
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SDNCN 62,5°



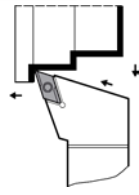
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SKACR/L 90°



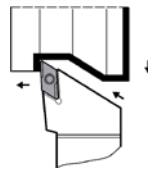
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SKHCR/L 107,5°



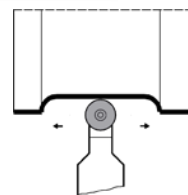
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SKJCR/L 93°



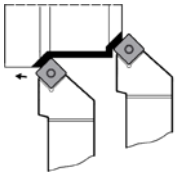
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SRDCN 45°



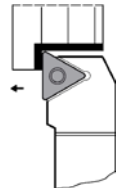
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SSSCR/L 45°



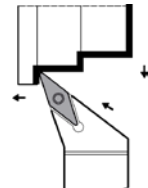
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STGCR/L 90°



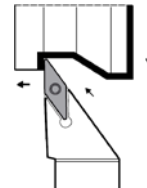
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SVHCR/L 107,5°



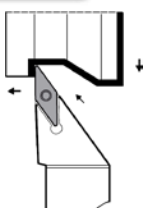
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SVJBR/L 93°



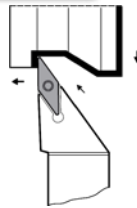
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SVJBR/L-IK 93°



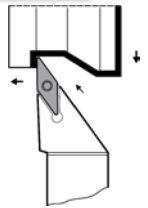
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SVJCR/L 93°



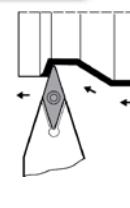
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SVJCR/L-IK 93°



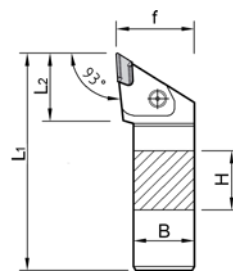
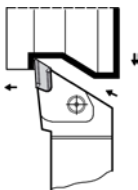
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SVVCN 72,5°



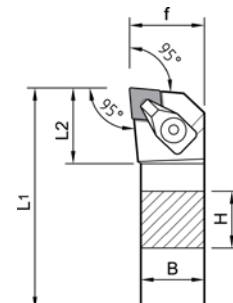
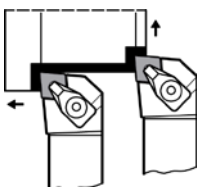
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CKJNR/L 93°



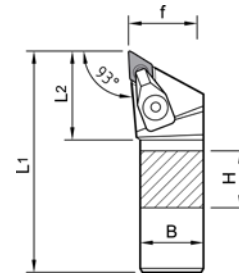
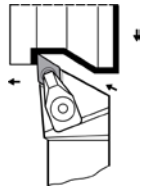
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts							
	R	L	H	B	L ₁	L ₂	f	Seite / Page: 1.53								
CKJNR 2020 K16	○		20	20	125	32	25	KNUX 1604--R	48.11.705	48.11.105	48.12.606 (SW4)	48.11.503	48.11.500 + 48.11.504	48.11.208	48.11.301	48.12.605 (SW2)
2525 M16	○		25	25	150	32	32									
3232 P16	○		32	32	170	32	40									
CKJNL 2020 K16	○		20	20	125	32	25	KNUX 1604--L	48.11.706	48.11.105	48.12.606 (SW4)	48.11.503	48.11.500 + 48.11.504	48.11.209	48.11.301	48.12.605 (SW2)
2525 M16	○		25	25	150	32	32									
3232 P16	○		32	32	170	32	40									

DCLNR/L 95°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts							
	R	L	H	B	L ₁	L ₂	f	Seite / Page: 1.48								
DCLNR/L 2020 K12	○	○	20	20	125	30	25	CN -- 1204 --	48.34.701	48.34.101	48.12.606 (SW4)	48.33.501	48.33.502	48.33.201	48.34.102	48.12.604 (SW2,5)
2525 M12	○	○	25	25	150	32	32									
3232 P12	○	○	32	32	170	32	40									

DDJNR/L 93°



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Endmills

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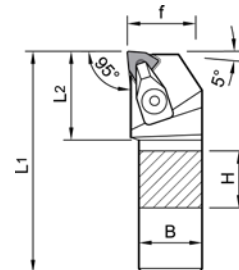
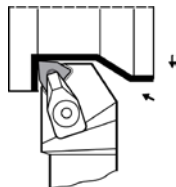
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

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werkzeuge
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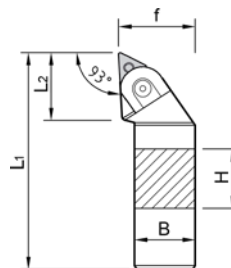
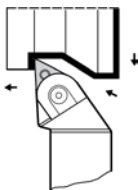
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile <i>Spare Parts</i>							
	R	L	H	B	L ₁	L ₂	f	Seite / Page: 1.52								
DDJNR/L 2020 K15	●	○	20	20	125	38	25	DN .. 1506 ..								
2525 M15	●	○	25	25	150	38	32									
3232 P15	○	○	32	32	170	38	40									

DWLNR/L 95°



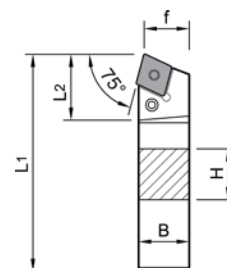
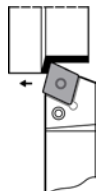
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile <i>Spare Parts</i>							
	R	L	H	B	L ₁	L ₂	f									
DWLNR/L 2020 K08	○	○	20	20	125	35	25	Seite / Page: 1.63 WN -- 0804 --								
2525 M08	○	○	25	25	150	35	32									

MTJNR/L 93°



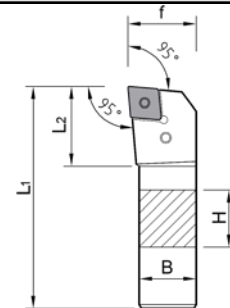
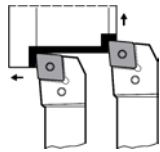
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.58	Ersatzteile Spare Parts						
	R	L	H	B	L ₁	L ₂	f								
MTJNR/L 2020 K16	●	○	20	20	125	35	25	TN -- 1604 --	48.10.707	48.10.510	48.10.205	48.10.105	48.33.501	48.10.503	48.12.603 (SW3)
2525 M16	●	●	25	25	150	35	32								
3232 P16	○	○	32	32	170	35	40								
2525 M22	●	●	25	25	150	40	32	TN -- 2204 --	48.10.708	48.10.511	48.10.206	48.34.101		48.33.502	48.12.606 (SW4)
3232 P22	○	○	32	32	170	40	40								

PCBNR/L 75°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.48	Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f						
PCBNR/L 2020 K12	○	○	20	20	125	27	17	CN -- 1204 --	48.12.414	48.12.113	48.33.201	48.12.901	48.12.603 (SW3)
2525 M12	○	○	25	25	150	27	22						
3232 P12			32	32	170	27	22						
2525 M16	○		25	25	150	33	22	CN -- 1606 --	48.12.415	48.12.114	48.12.202	48.12.902	
3232 P16			32	32	170	33	27						
3232 P19	○		32	32	170	40	27	CN -- 1906 --	48.12.416	48.12.115	48.12.203	48.12.903	48.12.606 (SW4)
4040 S19			40	40	250	40	35						

PCLNR/L 95°



Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM- Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

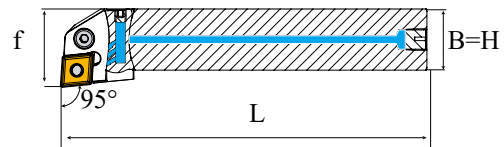
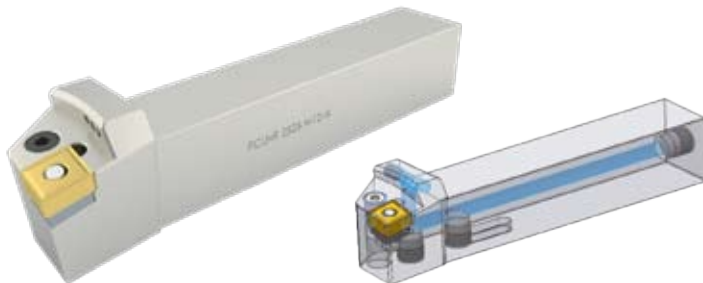
Gewinde-
werkzeuge
Threading Tools

Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Seite / Page: 1.48	Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f								
PCLNR/L 1616 H09	○	○	16	16	100	20	20			CN .. 0903 ..	48.12.417	48.12.116	48.12.201	48.12.905	48.12.604 (SW2,5)
2020 K09	○	○	20	20	125	22	25								
2525 M09	○	○	25	25	150	22	32								
1616 H12	●	●	16	16	100	28	20			CN .. 1204 ..	48.12.414	48.12.113	48.33.201	48.12.901	48.12.603 (SW3)
2020 K12	●	●	20	20	125	28	25								
2525 M12	●	●	25	25	150	28	32								
3232 P12	○	○	32	32	170	28	32			CN .. 1606 ..	48.12.415	48.12.114	48.12.202	48.12.902	48.12.606 (SW4)
2525 M16	○	○	25	25	150	33	32								
3232 P16	○	○	32	32	170	33	40								
3232 P19	○	○	32	32	170	38	40			CN .. 1906 ..	48.12.416	48.12.115	48.12.203	48.12.903	
4040 S19	○	○	40	40	250	38	50								

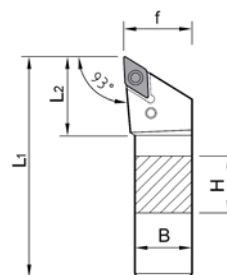
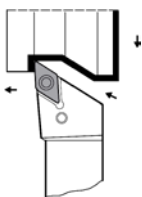
PCLNR/L-IK 95°

Außenklemmhalter mit Innenkühlung
External Toolholder with Internal Coolant



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Seite / Page: 1.48	Ersatzteile Spare Parts				
	R	L	H	B	L	f									
PCLNR/L 1616 H12 IK	●	●	16	16	100	20				CN .. 1204 ..	48.12.117				
2020 K12 IK	●	●	20	20	125	25					48.12.118	48.33.204	48.12.909	48.12.421	48.12.603
2525 M12 IK	●	●	25	25	150	32									

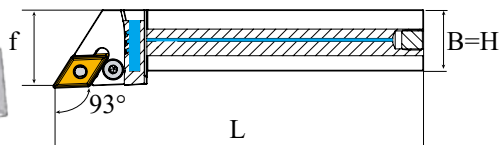
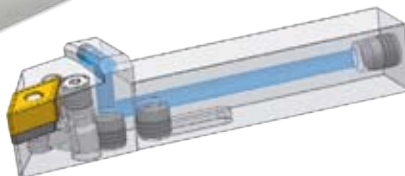
PDJNR/L 93°

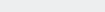


Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f						
PDJNR/L 1616 H11	●	○	16	16	100	25	20	Seite / Page: 1.52 DN ** 1104 **					
2020 K11	●	●	20	20	125	25	25						
2525 M11	○	○	25	25	150	30	32						
2020 K15	●	●	20	20	125	35	25	DN ** 1506 **					
2525 M15	●	●	25	25	150	35	32						
3232 P15	○	○	32	32	170	35	40						

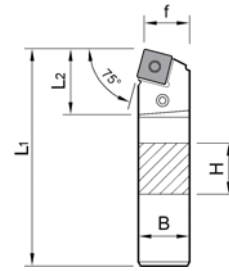
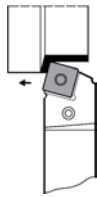
PDJNR/L-IK 93°

Außenklemmhalter mit Innenkühlung External Toolholder with Internal Coolant



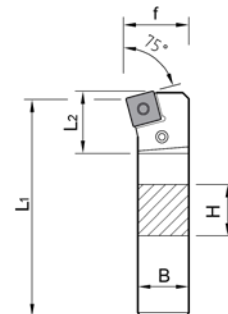
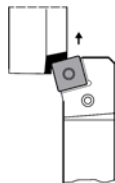
Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number				 Seite / Page: 1.52	Ersatzteile Spare Parts				
	R	L	H	B	L	f						
PDJNR/L 2020 K15 IK	●	●	20	20	125	25	DN -- 1506 --	48.12.119	48.33.205	48.12.909	48.12.422	48.12.603
2525 M15 IK	●	●	25	25	150	32		48.12.120				

PSBNR/L 75°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile <i>Spare Parts</i>				
	R	L	H	B	L ₁	L ₂	f						
PSBNR/L 2020 K12			20	20	125	28	17	Seite / Page: 1.56					
2525 M12			25	25	150	28	22						
3232 P12			32	32	170	28	27						
2525 M15			25	25	150	35	22	SN .. 1506 ..					
3232 P15			32	32	170	37	27						
3232 P19			32	32	170	40	27	SN .. 1906 ..					
4040 S19			40	40	250	40	35						

PSKNR/L 75°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f						
PSKNR/L 2020 K12			20	20	125	26	25	Seite / Page: 1.56					
2525 M12			25	25	150	26	32						
2525 M15			25	25	150	32	32	SN .. 1506 ..					
3232 P15			32	32	170	32	40						
3232 P19			32	32	170	40	40	SN .. 1906 ..					
4040 S19			40	40	250	50	50						

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/ Solid Carbide
Endmills

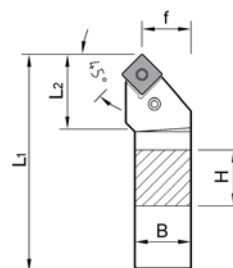
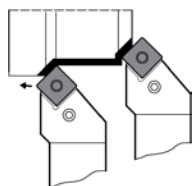
Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

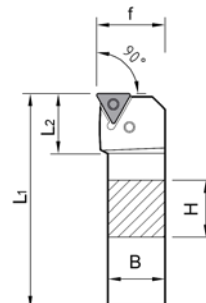
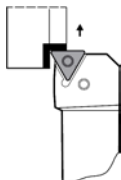
Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

PSSNR/L 45°



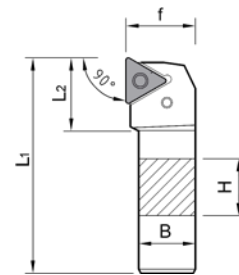
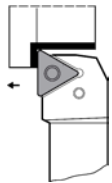
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f		Seite / Page: 1.56					
PSSNR/L 2020 K12	●	○	20	20	125	30	25			48.12.414	48.12.113	48.12.205	48.12.901	48.12.603 (SW3)
2525 M12	●	○	25	25	150	30	32	SN -- 1204 --						
2525 M15			25	25	150	30	32	SN -- 1506 --		48.12.415	48.12.114	48.12.206	48.12.902	
3232 P15			32	32	170	40	40							48.12.606 (SW4)
3232 P19	○	○	32	32	170	40	40	SN -- 1906 --		48.12.416	48.12.115	48.12.236	48.12.903	
4040 S19		○	40	40	250	40	50							

PTFNR/L 90°



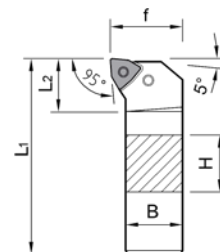
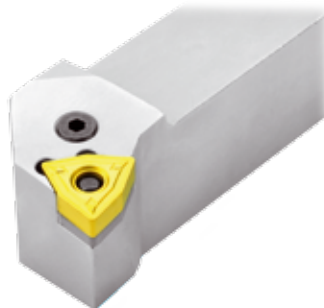
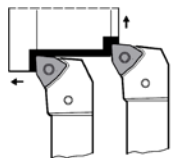
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f		Seite / Page: 1.58					
PTFNR/L 1616 H16	○	○	16	16	100	20	20			48.12.417	48.12.116	48.12.229	48.12.905	48.12.604 (SW2,5)
2020 K16	○	○	20	20	125	20	25	TN -- 1604 --						
2525 M16	○	○	25	25	150	20	32							
2525 M22	○	○	25	25	150	25	32	TN -- 2204 --		48.12.414	48.12.113	48.12.230	48.12.901	48.12.603 (SW3)
3232 P22			32	32	170	25	40							
3232 P27			32	32	170	33	40	TN -- 2706 --		48.12.415	48.12.114	48.12.231	48.12.902	
4040 S27			40	40	250	33	50							

PTGNR/L 90°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile <i>Spare Parts</i>				
	R	L	H	B	L ₁	L ₂	f						
PTGNR/L 1616 H16			16	16	100	20	20	Seite / Page: 1.58 TN -- 1604 --					
2020 K16	○	○	20	20	125	20	25						
2525 M16	○	○	25	25	150	20	32						
3232 P16			32	32	170	20	40						48.12.604 (SW2,5)
2525 M22	○	○	25	25	150	28	32	TN -- 2204 --	48.12.414	48.12.113	48.12.230	48.12.901	48.12.603 (SW3)
3232 P22			32	32	170	28	40						
3232 P27			32	32	170	33	40						
4040 S27			40	40	250	33	50	TN -- 2706 --	48.12.415	48.12.114	48.12.231	48.12.902	

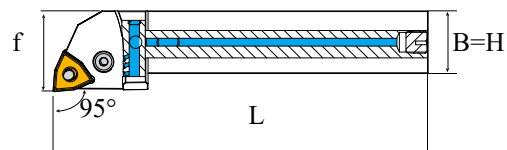
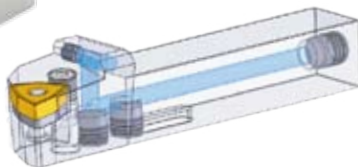
PWLNR/L 95°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f						
PWLNRL 1616 H06	○	○	16	16	100	20	20	Seite / Page: 1.63					
2020 K06	○	○	20	20	125	20	25						
2525 M06	○	○	25	25	150	20	32						
2020 K08	●	●	20	20	125	26	25	WN -- 0804 --					
2525 M08	●	●	25	25	150	26	32						
3232 P08	○	○	32	32	170	26	40						

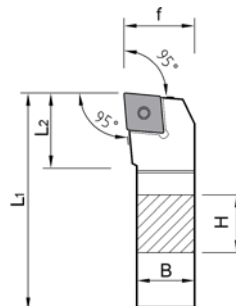
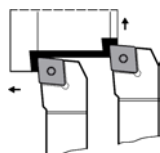
PWLNR/L-IK 95°

Außenklemmhalter mit Innenkühlung External Toolholder with Internal Coolant



Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number				Seite / Page: 1.63	Ersatzteile Spare Parts				
	R	L	H	B	L	f						
PWLNR/L 1616 H06 IK	●	●	16	16	100	20	WN -- 0604 --	48.12.121	48.33.203	48.12.910	48.12.423	48.12.604
2020 K06 IK	●	●	20	20	125	25						
2525 M06 IK	●	●	25	25	150	32						
2020 K08 IK	●	●	20	20	125	25	WN -- 0804 --	48.12.118	48.33.206	48.12.909	48.12.421	48.12.603
2525 M08 IK	●	●	25	25	150	32						

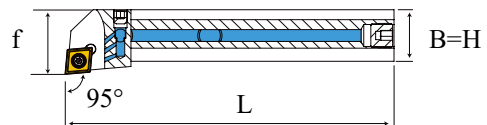
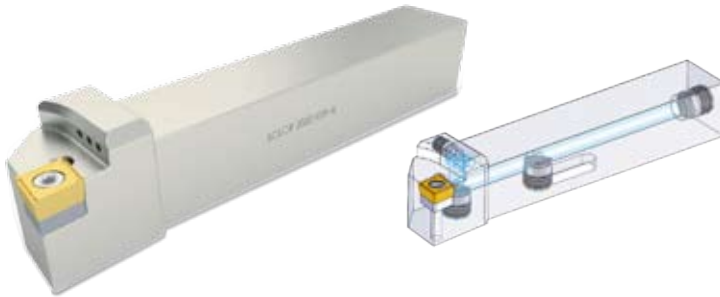
SCLCR/L 95°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions				Seite / Page: 1.46	Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂					
SCLCR/L 0808 D06	●	○	8	8	60	12	CC -- 0602 --	48.24.107	-	-	56.33.612 (T08)
1010 F06	●	○	10	10	80	12					
1212 F09	●	●	12	12	80	16	CC -- 09T3 --	48.13.102	48.13.201	48.13.301	56.33.613 (T15)
1616 H09	●	●	16	16	100	16					
2020 K09	●	●	20	20	125	25					
1616 H12	○	○	16	16	100	20	CC -- 1204 --	48.13.103	48.13.202	48.13.302	56.33.613 (T15)
2020 K12	●	●	20	20	125	25					
2525 M12	●	●	25	25	150	25					
3232 P12	○	○	32	25	170	25					

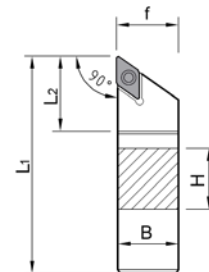
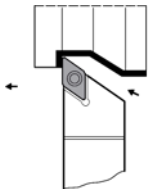
SCLCR/L-IK 95°

Außenklemmhalter mit Innenkühlung External Toolholder with Internal Coolant



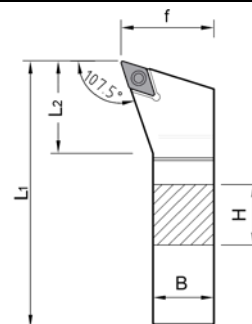
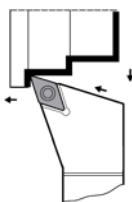
Bezeichnung Part Number	Lager Stock		Bezeichnung Part Number				 Seite / Page: 1.46	Ersatzteile <i>Spare Parts</i>			
	R	L	H	B	L	f					
SCLCR/L 1616 H09 IK	○	○	16	16	100	20	CC .. 09T3 ..	56.44.113	48.33.207	48.13.304	56.33.613 (T15)
2020 K09 IK	○	○	20	20	125	25					
2525 M12 IK	○	○	20	20	125	25	CC .. 1204 ..	56.44.109	48.33.208	48.13.305	

SDACR/L 90°



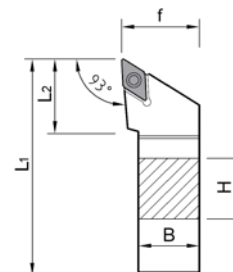
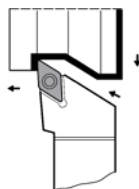
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SDACR/L 0808 K07			8	8	125	14	8.5	Seite / Page: 1.50				
1010 M07			10	10	150	14	10.5					
1212 M07			12	12	150	14	12.5					
1212 M11			12	12	150	21	12.5	Seite / Page: 1.50				
2525 M11			25	25	150	21	25.5					

SDHCR/L 107,5°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SDHCR/L 1010 E07	○		10	10	70	15	12	Seite / Page: 1.50	48.24.107	-	-	56.33.612 (T08)
1212 F07	○	○	12	12	80	15	16					
1616 H11	●	○	16	16	100	16	20	DC -- 11T3 --	48.13.102	48.13.203	48.13.301	56.33.613 (T15)
2020 K11	●	●	20	20	125	21	25					
2525 M11	●	●	25	25	150	22	32					

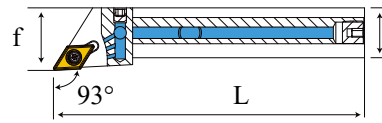
SDJCR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					 Seite / Page: 1.50	Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SDJCR/L 1010 E07	○		10	10	70	15	12	DC -- 0702 --	48.24.107	-	-	56.33.612 (T08)
1212 F07	●	○	12	12	80	15	16					
1616 H11	●	●	16	16	100	26	20	DC -- 11T3 --	48.13.102	48.13.203	48.13.301	56.33.613 (T15)
2020 K11	●	●	20	20	125	26	25					
2525 M11	●	●	25	25	150	29	32					

SDJCR/L-IK 93°

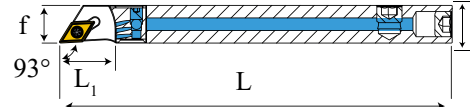
Außenklemmhalter mit Innenkühlung External Toolholder with Internal Coolant



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions				 Seite / Page: 1.50	Ersatzteile <i>Spare Parts</i>				
	R	L	H	B	L	f						
SDJCR/L 1212 K07 IK	○	○	12	12	125	16	DC .. 0702 ..	56.44.115	-	-	56.33.612 (T08)	
1616 H07 IK	○	○	16	16	100	20						
2020 K07 IK	○	○	20	20	125	25						
1616 H11 IK	○	○	16	16	100	20	DC .. 11T3 ..	56.44.113	48.33.209	48.13.304	56.33.613 (T15)	
2020 K11 IK	○	○	20	20	125	25						
2525 M11 IK	○	○	25	25	150	32						

SDJCR/L-IK-F 93°

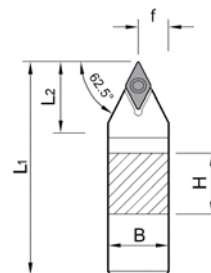
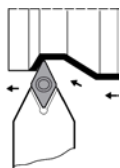
Außenklemmhalter mit IK für Langdrehautomaten External Toolholder with IC for Long-Automatically-Lathe



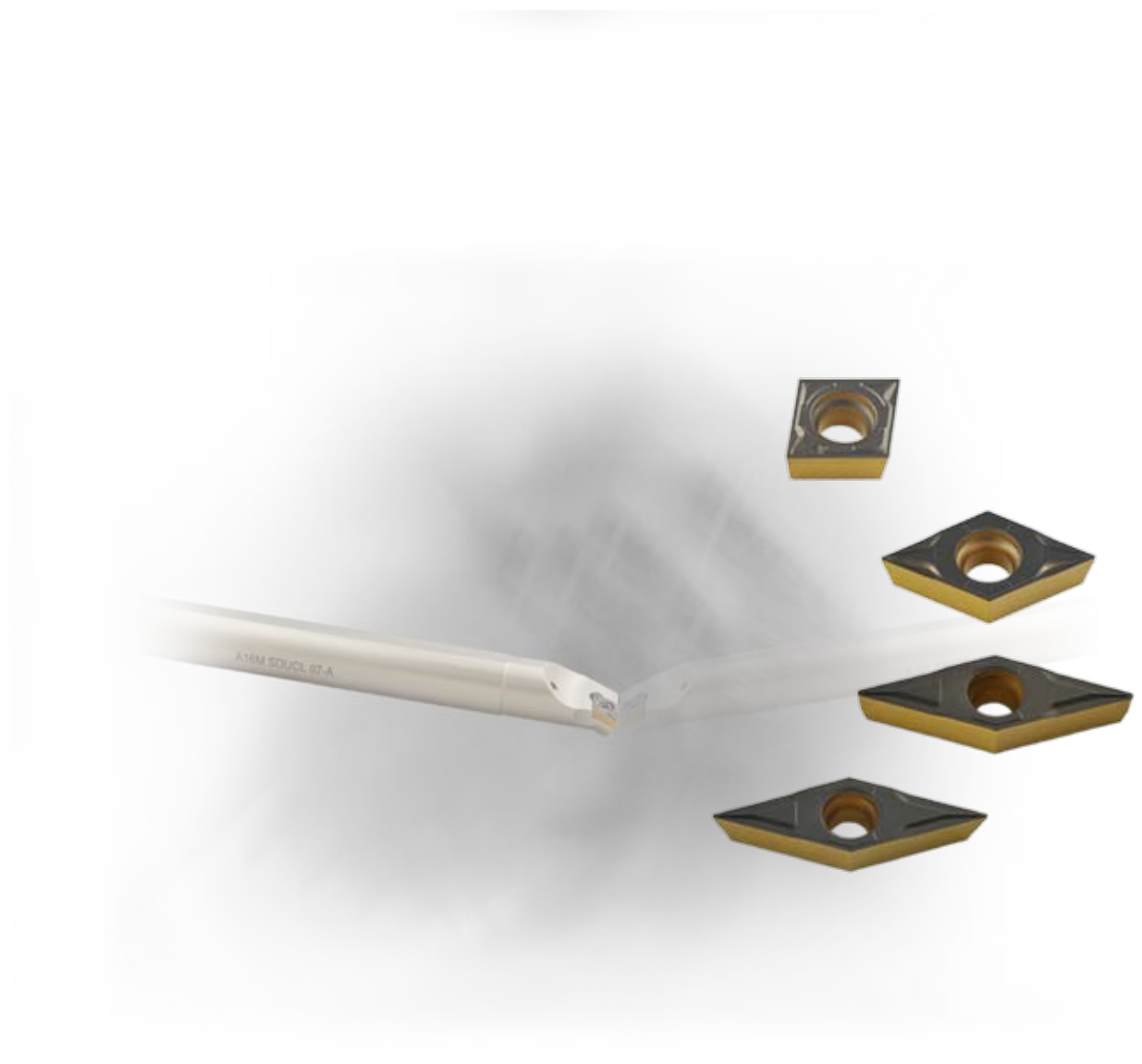
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile <i>Spare Parts</i>				
	R	L	H	B	L ₁	L ₂	f						
SDJCR/L 1212 K07 IK-F	○	○	12	12	125	27	12	Seite / Page: 1.50	56.44.115		-	56.33.612 (T08)	
1616 H07 IK-F	○	○	16	16	100	32	16						

SDNCN

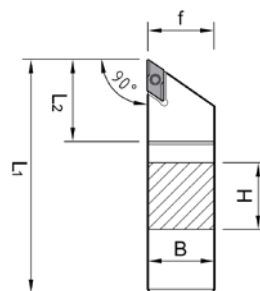
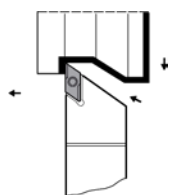
62,5°



Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions						 Seite / Page: 1.50	Ersatzteile Spare Parts			
		H	B	L ₁	L ₂	f						
SDNCN 1010 E07	○	10	10	70	20	5	DC -- 0702 --	48.24.107	-	-	56.33.612 (T08)	
1212 F07	○	12	12	80	20	6						
1212 M07		12	12	150	20	6						
1212 M11		12	12	150	30	6	DC -- 11T3 --	48.24.108	-	-	56.33.613 (T15)	
1616 H11	●	16	16	100	30	8						
2020 K11	●	20	20	125	30	10		48.13.102	48.13.203	48.13.301		
2525 M11	○	25	25	150	30	12.5						

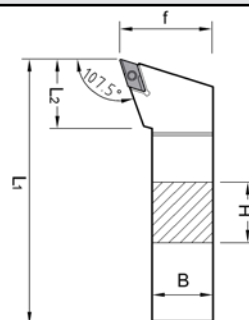
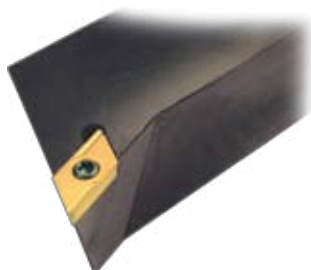
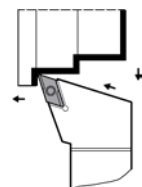


SKACR/L 90°



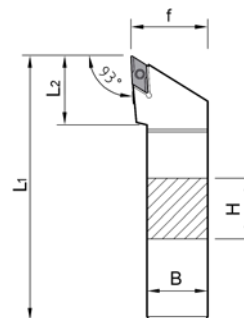
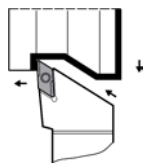
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SKACR/L 1212 M11	○	●	12	12	150	-	10.5	Seite / Page: 1.53 KC • X 1103 ••				
1616 M11	○	●	16	16	150	-	12.5					
2020 M11	○	●	20	20	150	-	16.5					
									48.13.104	-	-	56.33.612 (T08)

SKHCR/L 107,5°



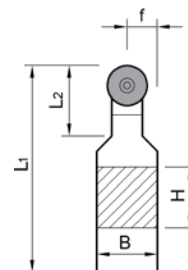
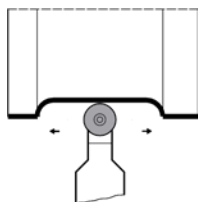
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SKHCR/L 1212 F11	○	●	12	12	80	15	16	Seite / Page: 1.53 KC • X 1103 ••				
1616 H11	○	●	16	16	100	24	20					
2020 K11	○	●	20	20	125	24	25					
2525 M11	○	●	25	25	150	29	32					
									48.13.104	-	-	56.33.612 (T08)

SKJCR/L 93°



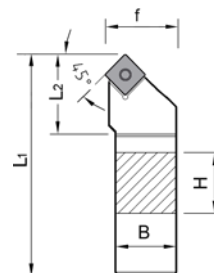
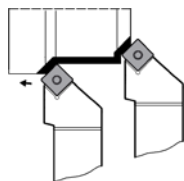
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					 Seite / Page: 1.53	Ersatzteile <i>Spare Parts</i>			
	R	L	H	B	L ₁	L ₂	f					
SKJCR/L 1212 F11	○		12	12	80	15	16	KC • X 1103 • R/L	48.13.104	-	-	56.33.612 (T08)
1616 H11	○	○	16	16	100	24	20					
2020 K11	○	○	20	20	125	24	25					
2525 M11	○		20	25	150	29	32					

SRDCN 45°



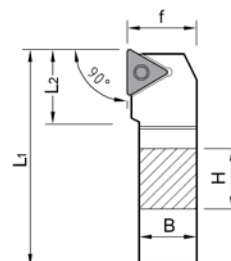
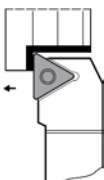
Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions					 Seite / Page: 1.54	Ersatzteile Spare Parts			
		H	B	L ₁	L ₂	f					
SRDCN 1212 F06		12	12	80	12	6	RC • T 0602 ••	48.24.107	-	-	56.33.612 (T08)
1616 H06		16	16	100	12	8					
2020 K06	○	20	20	125	12	10					
2525 M06	○	25	25	150	12	12.5					
1616 H08		16	16	100	16	8	RC • T 0803 ••	48.13.105	-	-	56.33.613 (T15)
2020 K08	○	20	20	125	16	10					
2525 M08	○	25	25	150	16	12.5					
1616 H10		16	16	100	20	8					
2020 K10		20	20	125	20	10	RC • T 1003 ••	48.13.102	48.13.204	48.13.301	56.33.613 (T15)
2525 M10	○	25	25	150	20	12.5					

SSSCR/L 45°



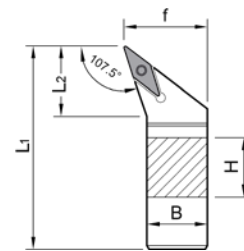
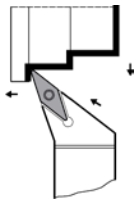
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					 Seite / Page: 1.55	Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SSSCR/L 1212 F09	●		12	12	80	18	16	SC .. 09T3 ..	48.13.102	-	-	56.33.613 (T15)
1616 H09	●	○	16	16	100	20	20					
2020 K09	●	○	20	20	125	22	25					
1616 H12			16	16	100	25	20	SC .. 1204 ..	48.13.103	48.13.206	48.13.302	56.33.613 (T15)
2020 K12	●	○	20	20	125	25	25					
2525 M12	●	○	25	25	150	25	32					
3225 P12			32	25	170	25	38					

STGCR/L 90°



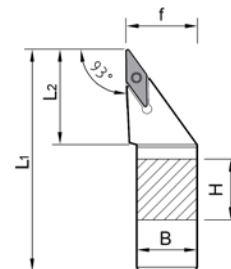
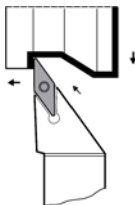
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					 Seite / Page: 1.57	Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
STGCR/L 0808 D09	○		8	8	60	8	10	TC .. 0902 ..	L60M2.2x5	-	-	75.20.621 (T06)
1010 E09	○		10	10	70	10	12					
1212 F11			12	12	80	15	16	TC .. 1102 ..	48.24.107	-	-	56.33.612 (T08)
1616 H11	○		16	16	100	15	20					
1616 H16			16	16	100	22	20	TC .. 16T3 ..	48.13.102	48.13.207	48.13.301	56.33.613 (T15)
2020 K16		○	20	20	125	22	25					
2525 M16	○		25	25	150	22	32					

SVHCR/L 107,5°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					 Seite / Page: 1.61	Ersatzteile <i>Spare Parts</i>			
	R	L	H	B	L ₁	L ₂	f					
SVHCR/L 1212 F11			12	12	80	11.5	16	VC .. 1103 ..	48.24.107	-	-	56.33.612 (T08)
1616 H11			16	16	100	11.5	20					
2020 K11			20	20	125	14.5	25					
2525 M11			25	25	150	20.0	32					
1616 H16			16	16	100	13.5	20	VC .. 1604 ..	48.13.102	48.13.209	48.13.301	56.33.613 (T15)
2020 K16	●		20	20	125	13.5	25					
2525 M16	●		25	25	150	20.0	32					

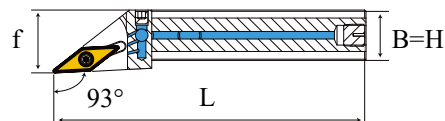
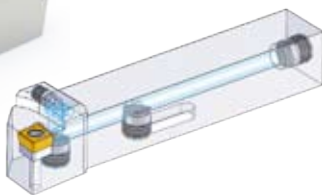
SVJBR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
								Seite / Page: 1.60				
SVJBR/L 1212 F11	○		12	12	80	11.5	16	VB .. 1103 ..	48.24.107	-	-	56.33.612 (T08)
1616 M11	○	○	16	16	100	11.5	20					
2020 K11			20	20	125	14.5	25					
2525 M11			25	25	150	20.0	32					
1616 H16			16	16	100	29.5	20	VB .. 1604 ..	48.13.102	48.13.209	48.13.301	56.33.613 (T15)
2020 K16	●	●	20	20	125	29.5	25					
2525 M16	●	○	25	25	150	32.5	32					

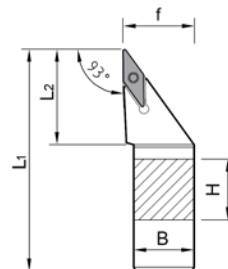
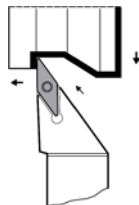
SVJBR/L-IK 93°

Außenklemmhalter mit Innenkühlung External Toolholder with Internal Coolant



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.60	Ersatzteile Spare Parts			
	R	L	H	B	L	f						
SVJBR/L 1010 J11 IK	○	○	10	10	110	12		VB .. 1103 ..	56.44.114	-	-	56.33.612 (T08)
1212 J11 IK	○	○	12	12	110	16						
2020 K16 IK	○	○	20	20	125	25		VB .. 1604 ..	56.44.113	48.33.210	48.13.304	56.33.613 (T15)
2525 M16 IK	○	○	25	25	150	32						

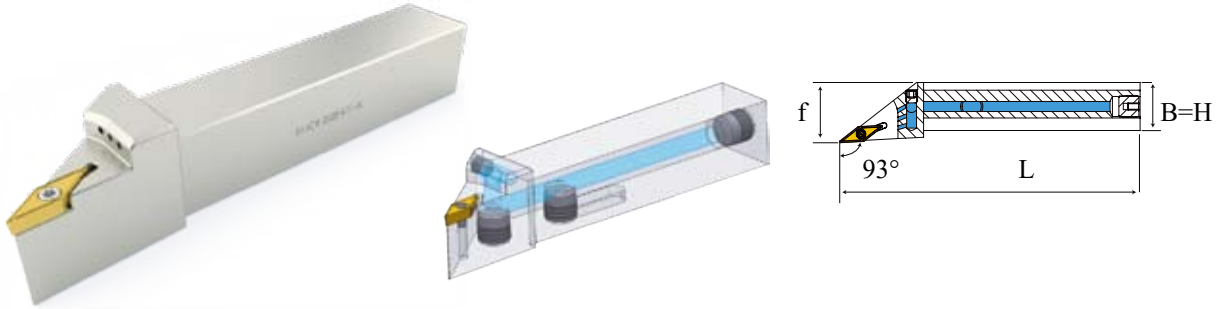
SVJCR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Seite / Page: 1.61	Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f							
SVJCR/L 1010 E11	○		10	10	70	14.5	12							
1212 F11	●	○	12	12	80	22.0	16							
1616 H11	●	●	16	16	100	25.0	20		VC .. 1103 ..	48.24.107	-	-	-	56.33.612 (T08)
2020 K11	●	○	20	20	125	32.0	25							
2525 M11	●	○	25	25	150	38.0	32							
1616 H16	●	○	16	16	100	29.5	20							
2020 K16	●	●	20	20	125	29.5	25		VC .. 1604 ..	48.13.102	48.13.209	48.13.301	-	56.33.613 (T15)
2525 M16	●	●	25	25	150	32.5	32							
3225 P16	○	○	32	25	170	35.0	32							

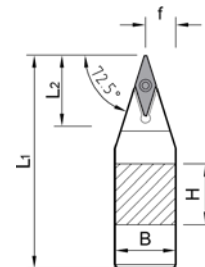
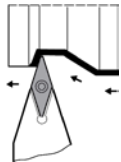
SVJCR/L-1K 93°

Außenklemmhalter mit Innenkühlung External Toolholder with Internal Coolant



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.61	Ersatzteile Spare Parts			
	R	L	H	B	L	f						
SVJCR/L 1616 H11 1K	○	○	16	16	100	20	VC .. 1103 ..	56.44.114	-	-	56.33.612 (T08)	56.33.613 (T15)
2020 K11 1K	○	○	12	20	125	25						
2020 K16 1K	○	○	20	20	125	25	VC .. 1604 ..	56.44.113	48.33.210	48.13.304	56.33.613 (T15)	
2525 M16 1K	○	○	25	25	150	32						

SVVCN 72,5°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.61	Ersatzteile Spare Parts			
			H	B	L ₁	L ₂	f					
SVVCN 1010 E11	○		10	10	70	18	5	VC .. 1103 ..	48.24.107	-	-	56.33.612 (T08)
1212 F11	○		12	12	80	27	6					
1616 H11			16	16	100	27	8					
2020 K11	○		20	20	125	27	10					
2525 M11			25	25	150	41	12	VC .. 1604 ..	48.13.102	48.13.209	48.13.301	56.33.613 (T15)
1616 H16	○		16	16	100	36	8					
2020 K16	○		20	20	125	41	10					
2525 M16	○		25	25	150	41	12					

ISO - Bezeichnungssystem für Bohrstangen / ISO Designation System for Boring Bars

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

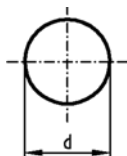
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendeplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

A

Stahlschaft mit
Kühlbohrung
Steel shank with
coolant hole



B

Stahlschaft mit
Dämpfung
Steel shank with
vibration clamping

D₁
(mm)

08

10

12

16

20

25

32

40

50

60

C

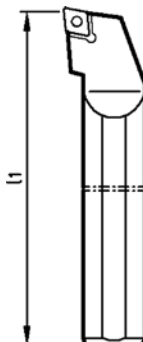
Hartmetallschaft mit
Stahlkopf
Hardmetal shank with
steel head

E

Hartmetallschaft mit
Stahlkopf und
Kühlbohrung
Hardmetal shank with
steel head and coolant
hole

S

Stahlschaft
Steel shank



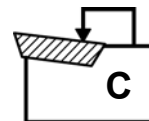
L₁
(mm)

L₁
(mm)

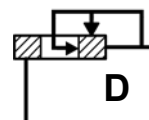
32	A	150	M
40	B	160	N
50	C	170	P
60	D	180	Q
70	E	200	R
80	F	250	S
90	G	300	T
100	H	350	U
110	J	400	V
125	K	450	W
140	L	500	Y

Sonderlänge
Special length

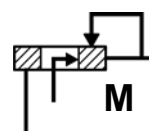
X



Von oben geklemmt
Top clamping



Von oben und über
Bohrung geklemmt
Top and hole clamping



Von oben und über
Bohrung geklemmt
Top and hole clamping



Über Bohrung geklemmt
Hole clamping



Durch Bohrung
aufgeschraubt
With screw through hole

A

32

S

P

Schaftausführung
Type of Shank

Schaft- Ø
Shank- Ø

Halterlänge
Length

Klemmsystem
Clamping Method

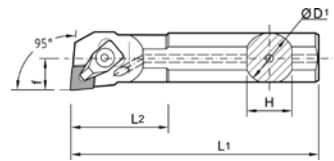
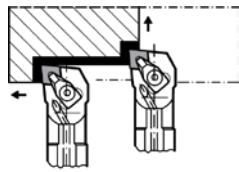
ISO - Bezeichnungssystem für Bohrstangen / ISO Designation System for Boring Bars

 80° C  55° D  75° E  86° M  35° V  85° A  82° B  55° K  H  L  O  P  R  S  T  W	 90° F  75° K  95° L  107.5° Q  45° S  93° U  60° W  85° Y Sonderform Special Style X	 3° A  5° B  7° C  15° D  20° E  25° F  30° G  0° N  11° P Sonstige Others O	 3° A  5° B  7° C  15° D  20° E  25° F  30° G  0° N  11° P Sonstige Others O	 3° A  5° B  7° C  15° D  20° E  25° F  30° G  0° N  11° P Sonstige Others O	 3° A  5° B  7° C  15° D  20° E
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Übersicht - Innendrehen Overview - Internal Turning

DCLNR/L 95° Seite / page: 1.29	DDUNR/L 93° Seite / page: 1.29	PCLNR/L 95° Seite / page: 1.30	PDUNR/L 93° Seite / page: 1.30
PSKNR/L 75° Seite / page: 1.31	PTFNR/L 90° Seite / page: 1.31	SCLCR/L 95° Seite / page: 1.32	SCLCR/L-CB 95° Seite / page: 1.33
SDQCR/L 107,5° Seite / page: 1.34	SDQCR/L-CB 93° Seite / page: 1.34	SDUCR/L 93° Seite / page: 1.35	SDUCR/L-CB 93° Seite / page: 1.35
SKUCR/L 93° Seite / page: 1.36	SSSCR/L 45° Seite / page: 1.36	STFCR/L 91° Seite / page: 1.37	SVQCR/L 107,5° Seite / page: 1.37
SVUCR/L 93° Seite / page: 1.38	HSS A SCLCR/L 95° Seite / page: 1.39	HSS A SDUCR/L 93° Seite / page: 1.39	

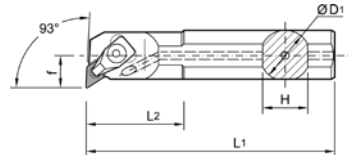
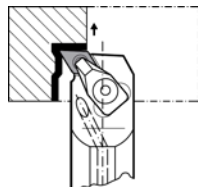
DCLNR/L 95°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.48	Ersatzteile Spare Parts							
	R	L	Dmin	D ₁	H	L ₁	L ₂	f									
A25R DCLNR/L 12	●	●	32	25	23	200	50	17	CN ** 1204 **								
A32S DCLNR/L 12	○	○	40	32	30	250	60	22									
A40T DCLNR/L 12			50	40	37	300	60	27									
A50U DCLNR/L 12			63	50	47	350	65	35									

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

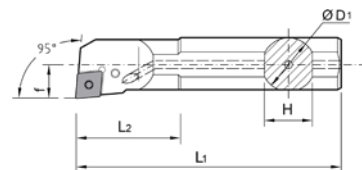
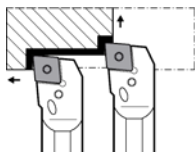
DDUNR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.52	Ersatzteile Spare Parts							
	R	L	Dmin	D ₁	H	L ₁	L ₂	f									
A32S DDUNR/L 15			40	32	30	250	55	22	DN ** 1506 **								
A40T DDUNR/L 15			50	40	37	300	55	27									

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

PCLNR/L 95°

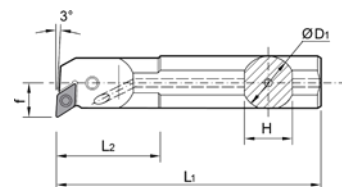
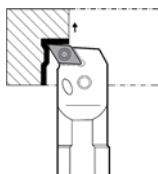


Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts				
	R	L	Dmin	D ₁	H	L ₁	L ₂	f						
A25R PCLNR/L 12	●	●	32	25	24	200	40	17	Seite / Page: 1.48 CN .. 1204 ..	48.23.103	48.23.402	-	-	48.12.604 (SW2,5)
A32T PCLNR/L 12	●	●	40	32	30	300	50	22		48.12.113	48.12.414	48.33.204	48.12.901	48.12.603 (SW3)
A40T PCLNR/L 12	●	○	54	40	38,5	300	55	27						
A50U PCLNR/L 12	○	○	63	50	48,5	350	56	35						

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

S : Stahlschaft / Steel Shank

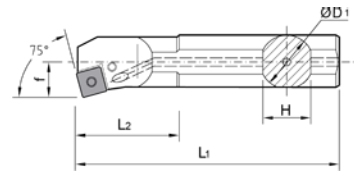
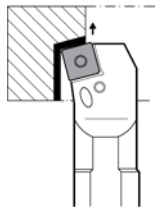
PDUNR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts				
	R	L	Dmin	D ₁	H	L ₁	L ₂	f						
A20Q PDUNR/L 11	●	○	25	20	19	180	-	16	Seite / Page: 1.52 DN .. 1104 ..	48.23.102	48.23.403	-	-	48.12.605 (SW2)
A25R PDUNR/L 11	○	○	31.5	25	24	200	-	18.5		48.12.116	48.12.417	48.12.204	48.12.905	
A32S PDUNR/L 11	○	○	40	32	31	250	-	22						
A32S PDUNR/L 15	●	○	40	32	31	250	50	22	DN .. 1506 ..	48.12.113	48.12.418	48.33.202	48.12.901	48.12.603 (SW3)
A40T PDUNR/L 15	●	○	50	40	38.5	300	50	27						

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

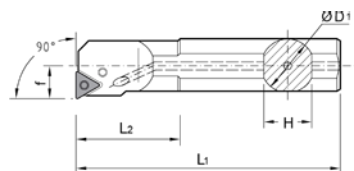
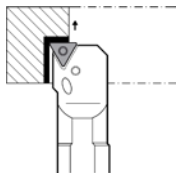
PSKNR/L 75°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts				
	R	L	Dmin	D1	H	L1	L2	f						
A25R PSKNR/L 12	○	○	32	25	24	200	42	17	Seite / Page: 1.56 SN .. 1204 ..	48.23.103	48.23.402	-	-	48.12.604 (SW2,5)
A32S PSKNR/L 12	○	○	44	32	31	250	50	22		48.12.113	48.12.414	48.23.203	48.12.901	48.12.603 (SW3)
A40T PSKNR/L 12			54	40	38.5	300	55	27						

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

PTFNR/L 90°

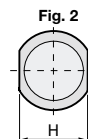
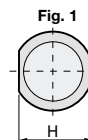
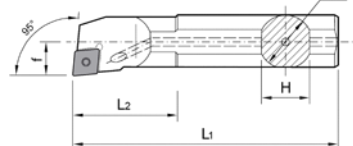
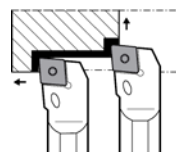


Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts				
	R	L	Dmin	D1	H	L1	L2	f						
S16R PTFNR/L 11	○	○	21	16	15	150	-	11	TN .. 1103 ..	48.23.102	48.23.406	-	-	48.12.605 (SW2)
S20S PTFNR/L 11	○	○	25	20	19	180	-	13						
A25R PTFNR/L 16	○	○	32	25	24	200	40	17	TN .. 1604 ..	48.23.102	48.23.404	-	-	48.12.605 (SW2)
A32S PTFNR/L 16	○	○	44	32	31	250	50	22		48.12.116	48.12.417	48.23.202	48.12.905	48.12.604 (SW2,5)
A40T PTFNR/L 16	○	○	54	40	38.5	300	55	27						

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

S : Stahlschaft / Steel Shank

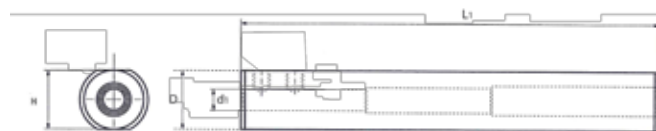
SCLCR/L 95°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Fig.	 Seite / Page: 1.46	Ersatzteile Spare Parts			
	R	L	Dmin	D1	H	L1	L2	f						
E04G SCLCR/L 0305	●	●	5	4	3.8	90	-	2.5	1	CCET 0301 ..	48.24.142	-	-	75.20.621 (T06)
E05H SCLCR/L 0306	●	○	6	5	4.4	100	-	3.0			48.24.142	-	-	
E06J SCLCR/L 0307	○	●	7	6	5.7	110	-	3.5			48.24.143	-	-	
E06J SCLCR/L 0407	●	●	7	6	5.7	110	-	3.5			48.24.143	-	-	
E07K SCLCR/L 0408	●	●	8	7	6.4	125	-	4.0	2	CC .. 0602 ..	48.24.107	-	-	56.33.612 (T08)
A0608H SCLCR/L 06	●	●	8	8	7	100	25	4.5			48.24.107	-	-	
A0810J SCLCR/L 06	●	●	11	10	9	110	32	6.0			48.24.107	-	-	
A1012K SCLCR/L 06	●	●	13	12	11	125	38	7.0			48.24.107	-	-	
A1216M SCLCR/L 06	●	●	16	16	15	150	50	9.0	2	CC .. 09T3 ..	48.24.108	-	-	56.33.613 (T15)
A08F SCLCR/L 06	●	●	11	8	7	80	16	5.5			48.24.107	-	-	
A10H SCLCR/L 06	●	●	13	10	9	100	20	6.0			48.24.107	-	-	
A12K SCLCR/L 06	●	●	17	12	11	125	23	9.0			48.24.107	-	-	
A16M SCLCR/L 09	●	●	21	16	15	150	30	11.0	2	CC .. 1204 ..	48.13.103	48.13.202	48.13.302	56.33.613 (T15)
A20Q SCLCR/L 09	●	●	25	20	18	180	38	13.0			48.13.103	48.13.202	48.13.302	
A25R SCLCR/L 09	●	●	32	25	23	200	39	17.0			48.13.103	48.13.202	48.13.302	
A32S SCLCR/L 12	○	○	40	32	31	250	50	22.0			48.13.103	48.13.202	48.13.302	
A40T SCLCR/L 12	○	○	50	40	38.5	300	60	27.0	1	CC .. 09T3 ..	48.24.108	-	-	56.33.613 (T15)
E08K SCLCR/L 06	●	●	11	8	7.5	125	-	5.0			48.24.107	-	-	
E10M SCLCR/L 06	●	●	14	10	9.5	150	-	6.0			48.24.107	-	-	
E12Q SCLCR/L 06	●	●	17	12	11.5	180	-	9.0			48.24.107	-	-	
E16R SCLCR/L 09	●	●	21	16	15.5	200	32	11.0	1	CC .. 09T3 ..	48.24.108	-	-	56.33.613 (T15)
E20S SCLCR/L 09	●	●	25	20	19	250	38	13.0			48.24.108	-	-	
E25T SCLCR/L 09	●	●	32	25	24	300	45	17.0			48.24.108	-	-	
E25T SCLCR/L 09	●	●	32	25	24	300	45	17.0			48.24.108	-	-	

A: Stahlschaft mit Innenkühlung / Steel Shank with inner coolant
E: Hartmetallschaft mit Innenkühlung / Carbide Shank with inner coolant
S: Stahlschaft / Steel Shank

Schafthülsen Sleeves for Shanks

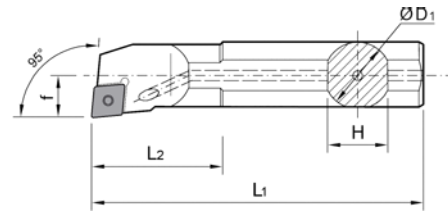
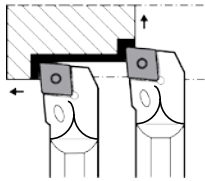


Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions				Ersatzteile Spare Parts		Passende Bohrstangen Suitable Boring bars
		D	d1	H	L1			
SH 0416	●	16	4	14	100	32.35.101	48.12.605	E04G SCLCR/L 0305
SH 0516	●	16	5	14	100	32.35.101	48.12.605	E05H SCLCR/L 0306

SCLCR/L

95° Anti-Vibration

CB-Hartmetallbohrstangen mit Innenkühlung
CB-Carbide Boring Bars with Through Coolant



Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

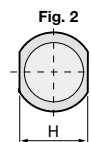
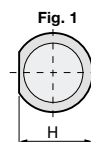
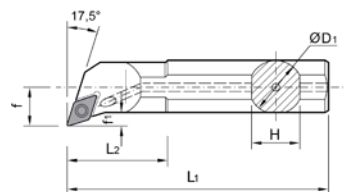
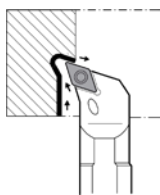
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Bezeichnung Part Number			Lager Stock		Maße [mm] Dimensions						Ersatzteile <i>Spare Parts</i>		
													
Seite / Page: 1.46													
E04G	SCLCR/L	03-CB	●	●	4.8	4	3.8	90	-	2.8	CCET 03 01	48.24.142	75.20.621 (T06)
E05H	SCLCR/L	03-CB	●	●	5.8	5	4.4	100	-	3.3			
E06J	SCLCR/L	0407-CB	●	●	7	6	5.7	110	-	3.5	CC .. 04 01	48.24.144	75.20.621 (T06)
E08K	SCLCR/L	06-CB	●	●	10	8	7	125	13	5.0	CC .. 06 02	48.24.107	56.33.612 (T08)
E10M	SCLCR/L	06-CB	●	●	12	10	9	150	17	7.0			
E12Q	SCLCR/L	06-CB	●	●	14	12	11	180	23	8.0			
E16R	SCLCR/L	09-CB	●	●	18	16	15	200	25	10	CC .. 09 T3	48.24.108	56.33.613 (T15)
E20R	SCLCR/L	09-CB	●	●	22	20	18	200	28	12			

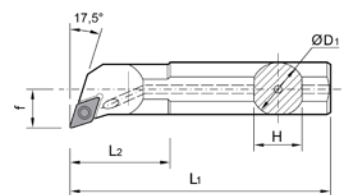
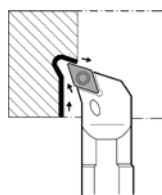
SDQCR/L 107,5°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Fig.		Ersatzteile Spare Parts			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f							
A10H SDQCR/L 07	●	●	12.5	10	9	100	20	7	2	Seite / Page: 1.50					
A12K SDQCR/L 07	●	●	17	12	11	125	24	9							
A16M SDQCR/L 07	●	●	21	16	15	150	30	11							
A20Q SDQCR/L 07	●	●	25	20	18	180	32	13							
A16Q SDQCR/L 11	●	●	21	16	15	180	32	11							
A20Q SDQCR/L 11	●	●	25	20	18	180	32	13	1	Seite / Page: 1.50					
A25R SDQCR/L 11	●	●	32	25	23	200	40	17							
E10M SDQCR/L 07	●	●	14	10	9.5	150	-	7							
E12Q SDQCR/L 07	●	●	17	12	11.5	180	-	9							
E16R SDQCR/L 07	●	●	21	16	15.5	200	-	11							
E20S SDQCR/L 07	●	○	25	20	19	250	-	13	1	Seite / Page: 1.50					
E25T SDQCR/L 11	●	●	32	25	24	300	-	17							

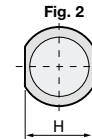
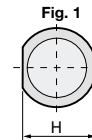
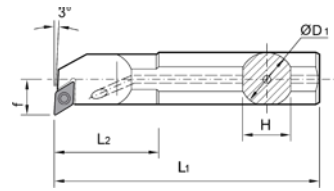
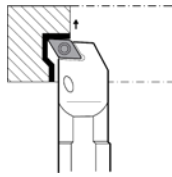
SDQCR/L 107,5° Anti-Vibration

CB-Hartmetallbohrstangen mit Innenkühlung CB-Carbide Boring Bars with Through Coolant



Bezeichnung Part Number		Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts				
		R	L	D _{min}	D ₁	H	L ₁	L ₂	f						
E10M	SDQCR/L 07-CB	●	●	13	10	9	150	16	7	Seite / Page: 1.50					
E12Q	SDQCR/L 07-CB	●	●	15	12	11	180	18	9				DC .. 07 02	48.24.107	56.33.612 (T08)
E16R	SDQCR/L 07-CB	●	●	19	16	15	200	20	11						
E20S	SDQCR/L 11-CB	●	●	24	20	18	250	24	13	48.24.113	56.33.613 (T15)				
E25T	SDQCR/L 11-CB	●	●	32	25	23	300	35	17						

SDUCR/L 93°



Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

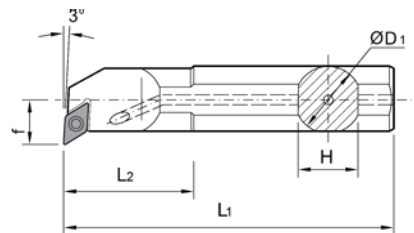
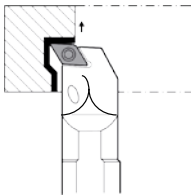
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Fig.	 Seite / Page: 1.50	Ersatzteile <i>Spare Parts</i>			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f						
A0810H SDUCR/L 07	●	●	12.5	10	9	100	22	7	2	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)
A1012K SDUCR/L 07	●	●	15.5	12	11	125	28	9						
A1216M SDUCR/L 07	●	●	19.5	16	15	150	36	11						
A10H SDUCR/L 07	●	●	14	10	9	100	20	7						
A12K SDUCR/L 07	●	●	17	12	11	125	24	9						
A16M SDUCR/L 07	●	●	21	16	15	150	30	11						
A16M SDUCR/L 11	○	○	20	16	15	150	30	11	1	DC .. 11T3 ..	48.24.108	-	-	56.33.613 (T15)
A20Q SDUCR/L 11	●	●	25	20	18	180	32	13						
A25R SDUCR/L 11	●	●	32	25	23	200	40	17						
A32S SDUCR/L 11	●	○	40	32	31	250	50	22						
A40T SDUCR/L 11	○	○	50	40	37	300	60	27						
E10M SDUCR/L 07	●	●	14	10	9.5	150	-	7						
E12Q SDUCR/L 07	●	●	17	12	11.5	180	-	9	1	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)
E16R SDUCR/L 07	●	●	21	16	15.5	200	-	11						
E20S SDUCR/L 11	●	●	25	20	19	250	-	13						
E25T SDUCR/L 11	●	●	32	25	24	300	-	17						

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

E : Hartmetallschaft mit Innenkühlung / Carbide Shank with inner coolant

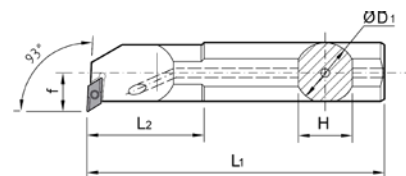
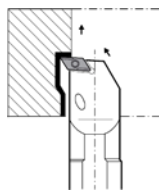
SDUCR/L 93° Anti-Vibration

CB-Hartmetallbohrstangen mit Innenkühlung CB-Carbide Boring Bars with Through Coolant



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							 Seite / Page: 1.50	Ersatzteile <i>Spare Parts</i>	
	R	L	D _{min}	D ₁	H	L ₁	L ₂	f				
E08K SDUCR/L 07-CB	●	●	11	8	7	125	13	7	DC .. 07 02	48.24.107	56.33.612 (T08)	
E10M SDUCR/L 07-CB	●	●	13	10	9	150	17	8				
E12Q SDUCR/L 07-CB	●	●	15	12	11	180	23	9				
E16R SDUCR/L 07-CB	●	●	19	16	15	200	25	11				
E20S SDUCR/L 07-CB	●	●	24	20	18	250	28	14				

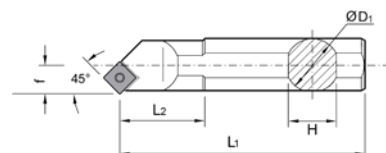
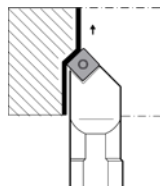
SKUCR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.53	Ersatzteile Spare Parts			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f					
A12K SKUCR/L 11	●	●	17	12	11.5	125	-	9.3	KC-X 1103 ..	48.13.104	-	-	56.33.612 (T08)
A16M SKUCR/L 11	●	●	21	16	15	150	-	11.3					
A20Q SKUCR/L 11	●	●	25	20	19	180	-	13.5					
A25R SKUCR/L 11	●	●	32	25	24	200	-	17.0					

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

SSSCR/L 45°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						 Seite / Page: 1.55	Ersatzteile Spare Parts			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f					
A16M SSSCR/L 09			21	16	15	150	30	11	SC .. 09T3 ..	48.24.108	-	-	56.33.613 (T15)
A20Q SSSCR/L 09	●	○	25	20	18	180	32	13					
A25R SSSCR/L 09			32	25	23	200	36	17					
A32S SSSCR/L 12			40	32	31	250	50	22	SC .. 1204 ..	48.13.103	48.13.206	48.13.302	
A40T SSSCR/L 12			49	40	39	300	60	27					

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

STFCR/L 90°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.57	Ersatzteile Spare Parts			
	R	L	Dmin	D1	H	L1	L2	f					
A12K STFCR/L 11			17	12	11	125	30	9	TC .. 1102 ..	48.24.107	-	-	56.33.612 (T08)
A16Q STFCR/L 11			21	16	15	180	35	11					
A20Q STFCR/L 11			25	20	18	180	36	13					
A25R STFCR/L 16			32	25	23	200	49	17	TC .. 16T3 ..	48.13.102	48.13.207	48.13.301	56.33.613 (T15)
A32S STFCR/L 16			40	32	31	250	50	22					

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

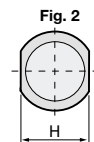
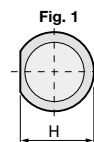
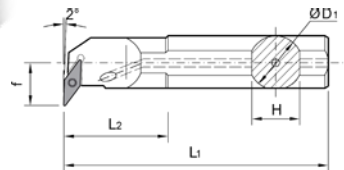
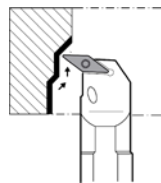
SVQCR/L 107,5°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.61	Ersatzteile Spare Parts			
	R	L	Dmin	D1	H	L1	L2	f					
A16Q SVQCR/L 11	●		21	16	15	180	30	11	VC .. 1103 ..	48.24.107	-	-	56.33.612 (T08)
A20Q SVQCR/L 11	○		25	20	18	180	32	13					
A25R SVQCR/L 11	○		32	25	23	200	36	17					
A32S SVQCR/L 16			40	32	30	250	50	22	VC .. 1604 ..	48.13.102	48.13.208	48.13.301	56.33.613 (T15)

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

SVUCR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Fig.		Ersatzteile Spare Parts			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f						
A16Q SVUCR/L 11	●	○	21	16	15	180	30	11	2	VC .. 1103 ..	48.24.107	-	-	56.33.612 (T08)
A20Q SVUCR/L 11	●	○	25	20	18	180	32	13						
A25R SVUCR/L 11	○	○	32	25	23	200	36	17						
E16R SVUCR/L 11	○	○	21	16	15.5	200	16	11	1	VC .. 1103 ..	48.24.107	-	-	56.33.612 (T08)
E20S SVUCR/L 11	○	○	25	20	19	250	20	13						
E25T SVUCR/L 11	○	○	32	25	24	300	25	17						

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

E : Hartmetallschaft mit Innenkühlung / Carbide Shank with inner coolant

SCLCR/L 95° Anti-Vibration

CB - Bohrstangen aus HSS
CB - Boring Bars made from HSS



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.46	Ersatzteile Spare Parts	
	R	L	Dmin	D ₁	H	L ₁	L ₂	f			
HSS A08J SCLCR/L 06-CB	●	●	10	8	7	110	13	5.0	CC.. 06 02	48.24.107W	56.33.612 (T08)
HSS A10K SCLCR/L 06-CB	●	●	12	10	9	125	17	7.0			
HSS A12L SCLCR/L 06-CB	●	●	14	12	11	140	23	8.0			
HSS A16Q SCLCR/L 09-CB	●	●	18	16	15	180	25	10	CC.. 09 T3	48.24.108W	56.33.613 (T15)
HSS A20R SCLCR/L 09-CB	●	●	22	20	18	200	28	12			
HSS A25S SCLCR/L 09-CB	●	●	29	25	23	250	34	16.5		48.24.113	

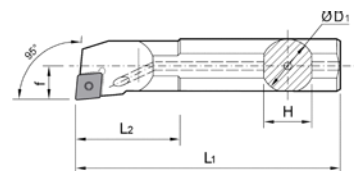
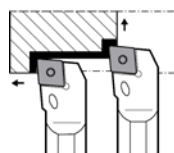
SDUCR/L 93° Anti-Vibration

CB - Bohrstangen aus HSS
CB - Boring Bars made from HSS



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.50	Ersatzteile Spare Parts	
	R	L	Dmin	D ₁	H	L ₁	L ₂	f			
HSS A08J SDUCR/L 07-CB	●	●	11	8	7	110	13	7	DC.. 07 02	48.24.107W	56.33.612 (T08)
HSS A10K SDUCR/L 07-CB	●	●	13	10	9	125	17	8			
HSS A12L SDUCR/L 07-CB	●	●	15	12	11	140	23	9			
HSS A16Q SDUCR/L 07-CB	●	●	19	16	15	180	25	11			
HSS A20R SDUCR/L 07-CB	●	●	24	20	18	200	28	14			
HSS A25S SDUCR/L 11-CB	●	●	30	25	23	250	34	17.5	DC.. 11 T3	48.24.113	56.33.613 (T15)

SET A08H-A16M SCLCR/L 95°

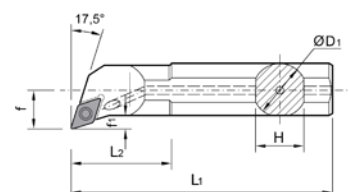
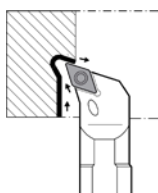
Bohrstangen mit IK
Boring Bars with IC


Bestehend aus: Consisting of:	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.46	Ersatzteile Spare Parts			
	R	L	Dmin	D1	H	L1	L2	f					
A08F SCLCR/L 06			11	8	7	80	16	5.5	CC .. 0602 ..	48.24.107	-	-	56.33.612 (T08)
A10H SCLCR/L 06	•	•	13	10	9	100	20	6.0					
A12K SCLCR/L 06			17	12	11	125	23	9.0					56.33.613 (T15)
A16M SCLCR/L 09			21	16	15	150	30	11.0	CC .. 09T3 ..	48.24.108			

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

Bitte wählen Sie linkes oder rechtes Set. Please choose left or right set.

SET A10J-A16M SDQCR/L 107,5°

Bohrstangen mit IK
Boring Bars with IC


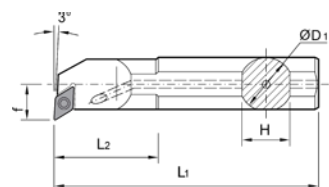
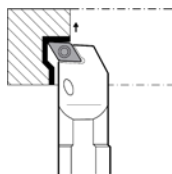
Bestehend aus: Consisting of:	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.50	Ersatzteile Spare Parts			
	R	L	Dmin	D1	H	L1	L2	f					
A10H SDQCR/L 07			12.5	10	9	100	20	7.0	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)
A12K SDQCR/L 07	•	•	17	12	11	125	24	9.0					
A16M SDQCR/L 07			21	16	15	150	30	11.0					

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

Bitte wählen Sie linkes oder rechtes Set. Please choose left or right set.

SET A10J-A16M SDUCR/L 93°

Bohrstangen mit IK
Boring Bars with IC



Bestehend aus: Consisting of:	Lager Stock		Maße [mm] Dimensions							 Seite / Page: 1.50	Ersatzteile <i>Spare Parts</i>			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f						
A10H SDUCR/L 07			14	10	9	100	20	7	DC -- 0702 --	48.24.107	-	-	56.33.612 (T08)	
A12K SDUCR/L 07	●	●	17	12	11	125	24	9						
A16M SDUCR/L 07			21	16	15	150	30	11						

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

Bitte wählen Sie linkes oder rechtes Set. Please choose left or right set.

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM- Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

SET E-SCLCR/L 95°

Hartmetall Bohrstangen mit IK
Carbide Boring Bars with IC


Bezeichnung Part Number	Lager Stock		Bestehend aus: Consisting of:						Seite / Page: 1.46	Ersatzteile Spare Parts			
	R	L	Dmin	D1	H	L1	L2	f					
E08K SCLCR/L 06			11	8	7.5	125	17	5	CC .. 0602 ..	48.24.107	-	-	56.33.612 (T08)
E10M SCLCR/L 06	●	●	14	10	9.5	150	20	6					
E12Q SCLCR/L 06			17	12	11.5	180	22	9					

E : Hartmetallschaft mit Innenkühlung / Carbide Shank with inner coolant
Bitte wählen Sie linkes oder rechtes Set. Please choose left or right set.

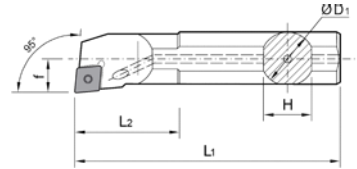
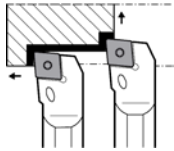
SET E-SDUCR/L 93°

Hartmetall Bohrstangen mit IK
Carbide Boring Bars with IC


Bezeichnung Part Number	Lager Stock		Bestehend aus: Consisting of:						Seite / Page: 1.50	Ersatzteile Spare Parts			
	R	L	Dmin	D1	H	L1	L2	f					
E10M SDUCR/L 07			14	10	9.5	150	-	7	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)
E12Q SDUCR/L 07	●	●	17	12	11.5	180	-	9					

E : Hartmetallschaft mit Innenkühlung / Carbide Shank with inner coolant
Bitte wählen Sie linkes oder rechtes Set. Please choose left or right set.

SET A0608H-A1216M SCLCR/L 06₉₅ Abgesetzte Bohrstangen mit IK Boring Bars with IC



Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

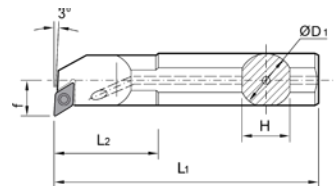
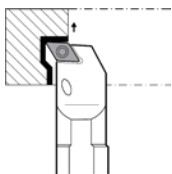
Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Bestehend aus: Consisting of:	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.46	Ersatzteile Spare Parts			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f					
A0608H SCLCR/L 06			8	8	7	100	25.0	4.5	CC .. 0602 ..	48.24.107	-	-	56.33.612 (T08)
A0810J SCLCR/L 06	•	•	11	10	9	110	32.0	6.0					
A1012K SCLCR/L 06			13	12	11	125	38.0	7.0					
A1216M SCLCR/L 06			16	16	15	150	50.0	9.0					

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

Bitte wählen Sie linkes oder rechtes Set. Please choose left or right set.

SET A0810H-A1216M SDUCR/L 07₉₃ Abgesetzte Bohrstangen mit IK Boring Bars with IC

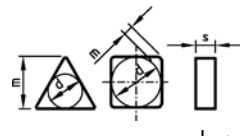


Bestehend aus: Consisting of:	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.50	Ersatzteile Spare Parts			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f					
A0810H SDUCR/L 07			12.5	10	9	100	22	7	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)
A1012K SDUCR/L 07	•	•	15.5	12	11	125	28	9					
A1216M SDUCR/L 07			19.5	16	15	150	36	11					

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

Bitte wählen Sie linkes oder rechtes Set. Please choose left or right set.

ISO - Bezeichnungssystem für Wendschneidplatten ISO Designation System for Indexable Inserts

 80° C 55° D 75° E 86° M 35° V  85° A 82° B 55° K  H  L  O  P  R  S  T  W	 3° A 5° B 7° C 15° D 20° E 25° F 30° G 0° N 11° P Sonstige Others O	 Grenzabmaße (mm) Range of tolerance d +/- m +/- s +/- Klasse 0.025 0.005 0.025 A 0.025 0.013 0.025 C 0.025 0.025 0.025 E 0.013 0.005 0.025 F 0.025 0.025 0.05-0.13 G 0.013 0.013 0.025 H 0.05-0.15 0.005 0.025 J 0.05-0.15 0.013 0.025 K 0.05-0.15 0.025 0.025 L 0.05-0.15 0.08-0.2 0.05-0.13 M 0.05-0.15 0.08-0.2 0.025 N 0.08-0.25 0.13-0.38 0.13 U
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T

N

M

G

Plattenform
Shape

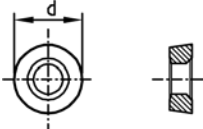
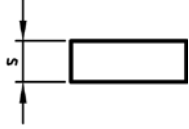
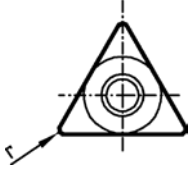
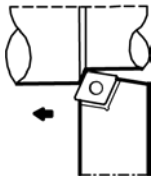
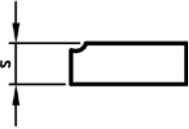
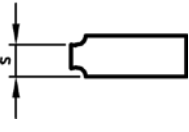
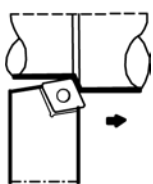
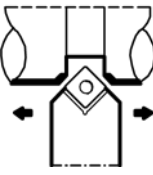
Freiwinkel
Clearance Angle

Toleranzen
Tolerances

Plattentyp
Type of Inserts

ISO - Bezeichnungssystem für Wendeschneidplatten

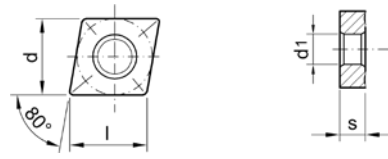
ISO Designation System for Indexable Inserts

												F Scharf Sharp				R 			
												E Gerundet Rounded							
												T Gefast Chamfered				L 			
												S Gefast und gerundet Chamfered and rounded				N 			

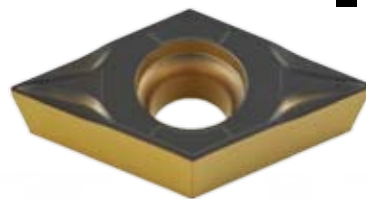
16	04	04	E	R
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Schneidenlänge Length of Cutting Edge	Plattendicke Thickness of Insert	Eckenradius Corner Radius	Schneidkante Cutting Edge	Schneidrichtung Cutting Direction
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CN

[illegible]

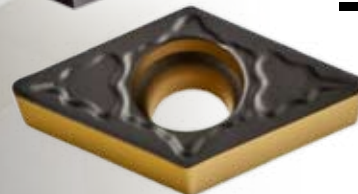
- F30



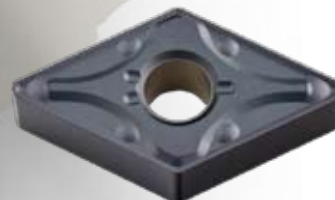
- M30



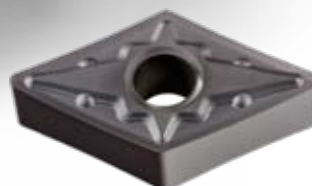
- MD



- S33

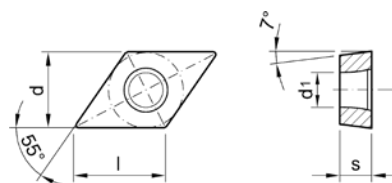


- S30



- C22





Werkstück / Workpiece

Stahl / Steel	A (P)	○	○	○	○	●	●	●	●	●	●	●	●	●	●	●	●	●	○
Rostfreier Stahl / Stainless steel	R (M)	○	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○
Guss / Cast iron	F (K)	○	○	○	○	●	●	●	●	●	●	●	●	●	●	●	●	○	
Nichtmet. Werkstoffe / Non-fer. metall.	N	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
Warmf. Leg., Titanleg. / Heat res. alloys, Titan, dll.	S	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
Gehärteter Stahl / Hardened steel	H	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

Machinentyp
Machining types

●

Hauptanwendung / Main application

○

Nebenanwendung / Additional application

Wendeplatten Inserts	Bezeichnung Part Number	Beschichtet Coated										Unbeschichtet Uncoated	Maße Dimensions [mm]				Schnittdaten Cutting Data [mm]				
		TK 5410	TM 5125	TM 5130	TP 2135	TP 2235	TP 3020	TP 3120	TP4015+	TP4015+	TP4025+		TP 5025	TP 5345	TWS7225	TK 1310	l	Ø d	s	Ø d ₁	f _n (mm/rev)
	DCMT-F30															07	6.35	2.38	2.80	0,03~0,11	0,06~1,70
	07 02 04 - F30											●				07	6.35	2.38	2.80	0,05~0,17	0,10~1,70
	11 T3 02 - F30											●				11	9.52	3.97	4.40	0,04~0,15	0,08~2,00
	11 T3 04 - F30											●				11	9.52	3.97	4.40	0,06~0,23	0,11~2,00
	DCMT-JTM															07	6.35	2.38	2.80	0,06~0,20	0,20~2,00
	07 02 08 - JTM															07	6.35	2.38	2.80	0,08~0,30	0,20~2,00
	11 T3 04 - JTM															11	9.52	3.97	4.40	0,08~0,25	0,30~3,00
	11 T3 08 - JTM															11	9.52	3.97	4.40	0,10~0,30	0,30~3,00
	11 T3 12 - JTM													○		11	9.52	3.97	4.40	0,05~0,25	0,20~1,50
	DCMT-M30															07	6.35	2.38	2.80	0,05~0,20	0,20~1,50
	07 02 08 - M30		●						●							07	6.35	2.38	2.80	0,05~0,25	0,20~1,50
	11 T3 04 - M30		●						●							11	9.52	3.97	4.40	0,08~0,23	0,25~2,00
	11 T3 08 - M30		●						●							11	9.52	3.97	4.40	0,08~0,25	0,25~2,00
	DCMT-MD															07	6.35	2.38	2.80	0,06~0,17	0,20~2,40
	07 02 08 - MD								●			●				07	6.35	2.38	2.80	0,08~0,23	0,40~2,40
	11 T3 02 - MD								●			●				11	9.52	3.97	4.40	0,04~0,22	0,10~2,00
	11 T3 04 - MD								●			●				11	9.52	3.97	4.40	0,06~0,17	0,30~3,00
	11 T3 08 - MD								●			●				11	9.52	3.97	4.40	0,08~0,23	0,50~3,00



- JTM



- JBF



- JBM

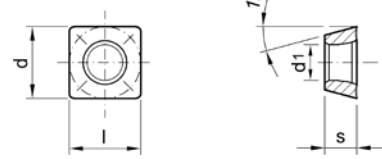


- JBR

SC ☐ ☐



90°



Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Werkstück / Workpiece	Stahl / Steel	A (P)																		
	Rostfreier Stahl / Stainless steel	R (M)																		
	Guss / Cast iron	F (K)																		
	Nichtmet. Werkstoffe / Non-fer. metall.	N																		
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S																		
	Gehärteter Stahl / Hardened steel	H																		

Machinentyp
Machining types

●

Hauptanwendung / Main application

○

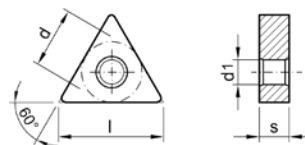
Nebenanwendung / Additional application

Wendeplatten Inserts	Bezeichnung Part Number	Beschichtet Coated												Unbeschichtet Uncoated	Maße Dimensions [mm]				Schnittdaten Cutting Data [mm]		
		TK 5410	TK 5810	TM 5125	TM 5130	TP 2135	TP 2235	TP 3020	TP 3120	TP 4015+	TP 4025+	TP 5025	TP 5345		TW 57225	TK 1310	l	Ø d	s	Ø d ₁	f _n (mm/rev)
	SCGT-ALX														●	09	9.52	3.97	4.40	0,02~0,30	0,10~4,00
	09 T3 02 - ALX														●	09	9.52	3.97	4.40	0,02~0,40	0,10~4,00
	09 T3 04 - ALX	●	●												●	09	9.52	3.97	4.40	0,03~0,50	0,10~4,00
	09 T3 08 - ALX	○	●												●	09	9.52	3.97	4.40	0,03~0,50	0,10~4,00
	12 04 02 - ALX														●	12	12.70	4.76	5.50	0,02~0,30	0,10~5,00
	12 04 04 - ALX	●	●												●	12	12.70	4.76	5.50	0,02~0,40	0,10~5,00
	12 04 08 - ALX	○	●											●	12	12.70	4.76	5.50	0,03~0,50	0,10~5,00	

Machinentyp
Machining types

● Hauptanwendung / Main application
○ Nebenanwendung / Additional application

Werkstück / Workpiece	Stahl / Steel	A (P)	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	
	Rostfreier Stahl / Stainless steel	R (M)	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	
	Guss / Cast iron	F (K)	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	
	Nichtmet. Werkstoffe / Non-fer. metall.	N	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	
	Warmf. Leg. / Titanleg. / Heat res. alloys, Titan. all.	S	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	
	Gehärteter Stahl / Hardened steel	H	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	●	○	
		Machinentyp Machining types																			
		● Hauptanwendung / Main application ○ Nebenanwendung / Additional application																			
Wendeplatten Inserts	Bezeichnung Part Number	Beschichtet Coated												Unbeschichtet Uncoated	Maße Dimensions [mm]				Schnittdaten Cutting Data [mm]		
		TK 5410	TK 5810	TM 5125	TM 5130	TP 2135	TP 2235	TP 3020	TP 3120	TP 4015+	TP 4025+	TP 5025	TP 5345		TW57225	TK 1310	l	Ø d	s	Ø d ₁	f _n (mm/rev)
	SCMT-F30															09	9.52	3.97	4.40	0,06~0,23	0,16~2,00
	09 T3 04 - F30															12	12.70	4.76	5.50	0,07~0,27	0,14~2,00
	12 04 04 - F30																				
	SCMT-JTM														●	09	9.52	3.97	4.40	0,08~0,25	0,30~3,00
	09 T3 04 - JTM														●	09	9.52	3.97	4.40	0,10~0,30	0,30~3,00
	09 T3 08 - JTM														●	12	12.70	4.76	5.56	0,10~0,25	0,30~3,50
	12 04 04 - JTM														●	12	12.70	4.76	5.56	0,15~0,35	0,30~4,00
	12 04 08 - JTM														○	12	12.70	4.76	5.56	0,20~0,50	0,80~3,00
	SCMT-M30			●					●							12	12.70	4.76	5.56	0,08~0,25	0,25~2,00
	12 04 08 - M30																				
	SCMT-MD									●	●					09	9.52	3.97	4.40	0,06~0,17	0,20~2,50
	09 T3 04 - MD									●	●					09	9.52	3.97	4.40	0,08~0,23	0,30~2,50
	09 T3 08 - MD										●	●				12	12.70	4.76	5.50	0,06~0,17	0,80~3,00
	12 04 04 - MD										●	●				12	12.70	4.76	5.50	0,08~0,23	0,50~3,50
	12 04 08 - MD																				

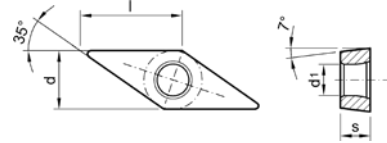
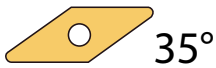
TN ☐ ☐


Werkstück/Workpiece	Stahl / Steel	A (P)	●	○	○	○	○	●	●	●	●	●	●	○		Machinentyp Machining types ● Hauptanwendung / Main application ○ Nebenanwendung / Additional application					
	Rostfreier Stahl / Stainless steel	R (M)	○	○	●	●	●	○	○	○	○	○	○	●	●						
	Guss / Cast iron	F (K)	○	○	○	○	○	○	○	○	○	○	○	○	○						
	Nichtmet. Werkstoffe / Non-fer. metall.	N	○	○	○	○	○	○	○	○	○	○	○	○	○						
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S	○	○	○	○	○	○	○	○	○	○	○	○	○						
	Gehärteter Stahl / Hardened steel	H													○						
Wendeplatten Inserts		Bezeichnung Part Number	Beschichtet Coated												Unbeschichtet Uncoated	Maße Dimensions [mm]				Schnittdaten Cutting Data [mm]	
			TK 5410	TK 5510	TK 5810	TM 5125	TM 5130	TP 2135	TP 2235	TP 3020	TP 3120	TP4025+ TP 5025	TP 5345	TW5725		TK 1310	l	Ø d	s	Ø d ₁	f _n (mm/rev)
	16 04 02 - A20					●								●	16	9.52	4.76	3.80	0,05~0,15	1,00~3,00	
	16 04 04 - A20	○		○										●	16	9.52	4.76	3.80	0,12~0,30	1,00~3,50	
	16 04 08 - A20	○		○										●	16	9.52	4.76	3.80	0,15~0,35	1,30~3,50	
	16 04 12 - A20					●								●	16	9.52	4.76	3.80	0,15~0,55	1,30~3,50	
	22 04 08 - A20					●								●	22	12.70	4.76	5.16	0.10~0.40	0.80~3.50	

Machinentyp
Machining types

● Hauptanwendung / Main application
○ Nebenanwendung / Additional application

Werkstück/Workpiece	Stahl / Steel	A (P)	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
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VC ☐ ☐

Werkstück / Workpiece

Stahl / Steel	A (P)																			
Rostfreier Stahl / Stainless steel	R (M)																			
Guss / Cast iron	F (K)																			
Nichtmet. Werkstoffe / Non-fer. metall.	N																			
Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S																			
Gehärteter Stahl / Hardened steel	H																			

Machinentyp
Machining types

●

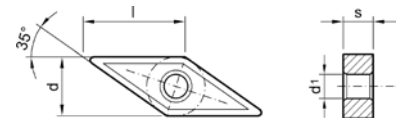
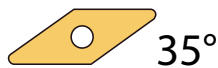
Hauptanwendung / Main application

○

Nebenanwendung / Additional application

Wendeplatten Inserts	Bezeichnung Part Number	Beschichtet Coated												Unbeschichtet Uncoated	Maße Dimensions [mm]				Schnittdaten Cutting Data [mm]		
		TK 5410	TK 5810	TN 5125	TN 5130 +	TP 2135	TP 2235	TP 3020	TP 3120	TP 4015+	TP 4025+	TP 5025	TP 5345		TN 57225	TK 1310	l	Ø d	s	Ø d ₁	f _n (mm/rev)
	VC GT-ALS 2				●											11	6.35	3.18	2.80	0,01~0,30	0,05~3,50
	11 03 02 - ALS2				●											11	6.35	3.18	2.80	0,02~0,40	0,10~4,00
	16 04 02 - ALS2				●											16	9.52	4.76	4.40	0,01~0,30	0,05~4,50
	16 04 04 - ALS2				●											16	9.52	4.76	4.40	0,02~0,40	0,10~5,00
	16 04 08 - ALS2				●											16	9.52	4.76	4.40	0,03~0,50	0,10~5,00
	VC GT-ALX													●		11	6.35	3.18	2.80	0,008~0,15	0,05~2,50
	11 03 02 - ALX	●	●										●	●		11	6.35	3.18	2.80	0,01~0,30	0,05~3,50
	11 03 04 - ALX	●	●										●	●		11	6.35	3.18	2.80	0,02~0,40	0,10~4,00
	11 03 08 - ALX	○	●											●		11	6.35	3.18	2.80	0,03~0,50	0,10~5,00
	13 03 02 - ALX	●	●											●		13	7.94	3.18	3.40	0,01~0,30	0,10~4,50
	13 03 04 - ALX	●	●											●		13	7.94	3.18	3.40	0,02~0,40	0,10~4,50
	16 04 02 - ALX	●	●										●	●		16	9.52	4.76	4.40	0,01~0,30	0,05~4,50
	16 04 04 - ALX	●	●										●	●		16	9.52	4.76	4.40	0,02~0,40	0,10~5,00
	16 04 08 - ALX	●	●										●	●		16	9.52	4.76	4.40	0,03~0,50	0,10~5,00
	16 04 12 - ALX	○	●											●		16	9.52	4.76	4.40	0,03~0,50	0,10~5,00
	22 05 30 - ALX	○	●											●		22	12.70	5.56	5.60	0,08~1,00	0,15~7,00

[illegible]

VN ☐ ☐


Werkstück/Workpiece	Stahl / Steel	A (P)	○	○	○	○	●	●	●	●	●	●	○	
	Rostfreier Stahl / Stainless steel	R (M)	○	●	●	●	○	○	○	○	○	○	●	●
	Guss / Cast iron	F (K)	●	●	●	●	●	●	●	●	●	●	●	○
	Nichtmet. Werkstoffe / Non-fer. metall.	N	●	○	○	○	○	○	○	○	○	○	○	●
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S	●	○	○	○	○	○	○	○	○	○	○	○
	Gehärteter Stahl / Hardened steel	H											○	

Machinentyp
Machinery types

● Hauptanwendung / Main application
○ Nebenanwendung / Additional application

Wendeplatten Inserts	Bezeichnung Part Number	Beschichtet Coated														Unbeschichtet Uncoated	Maße Dimensions [mm]				Schnittdaten Cutting Data [mm]	
		TK 5410	TK 5810	TM 5125	TM 5130	TP 2135	TP 2235	TP 3020	TP 3120	TP4015+	TP4025+	TP 5025	TP 5345	TW57225	TK 1310		l	Ø d	s	Ø d ₁	f _n (mm/rev)	a _p (mm)
	VNGG-A20	16 04 01 - A20				●									●	16	9.52	4.76	3.81	0,02~0,10	0,80~3,00	
		16 04 02 - A20				●									●	16	9.52	4.76	3.81	0,05~0,15	0,80~3,00	
		16 04 04 - A20				●									●	16	9.52	4.76	3.81	0,08~0,30	0,80~3,50	
		16 04 08 - A20				●									●	16	9.52	4.76	3.81	0,10~0,35	0,80~3,50	

Machinentyp
Machining types

- Hauptanwendung / Main application
- Nebenanwendung / Additional application

Werkstück / Workpiece	Stahl / Steel	A (P)	○	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
	Rostfreier Stahl / Stainless steel	R (M)	○	○	●	●	●	●	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
	Guss / Cast iron	F (K)	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
	Nichtmet. Werkstoffe / Non-fer. metall.	N	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	
Gehärteter Stahl / Hardened steel	H	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	

Machinentyp
Machining types

●

Hauptanwendung / Main application

○

Nebenanwendung / Additional application

Wendeplatten Inserts	Bezeichnung Part Number	Beschichtet Coated													Unbeschichtet Uncoated	Maße Dimensions [mm]				Schnittdaten Cutting Data [mm]		
		TK 5410	TK 5810	TM 5125	TM 5130	TP 2135	TP 2235	TP 3020	TP 3120	TP4015+	TP4025+	TP 5025	TP 5345	TP57225		TK 1310	l	Ø d	s	Ø d ₁	f _n (mm/rev)	a _p (mm)
	VNMG-JBF	16 04 04 - JBF													○		16	9.52	4.76	3.80	0,08~0,18	0,10~2,00
	16 04 08 - JBF														●		16	9.52	4.76	3.80	0,10~0,35	0,10~2,50
	VNMG-JBM	16 04 04 - JBM													●		16	9.52	4.76	3.80	0,10~0,25	0,40~3,00
	16 04 08 - JBM														●		16	9.52	4.76	3.80	0,10~0,40	0,40~3,50
	16 04 12 - JBM														○		16	9.52	4.76	3.80	0,13~0,50	0,80~4,50
	VNMG-S30	16 04 04 - S30			○												16	9.52	4.76	3.81	0,08~0,35	0,50~4,00
	16 04 08 - S30				●												16	9.52	4.76	3.81	0,10~0,40	1,00~4,50
	VNMG-MD	16 04 04 - MD										●	●				16	9.52	4.76	3.80	0,08~0,45	0,50~3,00
	16 04 08 - MD											●	●				16	9.52	4.76	3.80	0,10~0,50	1,00~4,00
	16 04 12 - MD											●	●				16	9.52	4.76	3.80	0,20~0,50	1,50~4,00

Machinentyp
Machining types

- Hauptanwendung / Main application
- Nebenanwendung / Additional application

ALUMINIUM

**Für jede Anwendung
die richtige Sorte.**

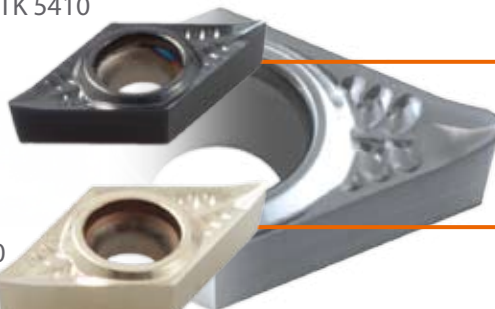
***For each application
the best grade.***

DCGT-TK 1310



Unbeschichtet *uncoated*
(Feinstkorn Micrograin)
für *for* Aluminium

DCGT-TK 5410



Saphitec für *for*
Aluminium, HRSA, GFK, CFK,

DCGT-TK 5810



Goldtec ZrN-beschichtet *coated*
Aluminium + Sonderlegierungen
Special Alloys

DCGT-TP 5345



für *for*
Niro Stainless Steel

CBN



CCMW CNMA CPMW

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM- Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepaltenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)				
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number		Ecke Corner EW CDX 09		
				F	T	
CCMW 		06 02 02		○	○	
		06 02 04		○	○	
		06 02 08		○	○	
		09 T3 02		○	○	
		09 T3 04		○	○	
		09 T3 08		○	○	
		12 04 02		○	○	
		12 04 04		○	○	
		12 04 08		○	○	
Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)				
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number		Ecke Corner EW CDX 09		
				F	T	
CNMA 		09 03 02		○	○	
		09 03 04		○	○	
		09 03 08		○	○	
		12 04 02		○	○	
		12 04 04		○	○	
		12 04 08		○	○	
		12 04 12		○	○	
Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)				
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number		Ecke Corner EW CDX 09		
				F	T	
CPMW 		05 02 02		○	○	
		05 02 04		○	○	
		06 02 02		○	○	
		06 02 04		○	○	
		09 T3 02		○	○	
		09 T3 04		○	○	
		09 T3 08		○	○	
		12 04 02		○	○	
		12 04 04		○	○	
		12 04 08		○	○	

Bitte angeben / Please state : F: scharfe Ausführung / sharp version T: gefaste Ausführung / chamfered version

CBN


DCMW DNMA

EPMW

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application
	Rostfreier Stahl / Stainless steel	R (M)				○ Nebenanwendung / Additional application
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg.,Titanleg. / Heat res. alloys,Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	Ecke Corner EW CDX 09			
			F	T		
DCMW 		07 02 02	○	○		
		07 02 04	○	○		
		07 02 08	○	○		
		11 T3 02	○	○		
		11 T3 04	○	○		
		11 T3 08	○	○		

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application
	Rostfreier Stahl / Stainless steel	R (M)				○ Nebenanwendung / Additional application
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg.,Titanleg. / Heat res. alloys,Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	Ecke Corner EW CDX 09			
			F	T		
DNMA 		15 04 02	○	○		
		15 04 04	○	○		
		15 04 08	○	○		
		15 06 02	○	○		
		15 06 04	○	○		
		15 06 08	○	○		
		15 06 12	○	○		

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application
	Rostfreier Stahl / Stainless steel	R (M)				○ Nebenanwendung / Additional application
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg.,Titanleg. / Heat res. alloys,Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	Ecke Corner EW CDX 09			
			F	T		
EPMW 		05 02 02	○	○		
		05 02 04	○	○		
		06 02 02	○	○		
		06 02 04	○	○		
		08 03 02	○	○		
		08 03 04	○	○		
		08 03 08	○	○		

Bitte angeben / Please state : F: scharfe Ausführung / sharp version T: gefaste Ausführung / chamfered version

CBN



90°

SCMW SNMA SNMN

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM-Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendeplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)				
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	Ecke Corner EW CDX 09			
			F	T		
SCMW 		09 03 02	○	○		
		09 03 04	○	○		
		09 03 08	○	○		
		09 T3 02	○	○		
		09 T3 04	○	○		
		09 T3 08	○	○		
		12 04 02	○	○		
		12 04 04	○	○		
		12 04 08	○	○		

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)				
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	Ecke Corner EW CDX 09			
			F	T		
SNMA 		12 03 02	○	○		
		12 04 02	○	○		
		12 04 08	○	○		

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)				
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	Ecke Corner EW CDX 09			
			F	T		
SNMN 		12 03 04	○	○		
		12 03 08	○	○		
		12 04 04	○	○		

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CBN


SPMN

TCMW TNMA

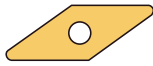
Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types ● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)			
	Guss / Cast iron	F (K)			
	Nichtmet. Werkstoffe / Non-fer. metall.	N			
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S			
	Gehärteter Stahl / Hardened steel	H			
Wendeplatten Inserts	Bezeichnung Part Number	Ecke Corner EW CDX 09			
		F	T		
SPMN 	09 03 02	○	○		
	09 03 04	○	○		
	09 03 08	○	○		
	12 03 02	○	○		
	12 03 04	○	○		
	12 03 08	○	○		
Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types ● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)			
	Guss / Cast iron	F (K)			
	Nichtmet. Werkstoffe / Non-fer. metall.	N			
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S			
	Gehärteter Stahl / Hardened steel	H			
Wendeplatten Inserts	Bezeichnung Part Number	Ecke Corner EW CDX 09			
		F	T		
TCMW 	09 02 02	○	○		
	09 02 04	○	○		
	09 02 08	○	○		
	11 02 02	○	○		
	11 02 04	○	○		
	11 02 08	○	○		
	16 T3 02	○	○		
	16 T3 04	○	○		
	16 T3 08	○	○		
Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types ● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)			
	Guss / Cast iron	F (K)			
	Nichtmet. Werkstoffe / Non-fer. metall.	N			
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S			
	Gehärteter Stahl / Hardened steel	H			
Wendeplatten Inserts	Bezeichnung Part Number	Ecke Corner EW CDX 09			
		F	T		
TNMA 	16 04 02	○	○		
	16 04 04	○	○		
	16 04 08	○	○		

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CBN



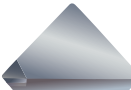
60°



35°

TPMN

VBMW VCMW

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)				
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg.,Titanleg. / Heat res. alloys,Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	Ecke Corner EW CDX 09			
			F	T		
TPMN 	11 03 02	○	○			
	11 03 04	○	○			
	11 02 08	○	○			

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)				
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				

Wendeplatten Inserts	Bezeichnung Part Number	Ecke Corner EW CDX 09		
		F	T	
VBMW 	16 04 02	○	○	
	16 04 04	○	○	
	16 04 08	○	○	

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types ● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)			
	Guss / Cast iron	F (K)			
	Nichtmet. Werkstoffe / Non-fer. metall.	N			
	Warmf. Leg.,Titanleg. / Heat res. alloys,Titan. all.	S			
	Gehärteter Stahl / Hardened steel	H			
Wendeplatten Inserts		Bezeichnung Part Number	Ecke Corner EW CDX 09		
			F	T	
VCMW 		11 03 02	○	○	
		11 03 04	○	○	
		11 03 08	○	○	
		16 04 02	○	○	
		16 04 04	○	○	
		16 04 08	○	○	
		16 04 12	○	○	

Bitte angeben / Please state : F: scharfe Ausführung / sharp version T: gefaste Ausführung / chamfered version

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM- Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendeplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

CBN



35°

VNMA

Werkstück Workpiece	Stahl / Steel	A (P)			
	Rostfreier Stahl / Stainless steel	R (M)			
	Guss / Cast iron	F (K)			
	Nichtmet. Werkstoffe / Non-fer. metall.	N			
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S			
	Gehärteter Stahl / Hardened steel	H			
Wendeplatten Inserts	Bezeichnung Part Number	Ecke Corner EW CDX 09			
		F	T		
VNMA 	16 04 02	○	○		
	16 04 04	○	○		
	16 04 08	○	○		

Machinentyp
Machining types

- Hauptanwendung / Main application
- Nebenanwendung / Additional application

Bitte angeben / Please state : F: scharfe Ausführung / sharp version T: gefaste Ausführung / chamfered version

PKD



80°

CCMW CNMA



55°

DCMW

Werkstück Workpiece	Stahl / Steel	A (P)		
	Rostfreier Stahl / Stainless steel	R (M)		
	Guss / Cast iron	F (K)		
	Nichtmet. Werkstoffe / Non-fer. metall.	N		
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S		
	Gehärteter Stahl / Hardened steel	H		

Machinentyp
Machining types

- Hauptanwendung / Main application
○ Nebenanwendung / Additional application

Wendeplatten Inserts	Bezeichnung Part Number	1 Ecke / Corner TY 1110 PKD	
		F	T
CCMW 	06 02 01		
	06 02 02		
	06 02 04		
	09 T3 02		
	09 T3 04		
	09 T3 08		
	12 04 04		
	12 04 08		

Werkstück Workpiece	Stahl / Steel	A (P)		
	Rostfreier Stahl / Stainless steel	R (M)		
	Guss / Cast iron	F (K)		
	Nichtmet. Werkstoffe / Non-fer. metall.	N		
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S		
	Gehärteter Stahl / Hardened steel	H		

Machinentyp
Machining types

- Hauptanwendung / Main application
○ Nebenanwendung / Additional application

Wendeplatten Inserts	Bezeichnung Part Number	1 Ecke / Corner TY 1110 PKD	
		F	T
CNMA 	12 04 04		
	12 04 08		

Werkstück Workpiece	Stahl / Steel	A (P)		
	Rostfreier Stahl / Stainless steel	R (M)		
	Guss / Cast iron	F (K)		
	Nichtmet. Werkstoffe / Non-fer. metall.	N		
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S		
	Gehärteter Stahl / Hardened steel	H		

Machinentyp
Machining types

- Hauptanwendung / Main application
○ Nebenanwendung / Additional application

Wendeplatten Inserts	Bezeichnung Part Number	1 Ecke / Corner TY 1110 PKD	
		F	T
DCMW 	07 02 01		
	07 02 02		
	07 02 04		
	11 T3 02		
	11 T3 04		
	11 T3 08		

Bitte angeben / Please state : F: scharfe Ausführung / sharp version T: gefaste Ausführung / chamfered version

PKD


DNMA

RCMW

TCMW

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application
	Rostfreier Stahl / Stainless steel	R (M)				○ Nebenanwendung / Additional application
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	1 Ecke / Corner TY 1110 PKD			
			F	T		
DNMA 		11 04 04	○	○		
		11 04 08	○	○		
		15 06 04	○	○		
		15 06 08				

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application
	Rostfreier Stahl / Stainless steel	R (M)				○ Nebenanwendung / Additional application
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	Fullface TY 1110 PKD			
			F	T		
RCMW 		06 02 00				
		08 03 00				
		10 03 00				
		12 T3 00				

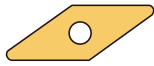
Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types	● Hauptanwendung / Main application
	Rostfreier Stahl / Stainless steel	R (M)				○ Nebenanwendung / Additional application
	Guss / Cast iron	F (K)				
	Nichtmet. Werkstoffe / Non-fer. metall.	N				
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S				
	Gehärteter Stahl / Hardened steel	H				
Wendeplatten Inserts		Bezeichnung Part Number	1 Ecke / Corner TY 1110 PKD			
			F	T		
TCMW 		09 02 01				
		09 02 02				
		09 02 04				
		11 02 02				
		11 02 04				
		11 02 08				
		16 T3 04				
		16 T3 08				

Bitte angeben / Please state : F: scharfe Ausführung / sharp version T: gefaste Ausführung / chamfered version

PKD



60°



35°

TNMA

VCMW

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types ● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)			
	Guss / Cast iron	F (K)			
	Nichtmet. Werkstoffe / Non-fer. metall.	N			
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S			
	Gehärteter Stahl / Hardened steel	H			
Wendeplatten Inserts		Bezeichnung Part Number		1 Ecke / Corner TY 1110 PKD	
				F T	
TNMA		16 04 02			
		16 04 04			
		16 04 08			

Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types ● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)			
	Guss / Cast iron	F (K)			
	Nichtmet. Werkstoffe / Non-fer. metall.	N			
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S			
	Gehärteter Stahl / Hardened steel	H			
Wendeplatten Inserts		Bezeichnung Part Number		1 Ecke / Corner TY 1110 PKD	
				F T	
VCMW		11 03 02			
		11 03 04			
		11 03 08			
		16 04 02			

Bitte angeben / Please state : F: scharfe Ausführung / sharp version T: gefaste Ausführung / chamfered version

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM- Fräser
HDS-/ Solid Carbide
Endmills

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendeplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Schneidstoffsorten-Übersicht zum Drehen Description of Carbide Grades for Turning

ISO	P						M				K					Gehärtet Hardened		
Material Material	hoch high		mittel medium		niedrig low	unterbrochener Schnitt intermittent cutting	hoch high		mittel medium		niedrig low	hoch high		mittel medium		niedrig low	niedrig low	
	P01	P10	P20	P30	P40	P50	M10	M20	M30	M40	K01	K10	K20	K30	K40			
Hartmetall beschichtet Coated Carbide			TWS 7225					TWS 7225				TK 5510						
		TP 3020						TM 5125										
			TP 2135 TP 2235									TK 5410						
				TP 5345					TM 5130				TK 5810					
		TP 4015+																
		TP 4025+						TP 4015+										
			TP 3120					TP 4025+										
		TP 5025						TP 5025										
CBN																	CDX09	
Hartmetall unbeschichtet Uncoated Carbide												TK 1210 TK 1310						

Schneidstoffsorten-Schlüssel zum Drehen Code Explanation of Carbide Grades for Turning

C N M G 120404 - A20

T **K** **12** **10**

Anwendung 1 Application 1	T	Drehen / Turning
	M	Fräsen / Milling
	G	Stechen / Grooving
	T	Gewinde / Threading
	D	Bohren / Drilling

Anwendung 2 Application 2	P	Stahl / Steel
	M	Niro / Stainless Steel
	K	Nichteisen, Kunststoff, Aluminium Non Metallic Materials
	S	warmfeste Legierungen / Heat Resistant Alloys
	H	gehärteter Stahl / Hardened Steel
	U	universell / all-purpose
	W	DIA
	X	CBN
	Y	PKD
	Z	Cermet
	D	DLC
	C	Keramik / Ceramics

Serien-Nr. Serial-No.	11-20	unbeschichtet / uncoated
	21-50	CVD
	51-99	PVD

ISO	10	
	20	
	30	
	40	
	50	
	...	

Drehen
Turning

Fräswerkzeuge
Milling Tools

HDS-/VHM- Fräser
HDS-/ Solid Carbide
Endmills

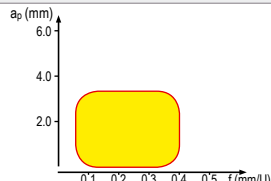
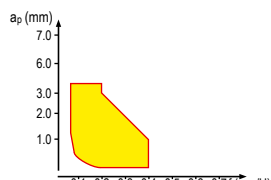
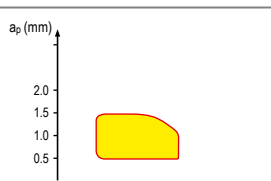
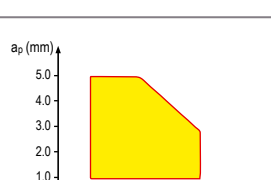
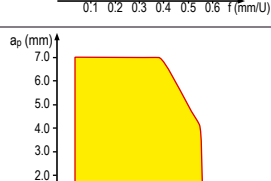
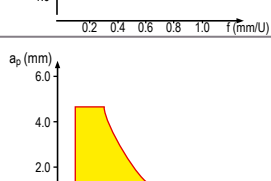
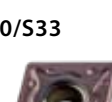
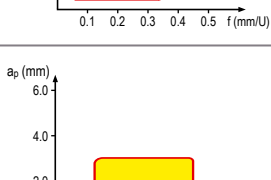
Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

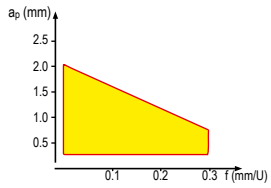
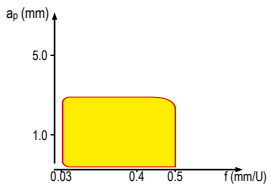
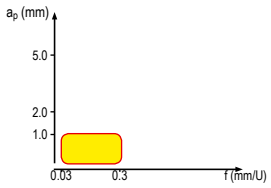
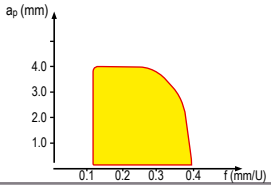
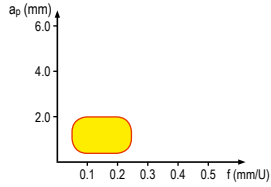
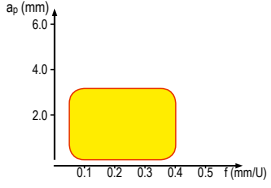
Gewinde-
werkzeuge
Threading Tools

Wendepaltenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Spanleitstufen zum Drehen / Chipbreakers for Turning

Spanleitstufe Chipbreaker	Anwendungsbereich Application Range	Highlights	Highlights
A20 		Alu-Legierungen, Niro, St 37 • scharfe Schneidkanten (Umfangsschliff) • extrem großer Spanwinkel	Alu-alloys, stainless steel • Sharp cutting edge (ground circumference) • Extremely high helix
C22 		• hervorragende Spankontrolle beim Kopierdrehen und der Innenbearbeitung • sehr gute Oberflächen beim Plandrehen	• Excellent chip control while copy turning and internal machining • Very good surface while face turning
JBF 		• hohe Oberflächengüte durch gute Spankontrolle bei geringen Schnitttiefen	• High quality surface due to good chip control while low cutting depths
JBM 		• weiter Anwendungsbereich bei der mittleren Schlichtbearbeitung bis hin zur mittleren Schruppbearbeitung • typischer Einsatz in der universellen Anwendung auf CNC- Maschinen	• Wide range of application while middle finishing up to middle roughing • Typical usage in universal working on CNC machines
JBR 		• erste Wahl für unterbrochenen Schnitt und Schruppen im P- und M- Anwendungsbereich	• First choice for interrupted cut and roughing of P- and M- application range
MD 		Standard-Geometrie im mittleren Bereich • vor allem CNC-Bearbeitung • sehr gute Spankontrolle • geeignet für Niro - Bearbeitung	Medium cutting • Wide range of chip control from medium-finishing to medium-roughing • Chip breaker especially for CNC machining • Suitable for stainless steel machining
S30/S33 		• scharfe, stabile Schneidkante • hervorragende Spankontrolle auch bei langspanenden, weichen, rostfreien Stählen und Baustählen	• Sharp, strong cutting edge • Excellent chip control also at long-chipping soft stainless and mild steels

Spanleitstufen zum Drehen / Chipbreakers for Turning

Spanleitstufe Chipbreaker		Anwendungsbereich Application Range	Highlights	Highlights
Positive Wendeschneidplatten / Positive Inserts	ALS2 		Schlichtbearbeitung - Haupteinsatzgebiet ist das Schlichten und Vorschlichten von schwer zerspanbaren Werkstoffen, rostfreien Stählen und Stahl, insbesondere auch bei dünnwandigen und schlanken Bauteilen.	Finishing • Heavy alloys, Alloys, stainless steel and steel • Particularly on thin-walled and slim parts
	ALX 		Aluminiumbearbeitung • sehr großer Spanwinkel, geschliffene Schneidkante • Bearbeitung von Aluminium, Kunststoffen, Feinstbearbeitung von Niro	Aluminium cutting • Exclusive chipbreaker for aluminium and aluminium alloy, finishing of stainless steel • High rake angle, precision - ground cutting edge
	F30 		Schlichtbearbeitung • großer Spanwinkel, scharfe Schneidkante • hohe Oberflächengüten, auch bei der Innenbearbeitung	Finishing • High helix, sharp cutting edge • Very good surface quality, also in case of internal machining
	JTM 		• universelle Geometrie für die mittlere Bearbeitung im P-, M- und S-Anwendungsbereich • exzellente Spankontrolle über einen sehr großen Vorschubbereich	• Universal geometry for the middle machining in P-, M-, and S-application range • Excellent chip control for a wide range of feeds
	M30 		Mittlere Bearbeitung bis Schlichten • optimale Spankontrolle auch bei zähen Zerspanung Materialien • hohe Oberflächengüte durch scharfe Schneidkante und geringe Schnittkräfte	Medium cutting • Optimized chipcontrol at ductile materials • Very good surface due to sharp cutting edge and marginal cutting force
	MD 		Mittlere Bearbeitung • auf antriebsschwachen Maschinen und Bohrungsbearbeitung	Medium cutting • Excellent chip control at wide range of cutting conditions • Suitable for stainless steel cutting

Anwendung / Application

C N M G 120408

M...

A	Aluminium / Aluminium
C	Kopieren / Copying
F	Schlichten / Finishing
H	Schweres Schruppen / Heavy Roughing
M	Mittlere Bearbeitung / Medium Cutting
R	Schruppen / Roughing
S	Mittlere Bearbeitung für Niro / Medium Cutting of Stainless Steel



Schnittdaten-Empfehlungen zum Drehen - allgemein

Cutting Data Recommendations for Turning - in general

Werkstückwerkstoff Material	Legierung Alloy	Brinell-Härte hardness HB	VDI 3323 Gruppe	Schnittgeschwindigkeiten / Cutting speeds v_c [m/min]			
				TK 1210 (K20F) TK 1310 (K10)	TK 5410 (K10C)	TK 5510 (K20C)	TK 5810 (K10C)
A (P)	unlegierter Stahl / mild steel	geglüht / annealed $\leq 0,15\% \text{ C}$	125	1			100 - 150
		geglüht / annealed $0,15\% - 0,45\% \text{ C}$	150-250	2			80 - 140
		vergütet / heat treated $\geq 0,45\% \text{ C}$	300	3			70 - 110
	niedriglegierter Stahl / lower alloyed steel	geglüht / annealed	180	6			80 - 130
		vergütet / heat treated	275	7			70 - 120
		vergütet / heat treated	300	8			60 - 90
		vergütet / heat treated	350	9			
	hochlegierter Stahl / highly alloyed steel	geglüht / annealed	200	10			80 - 110
		vergütet / heat treated	350	11			
	nichtrostender Stahl / corrosion-resistant steel	geglüht / annealed	200	12			130 - 180
		vergütet / heat treated	350	13			
R (M)	rostfreier Stahl / stainless steel	ferritisch, martensitisch, gegläht / ferritic, martensitic, annealed	200	14			
		austenitisch / austenitic	180	14			90 - 130
		Duplex	230-260	14			
		austenitisch, ferritisch / austenitic, ferritic	330	14			
F (K)	Grauguss / grey cast iron	perlitisches, ferritisches / pearlitic, ferritic	180	15	140 - 200		160 - 220
		perlitisches, martensitisches / pearlitic, martensitic	260	16	100 - 160		130 - 180
	Grauguss mit Kugelgraphit / nodular cast iron	ferritisches / ferritic	160	17	160 - 200		150 - 220
		perlitisches / pearlitic	250	18	110 - 150		120 - 170
	Temperguss / malleable cast iron	ferritisches / ferritic	130	19	160 - 220		160 - 220
		perlitisches / pearlitic	230	20	140 - 180		140 - 200
N	Aluminium - Knetlegierungen / forging alloy	nicht aushärtbar / not hardenable	60	21	300 - 3000		250 - 2800
		aushärtbar / hardenable	100	22	200 - 2000		180 - 2500
	Aluminium - Gusslegierungen / casting alloy	nicht aushärtbar / not hardenable $< 12\% \text{ Si}$	80	23	400 - 2000		300 - 1800
		aushärtbar / hardenable $< 12\% \text{ Si}$	90	24	400 - 1100		300 - 1800
		nicht aushärtbar / not hardenable $> 12\% \text{ Si}$	130	25	200 - 1000		170 - 1000
	Kupfer und Kupfer-Legierungen (Bronze, Messing) / copper and copper alloys (bronze, brass)	Automatenlegierungen / free cutting alloys (1% Pb)		26	250 - 800		220 - 900
		Messing, Rotguss / brass, red bronze		27	200 110		190 - 800
		Bronze / bronze	90	28	150 - 600		150 - 650
		bleifreies Kupfer und Elektrolytkupfer / unleaded copper	100	29	150 - 400		130 - 500
	nichtmetallische Werkstoffe / non metallic materials	Duroplaste / thermoset	100	29	100 - 220		70 - 200
		faserverstärkte Kunststoffe / fiber reinforced plastic		29	80 - 200		70 - 220
		Hartgummi / ebonite		30	100 - 300		90 - 280
S	warmfeste Legierungen / heat resistant alloys	Fe-Basis/base, gegläht / annealed	200	31		40 - 80	30 - 60
		Fe-Basis/base(Incoloy), ausgehärtet / hardened	280	32		35 - 55	20 - 55
		Ni-Basis/base (Inconel), gegläht / annealed	250	33		30 - 60	20 - 50
		Ni- oder Co-Basis, ausgehärtet / hardened	30-58 HRC	24		25 - 35	20 - 40
		Ni- oder Co-Basis, gegossen / cast	1500-2200 Nmm ²	35		20 - 40	20 - 30
	Titanlegierungen / titanium alloys	Reintitan / Pure titanium	Rm 400	36		70 - 160	60 - 150
		Alpha- + Beta-Legierungen / alloys	Rm 1050	37		50 - 130	30 - 90

Schnittdaten-Empfehlungen zum Drehen - allgemein

Cutting Data Recommendations for Turning - in general

Schnittgeschwindigkeiten / Cutting speeds v_c [m/min]											
TM 5125+ (M25C)	TM 5130+ (M30C)	TP 2135 TP 2235 (P35C)	TP 3020 (P10/P30C)	TP 3120 (P25C)	TP 4015+ (P15/M20C)	TP 4025+ (P25/M20C)	TP 5025+ (P25C)	TP 5345 (P45C)	TWS 7225 (M25/P30C)	CDX09 (CBN)	TY 1110 (PKD)
120 - 280	80 - 150	170 - 230	180 - 300	180 - 300	120 - 300	120 - 280	120 - 280	180 - 240	190 - 280		
130 - 250	70 - 130	150 - 180	150 - 220	150 - 220	130 - 280	130 - 250	130 - 250	150 - 200	170 - 240		
100 - 180	70 - 120	110 - 150	120 - 200	120 - 200	100 - 200	100 - 180	100 - 180	150 - 200	130 - 200		
80 - 200		160 - 190	160 - 250	160 - 250	100 - 250	100 - 230	100 - 230	170 - 200	170 - 250		
60 - 180		80 - 140	90 - 180	90 - 180	80 - 220	80 - 200	80 - 200	100 - 160	100 - 190		
		70 - 130	80 - 170	80 - 170	60 - 200	60 - 180	60 - 180	90 - 150	90 - 170		
		60 - 120	120 - 190	120 - 190	50 - 140	50 - 130	50 - 130	80 - 140	80 - 160		
		110 - 200	80 - 160	80 - 160	80 - 200	80 - 180	80 - 180	130 - 170	130 - 200		
		40 - 80	120 - 180	120 - 180	50 - 130	50 - 120	50 - 120	80 - 130	80 - 150		
100 - 180	70 - 120	130 - 170	100 - 170	100 - 170	100 - 190	100 - 180	100 - 180	140 - 180	130 - 210		
70 - 150	60 - 100	100 - 160	90 - 180	90 - 180	70 - 170	70 - 150	70 - 150	115 - 170	110 - 190		
120 - 220	70 - 120	130 - 200	140 - 200	140 - 200	120 - 250	120 - 220	100 - 250	140 - 200	140 - 200		
80 - 200	80 - 150	90 - 190	90 - 180	90 - 180	100 - 220	100 - 200	90 - 150	110 - 190	90 - 200		
60 - 140	60 - 120	70 - 150					60 - 90	80 - 150	80 - 130		
50 - 120	50 - 100	40 - 60	60 - 90	60 - 90			50 - 80	55 - 75	80 - 100	80 - 150	
					130 - 310	130 - 280				300 - 1000	
					120 - 300	120 - 270				300 - 800	
					110 - 280	110 - 260				300 - 450	
					100 - 270	100 - 250				250 - 350	
					90 - 260	90 - 250					
					90 - 260	90 - 250					
								100 - 500			250 - 3500
								100 - 400			250 - 1300
								100 - 350			250 - 3500
								100 - 800			250 - 1500
								80 - 250			200 - 500
											100 - 600
											100 - 1300
											250 - 2500
											60 - 320
											80 - 250
											60 - 180
								40 - 70	80 - 110		
								30 - 60	60 - 100		
								30 - 60	35 - 80		
								20 - 30	30 - 40		
									20 - 35		
									60 - 100		
									30 - 60		

Drehen
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