

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

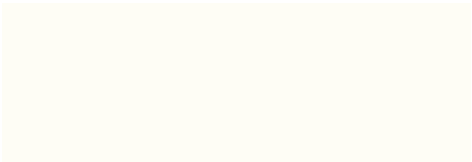
HDS-/VHM- Fräser
HDS-/ Solid Carbide
Endmills

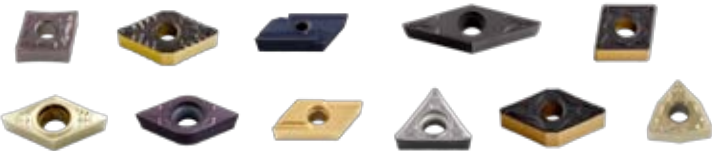
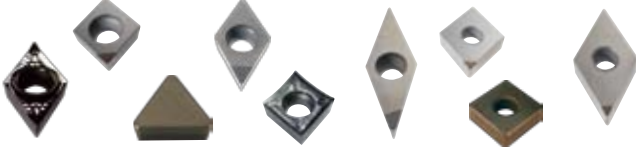
Stech- und
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ISO - Bezeichnungssystem für Klemmhalter / ISO Designation System for Toolholders

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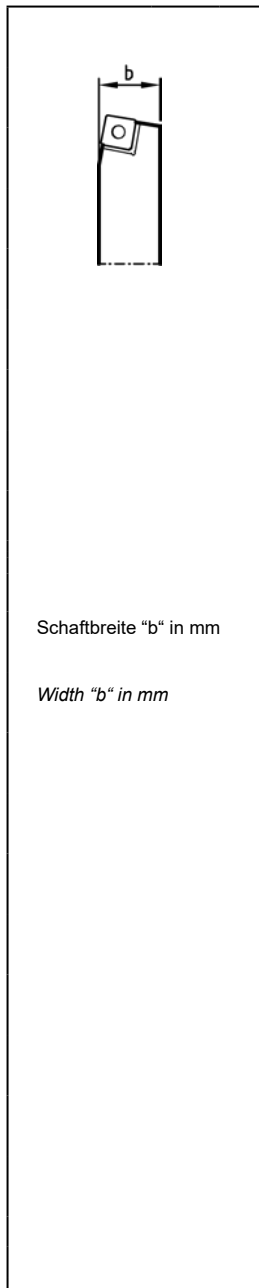
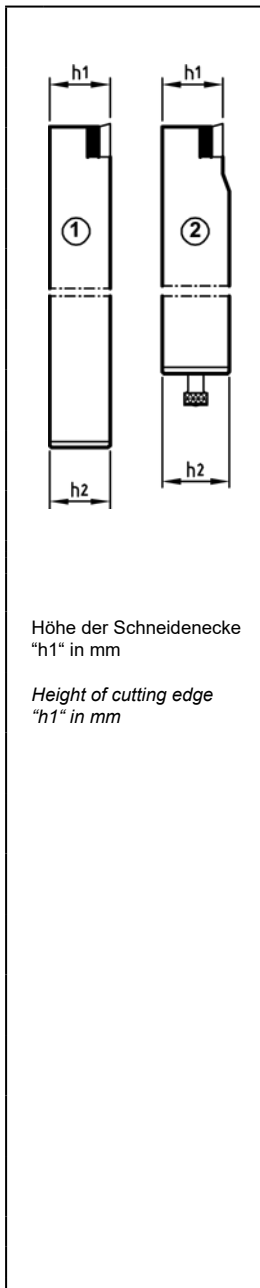
Mini/ Micro
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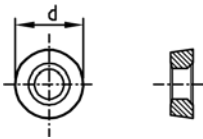
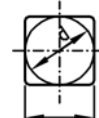
Wendepaltenbohrer
VHM-Bohrer
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Solid Carbide Drills

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 S T W	90° A 75° B 90° C 45° D 60° E 90° F 90° G 107.5° H 93° J 75° K 95° L 50° M 63° N 75° R 45° S 60° T 93° U 72.5° V 60° W 85° 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
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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	

																																					
	<table><tr><th>d (mm)</th></tr><tr><td>06</td></tr><tr><td>08</td></tr><tr><td>10</td></tr><tr><td>12</td></tr><tr><td>16</td></tr><tr><td>20</td></tr><tr><td>25</td></tr><tr><td>32</td></tr></table>	d (mm)	06	08	10	12	16	20	25	32																											
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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

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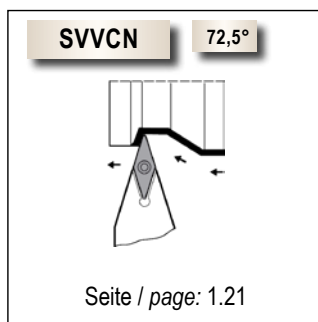
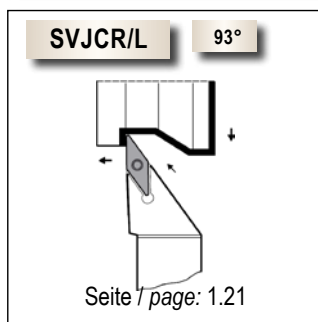
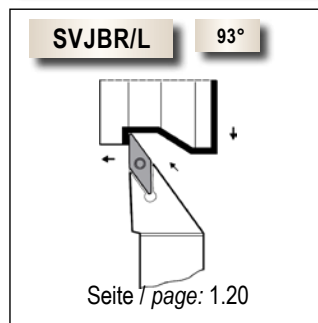
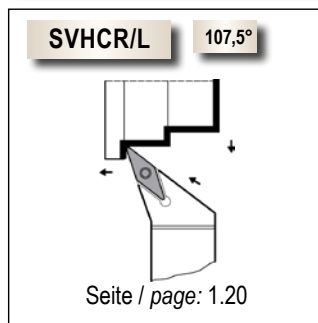
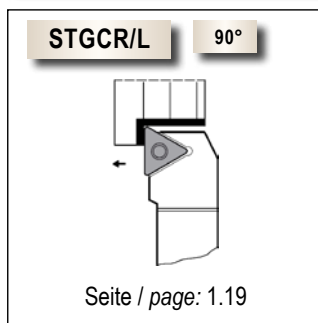
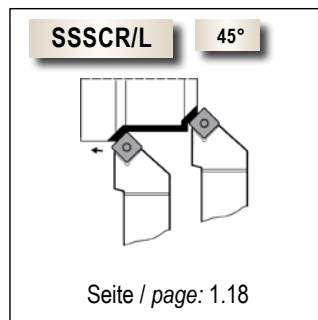
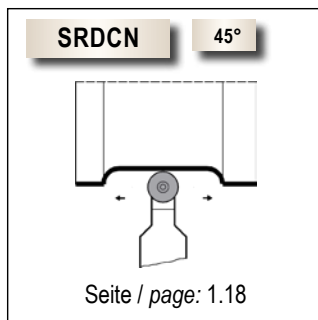
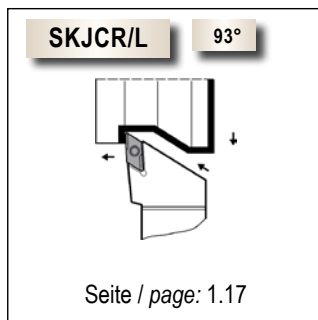
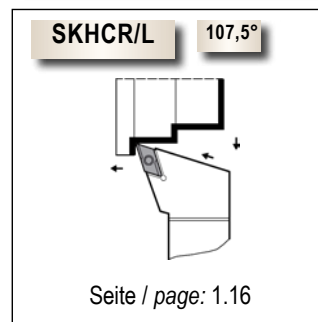
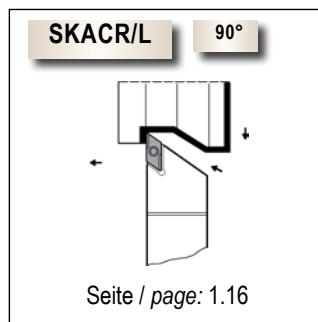
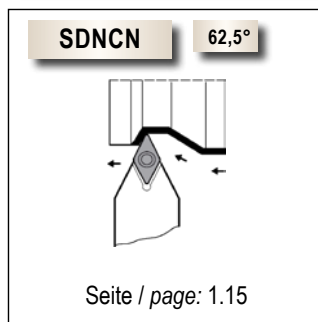
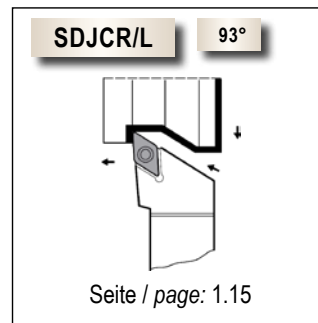
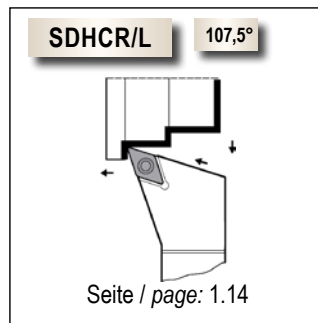
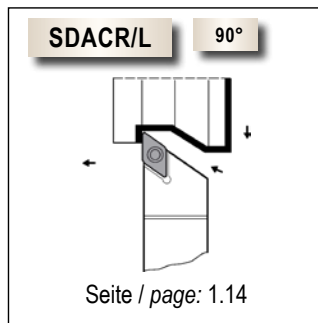
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Übersicht - Außendrehen Overview - External Turning

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Übersicht - Außendrehen Overview - External Turning



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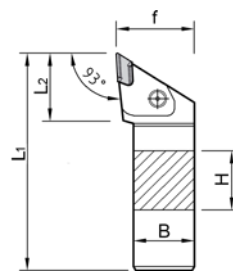
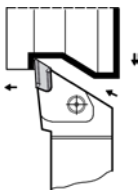
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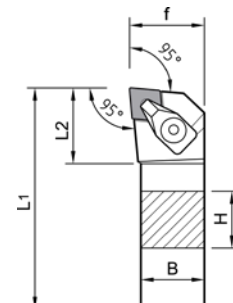
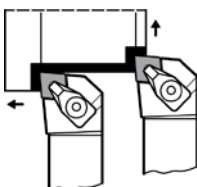
Wendelplattenbohrer
VHM-Bohrer
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Solid Carbide Drills

CKJNR/L 93°



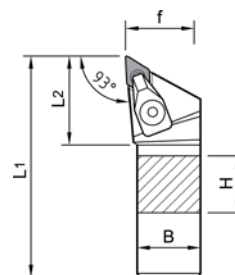
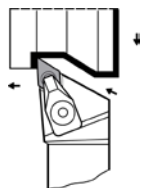
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	R	L	H	B	L ₁	L ₂	f		Seite / Page: 1.49							
CKJNR 2020 K16	○		20	20	125	32	25	KNUX 1604--R	48.11.705	48.11.105	48.12.606 (SW4)	48.11.503	48.11.500 + 48.11.504	48.11.208	48.11.301	48.12.605 (SW2)
2525 M16	○		25	25	150	32	32									
3232 P16	○		32	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°



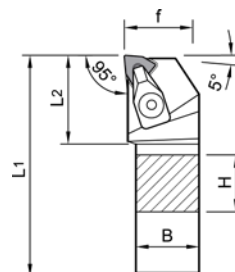
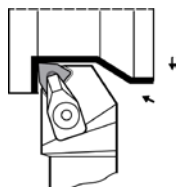
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	R	L	H	B	L ₁	L ₂	f	Seite / Page: 1.44								
DCLNR/L 2020 K12	○	○	20	20	125	30	25	CN -- 1204 --	48.34.701	48.34.101	48.12.606 (SW4)	48.33.501	48.33.502	48.33.201	48.34.102	48.12.604 (SW2,5)
2525 M12	○	○	25	25	150	32	32									
3232 P12	○	○	32	32	170	32	40									

DDJNR/L 93°



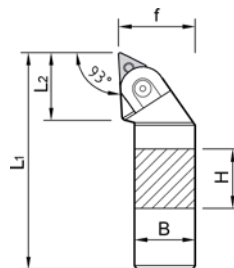
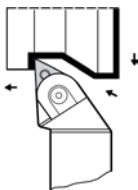
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2525 M15	●	○	25	25	150	38	32									
3232 P15	○	○	32	32	170	38	40									
								DN .. 1506 ..	48.34.701	48.34.101	48.12.606 (SW4)	48.33.501	48.33.502	48.33.202	48.34.102	48.12.604 (SW2,5)

DWLNR/L 95°



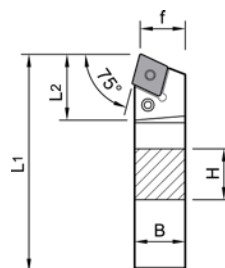
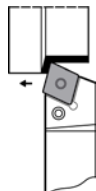
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	R	L	H	B	L ₁	L ₂	f									
DWLNR/L 2020 K08	○	○	20	20	125	35	25	Seite / Page: 1.59								
2525 M08	○	○	25	25	150	35	32									
								WN - 0804 -	48.34.701	48.34.101	48.12.606 (SW4)	48.33.501	48.33.502	48.34.201	56.44.102	56.33.614 (T20)

MTJNR/L 93°



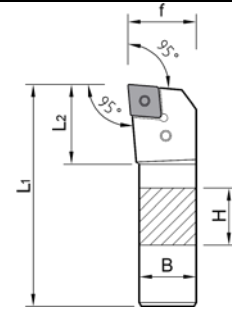
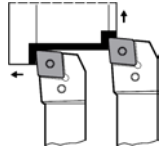
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile <i>Spare Parts</i>						
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MTJNR/L 2020 K16	●	○	20	20	125	35	25	Seite / Page: 1.54 TN -- 1604 --							
2525 M16	●	●	25	25	150	35	32								
3232 P16	○	○	32	32	170	35	40								
2525 M22	●	●	25	25	150	40	32	TN -- 2204 --							
3232 P22	○	○	32	32	170	40	40								

PCBNR/L 75°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.44	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	48.12.606 (SW4)
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°



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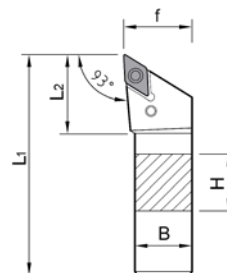
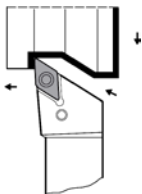
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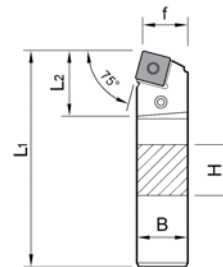
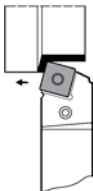
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2020 K12	●	●	20	20	125	28	25						
2525 M12	●	●	25	25	150	28	32						
3232 P12	○	○	32	32	170	28	32	CN .. 1606 ..					
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3232 P16	○	○	32	32	170	33	40						
3232 P19	○	○	32	32	170	38	40	CN .. 1906 ..					
4040 S19	○	○	40	40	250	38	50						

PDJNR/L 93°



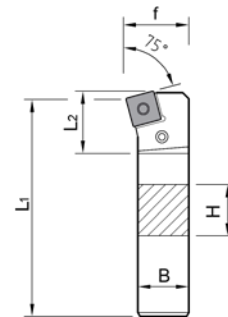
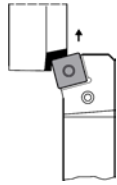
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f						
PDJNR/L 1616 H11	●	○	16	16	100	25	20	Seite / Page: 1.48					
2020 K11	●	●	20	20	125	25	25						
2525 M11	○	○	25	25	150	30	32						
2020 K15	●	●	20	20	125	35	25	Seite / Page: 1.48					
2525 M15	●	●	25	25	150	35	32						
3232 P15	○	○	32	32	170	35	40						

PSBNR/L 75°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts					
	R	L	H	B	L ₁	L ₂	f							
PSBNR/L 2020 K12			20	20	125	28	17	Seite / Page: 1.52						
2525 M12			25	25	150	28	22							
3232 P12			32	32	170	28	27							
2525 M15			25	25	150	35	22	SN -- 1506 --	48.12.415	48.12.114	48.12.206	48.12.902	48.12.603 (SW3)	
3232 P15			32	32	170	37	27							
3232 P19			32	32	170	40	27	SN -- 1906 --	48.12.416	48.12.115	48.12.236	48.12.903		48.12.606 (SW4)
4040 S19			40	40	250	40	35							

PSKNR/L 75°



Drehen
Turning

Fräswerkzeuge
Milling Tools

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

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

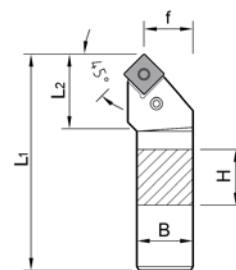
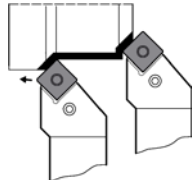
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

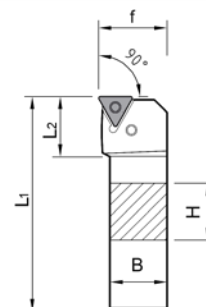
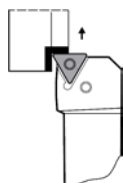
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile <i>Spare Parts</i>				
	R	L	H	B	L ₁	L ₂	f						
PSKNR/L 2020 K12			20	20	125	26	25	Seite / Page: 1.52					
2525 M12			25	25	150	26	32						
2525 M15			25	25	150	32	32	SN .. 1506 ..					
3232 P15			32	32	170	32	40						
3232 P19			32	32	170	40	40	SN .. 1906 ..					
4040 S19			40	40	250	50	50						

PSSNR/L 45°



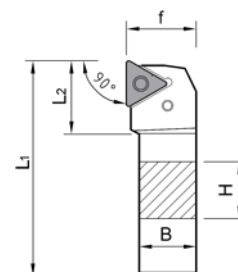
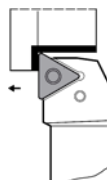
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts					
	R	L	H	B	L ₁	L ₂	f							
PSSNR/L 2020 K12	●	○	20	20	125	30	25	Seite / Page: 1.52	SN .. 1204 ..	48.12.414	48.12.113	48.12.205	48.12.901	48.12.603 (SW3)
2525 M12	●	○	25	25	150	30	32							
2525 M15			25	25	150	30	32	SN .. 1506 ..	48.12.415	48.12.114	48.12.206	48.12.902		
3232 P15			32	32	170	40	40							
3232 P19	○	○	32	32	170	40	40	SN .. 1906 ..	48.12.416	48.12.115	48.12.236	48.12.903	48.12.606 (SW4)	
4040 S19	○	○	40	40	250	40	50							

PTFNR/L 90°



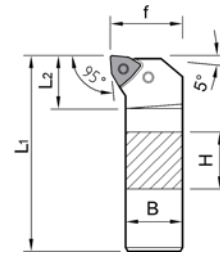
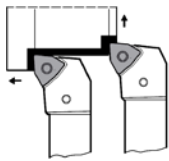
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f						
PTFNR/L 1616 H16	○	○	16	16	100	20	20	Seite / Page: 1.54					
2020 K16	○	○	20	20	125	20	25						
2525 M16	○	○	25	25	150	20	32						
2525 M22	○	○	25	25	150	25	32	TN .. 2204 ..	48.12.414	48.12.113	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 Spare Parts				
	R	L	H	B	L ₁	L ₂	f						
PTGNR/L 1616 H16			16	16	100	20	20	TN .. 1604 ..	48.12.417	48.12.116	48.12.229	48.12.905	48.12.604 (SW2,5)
2020 K16	○	○	20	20	125	20	25						
2525 M16	○	○	25	25	150	20	32						
3232 P16			32	32	170	20	40	TN .. 2204 ..	48.12.414	48.12.113	48.12.230	48.12.901	48.12.603 (SW3)
2525 M22	○	○	25	25	150	28	32						
3232 P22			32	32	170	28	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						

PWLNR/L 95°



Drehen
Turning

Fräswerkzeuge
Milling Tools

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

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

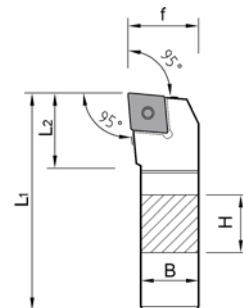
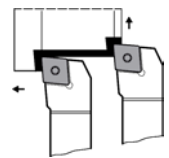
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepaltenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

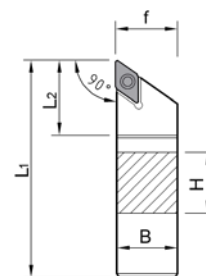
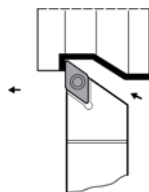
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.59	Ersatzteile Spare Parts				
	R	L	H	B	L ₁	L ₂	f						
PWLNR/L 1616 H06	○	○	16	16	100	20	20	WN -- 0604 --					
2020 K06	○	○	20	20	125	20	25						
2525 M06	○	○	25	25	150	20	32						
2020 K08	●	●	20	20	125	26	25	WN -- 0804 --					
2525 M08	●	●	25	25	150	26	32						
3232 P08	○	○	32	32	170	26	40						

SCLCR/L 95°



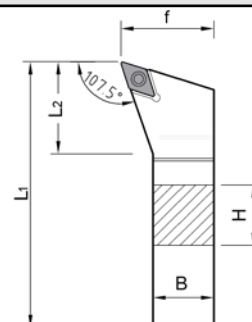
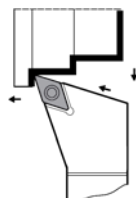
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.42	Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SCLCR/L 0808 D06	●	○	8	8	60	12	10	CC -- 0602 --	48.24.107	-	-	56.33.612 (T08)
1010 F06	●	○	10	10	80	12	12					
1212 F09	●	●	12	12	80	16	16					
1616 H09	●	●	16	16	100	16	20	CC -- 09T3 --	48.13.102	48.13.201	48.13.301	56.33.613 (T15)
2020 K09	●	●	20	20	125	25	25					
1616 H12	○	○	16	16	100	20	20					
2020 K12	●	●	20	20	125	25	25	CC -- 1204 --	48.13.103	48.13.202	48.13.302	56.33.613 (T15)
2525 M12	●	●	25	25	150	25	32					
3232 P12	○	○	32	25	170	25	40					

SDACR/L 90°



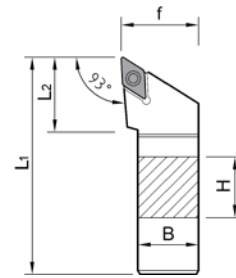
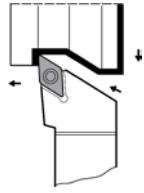
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.46	Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SDACR/L 0808 K07			8	8	125	14	8.5	DC -- 0702 --	48.24.107	-	-	56.33.612 (T08)
1010 M07			10	10	150	14	10.5					
1212 M07			12	12	150	14	12.5					
1212 M11			12	12	150	21	12.5	DC -- 11T3 --	48.24.108	-	-	56.33.613 (T15)
2525 M11			25	25	150	21	25.5		48.13.102	48.13.203	48.13.301	

SDHCR/L 107,5°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					Seite / Page: 1.46	Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SDHCR/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	16	20					
2020 K11	●	●	20	20	125	21	25	DC -- 11T3 --	48.13.102	48.13.203	48.13.301	56.33.613 (T15)
2525 M11	●	●	25	25	150	22	32					

SDJCR/L 93°



Drehen
Turning

Fräswerkzeuge
Milling Tools

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

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

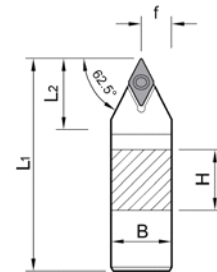
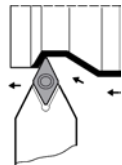
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

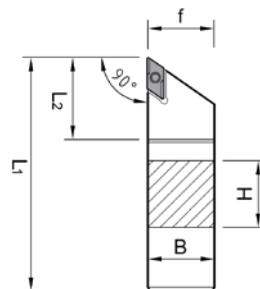
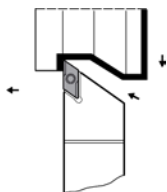
Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions							Seite / Page: 1.46	Ersatzteile Spare Parts			
		R	L	H	B	L ₁	L ₂	f					
SDJCR/L 1010 E07	○			10	10	70	15	12	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)
1212 F07	● ○			12	12	80	15	16					
1616 H11	● ●			16	16	100	26	20	DC .. 11T3 ..	48.13.102	48.13.203	48.13.301	56.33.613 (T15)
2020 K11	● ●			20	20	125	26	25					
2525 M11	● ●			25	25	150	29	32					

SDNCN 62,5°



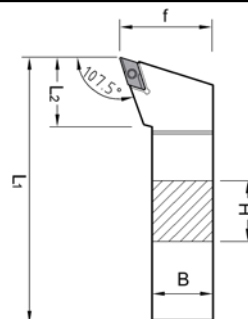
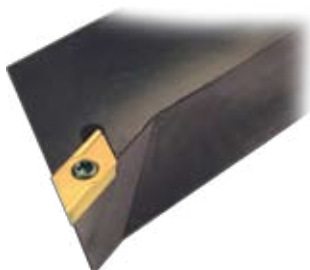
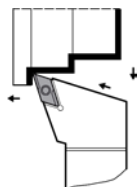
Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions						 Seite / Page: 1.46	Ersatzteile Spare Parts			
		H	B	L ₁	L ₂	f						
SDNCN 1010 E07	○	10	10	70	20	5	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)	
1212 F07	○	12	12	80	20	6						
1212 M07		12	12	150	20	6						
1212 M11		12	12	150	30	6	DC .. 11T3 ..	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°



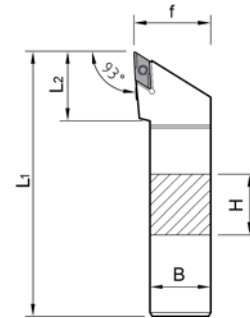
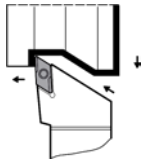
Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f					
SKACR/L 1212 M11	○	●	12	12	150	-	10.5	Seite / Page: 1.49 KC • X 1103 ••				
1616 M11	○	●	16	16	150	-	12.5					
2020 M11	○	●	20	20	150	-	16.5					
									48.13.104	-	-	56.33.612 (T08)

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: 1.49 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°



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

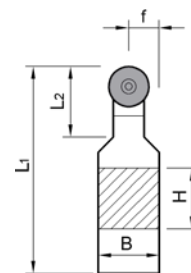
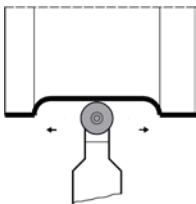
Gewinde-
werkzeuge
Threading Tools

Wendeplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						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

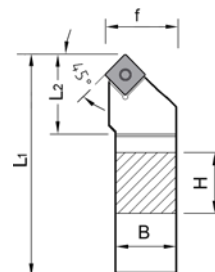
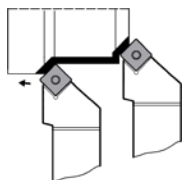
45°



Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions						Seite / Page: 1.50	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		RC-T 0803 ..	48.13.105	-	-	56.33.613 (T15)
1616 H08		16	16	100	16	8						
2020 K08	○	20	20	125	16	10						
2525 M08	○	25	25	150	16	12.5		RC-T 1003 ..	48.13.102	48.13.204	48.13.301	56.33.613 (T15)
1616 H10		16	16	100	20	8						
2020 K10		20	20	125	20	10						
2525 M10	○	25	25	150	20	12.5						

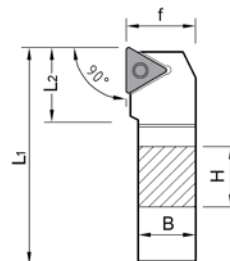
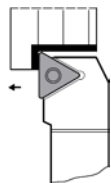
SSSCR/L

45°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions					 Seite / Page: 1.51	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°



Drehen
Turning

Fräswerkzeuge
Milling Tools

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

Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

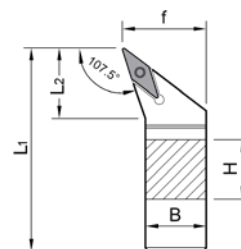
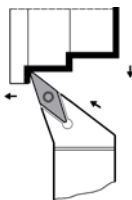
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

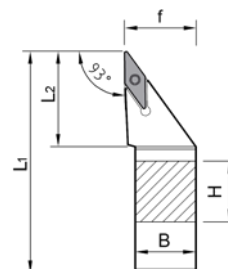
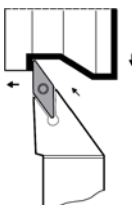
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		R	L	H	B	L ₁	L ₂	f					
STGCR/L 0808 D09	○			8	8	60	8	10	TC .. 0902 ..	L60M2.2x5	-	-	75.20.621 (T06)
1010 E09	○			10	10	70	10	12					
1212 F11				12	12	80	15	16	TC .. 1102 ..	48.24.107	-	-	56.33.612 (T08)
1616 H11	○			16	16	100	15	20					
1616 H16				16	16	100	22	20					
2020 K16	○			20	20	125	22	25	TC .. 16T3 ..	48.13.102	48.13.207	48.13.301	56.33.613 (T15)
2525 M16	○			25	25	150	22	32					

SVHCR/L 107,5°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f	Seite / Page: 1.57					
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						

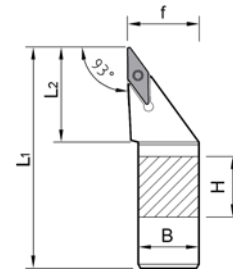
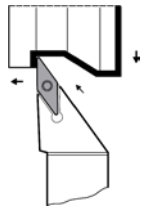
SVJBR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts			
	R	L	H	B	L ₁	L ₂	f	Seite / Page: 1.56					
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						

SVJCR/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

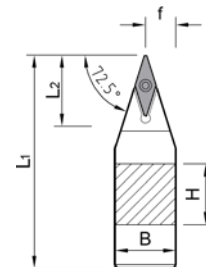
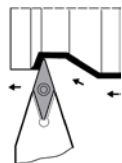
Gewinde-
werkzeuge
Threading Tools

Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions							Seite / Page: 1.57	Ersatzteile Spare Parts			
		R	L	H	B	L ₁	L ₂	f					
SVJCR/L 1010 E11	○			10	10	70	14.5	12	VC .. 1103 ..	48.24.107	-	-	56.33.612 (T08)
1212 F11	● ○			12	12	80	22.0	16					
1616 H11	● ●			16	16	100	25.0	20					
2020 K11	● ○			20	20	125	32.0	25					
2525 M11	● ●			25	25	150	38.0	32	VC .. 1604 ..	48.13.102	48.13.209	48.13.301	56.33.613 (T15)
1616 H16	● ○			16	16	100	29.5	20					
2020 K16	● ●			20	20	125	29.5	25					
2525 M16	● ●			25	25	150	32.5	32					
3225 P16	○ ○			32	25	170	35.0	32					

SVVCN

72,5°



Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions							Seite / Page: 1.57	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

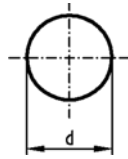
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

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

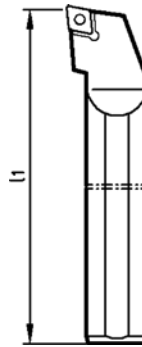
Hartmetallschaft mit
Stahlkopf
Hardmetal shank with
steel head

E

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

S

Stahlschaft
Steel shank



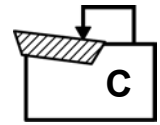
L₁
(mm)

L₁
(mm)

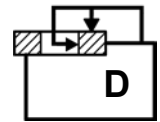
32	A	150	M
40	B	160	N
50	C	170	P
60	D	180	Q
70	E	200	R
80	F	250	S
90	G	300	T
100	H	350	U
110	J	400	V
125	K	450	W
140	L	500	Y

Sonderlänge
Special length

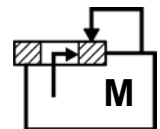
X



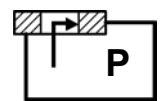
Von oben geklemmt
Top clamping



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	F			
	55° D				
	75° E	K			
	86° M				
	35° V	L			
	85° A	Q			
	82° B				
	55° K	S			
		U			
		W			
		Y			
		Sonderform Special Style			

C	L	N	L	12
Plattenform Shape	Halterform Style	Freiwinkel Clearance Angle	Halterauführung Holder Execution	Schneidenlänge Length of Cutting Edge

Drehen
Turning

Fräswerkzeuge
Milling Tools

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

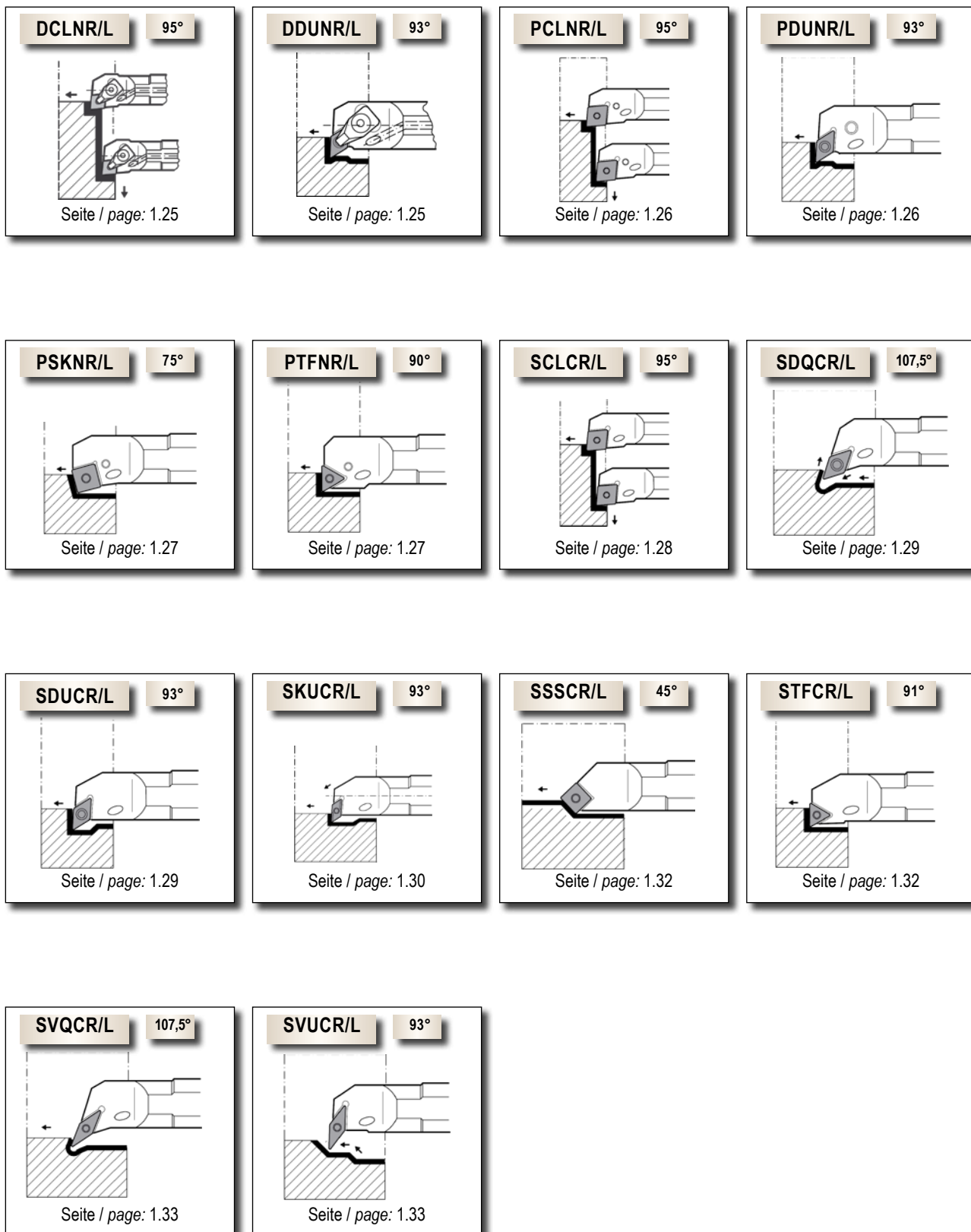
Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

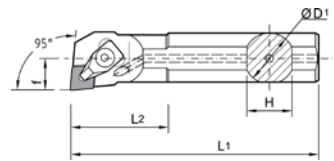
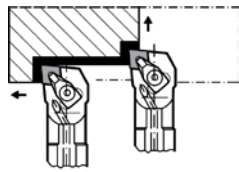
Gewinde-
werkzeuge
Threading Tools

Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Übersicht - Innendrehen Overview - Internal Turning



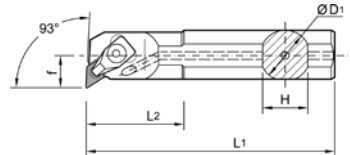
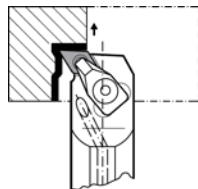
DCLNR/L 95°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.44	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

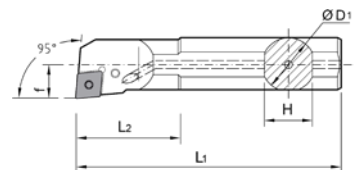
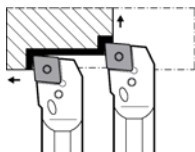
DDUNR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.48	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°

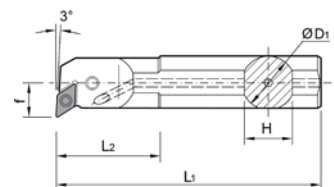
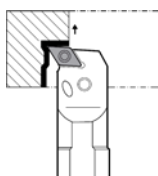


Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile <i>Spare Parts</i>							
	R	L	Dmin	D ₁	H	L ₁	L ₂	f									
A25R PCLNR/L 12	●	●	32	25	24	200	40	17	Seite / Page: 1.44 CN .. 1204 ..		48.23.103	48.23.402	-	-	48.12.604 (SW2,5)		
A32T PCLNR/L 12	●	●	40	32	30	300	50	22			48.12.113	48.12.414	48.33.204	48.12.901	48.12.603 (SW3)		
A40T PCLNR/L 12	●	○	54	40	38.5	300	55	27					48.23.201				
A50U PCLNR/L 12	○	○	63	50	48.5	350	56	35									

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

S : Stahlschaft / Steel Shank

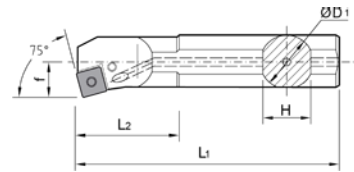
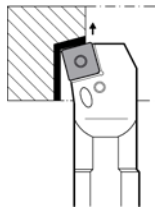
PDUNR/L 93°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Seite / Page: 1.48	Ersatzteile <i>Spare Parts</i>					
	R	L	Dmin	D ₁	H	L ₁	L ₂	f								
A20Q PDUNR/L 11	●	○	25	20	19	180	-	16	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

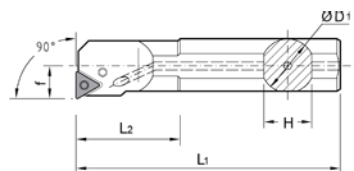
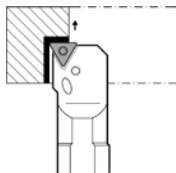
PSKNR/L 75°



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: 1.52 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°

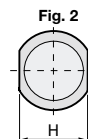
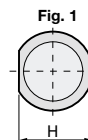
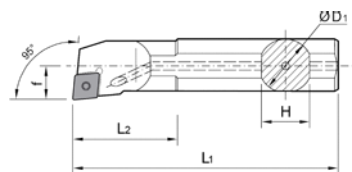
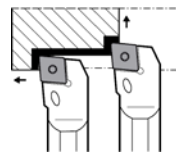


Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts				
	R	L	Dmin	D1	H	L1	L2	f						
S16R PTFNR/L 11	○	○	21	16	15	150	-	11	TN .. 1103 ..	48.23.102	48.23.406	-	-	48.12.605 (SW2)
S20S PTFNR/L 11	○	○	25	20	19	180	-	13						
A25R PTFNR/L 16	○	○	32	25	24	200	40	17	TN .. 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°



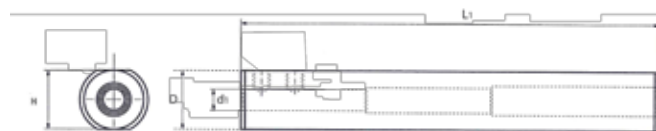
Bezeichnung Part Number		Lager Stock		Maße [mm] Dimensions						Fig.	 Seite / Page: 1.42	Ersatzteile <i>Spare Parts</i>					
		R	L	Dmin	D ₁	H	L ₁	L ₂	f								
E04G	SCLCR/L 0305	●	●	5	4	3.8	90	-	2.5	1		CCET 0301 ..	48.24.142	-	-	75.20.621 (T06)	
E05H	SCLCR/L 0306	●	○	6	5	4.4	100	-	3.0			CCET 0401 ..	48.24.143	-	-		
E06J	SCLCR/L 0307	○	●	7	6	5.7	110	-	3.5								
E06J	SCLCR/L 0407	●	●	7	6	5.7	110	-	3.5								
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								
A0810J	SCLCR/L 06	●	●	11	10	9	110	32	6.0								
A1012K	SCLCR/L 06	●	●	13	12	11	125	38	7.0								
A1216M	SCLCR/L 06	●	●	16	16	15	150	50	9.0								
A08F	SCLCR/L 06	●	●	11	8	7	80	16	5.5	2		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								
A16M	SCLCR/L 09	●	●	21	16	15	150	30	11.0								
A20Q	SCLCR/L 09	●	●	25	20	18	180	38	13.0								
A25R	SCLCR/L 09	●	●	32	25	23	200	39	17.0								
A32S	SCLCR/L 12	○	○	40	32	31	250	50	22.0	2		CC .. 09T3 ..	48.24.108	-	-	56.33.613 (T15)	
A40T	SCLCR/L 12	○	○	50	40	38.5	300	60	27.0			CC .. 1204 ..	48.13.103	48.13.202	48.13.302		
E08K	SCLCR/L 06	●	●	11	8	7.5	125	-	5.0								
E10M	SCLCR/L 06	●	●	14	10	9.5	150	-	6.0								
E12Q	SCLCR/L 06	●	●	17	12	11.5	180	-	9.0	1		CC .. 0602 ..	48.24.107	-	-	56.33.612 (T08)	
E16R	SCLCR/L 09	●	●	21	16	15.5	200	32	11.0								
E20S	SCLCR/L 09	●	●	25	20	19	250	38	13.0								
E25T	SCLCR/L 09	●	●	32	25	24	300	45	17.0								
E32T	SCLCR/L 12	○	○	40	32	30	300	50	22.0								
E40T	SCLCR/L 12	○	○	50	40	38	300	60	27.0			CC .. 09T3 ..	48.24.108	-	-		56.33.613 (T15)
												CC .. 1204 ..	48.13.103	48.13.202	48.13.302		56.33.613 (T15)

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

E : Hartmetallschaft mit Innenkühlung / Carbide Shank with inner coolant

S : Stahlschaft / Steel Shank

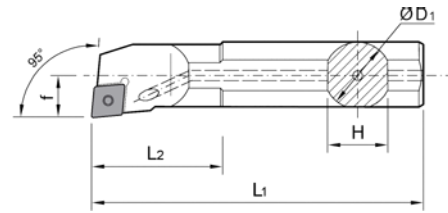
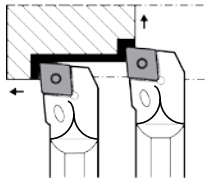
Schafthülsen Sleeves for Shanks



Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions				Ersatzteile Spare Parts		Passende Bohrstangen Suitable Boring bars
		D	d ₁	H	L ₁			
SH 0416	●	16	4	14	100	32.35.101	48.12.605	E04G SCLCR/L 0305 E05H SCLCR/L 0306
SH 0516	●		5					

SCLCR/L 95°

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

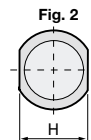
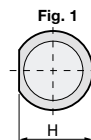
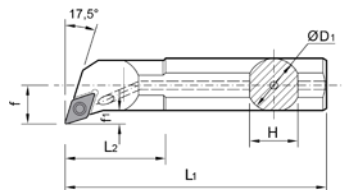
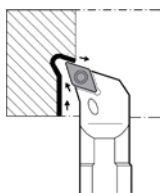
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendepplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

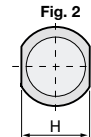
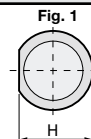
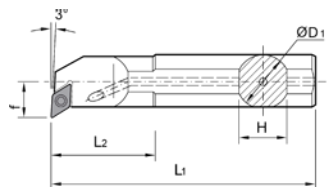
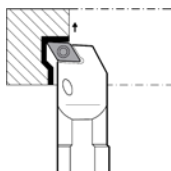
Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions							 Seite / Page: 1.42	Ersatzteile <i>Spare Parts</i>	
		D _{min}	D ₁	H	L ₁	L ₂	f				
E04G SCLCR 03-CB	●	4.8	4	3.8	90	-	2.8	CCET 03 01	48.24.142	75.20.621 (T06)	
E04G SCLCL 03-CB	●	4.8	4	3.8	90	-	2.8				
E05H SCLCR 03-CB	●	5.8	5	4.4	100	-	3.3				
E05H SCLCL 03-CB	●	5.8	5	4.4	100	-	3.3				
E06J SCLCR 0407-CB	●	7	6	5.7	110	-	3.5	CC .. 04 01	48.24.144	75.20.621 (T06)	
E06J SCLCL 0407-CB	●	7	6	5.7	110	-	3.5				
E08K SCLCR 06-CB	●	10	8	7	125	13	5.0	CC .. 06 02	48.24.107	56.33.612 (T08)	
E08K SCLCL 06-CB	●	10	8	7	125	13	5.0				
E10M SCLCR 06-CB	●	12	10	9	150	17	7.0				
E10M SCLCL 06-CB	●	12	10	9	150	17	7.0				
E12Q SCLCR 06-CB	●	14	12	11	180	23	8.0				
E12Q SCLCL 06-CB	●	14	12	11	180	23	8.0				
E16R SCLCR 09-CB	●	18	16	15	200	25	10	CC .. 09 T3	48.24.108	56.33.613 (T15)	
E16R SCLCL 09-CB	●	18	16	15	200	25	10				
E20R SCLCR 09-CB	●	22	20	18	200	28	12				
E20R SCLCL 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: 1.46	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)
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: 1.46	DC .. 11T3 ..	48.24.108	-	-	56.33.613 (T15)
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: 1.46	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)
E25T SDQCR/L 11	●	●	32	25	24	300	-	17							
E32T SDQCR/L 11	○	○	40	32	30	300	50	22							
E40T SDQCR/L 11	○	○	50	40	38	300	60	27							
E40T SDQCR/L 11	○	○	50	40	38	300	60	27							

SDUCR/L 93°



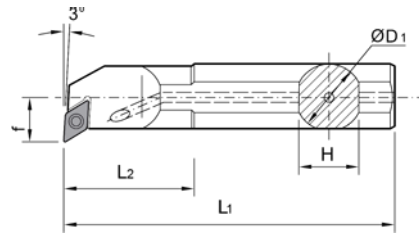
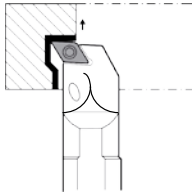
Bezeichnung Part Number		Lager Stock		Maße [mm] Dimensions					Fig.	 Seite / Page: 1.46	Ersatzteile Spare Parts				
		R	L	Dmin	D ₁	H	L ₁	L ₂			f				
A0810H	SDUCR/L 07	●	●	12.5	10	9	100	22	7	2	DC .. 0702 ..	48.24.107	-	-	56.33.612 (T08)
A1012K	SDUCR/L 07	●	●	15.5	12	11	125	28	9						
A1216M	SDUCR/L 07	●	●	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	2	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			48.13.102	48.13.203	48.13.301	
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						
E16R	SDUCR/L 07	●	●	21	16	15.5	200	-	11						
E20S	SDUCR/L 11	●	●	25	20	19	250	-	13	48.13.102	48.13.203	48.13.301			
E25T	SDUCR/L 11	●	●	32	25	24	300	-	17						
E32T	SDUCR/L 11	○	○	40	32	31	300	50	22						
E40T	SDUCR/L 11	○	○	50	40	38	300	60	27						

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

E : Hartmetallschaft mit Innenkühlung / Carbide Shank with inner coolant

SDUCR/L 93°

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

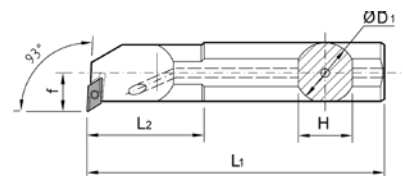
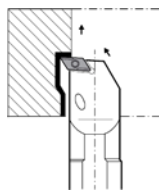
Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendeplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

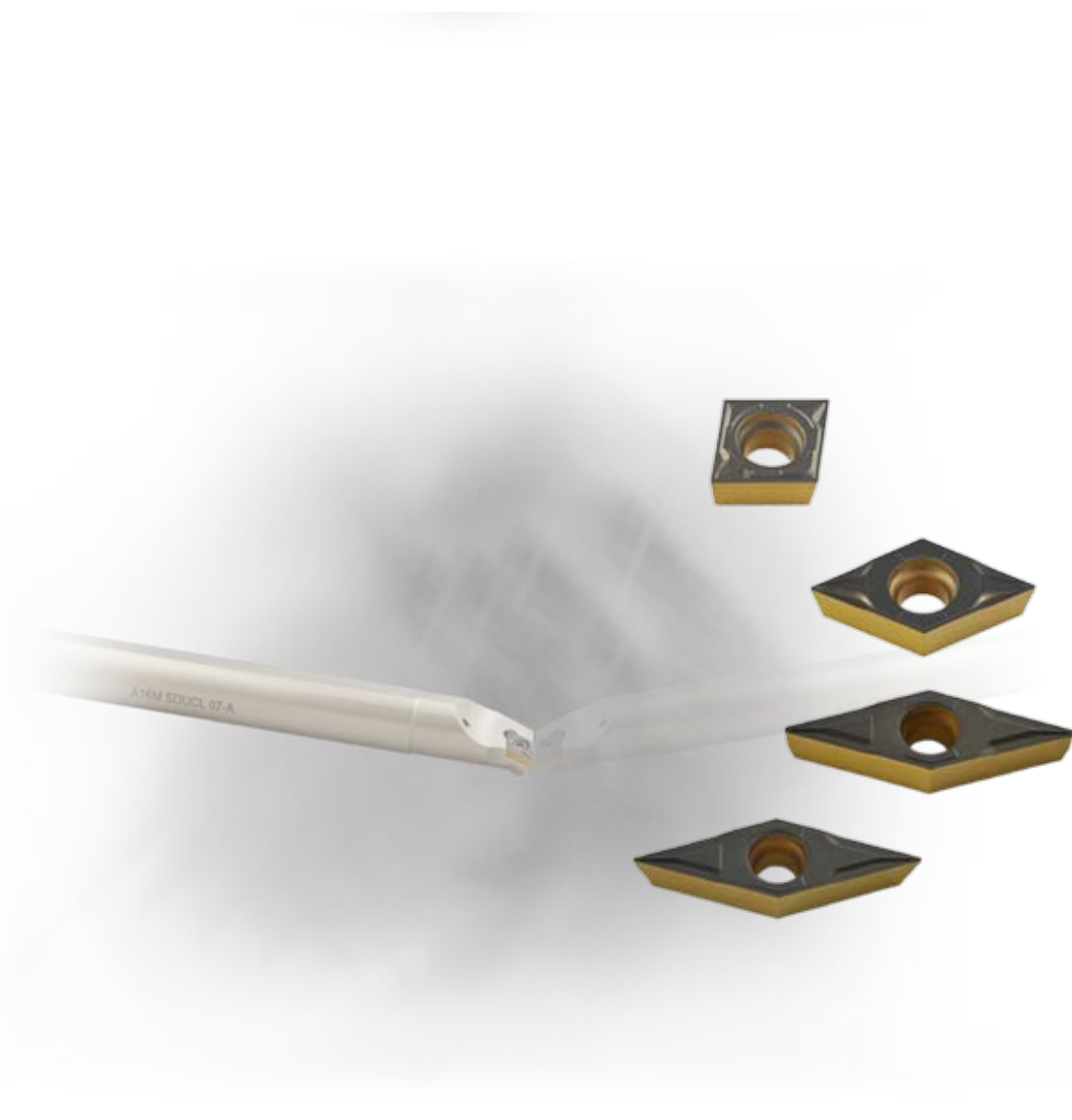
Bezeichnung Part Number	Lager Stock	Maße [mm] Dimensions							Seite / Page: 1.46	Ersatzteile Spare Parts	
		D _{min}	D ₁	H	L ₁	L ₂	f				
E08K SDUCR 07-CB	●	11	8	7	125	13	7	DC..07 02	48.24.107	56.33.612 (T08)	
E08K SDUCL 07-CB	●	11	8	7	125	13	7				
E10M SDUCR 07-CB	●	13	10	9	150	17	8				
E10M SDUCL 07-CB	●	13	10	9	150	17	8				
E12Q SDUCR 07-CB	●	15	12	11	180	23	9				
E12Q SDUCL 07-CB	●	15	12	11	180	23	9				
E16R SDUCR 07-CB	●	19	16	15	200	25	11				
E16R SDUCL 07-CB	●	19	16	15	200	25	11				
E20S SDUCR 07-CB	●	24	20	18	250	28	14				
E20S SDUCL 07-CB	●	24	20	18	250	28	14				

SKUCR/L 93°

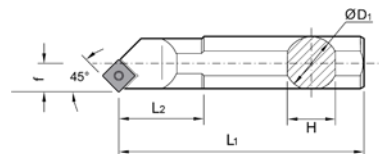
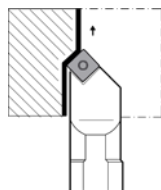


Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions							Ersatzteile Spare Parts			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f					
A12K SKUCR/L 11	●	●	17	12	11.5	125	-	9.3	KC • X 1103 ..	48.13.104	-	-	56.33.612 (T08)
A16M SKUCR/L 11	●	●	21	16	15	150	-	11.3					
A20Q SKUCR/L 11	●	●	25	20	19	180	-	13.5					
A25R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

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant



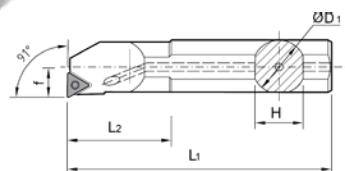
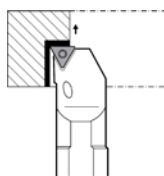
SSSCR/L 45°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.51	Ersatzteile Spare Parts			
	R	L	Dmin	D1	H	L1	L2	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	56.33.613 (T15)
A40T SSSCR/L 12			49	40	39	300	60	27					

A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

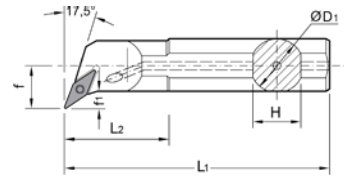
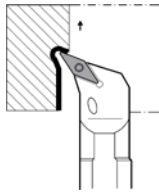
STFCR/L 90°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.53	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

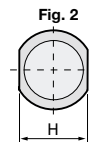
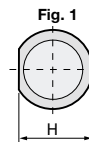
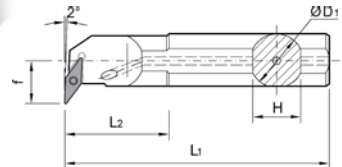
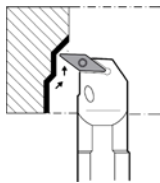
SVQCR/L 107,5°



Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.57	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°

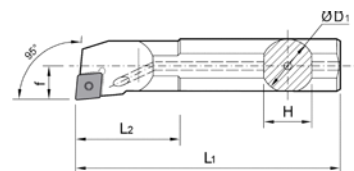
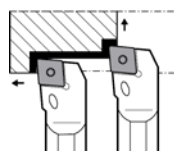


Bezeichnung Part Number	Lager Stock		Maße [mm] Dimensions						Fig.	Seite / Page: 1.57	Ersatzteile Spare Parts			
	R	L	Dmin	D1	H	L1	L2	f						
A16Q SVUCR/L 11	●	○	21	16	15	180	30	11	2	VC .. 1103 ..	48.24.107	-	-	56.33.612 (T08)
A20Q SVUCR/L 11	●	○	25	20	18	180	32	13						
A25R SVUCR/L 11	○	○	32	25	23	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

SET A08H-A16M SCLCR/L 95°

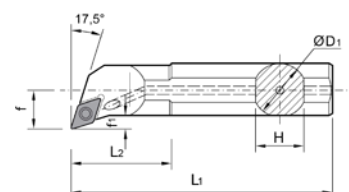
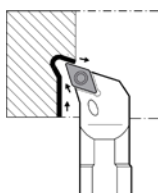
Bohrstangen mit IK
Boring Bars with IC


Bestehend aus: Consisting of:	Lager Stock		Maße [mm] Dimensions								Ersatzteile Spare Parts			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f						
A08H SCLCR/L 06			10	8	7	100	16	5	Seite / Page: 1.42					
A10J SCLCR/L 06	•	•	12	10	9	110	20	7						
A12K SCLCR/L 06			16	12	11	125	22	9						
A16M SCLCR/L 09			20	16	15	150	30	11	CC .. 09T3 ..	48.24.108			56.33.613 (T15)	

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


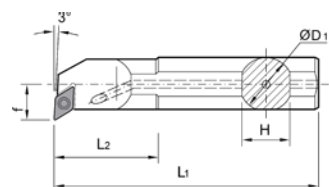
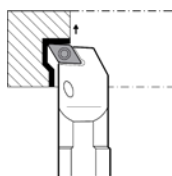
Bestehend aus: Consisting of:	Lager Stock		Maße [mm] Dimensions								Ersatzteile Spare Parts				
	R	L	Dmin	D ₁	H	L ₁	L ₂	f							
A10J SDQCR/L 07			12	10	9	110	20	7	Seite / Page: 1.46 DC .. 0702 ..	 48.24.107	 -	 -	 56.33.612 (T08)		
A12K SDQCR/L 07	●	●	16	12	11	125	22	9							
A16M SDQCR/L 07			20	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.

SET A10J-A16M SDUCR/L 93°

Bohrstangen mit IK
Boring Bars with IC



Bestehend aus: Consisting of:	Lager Stock		Maße [mm] Dimensions							 Seite / Page: 1.46	Ersatzteile Spare Parts			
	R	L	Dmin	D ₁	H	L ₁	L ₂	f						
A10J SDUCR/L 07			12	10	9	110	20	7	DC -- 0702 --	48.24.107	-	-	56.33.612 (T08)	
A12K SDUCR/L 07	●	●	16	12	11	125	24	9						
A16M SDUCR/L 07			20	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: 1.42	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.

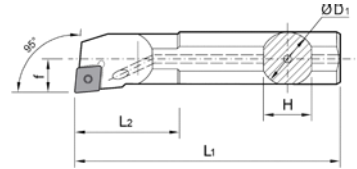
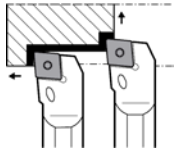
SET E-SDUCR/L 93°

Hartmetall Bohrstangen mit IK
Carbide Boring Bars with IC


Bezeichnung Part Number	Lager Stock		Bestehend aus: Consisting of:						Seite / Page: 1.46	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

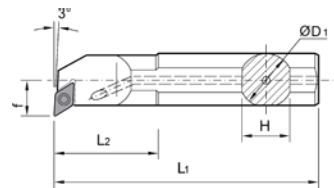
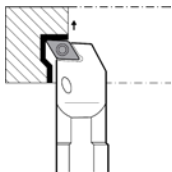
Wendelplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Bestehend aus: Consisting of:	Lager Stock		Maße [mm] Dimensions						Seite / Page: 1.42	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: 1.46	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					

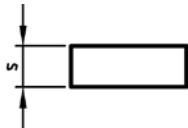
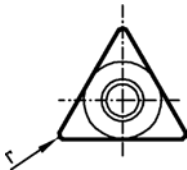
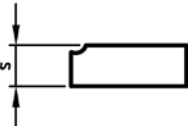
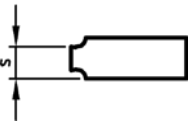
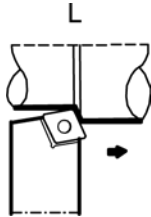
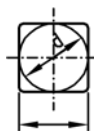
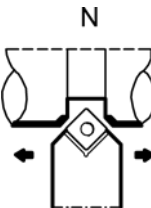
A : Stahlschaft mit Innenkühlung / Steel Shank with inner coolant

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	E M S d +/- m +/- s +/- Klasse Class 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	A C F G H J M N Q R T U W Sonderausführung Special Shape X
T	N	M	G
Plattenform Shape	Freiwinkel Clearance Angle	Toleranzen Tolerances	Plattentyp Type of Inserts

ISO - Bezeichnungssystem für Wendschneidplatten ISO Designation System for Indexable Inserts

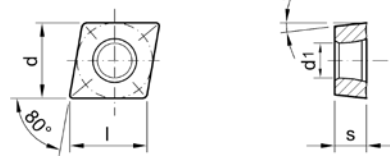
												F Scharf Sharp							
												E Gerundet Rounded							
												T Gefast Chamfered							
												S Gefast und gerundet Chamfered and rounded							

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
--	-------------------------------------	------------------------------	------------------------------	--------------------------------------

- 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

CC □ □



Drehen
Turning

Fräswerkzeuge
Milling Tools

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

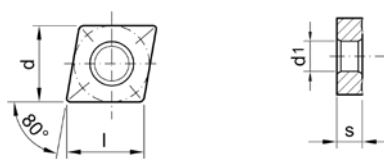
Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

Gewinde-
werkzeuge
Threading Tools

Wendeplattenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

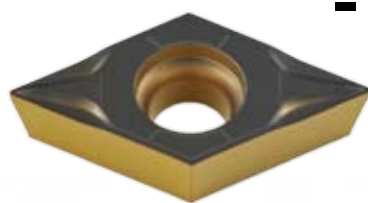
Werkstück / Workpiece		Beschichtet / Coated													Unbeschichtet / Uncoated	Maße / Dimensions [mm]				Schnittdaten / Cutting Data [mm]	
		TK 5410	TK 5810	TM 5125	TM 5130	TP 2135	TP 2235	TP 3020	TP 3120	TP4015+	TP4025+	TP 5025	TP 5345	TW5725	TK 1310	l	Ø d	s	Ø d ₁	f _m (mm/rev)	a _p (mm)
	Stahl / Steel	A (P)	○	○	○	○	○	○	○	○	○	○	○	○	○	06	6.35	2.38	2.80	0,03~0,11	0,06~1,70
	Rostfreier Stahl / Stainless steel	R (M)	○	○	○	○	○	○	○	○	○	○	○	○	○	06	6.35	2.38	2.80	0,05~0,17	0,10~1,70
	Guss / Cast iron	F (K)	○	○	○	○	○	○	○	○	○	○	○	○	○	09	9.52	3.97	4.40	0,04~0,15	0,08~2,00
	Nichtmet. Werkstoffe / Non-fer. metall.	N	○	○	○	○	○	○	○	○	○	○	○	○	○	09	9.52	3.97	4.40	0,06~0,23	0,11~2,00
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S	○	○	○	○	○	○	○	○	○	○	○	○	○	12	12.70	4.76	5.50	0,05~0,15	0,10~2,00
	Gehärteter Stahl / Hardened steel	H	○	○	○	○	○	○	○	○	○	○	○	○	○	12	12.70	4.76	5.50	0,07~0,27	0,14~2,00
	Stahl / Steel	A (P)	○	○	○	○	○	○	○	○	○	○	○	○	●	06	6.35	2.38	2.80	0,06~0,20	0,20~2,00
	Rostfreier Stahl / Stainless steel	R (M)	○	○	○	○	○	○	○	○	○	○	○	○	●	06	6.35	2.38	2.80	0,08~0,30	0,20~2,00
	Guss / Cast iron	F (K)	○	○	○	○	○	○	○	○	○	○	○	○	●	09	9.52	3.97	4.40	0,06~0,20	0,20~2,50
	Nichtmet. Werkstoffe / Non-fer. metall.	N	○	○	○	○	○	○	○	○	○	○	○	○	●	09	9.52	3.97	4.40	0,10~0,30	0,30~3,00
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S	○	○	○	○	○	○	○	○	○	○	○	○	●	12	12.70	4.76	5.50	0,05~0,25	0,20~1,50
	Gehärteter Stahl / Hardened steel	H	○	○	○	○	○	○	○	○	○	○	○	○	○	12	12.70	4.76	5.50	0,20~0,40	0,80~3,50
	Stahl / Steel	A (P)	○	○	○	○	○	○	○	○	○	○	○	○	○	06	6.35	2.38	2.80	0,05~0,20	0,40~1,00
	Rostfreier Stahl / Stainless steel	R (M)	○	○	○	○	○	○	○	○	○	○	○	○	○	06	6.35	2.38	2.80	0,05~0,25	0,40~1,00
	Guss / Cast iron	F (K)	○	○	○	○	○	○	○	○	○	○	○	○	○	09	9.52	3.97	4.40	0,05~0,20	0,40~1,50
	Nichtmet. Werkstoffe / Non-fer. metall.	N	○	○	○	○	○	○	○	○	○	○	○	○	○	09	9.52	3.97	4.40	0,05~0,25	0,40~1,50
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S	○	○	○	○	○	○	○	○	○	○	○	○	○	12	12.70	4.76	5.56	0,05~0,20	0,50~2,00
	Gehärteter Stahl / Hardened steel	H	○	○	○	○	○	○	○	○	○	○	○	○	○	12	12.70	4.76	5.56	0,05~0,25	0,50~2,00
	Stahl / Steel	A (P)	○	○	○	○	○	○	○	○	○	○	○	○	○	06	6.35	2.38	2.80	0,06~0,17	0,20~2,30
	Rostfreier Stahl / Stainless steel	R (M)	○	○	○	○	○	○	○	○	○	○	○	○	○	06	6.35	2.38	2.80	0,08~0,23	0,40~2,30
	Guss / Cast iron	F (K)	○	○	○	○	○	○	○	○	○	○	○	○	○	09	9.52	3.97	4.40	0,06~0,17	0,20~2,50
	Nichtmet. Werkstoffe / Non-fer. metall.	N	○	○	○	○	○	○	○	○	○	○	○	○	○	09	9.52	3.97	4.40	0,08~0,23	0,30~2,50
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S	○	○	○	○	○	○	○	○	○	○	○	○	○	12	12.70	4.76	5.50	0,06~0,17	0,30~3,50
	Gehärteter Stahl / Hardened steel	H	○	○	○	○	○	○	○	○	○	○	○	○	○	12	12.70	4.76	5.50	0,08~0,23	0,50~3,50
	Stahl / Steel	A (P)	○	○	○	○	○	○	○	○	○	○	○	○	○	12	12.70	4.76	5.50	0,14~0,40	0,70~3,50
	Rostfreier Stahl / Stainless steel	R (M)	○	○	○	○	○	○	○	○	○	○	○	○	○	12	12.70	4.76	5.50	0,14~0,40	0,70~3,50



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	TM5130+	TP 2135	TP 2235	TP 3020	TP 3120	TP4015+	TP4025+		TP 5025	TP 5345	TWS7225	TK 1310	l	Ø d	s	Ø d ₁	f _n (mm/rev)
 CNMG-S33	12 04 04 - S33				●										12	12.70	4.76	5.16	0,05~0,25	0,50~4,50	
	12 04 08 - S33				●										12	12.70	4.76	5.16	0,10~0,40	0,50~4,50	

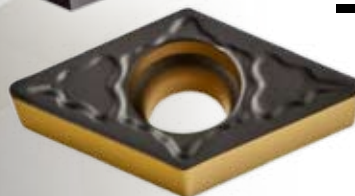
- F30



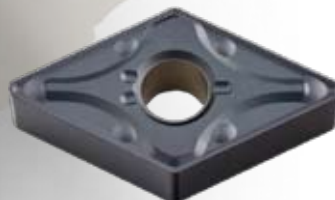
- M30



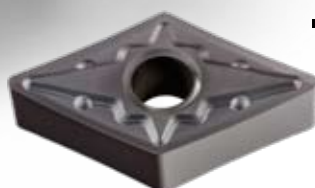
- MD



- S33



- S30

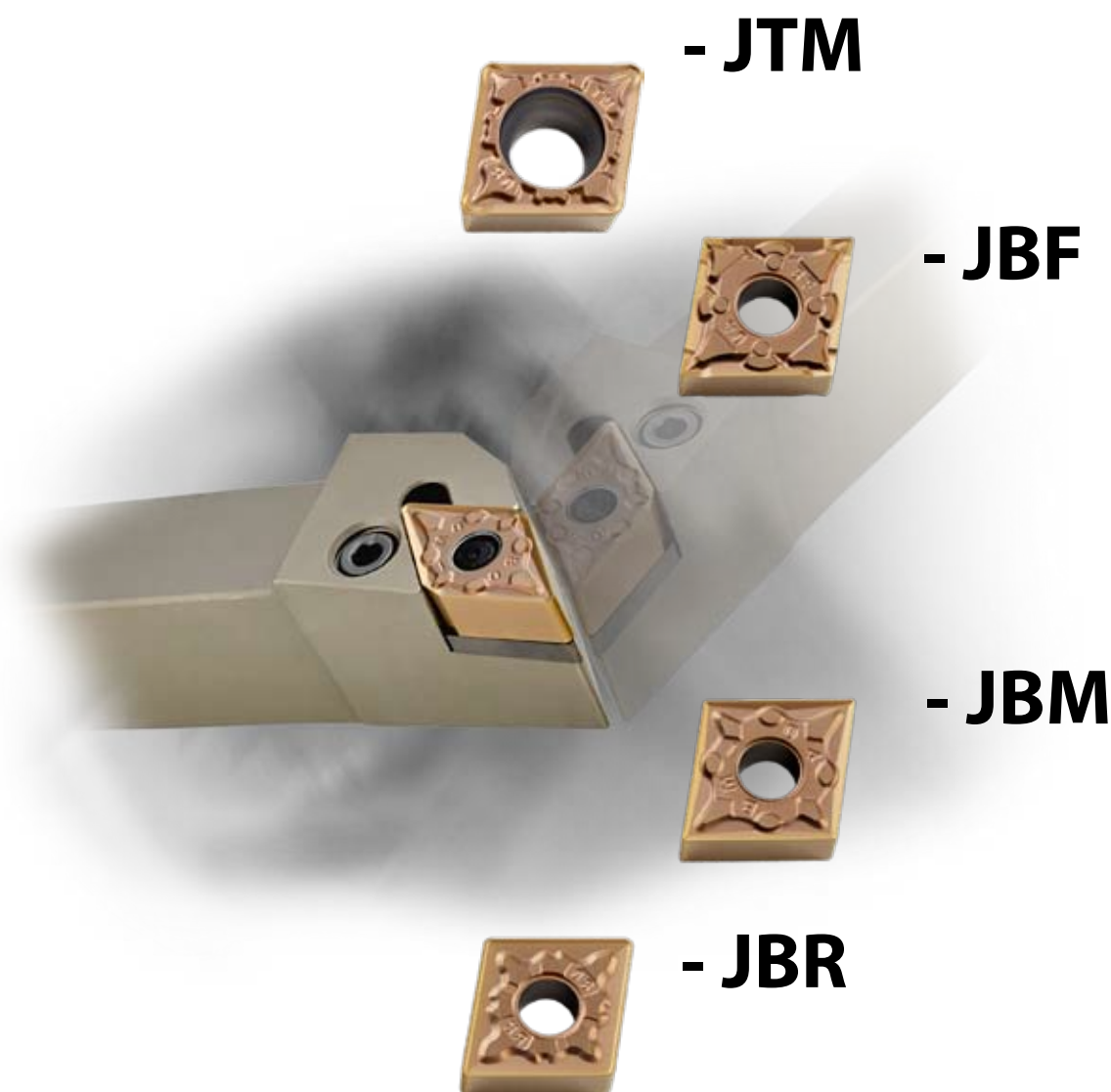


- C22



Unsere neuen Geometrien

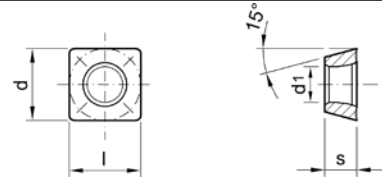
Our new geometries



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

○

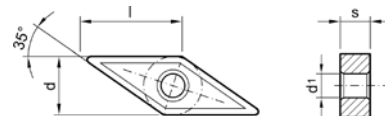
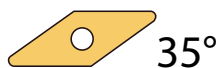
Nebenanwendung / Additional application

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)	●	○	●	○	●	○	●	○	●	○	●	○	●	○	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 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
	12 04 04 - F30															12	12.70	4.76	5.50	0,07~0,27	0,14~2,00
	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
	12 04 04 - JTM														●	12	12.70	4.76	5.56	0,10~0,25	0,30~3,50
	12 04 08 - JTM														●	12	12.70	4.76	5.56	0,15~0,35	0,30~4,00
	12 04 12 - JTM														○	12	12.70	4.76	5.56	0,20~0,50	0,80~3,00
	SCMT-M30	12 04 08 - M30			●					●						12	12.70	4.76	5.56	0,08~0,25	0,25~2,00
	SCMT-MD	09 T3 04 - MD									○	●				09	9.52	3.97	4.40	0,06~0,17	0,20~2,50
	09 T3 08 - MD										○	●				09	9.52	3.97	4.40	0,08~0,23	0,30~2,50
	12 04 04 - MD											●	●			12	12.70	4.76	5.50	0,06~0,17	0,80~3,00
	12 04 08 - MD											○	●			12	12.70	4.76	5.50	0,08~0,23	0,50~3,50

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																					
		Beschichtet Coated														Unbeschichtet Uncoated	Maße Dimensions [mm]				Schnittdaten Cutting Data [mm]		
Wendeplatten Inserts		TK 5410	TK 5810	TM 5125	TM 5130	TP 2135	TP 2235	TP 3020	TP 3120	TP 4015+	TP 4025+	TP 5025	TP 5345	TP 57225	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	TP 4015+	TP 4025+	TP 5025	TP 5345		TWS7225	TK 1310	l	Ø d	s	Ø d ₁	f _n (mm/rev)
	VNMG-JBF													○		16	9.52	4.76	3.80	0,08~0,18	0,10~2,00
	16 04 04 - JBF													●		16	9.52	4.76	3.80	0,10~0,35	0,10~2,50
	VNMG-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	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	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

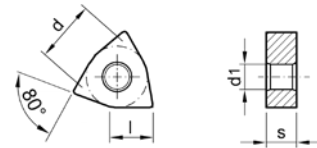
Machinentyp
Machining types

- Hauptanwendung / Main application
- Nebenanwendung / Additional application

WN ☐ ☐



80°



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	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
	06 04 04 - A20	○	○											●	06	9.52	4.76	3.80	0,10~0,30	0,50~3,00
	06 04 08 - A20	○	○											●	06	9.52	4.76	3.80	0,10~0,40	0,80~3,50
	08 04 04 - A20	○	●		●									●	08	12.70	4.76	5.20	0,10~0,45	0,50~4,50
	08 04 08 - A20	○	●		●									●	08	12.70	4.76	5.20	0,10~0,45	0,50~4,50
	08 04 12 - A20	○	○		●									●	08	12.70	4.76	5.20	0,10~0,50	0,50~4,50

Werkstück / Workpiece	Stahl / Steel	A (P)	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○	○
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● JD-Lager / JD-Stock
○ begrenzte Lagerhaltung - auf Anfrage / limited stock - upon request

Trägerwerkzeuge
Toolholders : 1.07, 1.13

Spanbrecher
Chipbreaker : 1.72, 1.73

ALUMINIUM

**Für jede Anwendung
die richtige Sorte.**

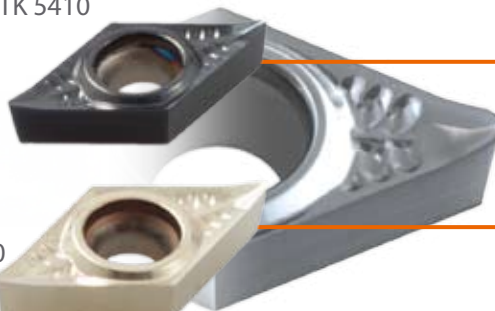
***For each application
the best grade.***

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



80°

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

Wendelplattenbohrer
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

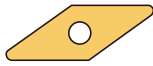
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	Rostfreier Stahl / Stainless steel	R (M)			
	Guss / Cast iron	F (K)			
	Nichtmet. Werkstoffe / Non-fer. metall.	N			
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S			
	Gehärteter Stahl / Hardened steel	H			
Wendeplatten Inserts	Bezeichnung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

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

CBN



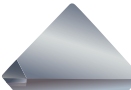
60°



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
	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	
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 ○ 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		
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 ○ 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	Fullface TY 1110 PKD			
		F	T		
RCMW 	06 02 00				
	08 03 00				
	10 03 00				
	12 T3 00				

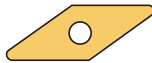
Werkstück Workpiece	Stahl / Steel	A (P)			Machinentyp Machining types ● Hauptanwendung / Main application ○ Nebenanwendung / Additional application
	Rostfreier Stahl / Stainless steel	R (M)			
	Guss / Cast iron	F (K)			
	Nichtmet. Werkstoffe / Non-fer. metall.	N			
	Warmf. Leg., Titanleg. / Heat res. alloys, Titan. all.	S			
	Gehärteter Stahl / Hardened steel	H			
Wendeplatten Inserts	Bezeichnung Part Number	1 Ecke / Corner TY 1110 PKD			
		F	T		
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																		
CBN																	CDX09	
Hartmetall unbeschichtet Uncoated Carbide																		

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

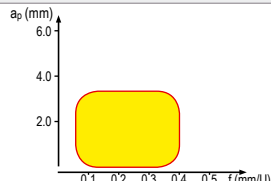
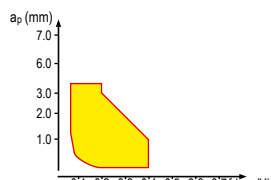
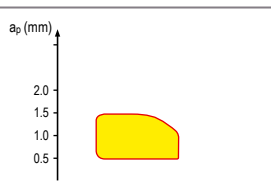
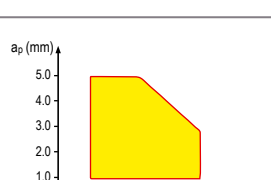
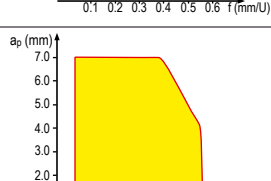
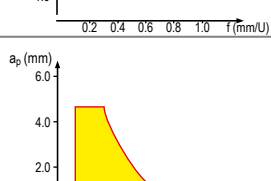
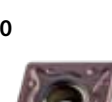
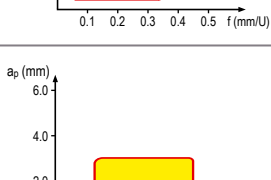
Stech- und
Abstechwerkzeuge
Grooving and
Parting off Tools

Mini/ Micro
Schneidwerkzeuge
Mini/ Micro Tools

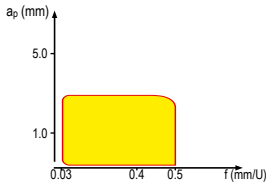
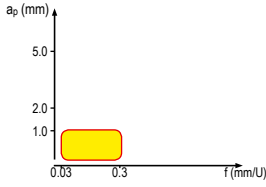
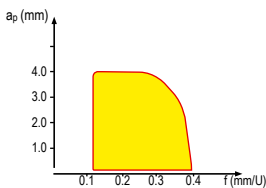
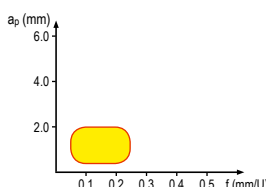
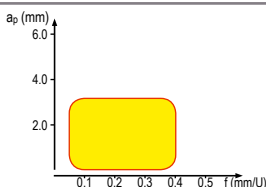
Gewinde-
werkzeuge
Threading Tools

Wendepaltenbohrer
VHM-Bohrer
Indexable Drills
Solid Carbide Drills

Spanleitstufen zum Drehen / Chipbreakers for Turning

Spanleitstufe Chipbreaker		Anwendungsbereich Application Range	Highlights	Highlights
Negative Wendeschneidplatten / Negative Inserts	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 		• 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

Positive Wendeschneidplatten / Positive Inserts	Spanleitstufe Chipbreaker	Anwendungsbereich Application Range	Highlights	Highlights
	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 Zerspanungsmaterialien • hohe Oberflächengüte durch scharfe Schneidkante und geringe Schnittkräfte	Medium cutting • Optimized chip control at ductile materials • Very good surface due to sharp cutting edge and marginal cutting force
	MD 		Mittlere Bearbeitung • auf antriebschwachen 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 TK 1310 (K10)	TK 5410 (K10C)	TK5510 (K10)	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, geglüht / 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 / leadless 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, geglüht / annealed	200	31		40 - 80	30 - 60
		Fe-Basis/base(Incoloy), ausgehärtet / hardened	280	32		35 - 55	20 - 55
		Ni-Basis/base (Inconel), geglüht / 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
H	gehärteter Stahl / hardened steel	gehärtet und angelassen / hardened and tempered	55 HRC	38			
			60 HRC	39			
	Hartguss / chilled cast iron	gegossen / cast	400	40			
	Gehärtetes Gusseisen / hardened cast iron	gehärtet und angelassen / hardened and tempered	55 HRC	40			

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 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 - 280	120 - 280	180 - 240	190 - 280		
130 - 250	70 - 130	150 - 180	150 - 220	150 - 220	130 - 250	130 - 250	150 - 200	170 - 240		
100 - 180	70 - 120	110 - 150	120 - 200	120 - 200	100 - 180	100 - 180	150 - 200	130 - 200		
80 - 200		160 - 190	160 - 250	160 - 250	100 - 230	100 - 230	170 - 200	170 - 250		
60 - 180		80 - 140	90 - 180	90 - 180	80 - 200	80 - 200	100 - 160	100 - 190		
		70 - 130	80 - 170	80 - 170	60 - 180	60 - 180	90 - 150	90 - 170		
		60 - 120	120 - 190	120 - 190	50 - 130	50 - 130	80 - 140	80 - 160		
		110 - 200	80 - 160	80 - 160	80 - 180	80 - 180	130 - 170	130 - 200		
		40 - 80	120 - 180	120 - 180	50 - 120	50 - 120	80 - 130	80 - 150		
100 - 180	70 - 120	130 - 170	100 - 170	100 - 170	100 - 180	100 - 180	140 - 180	130 - 210		
70 - 150	60 - 100	100 - 160	90 - 180	90 - 180	70 - 150	70 - 150	115 - 170	110 - 190		
120 - 220	70 - 120	130 - 200	140 - 200	140 - 200	120 - 220	100 - 250	140 - 200	140 - 200		
80 - 200	80 - 150	90 - 190	90 - 180	90 - 180	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 - 280				300 - 1000	
					120 - 270				300 - 800	
					110 - 260				300 - 450	
					100 - 250				250 - 350	
					90 - 250					
					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		
									80 - 200	
									40 - 180	
									40 - 180	

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

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